



# 2



# 3



# 1

**Automatic Welding stations of Peugeot seat frame manufacturing line**



# 4

| SPECIFICATIONS OF AUTOMATIC STATIONS FOR WELDING PEUGEOT 405 FRONT SEAT FRAME |               |          |          |          |          |        |
|---|---------------|----------|----------|----------|----------|--------|
| PARAMETERS  |               | Station1 | Station2 | Station3 | Station4 | Unit   |
| Rated Power<br>(50% Duty Factor)  | Transformer#1 | 70       | 70       | 70       | 70       | KVA    |
|   | Transformer#2 |          | 70       | 70       |          | KVA    |
|   | Transformer#3 |          | 42       |          |          | KVA    |
|   | Transformer#4 |          | 42       |          |          | KVA    |
| Secondary Voltage   | Transformer#1 | 10.5     | 10.5     | 10.5     | 10.5     | V      |
|   | Transformer#2 |          | 10.5     | 10.5     |          | V      |
|   | Transformer#3 |          | 7.0      |          |          | V      |
|   | Transformer#4 |          | 7.0      |          |          | V      |
| Air Pressure  | Unit Service  | 8        | 8        | 8        | 8        | Bar    |
| Station Working Time  |               | 20.0     | 50.0     | 30.0     | 30.0     | sec.   |
| Inlet Water Pressure  |               | 4        | 4        | 4        | 4        | Bar    |
| Coolant Water flow rate   |               | 9        | 15       | 11       | 8        | L/min. |