

Southern Copper and Supply 800-289-2728
HYDRAULIC EQUALIZING ADAPTERS AND ASSEMBLIES



Phone: 866-634-8884

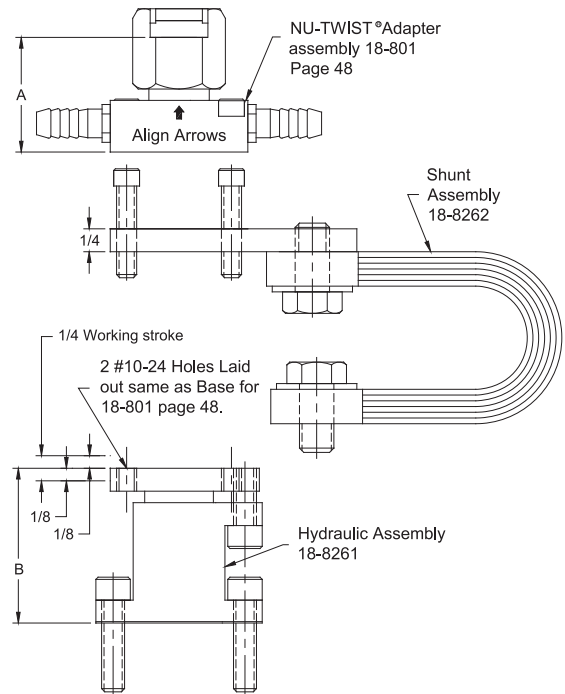
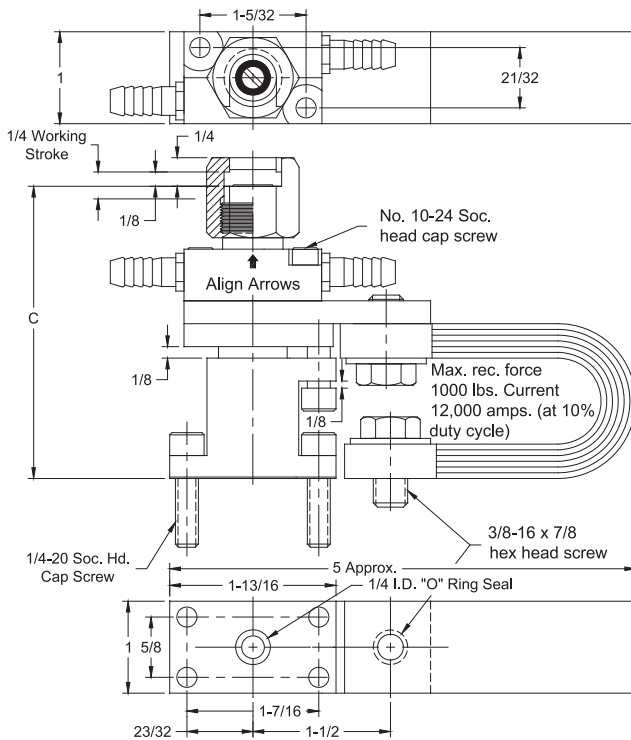
Fax: 866-239-6995

Email: cmw@cmwinc.com

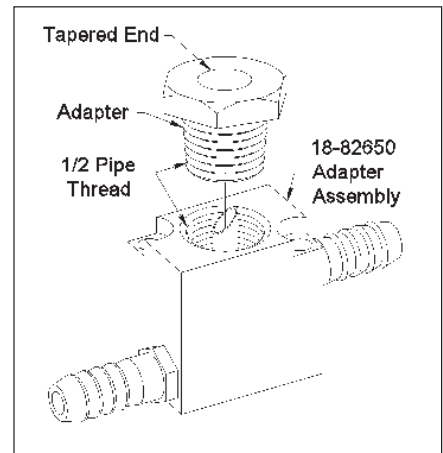
HYDRAULIC EQUALIZING ADAPTERS AND ASSEMBLIES

CMW Hydraulic Equalizing adapter units are used to equalize the weld force when two or more welds are required simultaneously. The equalizing action is developed in a closed hydraulic system - and is accomplished by hydraulically interconnecting two or more units. We recommend using fire resistant hydraulic fluid compatible with BUNA "N" such as HOUGHTO-SAFE #620, 1120 or equivalent. Consult your local industrial lubricant distributor.

18-826 #1 SIZE UNIT WITH NU-TWIST® SHOWN



Complete Unit Part No.	Unit Size.	Electrode Attachment	Included Tapered Adapters	Height A	Mean Height B	Mean Electrode Engagement Height C
18-826	#1	NU-TWIST®	-	1-1/4		3-13/64
18-82650	#1	1/2-14 Pipe Thd.	-	1-1/2		3-29/64
18-82651	#1 with adapters	5 RW Male cap	18-7465-07	1-59/64	1-43/64	3-7/8
18-82652		4 RW	18-746-07	1-51/64		3-3/4
18-82653		5 RW	18-747-07	1-51/64		3-3/4





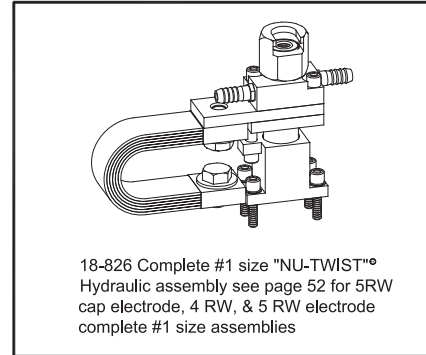
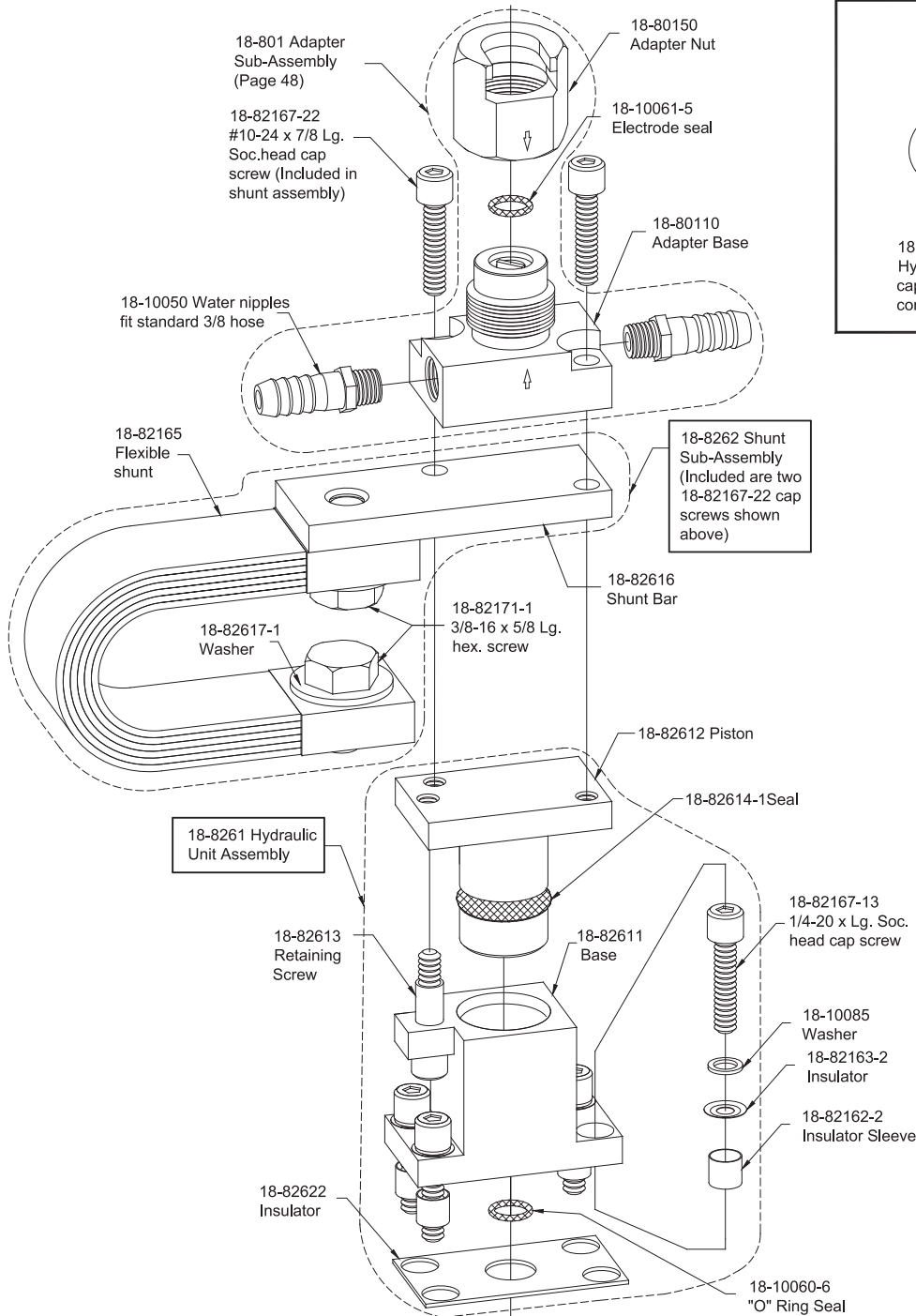
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HYDRAULIC EQUALIZING ADAPTERS AND ASSEMBLIES

18-826 COMPLETE #1 SIZE "NU-TWIST"® ASSEMBLY



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HYDRAULIC EQUALIZING ADAPTERS AND ASSEMBLIES



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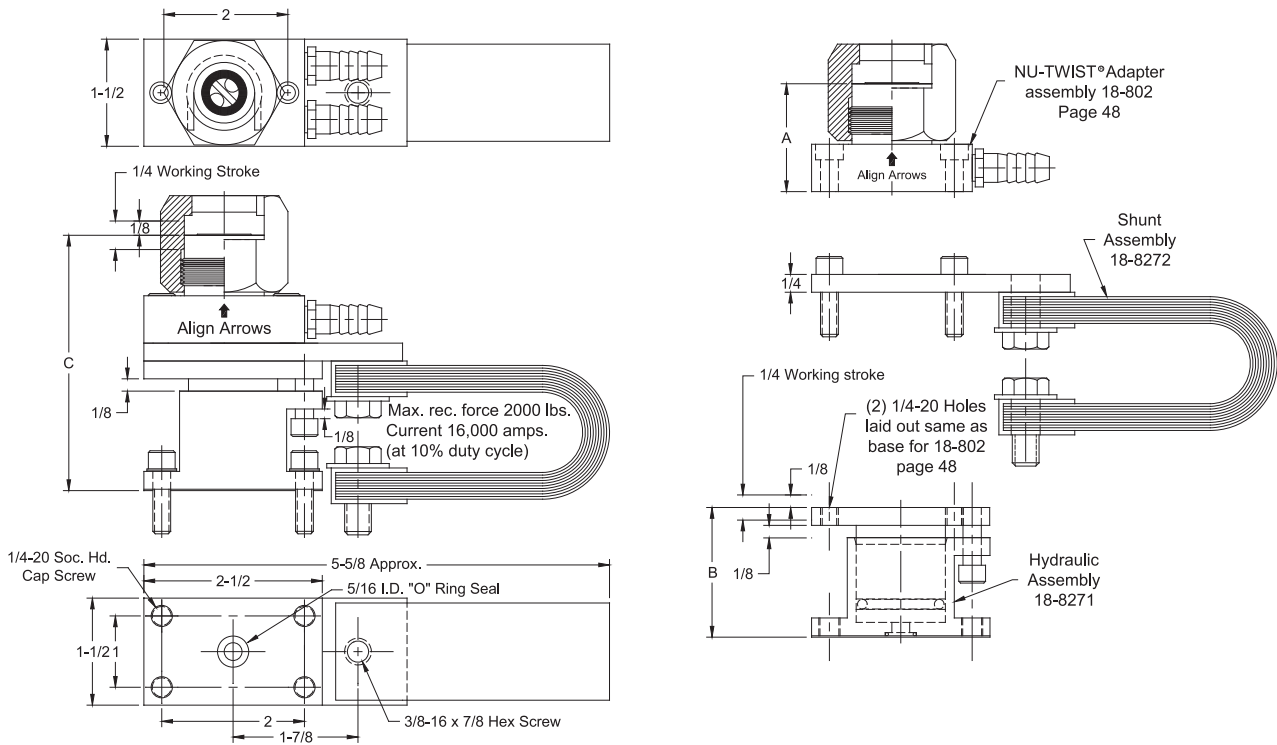
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18-827 #2 SIZE UNIT WITH "NU-TWIST"[®] SHOWN



Complete Unit Part No.	Unit Size.	Electrode Attachment	Height	Mean Height	Mean Electrode
			A	B	Base Height
18-827	#2	NU-TWIST	1-13/16	1-49/64	3-53/64



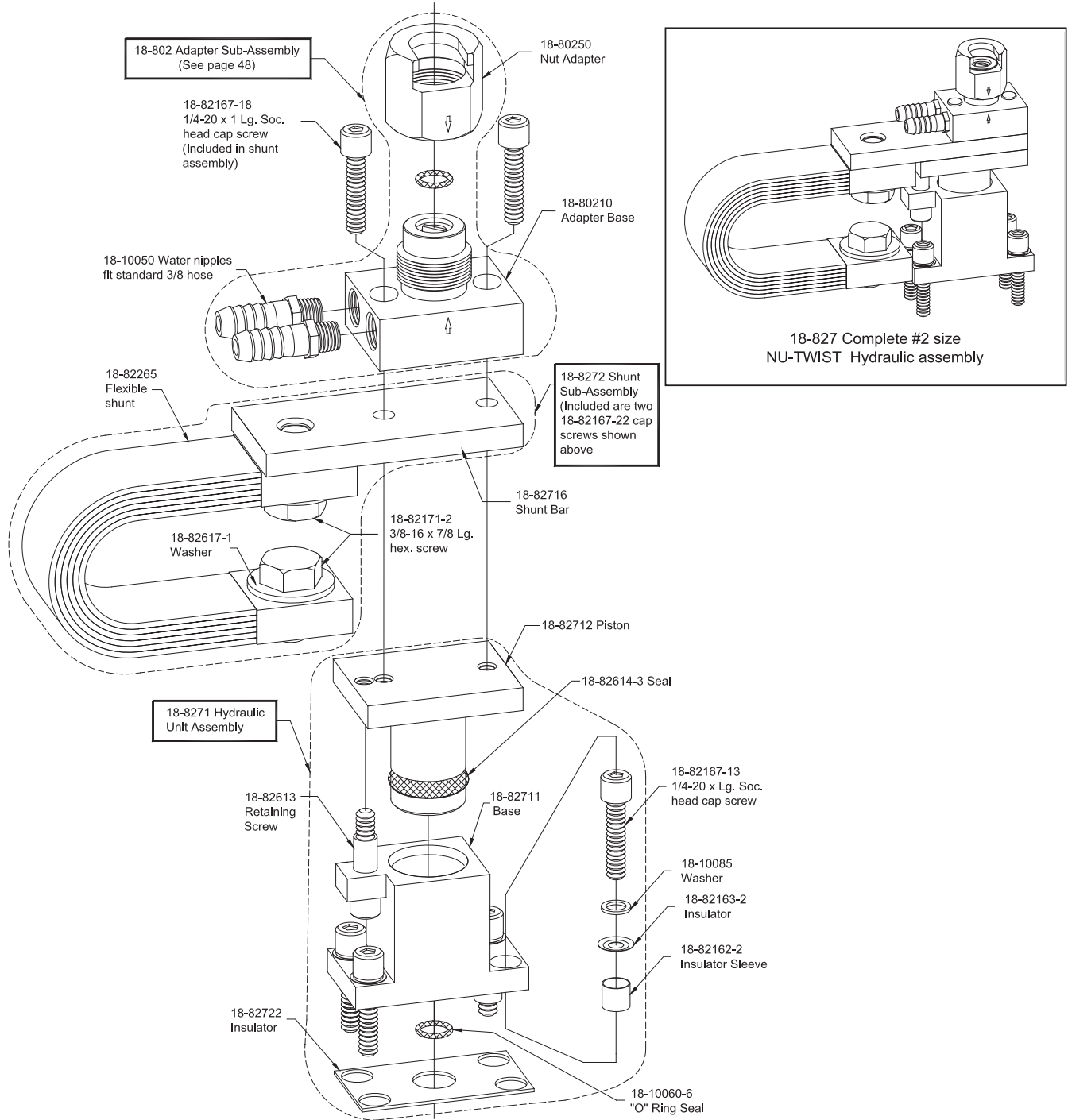
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HYDRAULIC EQUALIZING ADAPTERS AND ASSEMBLIES

18-827 COMPLETE #2 SIZE "NU-TWIST" ASSEMBLY



Southern Copper and Supply 800-289-2728
FIXED UNIT HYDRAULIC EQUALIZING ASSEMBLIES (WATER COOLED)



Phone: 866-634-8884

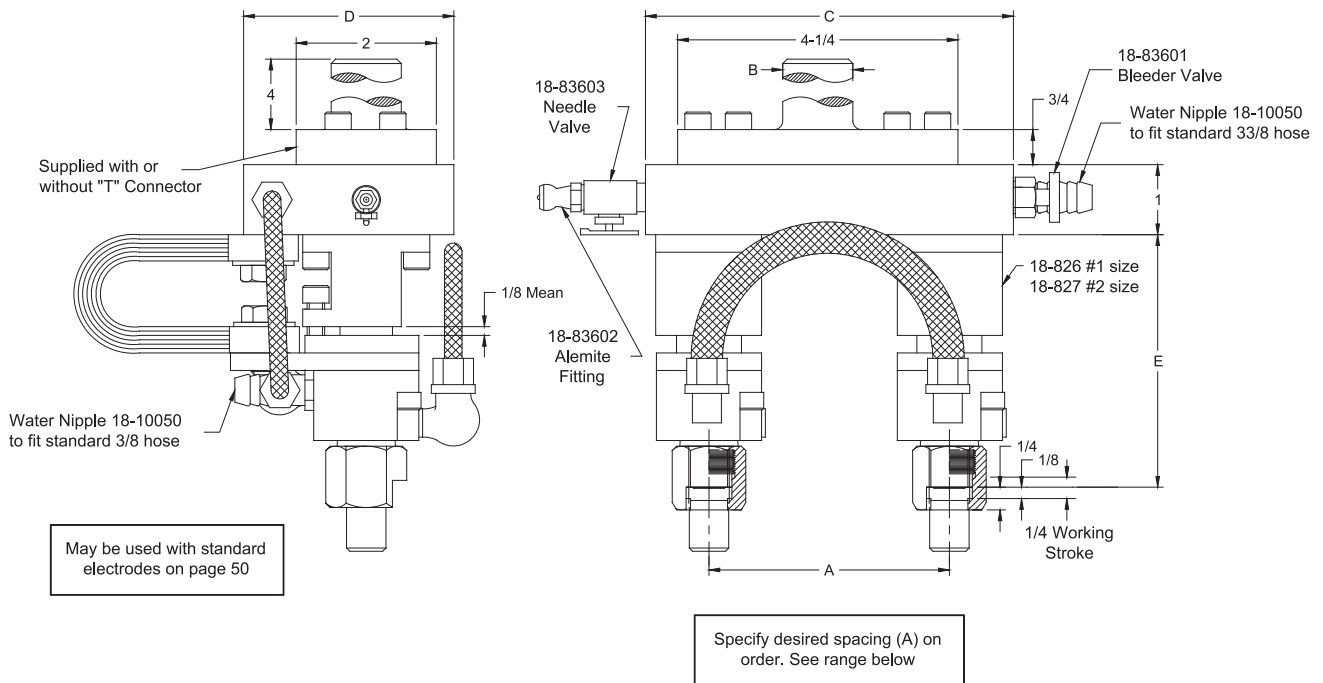
Fax: 866-239-6995

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FIXED UNIT HYDRAULIC EQUALIZING ASSEMBLIES

CMW Hydraulic Equalizing adapter units are used to equalize the weld force when two or more welds are required simultaneously. The equalizing action is developed in a closed hydraulic system - and is accomplished by hydraulically interconnecting two or more units. We recommend using fire resistant hydraulic fluid compatible with BUNA "N" such as HOUGHTO-SAFE #620, 1120 or equivalent. Consult your local industrial lubricant distributor.

TWO #1 OR #2 SIZE HYDRAULIC UNITS MOUNTED TO CUSTOMER'S DESIRED ELECTRODE SPACING.*



Assembly Unit Part No.	Unit Size	"T" Connector Shank Dia. B	Base Plate Length C	Base Plate Width D	Spacing* (Specify on Order) A	Max. Recommended Weld force Per Electrode LBS	Mean Height to Electrode Base E
18-846 18-84601-01	#1	None 1"	6	3	1-1/32" to 5"	1000 (12,000 Amps @ 10% duty cycle)	3-13/64
18-84601-02 18-84601-03		1-1/4" 1-1/2"					
18-847 18-84701-01	#2	None 1"	7-1/2	3-1/2	1-3/4" to 6"	2000 (16,000 Amps @ 10% duty cycle)	3-61/64
18-84701-02 18-84701-03		1-1/4" 1-1/2"					

- Note:
- Multiple units of 2-8 can also be supplied on custom designed base plates with or without "T" Connectors.
 - Units may be modified with adapters for RW tapered caps and electrodes

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ADJUSTABLE HYDRAULIC EQUALIZING ASSEMBLY 18-836



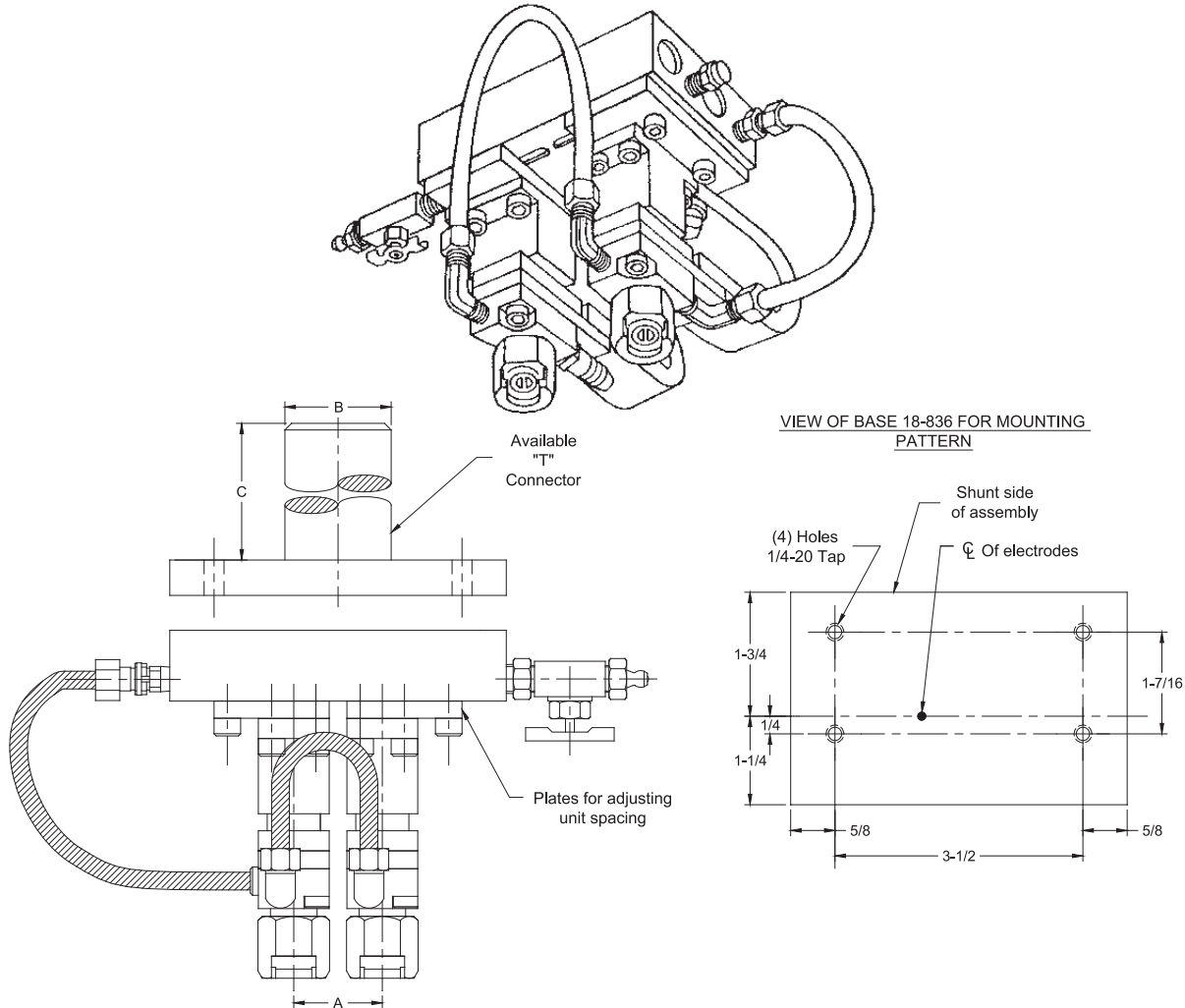
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ADJUSTABLE HYDRAULIC EQUALIZING ASSEMBLY 18-836

Part No. 18-836 (shown below) is a typical assembly using two 18-826 assemblies set up as a complete self-contained unit for making two spot welds at one time. **This unit is so arranged as to allow the center distances to be readily adjusted from 1-3/32" centers to 2-1/4" centers or by rearrangement of the same parts centers may be adjusted from 2-1/4" to 3-1/2".** This setup also include facilities for filling and bleeding the hydraulic units. "T" Mounting 18-83614 is available to order for assembly 18-836. We recommend using fire resistant hydraulic fluid compatible with BUNA "N" such as HOUGHTO-SAFE #620, 1120 or equivalent. Consult your local industrial lubricant distributor.



Assembly Part No.	Hydraulic Unit Size	Electrode Attachment ***	Adjustable Spacing Range A	"T" Connector			Max. Recommended Weld force Per Electrode LBS
18-836	#1	#1 NU-TWIST*	1-1/32 - 2-1/4 2-1/4 - 3-1/2*	NONE			1000 (12000 AMPS @ 10% Duty Cycle)
				Available	Dia. B	Length C	
				18-83614-01	**	4	
				18-83614-03	**	**	

* Partial disassembly, rearrangement of plates, and bleeding of unit will be necessary to switch centerline ranges.

** Customer must specify dimensions desired.

*** Other attachments available on request

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1100 SERIES ADJUST-A-PRESSURE WATER COOLED LOW INERTIA ELECTRODE HOLDER

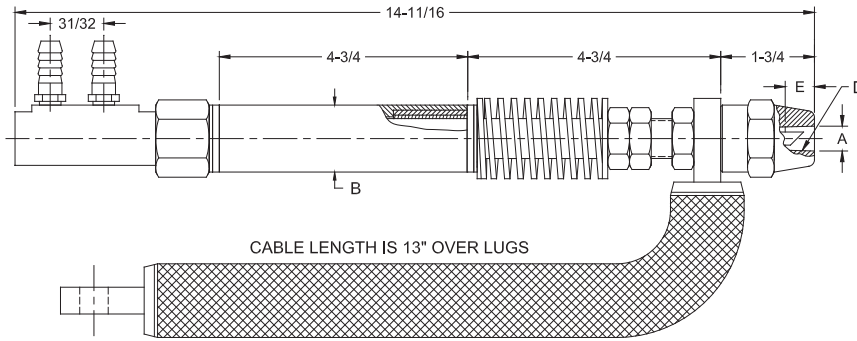


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1100 SERIES ADJUST-A-PRESSURE WATER COOLED LOW INERTIA ELECTRODE HOLDERS



Like other low-inertia holders the heavy duty Adjust-A-Pressure Holders are used for multiple spot and projection welding, and are excellent for indirect welding when mounted in the Adjust-A-Angle Adapter.

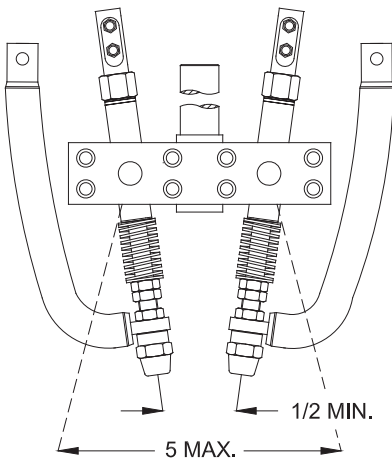
Electrical current is conducted through heavy flexible cables and holder is installed to prevent any damaging effects to the spring mechanism. Light duty springs supplied to order.

Part No. Holder Assy.*	Major Taper Dia. A	Barrel Dia. B	Taper D	Standard Electrode Taper Engagement E	Pressure Range (Pounds)
18-1101	.463	1-1/4	4 RW	1/2	to 500
18-1102	.625		5 RW	3/4	
18-1103	.463	1-1/2	4 RW	1/2	
18-1104	.625		5 RW	3/4	

* Standard holder uses 18-110006-1 spring. A heavy duty holder is available with spring 18-110006-2 for pressure to 1000 lbs.

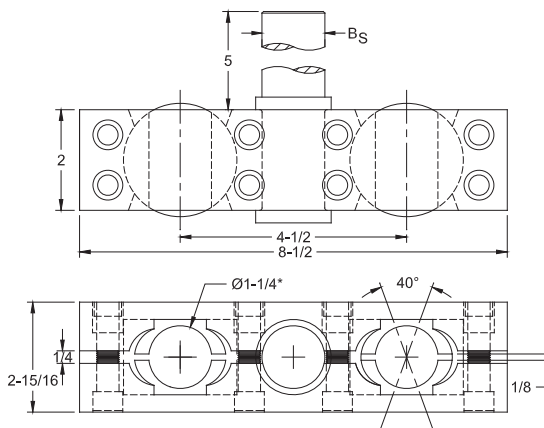
For additional holder information and replacement parts see page 59.

1150 SERIES ADJUST-A-ANGLE ADAPTERS



1100 SERIES HOLDERS ASSEMBLED IN 1150 SERIES ADAPTER

1150 SERIES ADJUST-A-ANGLE ADAPTERS ARE ADAPTABLE FOR USE WITH SPRING TYPE LOW INERTIA HOLDERS 1100 SERIES AS WELL AS STRAIGHT HOLDERS 100, 200, AND 300 SERIES.



Adapter Assembly Part No.	Shank Dia. B _S
18-1154	1
18-1155	1-1/4
18-1156	1-1/2

* Adapters for barrel sizes other than 1-1/4 dia. available as special order

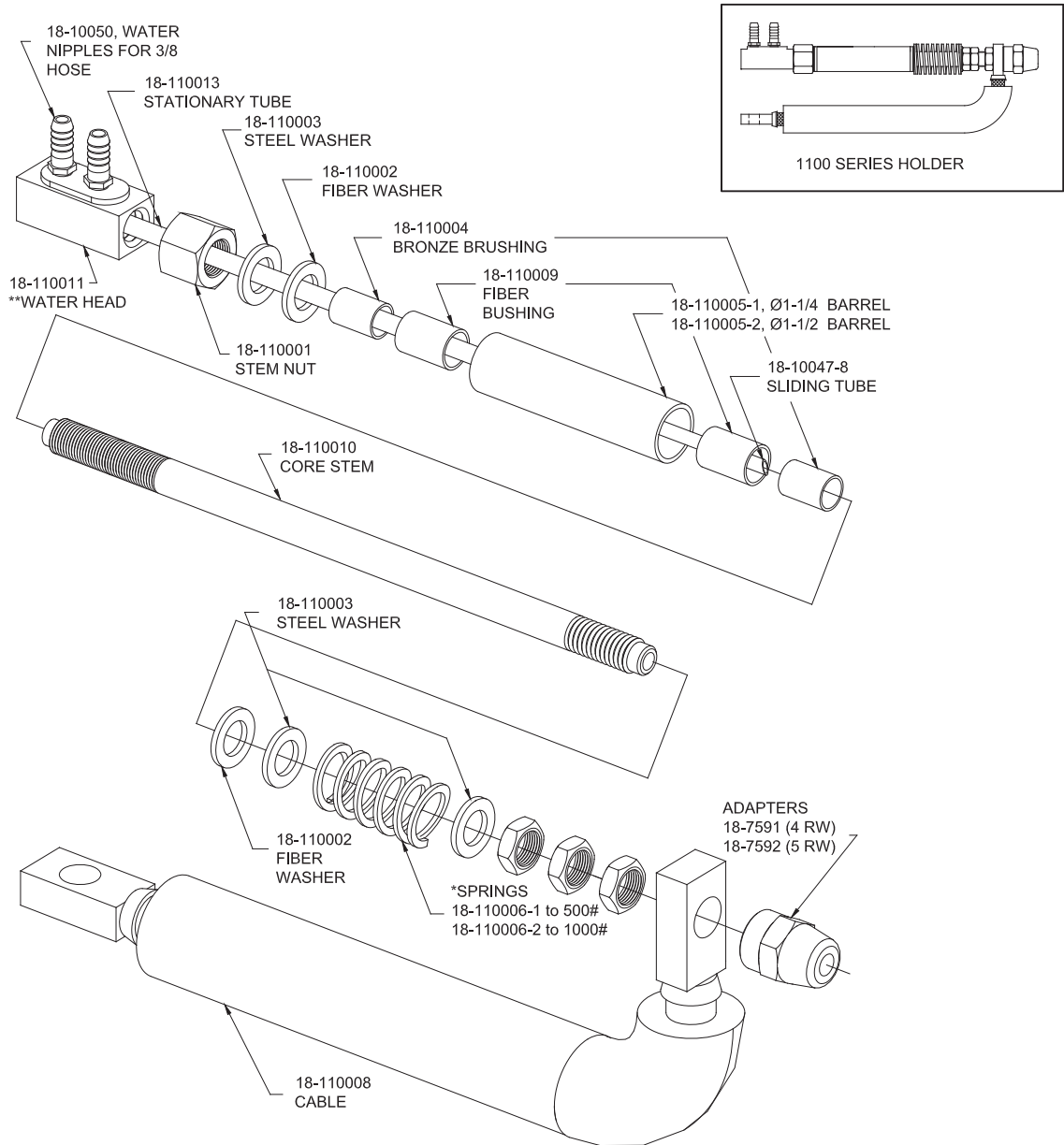


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1100 SERIES ADJUST-A-PRESSURE WATER COOLED LOW INERTIA ELECTRODE HOLDERS



** INCLUDES 18-110013, 18-10050, 18-10047-8

* SPRINGS: 500# SPRING IS PAINTED BLUE; 1000# SPRING IS PAINTED YELLOW

Part No. Holder Assy.*	Barrel	Adapter	Adjust -A- Angle Adapters
18-1101 18-1102	18-110005-1	18-7591 18-7592	Select from 1150 Series Chart page 58
18-1103 18-1104	18-110005-2	18-7591 18-7592	Special order

* See page 58 for more information

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APPLICATION SHEET FOR TYPICAL MULTIPLE SPOT WELDING SETUPS



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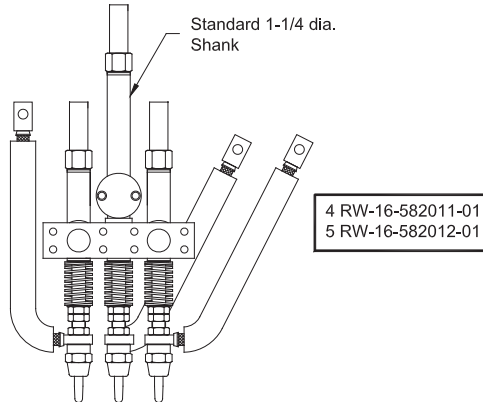
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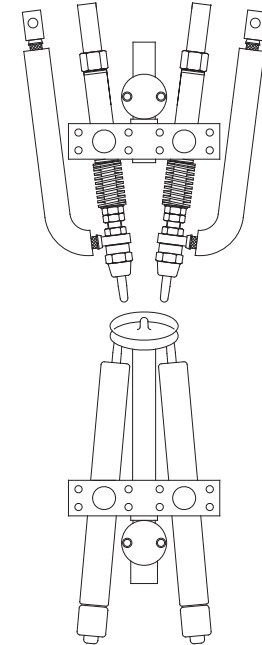
APPLICATION SHEET FOR TYPICAL MULTIPLE SPOT WELDING SETUPS

Typical Set Up For
3 Spots at a time in Parallel

- 1 CMW Std. 1150 Series Adapter
- 2 CMW Std. 1100 Series Holders
- 1 CMW Special 1100 Series Holder

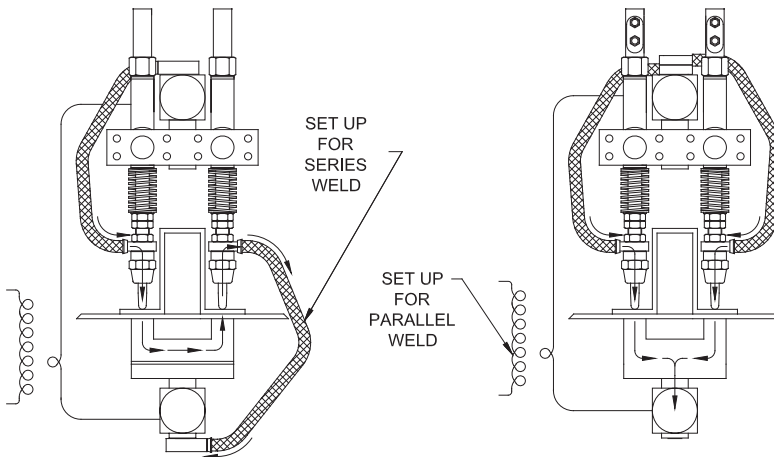


Typical Set Up For
2 spots simultaneously
in parallel



Upper
2-1100 Series Holders
1-1150 Series Adapter

Lower
2-100,200 or 300 Series Holders
1-1150 Series Adapter with special
center shank



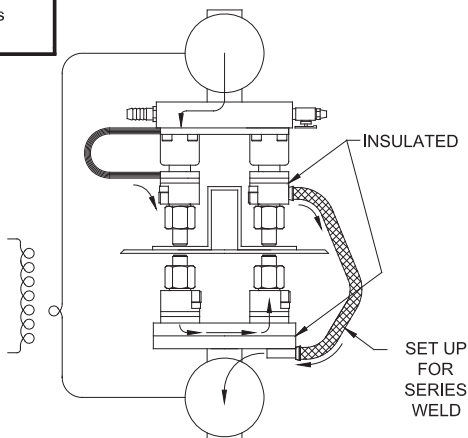
Contact Factory

All above items
priced and made
to special order

Illustrations
only

TYPICAL SET UP OF 800 SERIES "NU-TWIST"® UNITS

For dual spot welding using hydraulic "Nu-Twist"® Pressure equalizing subassemblies
and surface mounted adapters as basic building blocks



Upper
two
18-826
hydraulic
unit assemblies
mounted on
fixed centers
(See Pages
52, 53, 56)

Lower
two
18-801
surface
mounted
"Nu-Twist"®
Adapters
(See page 48)

