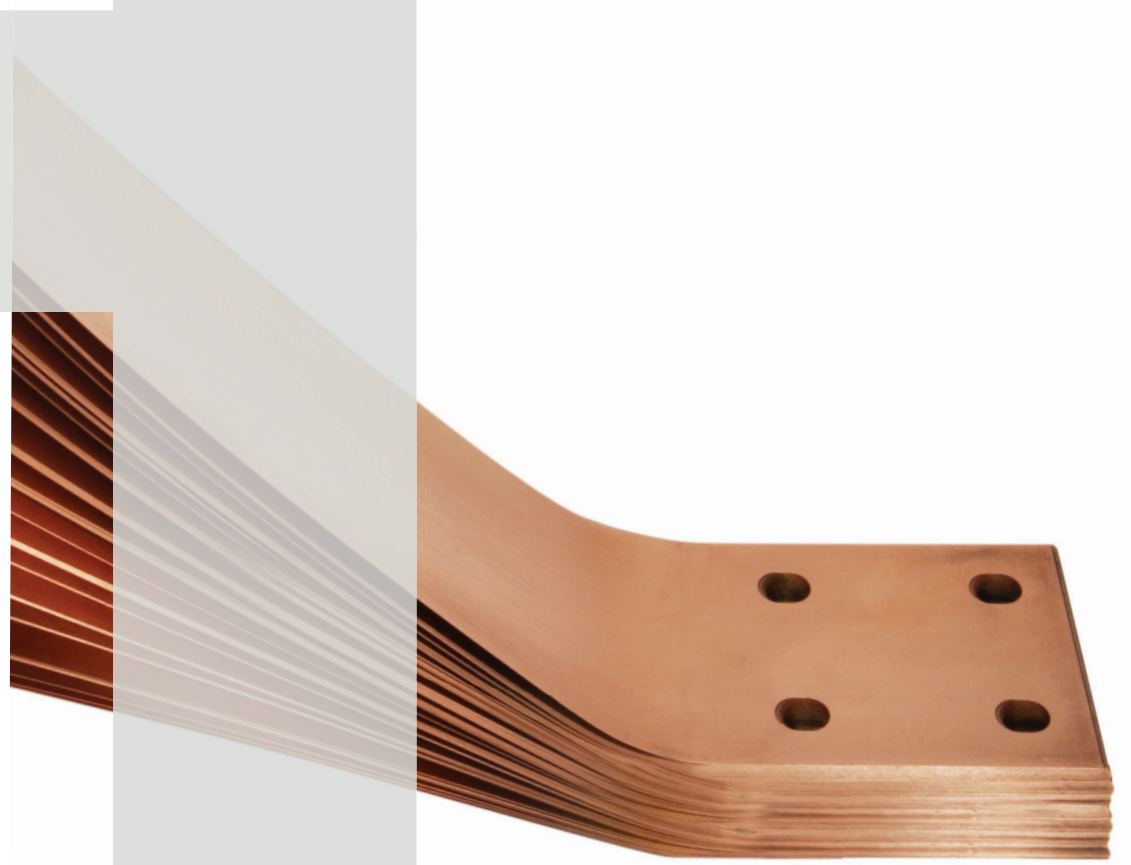


FORGET EVERYTHING YOU KNOW ABOUT  
ATOMIC DIFFUSION BONDING MACHINES:  
FROM TODAY, THINGS WILL NEVER  
BE THE SAME.



H

THE REVOLUTION HAS BEGUN!

**TECNA**  
Advanced Resistance Welding Systems and Balancers

**TECNA S.p.A.**  
Via Meucci 27  
40024, Castel San Pietro Terme, BOLOGNA  
Tel. +39-051-6954411  
Fax +39-051-6954490  
tecna@tecna.net

[www.tecna.net](http://www.tecna.net)



**TECNA**  
Advanced Resistance Welding Systems and Balancers

# A REVOLUTION IN ATOMIC DIFFUSION BONDING MACHINES



TECNA presents a new range of hydraulically operated portal welding machines  
**HYDRAULIC1500 - HYDRAULIC4000 - HYDRAULIC6000**

# UNBEATABLE FOR PRECISION AND REPEATABILITY

Thanks to cutting-edge sensors and components,  
the **repeatability of the geometry and of the electrical parameters**  
are finally **guaranteed and documented**.

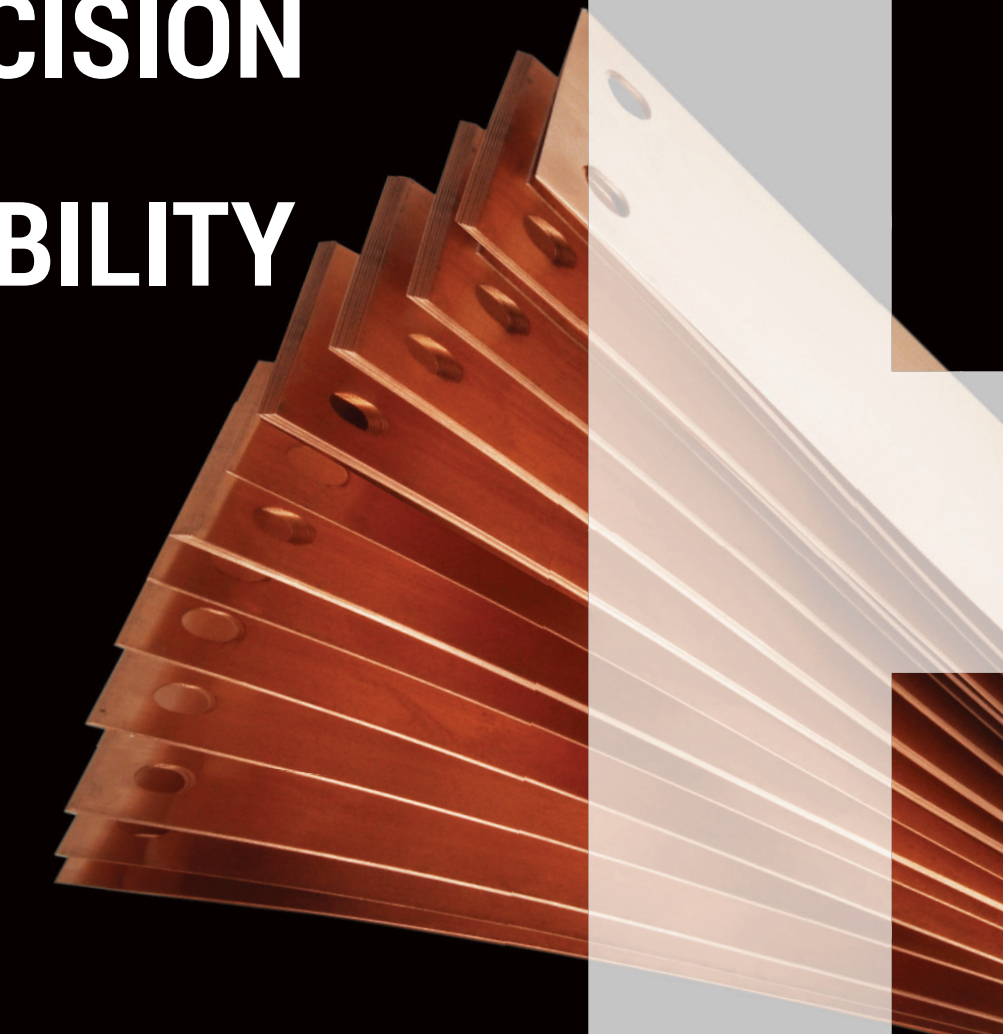
In any working area, regardless of the forces applied, we guarantee  
a precise and consistent **parallelism of the moving working surfaces**.

**Self-learning of the working dimensions**, adjustment and memorization of the welding  
cycle time to over 5 minutes and storage **up to 1000 different part numbers**.

**Real Energy Savings** and cutting-edge safety systems.

**Monitoring and detection systems** for component malfunction  
and **preventive maintenance** programs.

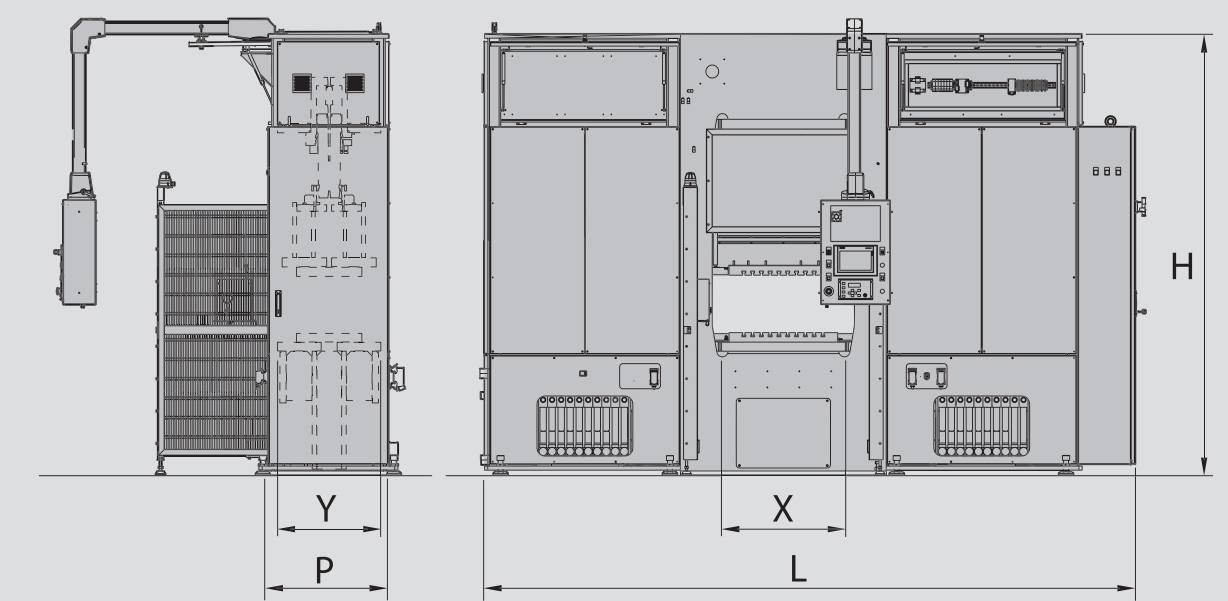
Option for **production synchronization** with additional machinery  
in a combined work process cell.





# H

## HYDRAULIC1500 - HYDRAULIC4000 - HYDRAULIC6000



		H1500	H4000	H6000
Welding max. power	kVA	2x250	2x400	2x630
Supply voltage	kVA	400	400	400
Frequency	Hz	50	50	50
Secondary nominal voltage v	v	11.75 10.6 9.5	13.8 12.2 10.7 9.3	14.2 12.8 11.4 10.3
Secondary thermal current at 100%	A	18.000	36.000	50.000
Actual cylinder stroke	mm	150	200	250
Cylinder slope down max speed	mm/sec	150	30	30
Maximum force at the electrodes at 250 bar - standard	kN	150	400	600
L	mm	3700	4100	5000
D	mm	820	870	950
H	mm	2800	2890	3000
X	mm	650	800	900
Y	mm	450	600	600

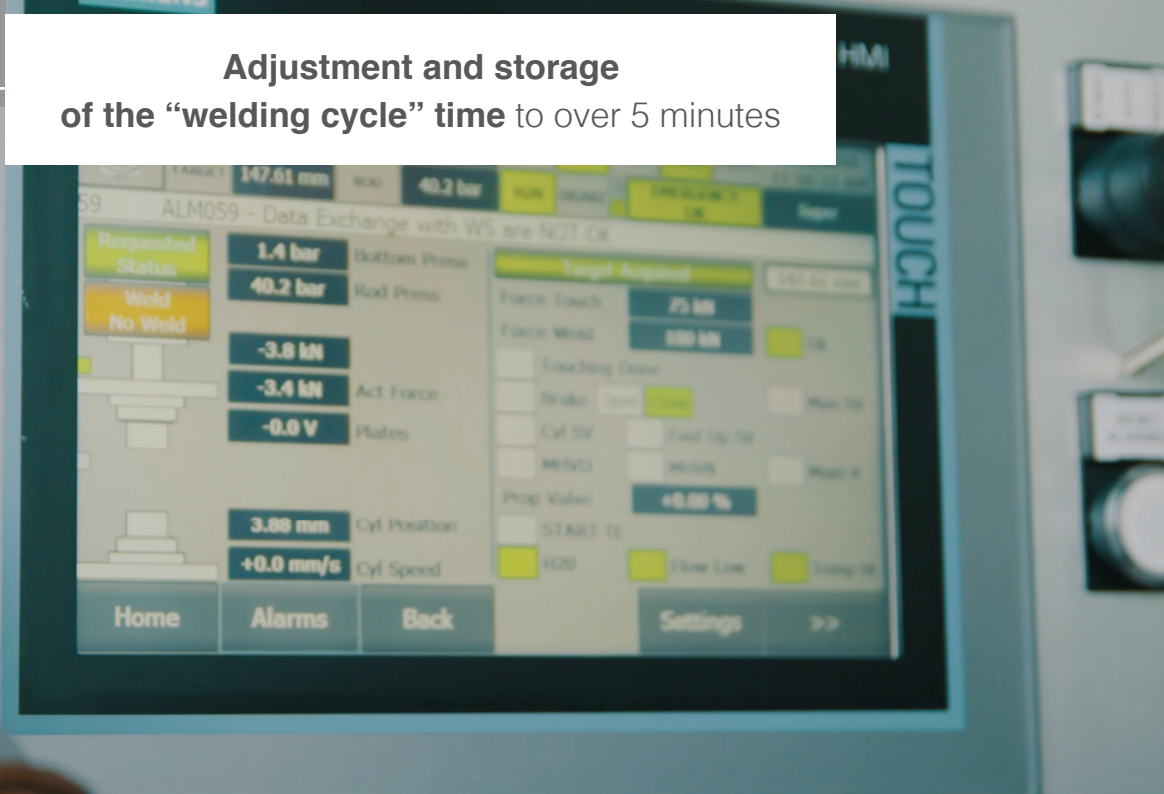


**"SELF-LEARNING WORKING DIMENSIONS"**  
device for a quick adjustment to different product parts

**"LOAD SENSING"** hydraulic drive with proportional control enabling efficient use of energy in the planned production cycles

Storage of **up to 1000 different part numbers**

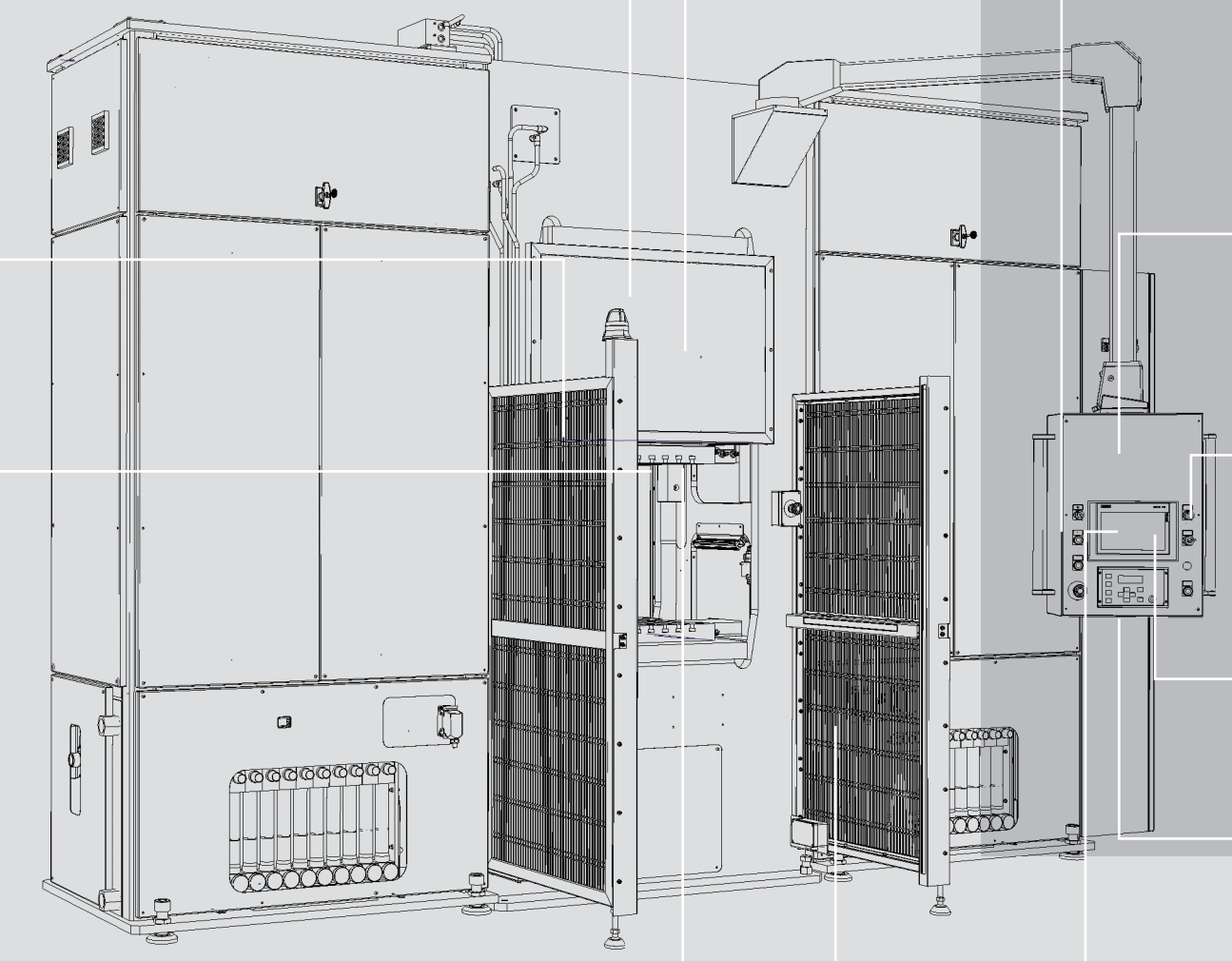
**Adjustment and storage of the "welding cycle" time to over 5 minutes**



Electronic position and pressure transducers for **perfect repeatability** of the stored production cycles

**Accident-prevention safety brake** for automatic locking of suspended masses

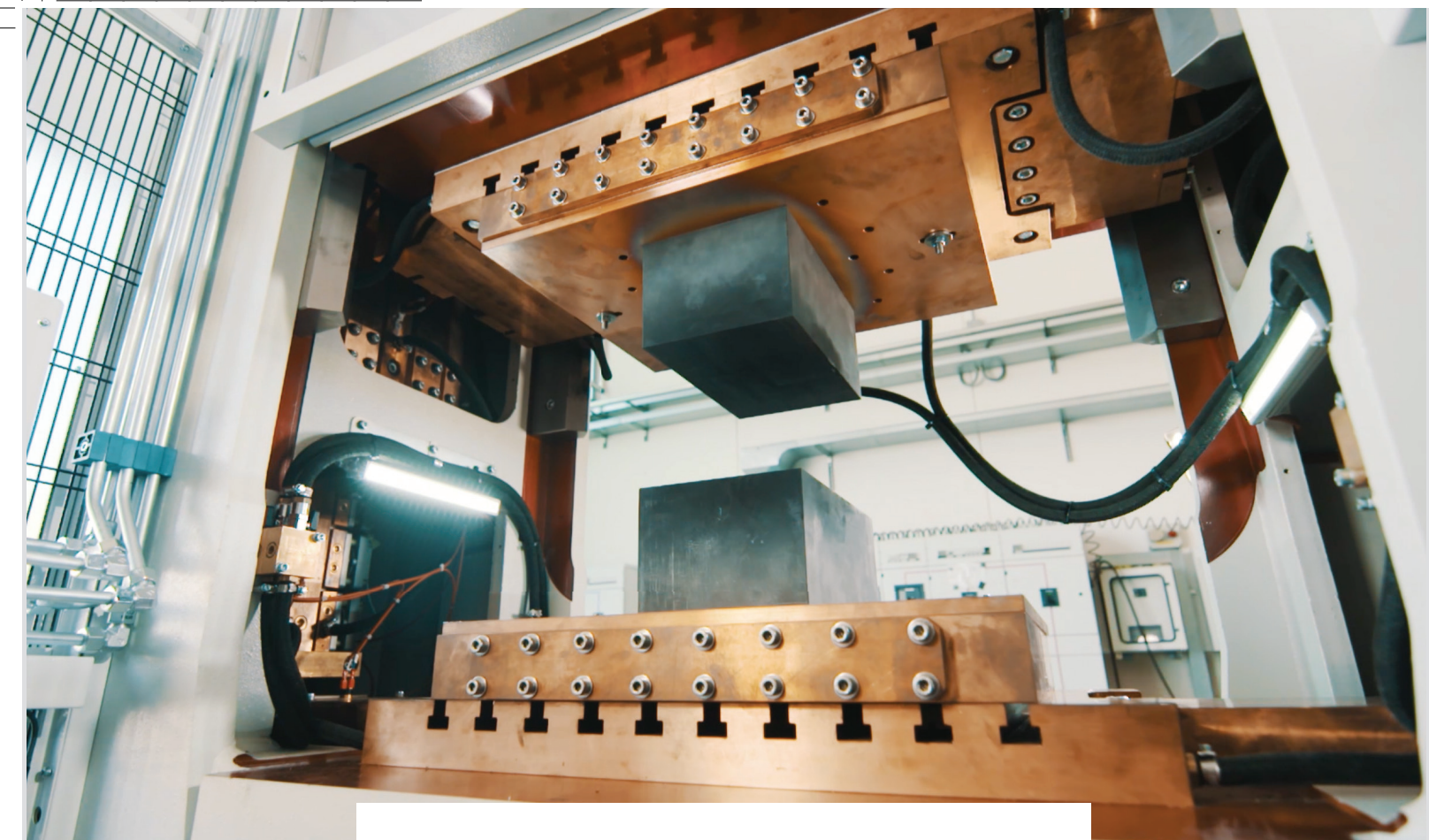
**Monitored** block valves



**"DRY LUBRICATED"** sliding parts to avoid the pollution of work surfaces

Accident prevention safety systems with **photoelectric double barriers**

Hydraulic circuit equipped with **"RER"** (real energy savings)



Work surface up to **900x600 mm**

System of **"CONSISTENT PARALLELISM"** for precise parallelism in any working area of the work surface regardless of the applied force

**Preventive maintenance** programs for component malfunction with **remote diagnosis** and **remote control**.

