



Areas of Application

The Switch-DA-4 is a device for the multi-point technology for drawn-arc - and short cycle welding and is designed for using of up to four stud welding guns on only one **inverter power unit DAI 2300** or **DAI-3300**.

Due to the multi-point technology, welding elements of different dimensions and relative to a component (product) can be welded more efficiently from one to the other diameter or length without time-consuming changeover. In "In-several passages welding" is not required; therefore the productivity is increased noticeably.

Technical Features

- Robust, powder-coated housing and generous dimensioning of all components carrying welding current;
- Standard version: Connection and operation of up to four stud welding guns in any combination or sequence; In general, each output is equipped with a gas module;
- Detection of the respective gun by START triggering on the gun or contact detection on the workpiece and immediate switching to the respective program location on the stud welder;
- No separate power supply necessary;
- Welding parameters for each gun separately via comfort control on the **control units DAI-2300 and DAI-3300** adjustable with display of the active gun slot (program slot);
- Comfort settings of welding current, welding time and gas function by means of a fixed and / or variable table at the control unit for each gun slot possible separately;

Optional:

- Process monitoring with displaying and storage of all mechanical and electrical welding parameters separately for each gun slot.

Technical Data

Connections welding-guns	4x separately controlled welding
Applicable welding-guns / automatic welding-heads	<p>Can be used in any combination (type of gun to be connected depending on the respective performance class of the control unit):</p> <p>GAP / GAP-M, DA-10 / DA-10M, DA-12 / DA-12M, DA-19M, DA-22M, DA-25M</p>
Process control system (optional)	<p>Separately and for each gun place selectable:</p> <p>Recording and evaluation of welding current and arc voltage as energy content over the welding time with definition of the upper and lower intervention limits</p> <p>Recording and evaluation*¹ of the data of an electromechanical position measuring system (stud overlap, lift dimension, melting rate, piston speed) with definition of the upper and lower intervention limits).</p> <p><i>¹* : Recording and evaluation only possible with optional process control system</i></p>
Power supply	Separately unnecessary power is supplied via the connection to the inverter DAI
Protection class	I (basic insulation)
Degree of protection	IP 23
Dimensions (L x W x H)	730mm x 360mm x 415mm
Weight	15 kg