



Areas of Application

The **Switch-4** is an additional device for the multi-point technology for drawn-arc - and short cycle welding / capacitor discharge welding and is designed for using of **up to four stud welding guns in combination with only one control unit DAI-1300 or control units of CDP-M-series.**

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

Technical Features

- Robust and compact stainless steel housing and generous dimensioning of all welding power transmitted components;
- Connection and operation of up to four drawn arc welding guns or up to four automatic welding gun in any combination or sequence (for automatic operation optional up to four automatic modules available at max configuration);
- Recognition of the particular used welding-gun by START-triggering or the workpiece contact detection and immediate switching to the respective program position on control unit
- Comfort settings of loading voltage (CD-process), welding current, welding time and gas function by means of fixed and / or variable table at the control unit for each gun separately possible;
- General equipped with gas modules;
- No separate power supply necessary;
- Welding parameters for each gun separately adjustable; comfort controls via the control unit and display of the currently active welding-gun (channel position).

Optional:

- Combination of automatic guns and manual welding guns in any sequence;
- Optional up to four fully automatic stud feeders BZ-V01 can be connected;
- Any additional options or features, such as automatic operation*¹, gas operation, encoder functions, electrical process control can be set separately for each welding-gun place.

***1: Automatic module in control unit necessary**

Technical specification

Connections welding guns	4x separately controlled welding guns / automatic welding heads can be connected
Applicable welding-guns / automatic welding-heads	<p>Can be used in any combination:</p> <p>Drawn-Arc and short-cycle process: GAP-M, DA-10 / DA-10M, DA-12 / DA-12M, ATP-8 / ATP-8M*¹</p> <p>Capcitor-dischare process: CONTACT-M, GAP / GAP-M, ATP-8 / ATP-8M*¹</p> <p>*1: Automatic module in control unit necessary</p>
Process control system (optional)	<p>selected separately for each welding gun</p> <p>Recording and analysis*¹ the data of an electromechanical measuring system (lift, depth of immersion, piston speed with setting the upper and lower action limits)</p> <p>*1: Analysis only in combination with digital process control system possible</p>
Power supply	Separately unnecessary power is supplied via the connection to the control unit
Protection class	I (basic insulation)
Degree of protection	IP 23
Dimensions incl. Connectors (L x W x H)	400mm x 200mm x 265mm
Weight	8 kg