

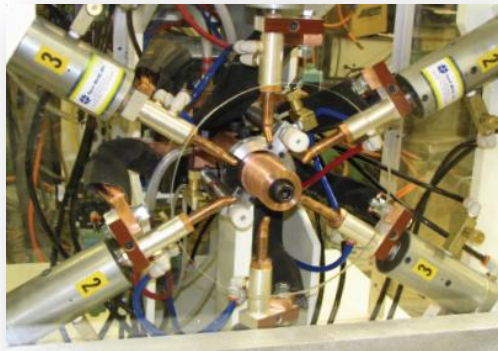
Spot Weld, Inc.
2290 Wycliff Street
St. Paul, MN 55114

Toll Free: 800-582-5229
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www.spotweldinc.com



SPOTWELD Incorporated
Excellence in Resistance Welding

Rapco Bench Style Spot Welders



ABOUT US

With 35 years of service and experience, we have the best trained and most knowledgeable resistance welding technicians available anywhere, period. Contact our friendly staff with your welding problem, and we will work efficiently and quickly to solve nearly all of the most complicated resistance welding applications.

BUILT TO YOUR NEEDS

Spot Weld, Incorporated can take your application specifications and build standard or special application spot welders to suit your needs. Just tell us the material you are welding, the metal thickness, and provide us with any special prints or sketches that communicate your welding needs. We'll take it from there!

INTRODUCTION

Spot Weld's "Rapco" Bench Type Resistance Welder is widely used by the metalworking industries today because of its extreme versatility. This general purpose machine represents a new high achievement in welder design and engineering, and embodies advantages which afford the greatest performance. Its modern design has incorporated ruggedness, accuracy, and reliable uninterrupted performance - all of which are of utmost importance to high production runs. The Spot Weld Rapco Bench welder offers the versatility of a resistance welder in a heavy plate steel, compact frame.

RAPCO STANDARD SPECIFICATIONS

KVA Sizes: 30, 50, 75, 100 or 150

Power Supply: 220 or 440 V, 50 or 60 Hz

Throat Depths: 6"

Electrode Holders: Water cooled, ejector type, furnished as standard on all machines.

Frame: Rugged, heavy gauge, one-piece, all steel body, strongly reinforced with welded stiffeners and ribs on heavy duty base.

Foot Switch: Air Operated

ABOUT

The Rapco series press type spot welder fills the need for fast precision spot welding where bench mounting is preferred. The desired weld pressure, weld time and welding current are pre-set by the precision weld control and stored memory for easy access and call-up.

RAPCO STYLE SINGLE POINT

The Single Point Rapco is the cornerstone of the Rapco line. If you are seeking a compact, economical welder with portability, this is your machine.

RAPCO FOUR POINT

The Rapco Four Point is a way to perform welds around the diameter of a tube, all at the same time. Many automotive parts today are made on this type of machine. This greatly increases the rate and accuracy of radial welds.

RAPCO SIX POINT

The Rapco Six Point is similar to the Four Point, except offers a greater number of welds. This has become the industry standard for bulkhead fittings, exhaust assemblies, and for tack welding radial seam

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Rapco Features and Benefits

ADAPTABILITY

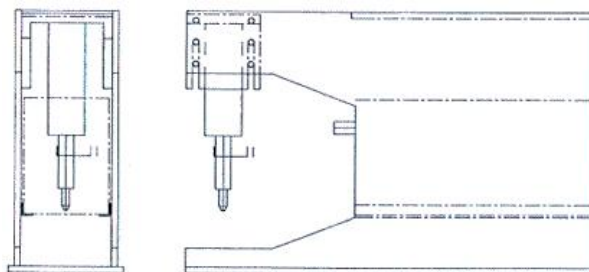
Experience being the best teacher, we have learned how to best align machinery with your needs. We take into account your production rate, your operators needs, electricity prerequisites, and of course your budget.

Confused by all the options available to you? Let us help you select from a long list of resistance welding styles:

- Single-Phase A/C
- Three- Phase A/C
- Medium Frequency Direct Current (MFDC) Inverter
- Seam Welding
- Rapid-Fire Welding
- Capacitive Discharge

ONE STOP SHOPPING

Our in-house capabilities include 3D solid modeling (CAD), Finite Element (stress) Analysis, CNC prototyping, MIG & TIG (GMAW & GTAW) welding, plasma cutting, Horizontal and vertical milling, lathe work, and engineering skills make all this work for you.



The main frame is high quality welded steel construction styled for trim appearance and functional design. The slim design requires a minimum of floor space. The upper arm extension is built integrally with the frame. The lower secondary can receive special tooling or a simpler electrode holder.

Optional Equipment

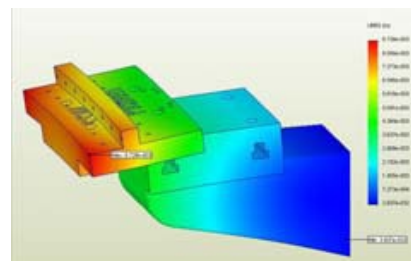
- **Adjustable, Retractable Cylinder**
This type of cylinder incorporates the features of an adjustable stroke cylinder, plus a retraction feature. Operation of the retraction stroke can be controlled by the foot switch.
- **Electrodes / Electrode Holders / Tip Dressers**
- **Chillers, Coolant and Re-Circulators**
- **Electrolytic Grease**
- **Safety Equipment**
- **Rapid Fire**
- **Palm Buttons**
- **Disconnect Switch**
- **Constant Current**
- **Bowl Feeders**
- **Low-Ride Casters**

Some of the key features that set our machine ahead of the competition are:

- Heavily Re-enforced Frame
- Ridged Lower Knee
- RAM (Upper cylinder holder adjusts up and down)
- Air Cylinder (Fast follow-up, low friction, low inertia capability, equipped with speed controls)
- Air Group & Accessories (Filter, automatic oiler, pressure gage and solenoid operated valve)
- Electronic Air (Total electronic air or high/low pressure transducer)
- Heavy Duty Water Cooled Transformer
- Precision Electronic Control
- Electrical Accessories (weld/no weld switch, single repeat switch and two stage foot switch)
- Tooling and Electrodes (Universal electrodes are available in standard spot and projection styles)

SERVICES AVAILABLE

- **Engineering & Design**
- **Custom Tooling & Fixtures**
- **Custom Machining**
- **Complete Machine Refurbishing**
- **Transformer Repair**
- **Installation and Setup**
- **Field Service & Maintenance**
- **Education / Training**
- **Technical Support**



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PROFESSIONALS

You get the individual attention you deserve at Spot Weld, Inc. You can rely on our courteous service. We know what we're talking about. If we don't have an answer, we'll say so, and then do our best to get it for you.

Call us with your questions about electrode tips, studs, holders or any kind of resistance spot weld equipment.

- Competitive Prices
- Large Stock
- High Quality
- Fast Delivery
- No Minimum Order

GAURANTEE

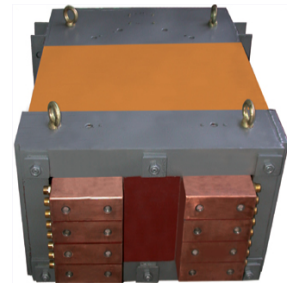
All our machines carry a like-new one-year parts and labor guarantee.

If you're not satisfied, we take it back!

Methods of Operation

- **Transformer**

The "heart of the welder" the Rocker Rite transformer is built to RWMA automotive and appliance standards. Transformer secondaries are of cast copper with integral, non-corrosive water cooling pipes. Class "F" insulation is used throughout. The transformer is bonded and sealed with high temperature varnish baked on each coil. The resulting unit is a high power factor, high efficiency transformer with low leakage reactance. All transformers provided are water cooled.



- **Supply Voltage and Frequency**

The Rapco type machine can be supplied for any one standard voltage supply of 220, 380, 440, or 550 volts, 50 or 60 cycles, single phase. Dual voltage, special voltages or frequencies are available as extras.



- **MFDC (Medium Frequency DC) - Optional**

Precisely controlled heating is required to achieve consistent, reliable welds. The medium frequency inverter achieves this level of control by precisely managing and monitoring weld parameters. The higher frequency permits much faster (1000 times per second) process control, which again results in better weld quality



- **Air Accessories**

Standard Equipment included air pressure regulator, gauge, lubricator, speed control valve, and solenoid valve for control of the cylinder.

- **Electrical Accessories**

Standard electrical accessories include a two stage foot switch. Dual palm buttons are available as options.

- **Controls**

Standard NEMA controls are mounted to the right side of the welder frame unless special tooling or customer preference precludes. JIB electrical specifications can be included as an extra.



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RAPCO WELDING MATERIAL SPECIFICATIONS

KVA Rating	Low Carbon Steel Max Weld Thickness*	Galvanized Steel	Stainless Steel**	Max Short Circuit Secondary Amps
30	Two pieces, 0.120"	Two pieces, 0.060"	Two pieces, 0.021"	18,500A
50	Two pieces, 0.194"	Two pieces, 0.090"	Two pieces, 0.037"	20,000A
75	Two pieces, 0.224"	Two pieces, 0.120"	Two pieces, 0.060"	25,500A

* Maximum material welding thicknesses are always estimates. Variables such as tooling, shunt or cable length, welder distance from primary, and other compounding variables can positively or negatively affect this number.

** Larger bore air cylinder may be required for welding stainless steel.

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