

Horizontal four-point sash welder



i About

The SW6000 horizontal four-point welders are robustly designed for long-term continual use with special features allowing multi-stack welding for vinyl sash. Multi-level fixturing with independent referencing assures strong, accurate welding on each level and more consistent cleaning of seams. Heavy-duty mechanical design with fully enclosed ball screws for sizing assures highly accurate sizes for single and multi-stack configurations. It comes in both primary and secondary beam sizes, and is one of the fastest and most compact systems available on the market today.

✓ Features

- Parallel welding resulting in symmetric bonds with mechanically synchronized weld tables
- Primary and secondary beam sizes available
- Industrial PC & PLC provide total control and allow for downloading of batches from office system
- Capacity upgrade kit for triple/quad stack (components include: heater plates, guards, setting plates and back fences)
- Full computer control with HMI and download capacity (standard)
- Horizontal loading with convenience mode
- Four linear traveling heating and setting plates with intermediate stop positions for notched welding (slope sill)
- Symmetric weld cycle using parallel welding techniques
- Machine sizing via local keypad entry or optional full computer control for flexible operation
- Protective guarding, light curtain and surround fencing ensure safety of operation
- Long-term continual operation with minimal maintenance

Performance Specifications

- **Voltage:** 480 VAC Wye +/-10%, 3 Phase, 60 Hz
- **Beam Size:** 6' x 6'
- **Max. Weld Size:** 72" x 72" (1829mm x 1829mm)
- **Min. Weld Size*:** 12" x 12" (305mm x 305mm)
- **Max. Weld Height:** 11" (279mm x 279mm)
- **Max. Capacity (with quad stacked tooling):** Up to 720 boxes per shift

**Smaller minimums achievable with fixturing*

System Software

- Touchscreen PC and B&R® PLC machine controller
- Machine sizing via local keypad entry, network download and bar code communication with PC interface

► Standard Equipment & Options

- Horizontal loading with convenience mode for large sizes
- Four linear traveling heating and setting plates
- Symmetric weld cycle using parallel welding technique for improved corner strength
- Dual Heat Zone Controls
- Single, Double, Triple, or Quad level weld fixtures
- Protective guarding and surround fencing
- Optional light curtains
- Mechanically synchronized weld tables
- Electrical cabinet temperature control w/ thermostat

► Standard Upgrades

- Transformer Kit, 208V Primary/480V Secondary
- Transformer Kit, 240V Primary/480V Secondary
- Transformer Kit, 600V Primary/480V Secondary
- Bar Code Reader Software
- Spare Parts Kits
- Weld fixture inserts for additional profiles
- Stainless steel pinch knives (Interior/Exterior)

► Complimentary Products

- SD20 Saw
- MC2000 & MC3000 Fab Centers
- Weld Break Tester
- SW7000
- TruWeld™

► Preferred Service Package

- Machine installation
- Standard GED 1-Year Equipment Warranty
- Machine operator/maintenance training



Request for Quote

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Designed &
Manufactured

About GED Integrated Solutions

GED Integrated Solutions is a Worldwide Supplier of fully integrated insulating glass (IG), vinyl window and door robotic automation fabrication systems and software. GED leads the industry with quality, capacity and cost-effective solutions as demonstrated by the revolutionary *Intercept*® Warm Edge spacer frame production systems as well as our innovative vinyl automation systems and value-driven scheduling and analytics software. GED's commitment to innovation, that addresses our customers' needs, is proven by the fact that 22 of the top 25 window and door manufacturers utilize GED's equipment and software.



TECHNICAL SPECIFICATIONS

For installation dimensions please refer to full line layout drawing

DIMENSIONS

Primary Beam	Beam Length	Machine Length
	6 ft. (182.9 cm)	122" (309.9 cm)
Secondary Beam	Beam Length	Machine Width
	6 ft. (182.9 cm)	90" (228.6 cm)
Operating Weight	<4375 lbs (<1984.5 kg)	
Work Table Height	33" - 37" (83.9 cm - 94 cm)	

SPECIFICATIONS

Welding Heads	4
Number of levels	Up to 4 sashes (3" limit per profile)

REQUIREMENTS

Power Supply Requirements	480 VAC Wye +/-10%, 3 Phase, 60 Hz NOTICE: The use of Wye power is required on this equipment. The use of Delta power is prohibited and will void warranty. If the facility has Delta power, an isolation transformer that converts the power to Wye center-ground-tap is required.
Full Load Amperage Draw (FLA)	31.48 AMP
Compressed Air Requirements	4 CFM @ 90 PSI

EJECTOR

Compressed Air Requirements	1.5 CFM @ 90 PSI
Motor Size	2 x 0.25 HP Gear Motor, 1:15

CONTROLS

Industrial PC	Touch Screen, 15" (38.1 cm) LCD, Network Capable Controller
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ENVIRONMENT

Operating Temperature	60°F to 104°F (16°C to 40°C)
Storage Temperature	-4°F to 122°F (-20°C to 50°C)
Humidity	10-90% Non-condensing
Noise Level	<85 dbA