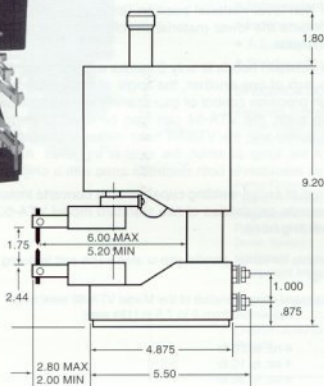


Model VTA-60

Precision Weld Head



The Model VTA-60 is Hughes' basic precision weld head. Originally designed for assembling high reliability electronic circuit modules, this unit's precision construction and flexibility have won places throughout the industry. Note that the VTA-60 serves as the basic model from which other Hughes heads have evolved. VTA-60 weld heads can be converted to the special-purpose configurations represented by models such as the VTA-61, 64, 66. This head is also suitable for vertical, opposed or offset electrode welding using ac, dc, or capacitor discharge welding power supplies. Conversion is simple and easily reversible. Versatility and adaptability are truly the keynote of this award-winning electromechanical device.



SPECIFICATIONS • Model VTA-60

Throat depth	5.20 in (132 mm)—may be extended to 6.00 in (152 mm)
Vertical work opening	1.75 in (44 mm)
Stroke	$\frac{1}{2}$ in (1 in optional)
Electrode force range	
Standard — Specify VTA-60	4 oz to 20 lb
Optional — Specify VTA-60-10	4 oz to 10 lb
Optional — Specify VTA-60-30	4 oz to 30 lb
Optional — Specify VTA-60-04	4 oz to 4 lb
Maximum weld energy rating	250 watt-seconds
Equipment included	One pair $\frac{1}{8}$ in dia. electrodes of RWMA-2 alloy, integral stroke stops, two No. 4 weld cables 12 in long
Additional equipment required	Foot pedal, welding power supply
Optional equipment	
Foot pedals	See page 27
Baseplate	Model MA-60-BP, page 28
Horizontal mounting bracket	Model MA-07-03, page 27
	Model MA-07-05, page 27 (heads with flex-line foot pedals)
Constant force kit	See page 27
Dimensions (H x W x D)	11 x 1.75 x 7.5 in (279 x 44 x 191 mm)
Weight	5 lb (2 kg) net, 10 lb (5 kg) shipping

Model VTA-61

Air-Operated Precision Weld Head



Fundamentally the same unit as the Model VTA-60, this weld head has the additional feature of air actuation. A three-mode actuating control system is included.

The integral stroke stops provided on all Hughes welding heads are especially useful on the VTA-61 to limit unnecessary electrode travel and to prevent excessive forging due to air pressure buildup or careless operation.

SPECIFICATIONS • Model VTA-61 Identical to those for the VTA-60 except for the following:

Electrode force range, continuously adjustable	
Standard — Specify VTA-61	4 oz to 20 lb
Optional — Specify VTA-61-10	4 oz to 10 lb
Optional — Specify VTA-61-30	4 oz to 30 lb
Optional — Specify VTA-61-04	4 oz to 4 lb
Operation mode	Air or foot pedal manual override
Compressed air required	85 psi maximum recommended
Power required	115 Vac, 10 W, fuse at 1 A
Equipment included	One pair $\frac{1}{8}$ in diameter electrodes of RWMA-2 alloy, integral stroke stops, two No. 4 weld cables 12 in long, air actuating assembly
Additional equipment required	Welding power supply
Optional equipment	
Horizontal mounting adapter	Model MA-07-04, page 27
Air filter-regulator-oiler	Model MA-15-05 (recommended), page 27
Dimensions (H x W x D)	11.63 x 1.75 x 10.5 in (295 x 44 x 267 mm)
Weight	7 lb (3 kg) net, 12 lb (5 kg) shipping
	Specify VTA-61-MC if 230 V is required.