

# PRO SPOT

# i4

WATER-COOLED INVERTER SPOT WELDING SYSTEM



DESIGNED FOR NEW ADVANCED STEELS:  
AHSS, HSS, T.R.I.P., BORON



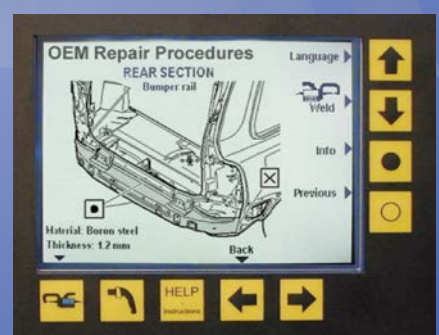
Ford LINCOLN  
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Boron Steel Welding



Weld Bonding



OEM, Training on-board





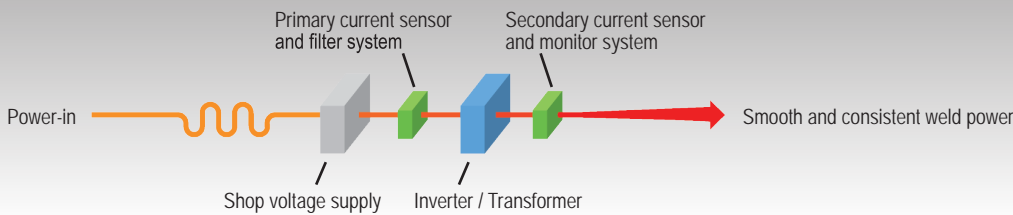
READY FOR TOMORROW'S STEELS - TODAY!



(cable holder not shown)



### Advanced Primary and Secondary Current Sensing System



The industry is changing. More than 10 different types of steel in one vehicle is not unusual. Steels such as AHSS, HSS, T.R.I.P., BORON are extremely advanced with yield tensile strengths over 1,000 MPa (megapascals).

#### UPGRADABLE WELD SOFTWARE

The i4's Current Sensing welding electrodes will never be obsolete because the i4's software is easily upgraded with a removable Flash Card as new data and information become available.

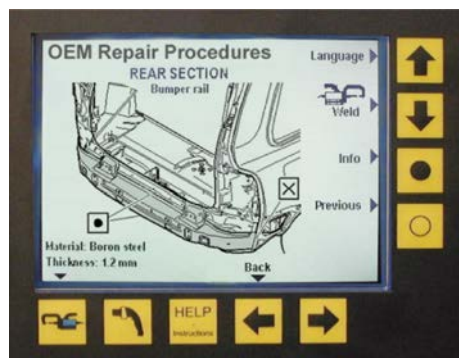
Cleans dirty power and always delivers smooth and clean weld current.

### Advanced Weld Features



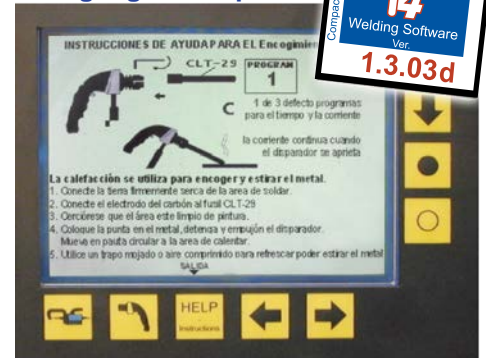
The two-sided weld program features four main weld modes: Single Weld, Dual Weld, Pulse Mode and Wave Mode. Upslope and Downslope of the weld current are automatically applied. With the Dual Weld Mode, current / time can change within the weld. Example: For the first 10 milliseconds a lower weld current is applied, then after a programmable pause, a higher weld current is applied for 8 milliseconds. The first pulse pre-heats the area, softening the metal, so when the second - higher pulse is applied, it recognizes the change in resistance as it applies the current. At that precise moment, the applied squeeze pressure can easily fuse the metals into a weld nugget. This feature is often used by OEM welders when welding Boron Steel, which is extremely hard.

### Advanced Weld Features



The i4 features an on-board training program which is easily accessible by using the large monitor on the front panel where images and instructions are displayed. The i4 is equipped with an OEM programmable feature which is capable of providing the user with detailed instructions and weld specifications provided by the OEM's as they become available.

### Languages / Help



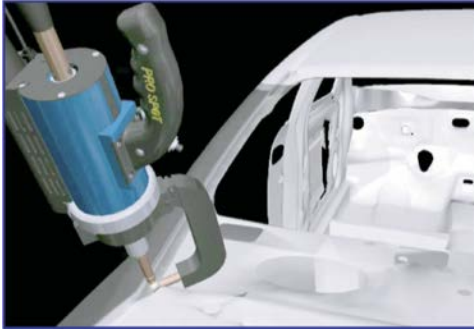
Questions? No problem. In any weld screen, just push the 'HELP / INSTRUCTION' button. The on-board instructions will guide you in the language of choice. By using Flash Card technology the software can be easily upgraded as new data becomes available. The expansion capability is enormous and practically endless.



### OEM Approved

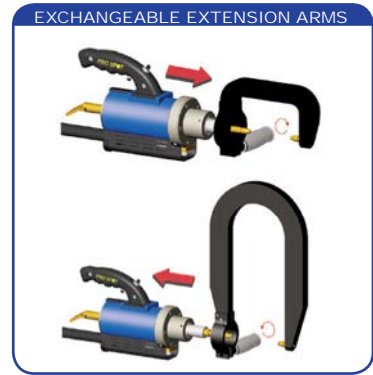
Pro Spot spot welding equipment is now approved by Toyota, Lexus, Chrysler, Mercedes-Benz, Smart, Maybach, GM, Nissan, Volvo, Mazda, Ford, Lincoln, Mercury, KIA, SAAB, Infiniti, ISUZU, Daewoo, Honda, Acura and others...

PS-500W: Two-Sided Double-Acting Spot Gun



PS-500W SPOT GUN FEATURES:

- Double-Acting Cylinder
- High squeeze pressure: >600Lbs  
Same pressure with all extension arm sizes
- Water-Cooled
- Self-aligning electrodes. No adjustment needed after changing arms
- Wide-spreading electrodes for hard to reach areas
- X-Gun adaptive
- Replaceable electrode caps



AVAILABLE ARMS

The Pro Spot i4 comes with a variety of extension arms to accommodate any welding job situation.

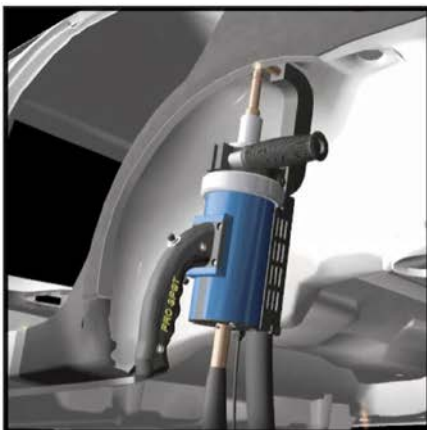
**NOTE:** Extension arms marked "optional" are available from your local distributor or online at [www.prospot.com](http://www.prospot.com)

X-Adapter (optional)

Switch between C and X guns in just 15 seconds. Best of both worlds in one gun!



The X-type design is used on certain applications where the C-type can't reach. 90% of all welding needs can be done with the C-type but for some radiator support and truck bed pinch welds, the X-Adapter excels. This Patented invention from Pro Spot now makes it possible to weld where you never could before!



Wheel House welding with PS-52-5/8 Arm makes it possible to weld the most difficult applications.



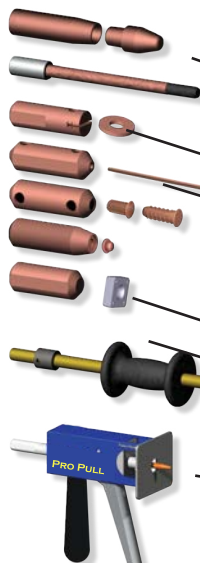
For deeper needs use the Pro Spot extension arms (PS-305 and PS-503-W). They are self-aligning and quick to install.



Spot welding of quarter panel using C-Arm (PS-302).



## SINGLE-SIDED GUN FEATURES



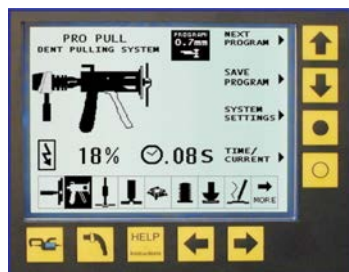
i4 comes standard with 4-cable system. That means quicker change between 2-sided and 1-sided welding. i4 is pre-programmed with 60 Single-Sided programs.

- Single-Sided Welding
- Carbon Shrinking
- Stitch Welding
- Washer Welding
- Nail Welding
- Bolt and Nut Welding
- Moulding Clip Rivet Welding
- Contact Shrinking
- Spot Hammer Dent Pulling
- Pro Pull Dent Pulling



## Pro Pull (optional)

New innovative tool for fast and accurate dent pulling.



Pro Pull is the latest in dent pulling technology for the collision industry. This tool makes dent pulling into art! It's designed to be extremely flexible. The replaceable blocking plates and adjustable weld shaft, maximizes the operator's options to maximize the pulling technique used when straightening the dent.

- ✓ Makes dent repair quick, easy and accurate
- ✓ Fast changing blocking plate system
- ✓ Adjustable weld shaft
- ✓ Available for any weld gun
- ✓ Paintless Dent Removal Available (optional)

## Built-in MIG Welder

The i4 features an easy upgrade to include a PR-155 MIG welder. It can be installed later as an upgrade package. This feature allows the convenience of spot and MIG welding in one unit!



## Overhead Installation

Pro Spot i4 comes in an overhead ceiling mounted version. The ceiling mounted version hangs from the ceiling at 20' bracket spacing.

- ✓ All the features of a portable i4 welder plus a MIG welder in one convenient ceiling mounted system!
- ✓ Nothing touches the floor... except your feet
- ✓ Always connected, ready to weld
- ✓ Stores out of the way when not in use
- ✓ No cables, air hoses or welders on the floor
- ✓ Moves very easily... just direct the welder to where you want to weld...its so easy!



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## i4 Technical Talk ...

**input voltage:** 3 phase  
208-240V 50/60 Hz.  
400-420-480 50/60 Hz.

**Welding amperage:** 12,500A max (3-phase)

**Welding cable length:** 8' (2.5m) standard

**Electrode Pressure:**

Standard Gun:  
Part No: PS-500W (Blue Cylinder)  
At 60 PSI (4.1 bar)-350 Lb (156 DaN)  
At 90 PSI (6.2 bar)-530 Lb (236 DaN)  
At 116 PSI (8 bar)-680 Lb (302 DaN)  
At 135 PSI (9.3 bar)-790 Lb (351 DaN)

High Pressure Gun:  
Part No: PS-600 (Black Cylinder)  
At 60 PSI (4.1 bar)-585 Lb (260 DaN)  
At 90 PSI (6.2 bar)-880 Lb (391 DaN)  
At 116 PSI (8 bar)-1130 Lb (503 DaN)  
At 135 PSI (9.3 bar)-1320 Lb (587 DaN)

**Cooling system:** Air (2 fans), Compressed air (weld gun and weld cables)  
Water cooling (inverter, transformer, welding gun)

**Micro processor:** i4 Upgradeable Software Platform

**Protection:** IP21

**Patents (3):** no. 5,239,155, no. 6,706,990, no. 6,539,770

**Dimensions (welder):** 28"(71.1cm)x12.5"(31.8cm)x50"(127cm)

**Shipping weight:** 373lb (169kg)

Manufactured by:  
Pro Spot International, Inc. U.S.A.

