

## Linear vibration welding systems – 100 Hz

Model	Vibration amplitude	Weld plane*	Clamp force	Lift table width x depth	Upper tooling width x depth	Upper tooling weight	Control	PPL Techno- logy
	mm	cm <sup>2</sup>	kN	mm	mm	kg		
M-112 L	1,8-4,0	15	2,5	100x100	178x178	1,5-2,5	PLC	yes
M-624 L/Li	1,8-4,0	500	25	1330x540	920x540	65-135	PLC/VC100	yes
M-824 L/Li	1,8-4,0	500	25	1500x600	920x540	65-135	PLC/VC100	yes
M-934 L/Li	1,8-4,0	500	25	1750x700	1400x540	90-160	PLC/VC100	yes
M-936 L/Li	1,8-4,0	750	25	1750x700	1400x540	100-200	PLC/VC100	yes

## Linear vibration welding systems – 240 Hz

Model	Vibration amplitude	Weld plane*	Clamp force	Lift table width x depth	Upper tooling width x depth	Upper tooling weight	Control	PPL Techno- logy
	mm	cm <sup>2</sup>	kN	mm	mm	kg		
M-112 H	0,9-1,8	15	2,5	100x100	178x178	1,5-2,5	PLC	yes
M-202 H	0,9-1,8	75	4,5	500x525	350x280	5,0-7,5	PLC	no
M-5i1 H/Hi	0,9-1,8	150	18	1020x540	390x376	20-40	PLC/VC100	yes
M-5i2 H/Hi	0,9-1,8	150	18	1020x540	880x376	35-65	PLC/VC100	yes
M-5i3 H/Hi	0,9-1,8	300	18	1020x540	880x376	40-70	PLC/VC100	yes
M-624 H/Hi	0,9-1,8	500	25	1330x540	920x540	35-65	PLC/VC100	yes
M-824 H/Hi	0,9-1,8	500	25	1500x600	920x540	35-65	PLC/VC100	yes
M-836 H/Hi	0,9-1,8	750	30	1500x600	1400x540	50-100	PLC/VC100	yes

## „All-electric“ vibration welding systems – 100 Hz / 240 Hz

Model	Vibration amplitude	Weld plane*	Clamp force	Lift table width x depth	Upper tooling width x depth	Upper tooling weight	Control	PPL- Techno- logy
	mm	cm <sup>2</sup>	kN	mm	mm	kg		
<b>100 Hz</b>								
M-624 LSi	1,8-4,0	500	25	1330X540	920x540	65-135	VC100	yes
M-934 LSi	1,8-4,0	500	25	1750x700	1400x540	90-160	VC100	yes
M-936 LSi	1,8-4,0	750	25	1750x700	1400x540	100-200	VC100	yes
<b>240 Hz</b>								
M-624 HSi	0,9-1,8	500	25	1330x540	920x540	35-65	VC100	yes

## Orbital vibration welding systems – 200 Hz

Model	Vibration amplitude	Weld plane*	Clamp force	Lift table width x depth	Upper tooling diameter	Upper tooling weight	Control	PMT Techno- logy
	mm	cm <sup>2</sup>	kN	mm	mm	kg		
M-203 PMT	0,75-1,5	40	4,5	500x525	288	5,0-7,5	PLC	yes

\* depending on material and geometry of the application