

WHY BUY AN OEM APPROVED WELDER?

OEMs invest a considerable amount of time and money evaluating and testing equipment for approval. When an OEM approves a welder it is confirming that the welder is capable of performing quality welds equivalent to those performed on the assembly line.

OEMs take into consideration not only welding performance, but also availability and after sales technical support.

TECNA is the only welder brand on the market that manufactures welders for the assembly line as well as for the collision repair shop. TECNA is in a unique position to transfer the technology developed for and on the assembly line to the collision repair environment.

In fact, the TECNA 3664 Smart Plus welder is an end of assembly line welder. **REPAIR IT LIKE THEY BUILT IT!**

CUSTOMIZE YOUR WELDER WITH THESE ACCESSORIES.

Arms & Electrodes

Additional accessory welding arms and electrode holder offset configurations are available. See back page for detailed specifications.



Single Sided 3587

The Single Sided gun 3587 was designed to add flexibility to the SMART welder 3664. Perform single sided spot welds, dent pulling and stud welding.

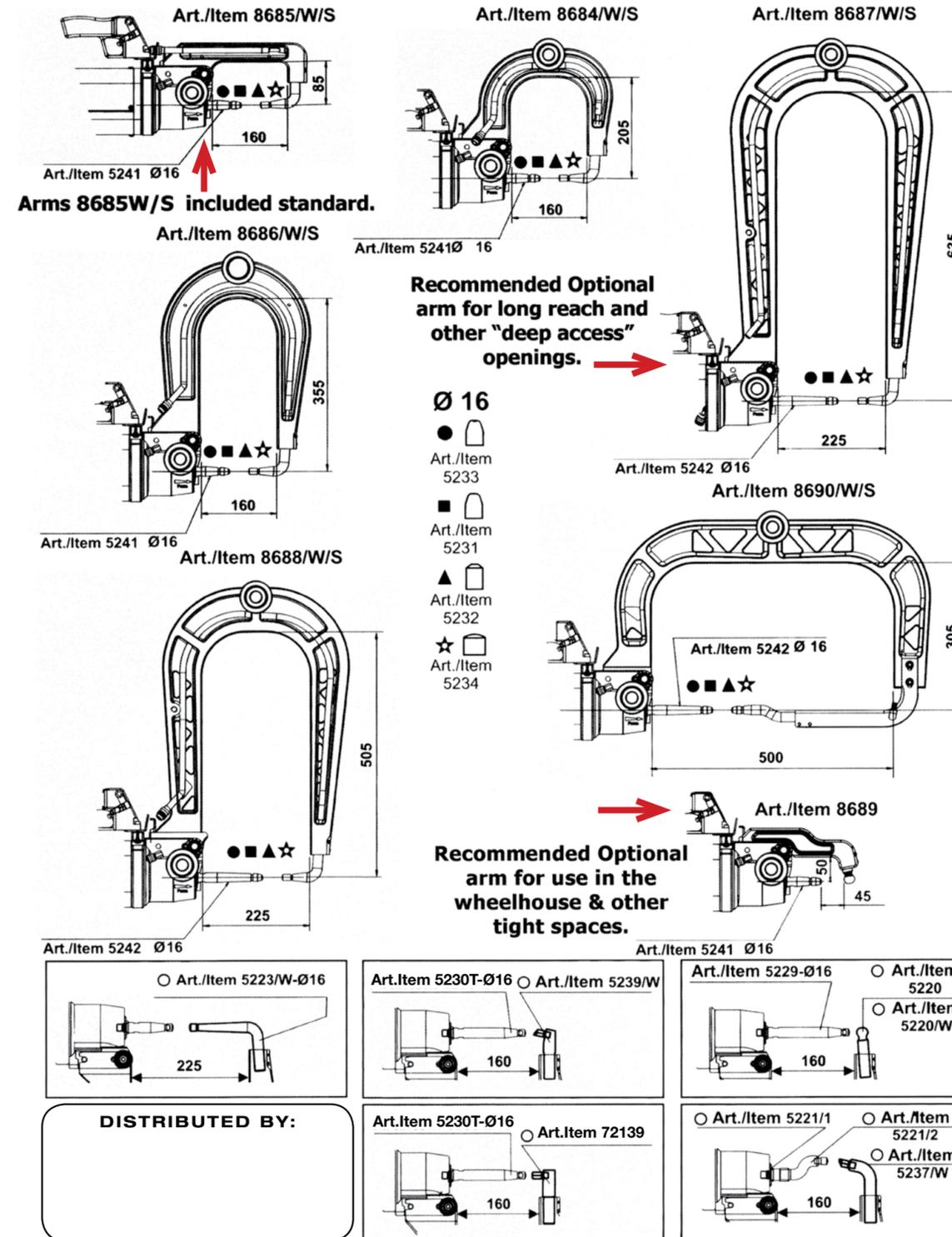


Protective Cover

The protective dust cover helps to keep your SMART welder clean and dust free. Actual cover design may vary from the picture.



TECNA USA
WELDING SYSTEMS



TECNA[®]

Smart-Plus Resistance Spot Welder

*TECNA : The MOST OEM approvals worldwide



TECNA[®] USA

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Welds Boron and All Ultra High Strength Steels.

Technical Data

Power Supply	Inverter
Input Power VAC	208/ 230/ 240V 3PH
Hz	50 / 60
Amp Draw	60 at 230V
No Load Voltage VDC	15
Nominal Power @ 100% KV	17 KVA
Max welding Current KA	14
Thermal Protection Class	F
Protection Level IP	21
Water Cooling to:	Transformer, welding gun, arms, electrode caps.
Pneumatic Assisted	Yes
Max. Compressed Air PSI	120
Multi Gun Capable	Yes
Control Panel	LCD Touch SMART-PLUS
Suspension Arm w/ Balancer	Yes
Smart-Plus C-Gun Part #	8679TS
C-Gun Cable Length	14 ft.
Standard Arms Part #	8685W/S
C Gun Max. Squeeze Force Lbs.	1100 lbs.
Dimensions	24 x 27 x 49 on cart
Gross Weight	310 lbs.
Net Weight	286 Lbs.

Superior Features

- Fully water-cooled, including transformer, welding gun, arms and electrodes caps.
- Output power 14,000 amps.
- Squeeze force 1350 lbs. max.
- Touch screen control
- Lightweight cables



Easy Upgrades

Use the USB Port and Flash drive to easily upgrade programs and software.

Shop Liability Control

Use the USB port to download and store all weld records on any job.

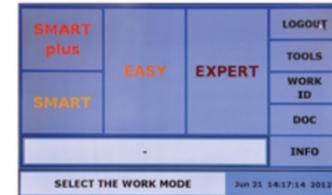
SAMPLE PRINTOUT OF WELD RECORDS

Spot n°	Weld time	Current	Energy	Pressure	SMART Res	Date	User	SMART para
1	628 mS	7,89 KA	1,29 KJ	6,3 Bar	OK	09/07/2012 16:39	FULL	-
2	322 mS	6,09 KA	0,50 KJ	6,1 Bar	OK	09/07/2012 16:39	FULL	-
3	628 mS	7,89 KA	1,46 KJ	7,4 Bar	OK	09/07/2012 16:39	FULL	-
4	628 mS	7,89 KA	1,46 KJ	7,5 Bar	OK	09/07/2012 16:39	FULL	-
5	323 mS	6,16 KA	0,53 KJ	6,1 Bar	OK	09/07/2012 16:39	FULL	-
6	628 mS	7,89 KA	1,59 KJ	6,3 Bar	OK	09/07/2012 16:40	FULL	-
7	1255 mS	7,99 KA	1,67 KJ	6,7 Bar	OK	09/07/2012 16:40	FULL	Fe/Zn 2 Layers 0.7+0.7 C
8	1252 mS	7,99 KA	1,71 KJ	7,0 Bar	OK	09/07/2012 16:40	FULL	Fe/Zn 2 Layers 0.7+0.7 C
9	1251 mS	7,99 KA	1,72 KJ	7,0 Bar	OK	09/07/2012 16:40	FULL	Fe/Zn 2 Layers 0.7+0.7 C
10	10 mS	0,29 KA	0,00 KJ	2,9 Bar	-	09/07/2012 16:40	FULL	-
11	10 mS	0,29 KA	0,00 KJ	2,8 Bar	-	09/07/2012 16:40	FULL	-
12	806 mS	3,03 KA	1,26 KJ	4,9 Bar	-	09/07/2012 16:41	FULL	-
13	900 mS	7,69 KA	8,12 KJ	8,1 Bar	-	09/07/2012 16:41	FULL	-
14	900 mS	7,69 KA	8,85 KJ	8,2 Bar	-	09/07/2012 16:42	FULL	-
15	900 mS	7,69 KA	8,12 KJ	8,2 Bar	-	09/07/2012 16:42	FULL	-
16	900 mS	7,69 KA	7,47 KJ	8,1 Bar	-	09/07/2012 16:42	FULL	-
17	900 mS	7,69 KA	8,09 KJ	8,1 Bar	-	09/07/2012 16:42	FULL	-
18	900 mS	7,69 KA	7,96 KJ	8,1 Bar	-	09/07/2012 16:42	FULL	-
19	900 mS	7,69 KA	7,78 KJ	8,1 Bar	-	09/07/2012 16:42	FULL	-
0	700 mS	6,99 KA	2,30 KJ	0,0 Bar	-	09/07/2012 16:44	FULL	-

What is Smart Technology?

Smart Technology as developed by TECNA is a sophisticated software that allows the welder to perform a weld with little or no operator input. TECNA supplies the welder model 3664 with two levels of **SMART** welding modes. In fully automatic **SMART-Plus** mode the operator is not required to input any information. The welder determines automatically the thickness and type of steel to be welded, and sets all the welding parameters including output power, weld time, and squeeze force. The weld and weld settings are monitored and adjusted 2000 times per second producing a factory quality weld.

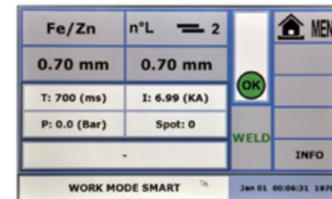
Select Welding Mode



Smart-Plus Mode



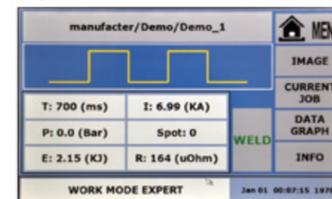
Smart Mode



Easy Mode



Expert Mode



In **SMART** mode the welder requires the operator to input some information such as type of steel, number of layers and thickness. The welder compares the information entered by the operator to what it senses. If the information is marginally different, the welder will override the information entered by the operator and performs the weld. If the information entered by the operator is too different from what the welder senses, the welder will not perform the weld and it will alert the operator with a red light on the touch screen.

Select SMART-Plus Welding Mode

- Welding system seamlessly sets welding parameters WITHOUT ANY operator input. **SMART-Plus** detects material type. **SMART-Plus** detects thickness of material.
- **SMART-Plus** recognizes connected gun.
- **SMART-Plus** C-Trans Gun 8679TS with built in sensors works effortlessly with **SMART-Plus** software.

Select SMART Welding Mode

- Operator enters material information such as material type, thickness, and number of layers.
- The **SMART** control senses incorrectly entered information and it can adjust as needed or interrupt the weld and inform the user.
- The **SMART** control recalibrates itself as required resetting the baseline to adapt for changes in the shape and cleanliness of the electrode.

Select EASY Welding Mode

- Allows user to set current, weld duration and squeeze force to perform weld requiring special parameters.
- Save your own personal weld parameters in memory.

Select EXPERT Welding Mode

- Pre-set welding parameters by car manufacturer, model and area of car body to be welded.

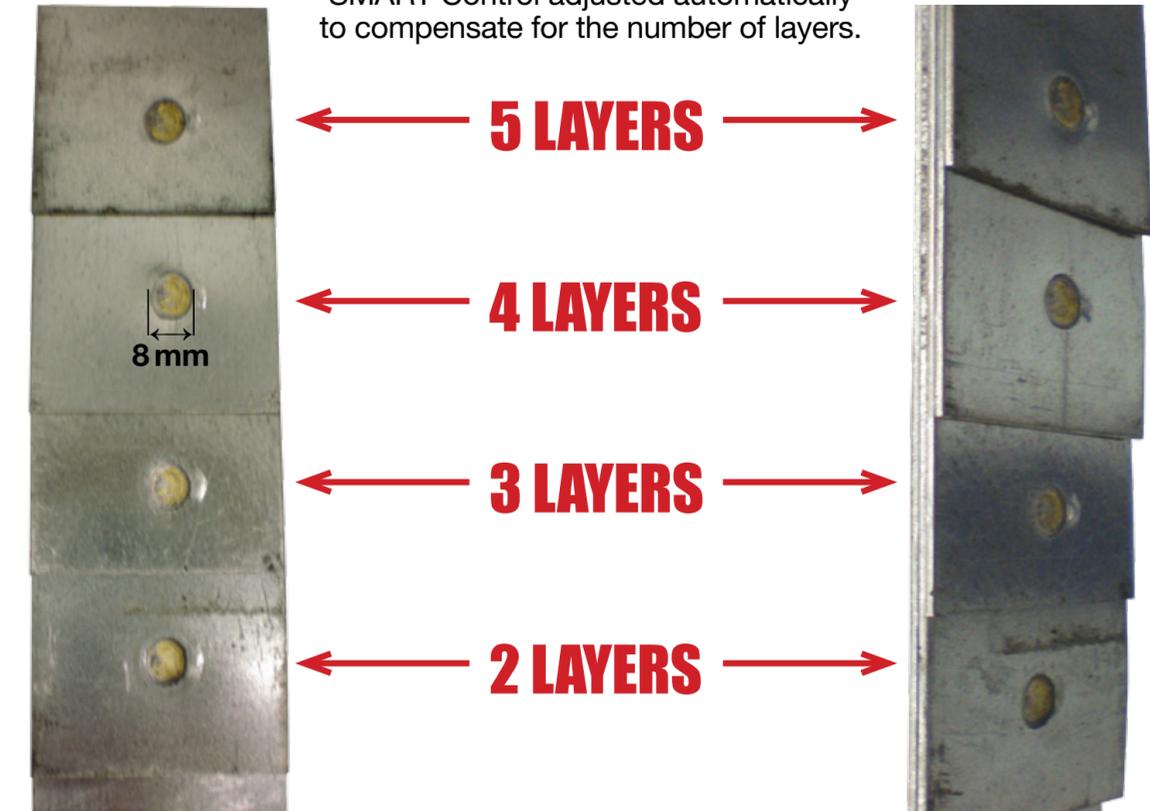
Welding Modes SMART-Plus and SMART

- Have easy to read red, yellow, green lights indicating the quality of each completed weld.

*Log on to www.cebotecusa.com for specific approval information for each model, OEM equipment programs, special software, updates and changes.

SMART Control Welder Model 3664 by TECNA EASILY WELDS BORON & OTHER HIGH STRENGTH STEELS

All welds were produced with the same welder settings. SMART Control adjusted automatically to compensate for the number of layers.



Each Layer Is 1 mm Thick

APPROVED FOR WELD BONDING