

WELDOR®

WELDING TABLES AND MODULAR FIXTURES



WELDING TABLES

Advantage of fast and precise fabrication with maximum flexibility



HEAVY
ROBUST
PRECISE

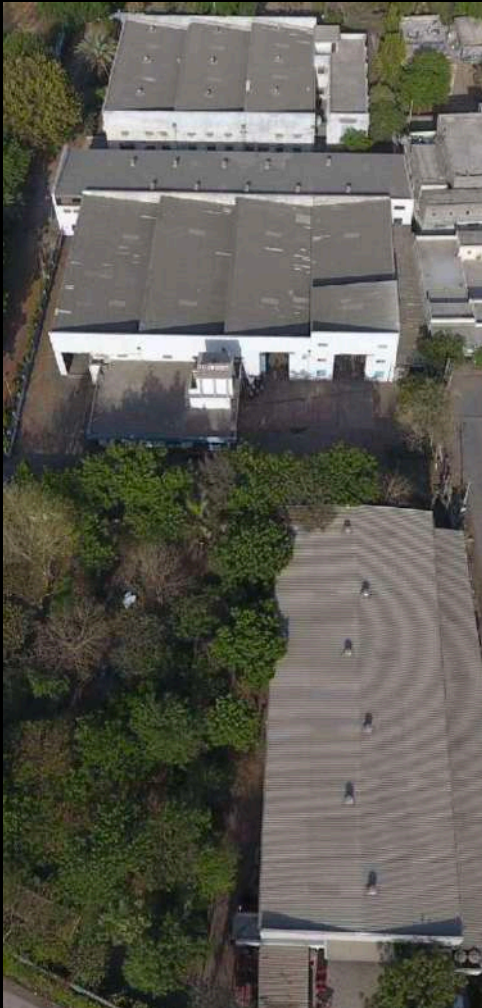


**Weldor Appliances Pvt Ltd
(Gujarat, India)**

For many years the Weldor group has been successfully designing, producing and distributing welding and clamping systems worldwide.

Total of 170,000 square feet of working space which has fabrication shop, machine shop, assembly shop with world class machines.

Delivery lead times are minimised with 18,000 square feet of storage.



**All Weldor products in
detail**

Detailed information on our products as well as other product versions and our product range can be found online at www.weldor.in



Weldor's unique and specially formulated materials and processes provide features which are not generally offered by other manufacturers.



Quality

- Product innovations, high-quality materials, accurate processing
- On-going product development from field experience and customer feedback.

Surface hardened accessories

- Improved protection against corrosion
- Improved protection against scratches
- Improved protection against welding spatters



Why Welding tables?

- **Flatness & Precision:** Welding tables provide a perfectly flat, stable surface for accurate assembly and welding.
- **Faster Setup:** Modular holes and slots make it easy to clamp and position workpieces quickly.
- **Better Quality:** Consistent setup leads to higher-quality welds and repeatable results.



Introduction to Welding Tables

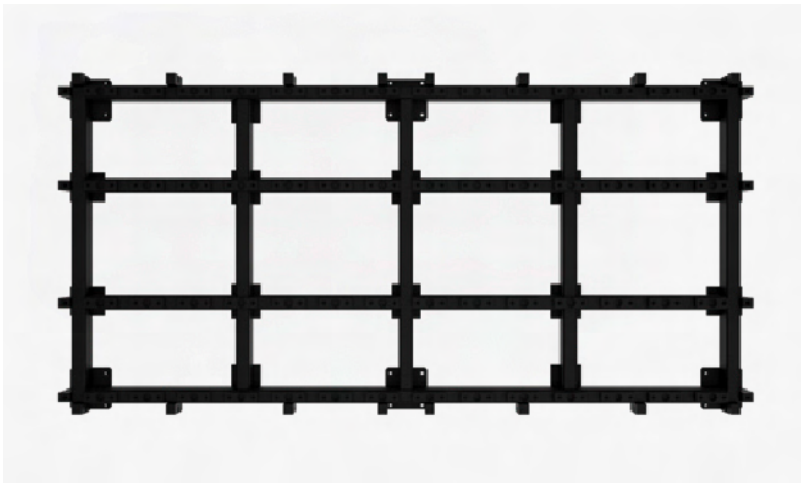
Weldor engineers developed the prime line by customer demand for an affordable, heavy duty welding table.

The Prime Welding Table is the optimal solution for precision vertical and horizontal fixturing to expand your capabilities in welding and fabrication.

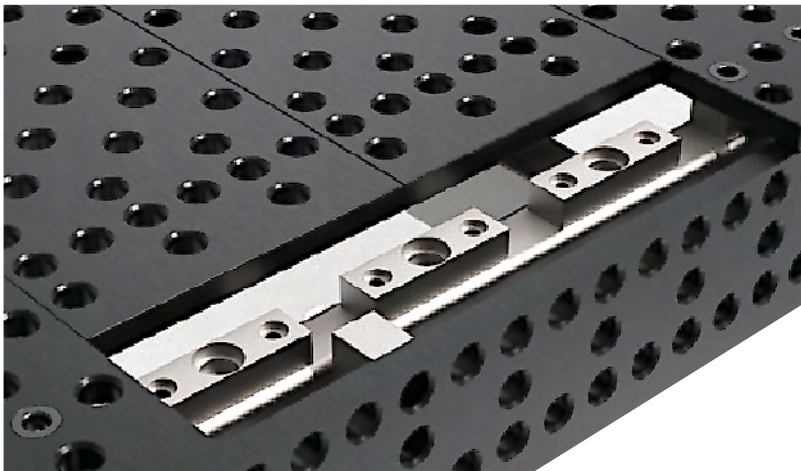
Each plate is made from a low alloy tool steel that's tough. After surface milling and machining, each plate is further enhanced with a nitriding process and black oxide process that improves hardness, corrosion resistance, and resistance to weld spatter. Plates on the table can be repositioned, or removed as applications dictate a plate locating system means the spacing of the holes are always within tolerance without the need for special re-calibration.

The unique and versatile prime tables are complemented by a complete range of modular fixtures and clamping accessories. Visit our website to see the latest additions to the prime product line and access technical details such as CAD drawings.

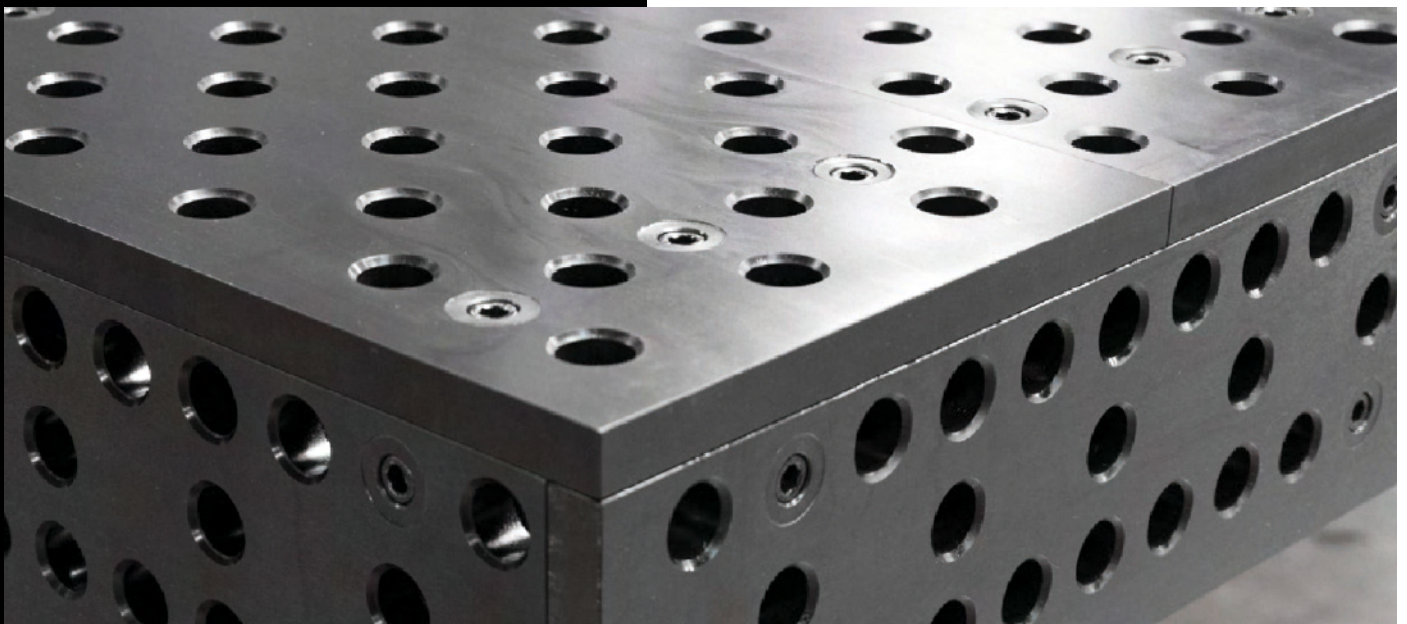
The system of $\text{Ø}16\text{mm}$ and $\text{Ø}28\text{mm}$ CNC machined table holes in a 100 mm grid pattern is the ideal platform for rapid, precise and accurate fixturing.



Prime tables combine the rigidity and accuracy of a welded and machined frame with the flatness of precision ground, CNC machined plates.



The Locating Bushing design allows you to easily remove, re-position, re-align, and reverse the Table Plates. Table Plates can be positioned to create the custom work surface configuration required for each unique fixturing application.



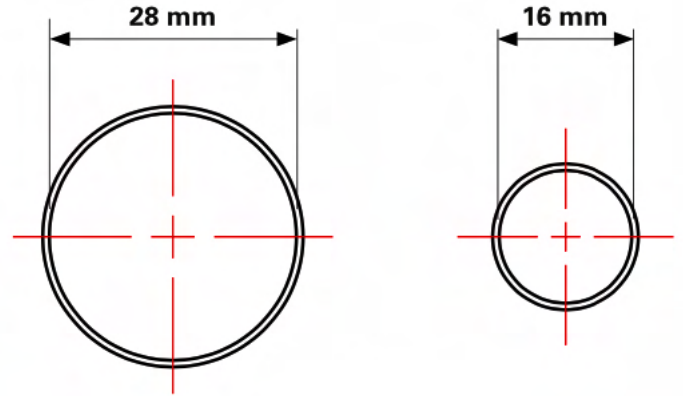


System Overview

There are 2 types of clamping sizes depending upon customer's requirements. D16 and D28. D16 has Ø16mm bore holes and comparatively light to medium duty accessories. D28 has Ø28mm bore holes for heavy duty clamping.

System Bore Hole

Large chamfer on top for easy insertion. Chamfer on underside as well to maximise bolt clamping force.

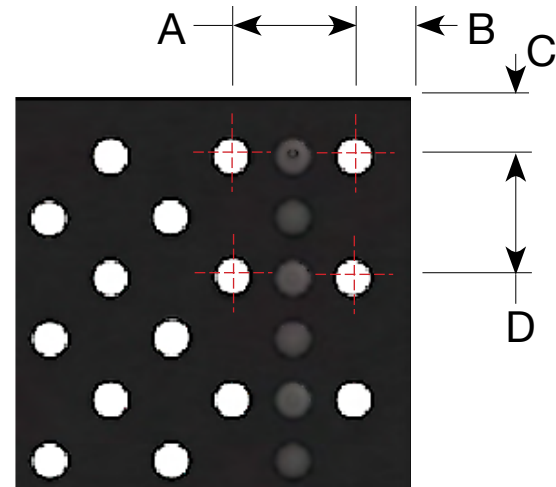


<i>Bore System</i>	<i>Hole Diameter</i>	<i>Hole pitch (spacing)</i>	<i>Hole Chamfer</i>
D16	Ø16mm +0.1/-0.00mm	50mm ±0.05mm	Meets M10 CSK
D28	Ø28mm ±0.15/-0.00mm	100mm ±0.05mm	Meets M16 CSK

Hole Pattern

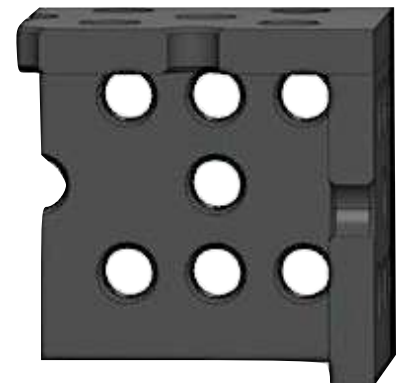
Borehole spacing in D28 is 100 mm with additional 100 mm grid offset by 50 mm in the X and Y axis aka diagonal grid and straight grid with 50mm x 50mm in borehole D16.

<i>Bore System</i>	<i>A</i>	<i>B</i>	<i>C</i>	<i>D</i>
D16	50mm	25mm	25mm	50mm
D28	100mm	50mm	50mm	100mm



Material Thickness

<i>Bore System</i>	<i>Thickness</i>	<i>Table top finish</i>	<i>Additional treatment</i>
D16	15mm	Nitriding	Blackodise
D28	23mm	Nitriding	Blackodise





Self locating system for top and side plates

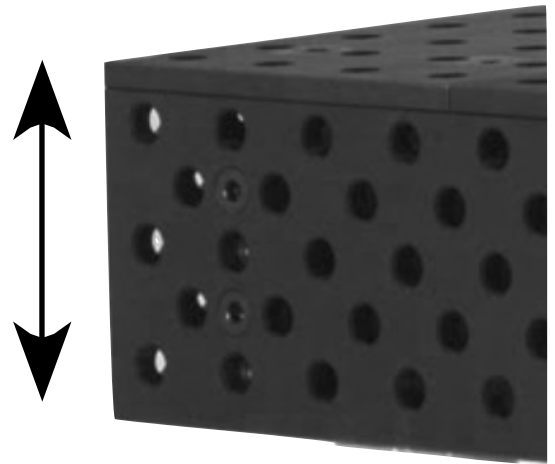
Locating features in the table frame and plate combined with our locator bushings for self alignment. **This allows 2X life of top plates**



Side plates (3D)

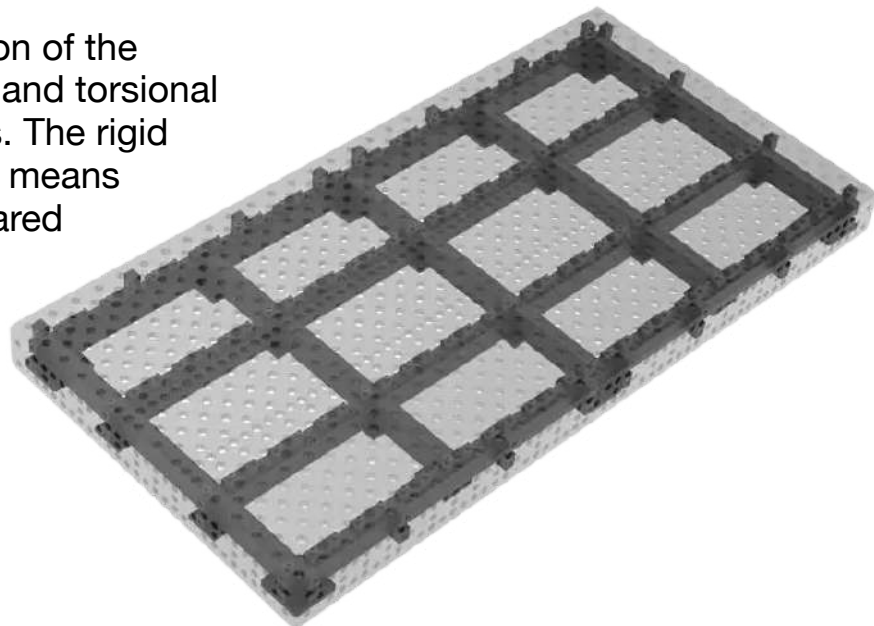
D16 tables comes with 2 options for 3D side plates, 100mm and 200mm.

D28 tables come with 200mm side plates as standard.



Stronger and rigid frame

The machined tubular frame construction of the prime table provides improved flatness and torsional stiffness compared to plate only frames. The rigid frame with modular plates on the prime means less high spots and less twisting compared to welded plate designs. The welded construction of a plate only design often leads to distortion and high spots around the corners and centre.





Self-locating Table Plates

Plates can be repositioned, then easily realigned to the original position. Reposition the table plates as needed to increase the width of the table for oversized or complex fixtures. This allows you to easily remove, re-position and re-align the table plates. Table Plates can be positioned to create the custom work surface configuration required for each unique fixturing application.



ONLY WELDOR PROVIDES OXY-NITRIDING PROCESS.

Only Weldor welding tables are oxy-nitrided. This unique process makes table plates last way longer which is highly resistant against rust. This process adds hardness of around 35-40HRC to the surface of the plates.



ONLY WELDOR PROVIDES GRID LINES AND RULER ENGRAVING

Another unique feature of Weldor Welding tables is the grid lines and ruler engravings which no other supplier has. These engravings make working with the table fast and minimise the use of tools like squares and measuring tapes.





Weldor tables feature 6 legs compared to competitors' 4 legs on 2.4mx 1.2m and 2.0m x 1.0m table sizes for greater rigidity and flatness



3000mm x 1500mm 3D table



1500mm x 1500mm 3D table



2000mm x 1200mm 2D table



Welding Tables: Length x Width

SN	Length	Width
1	600mm	1000mm or 1200mm or 1500mm
2	1000mm	1000mm or 1200mm or 1500mm
3	1200mm	1000mm or 1200mm or 1500mm
4	1500mm	1000mm or 1200mm or 1500mm
5	2000mm	1000mm or 1200mm or 1500mm
6	2400mm	1000mm or 1200mm or 1500mm
7	3000mm	1000mm or 1200mm or 1500mm
8	4000mm	1000mm or 1200mm or 1500mm
9	5000mm	1000mm or 1200mm or 1500mm
10	6000mm	1000mm or 1200mm or 1500mm
11	3000mm	2000mm or 2500mm or 3000mm
12	4000mm	2000mm or 2500mm or 3000mm
13	5000mm	2000mm or 2500mm or 3000mm
14	6000mm	2000mm or 2500mm or 3000mm
15	8000mm	2000mm or 2500mm or 3000mm

- **There are multiple combinations of length x width of modular welding tables.**
- **Choose from 2D table or 3D table. Only the top makes a 2D table and side plates can be added to 2D table for making the table 3D.**
- **There are 2 options available for 3D table of D16:**
 - 1. 100mm width of side plate (3D plate)**
 - 2. 200mm width of side plate (3D plate)**
- **D28 table has 200mm side plate (3D plate) as standard for 3D tables.**
- **Stainless steel tables are available and are manufactured against order.**



Welding Tables come with a wide range of mounting options to suit every workspace. Legs are ordered individually and the quantity required will vary depending on table size.

Legs mount onto plates at the bottom of the table. Levelling feet with spindles at the bottom of the legs offer fine adjustment and levelling. This levelling is ±20mm.



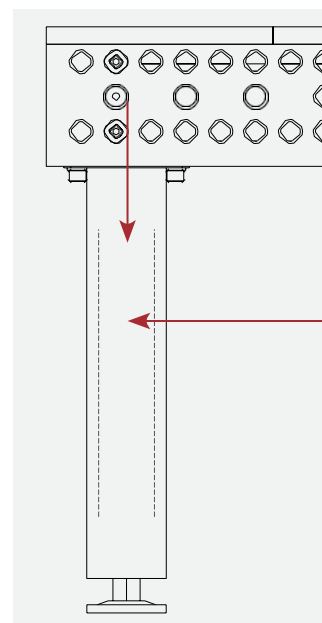
INSTALLATION TABLE LEGS:

Four M12 hex drive cap screws and washers are included with each leg.



MAXIMUM SAFE BEARING LOAD:

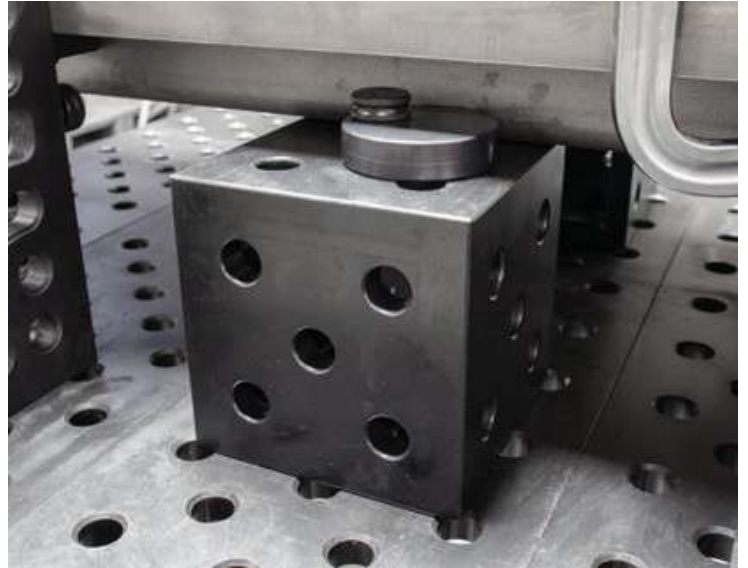
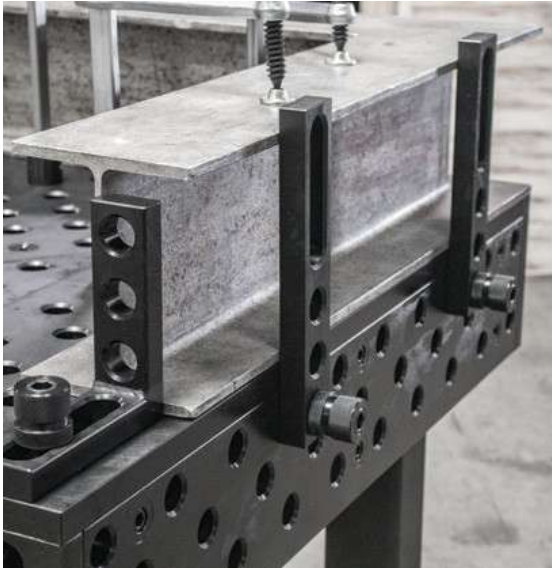
- Vertical force direction: 20 kN
- Horizontal force direction: 2 kN
- Maximum stability ensured by large section tube (100 x 100 mm).





Stops

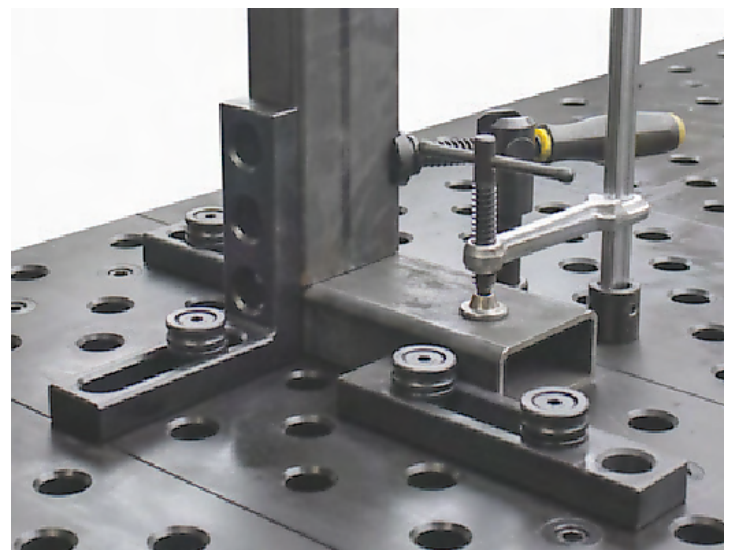
Stops are used to align workpieces anywhere on the table. Slots provide adjustment while holes provide anchoring points for accessories such as clamps and V-blocks.



Eccentric Stops provide infinite adjustment in a compact package. The large round stop can also be used as a ground connection and features an M10 thread.

Flat Angles

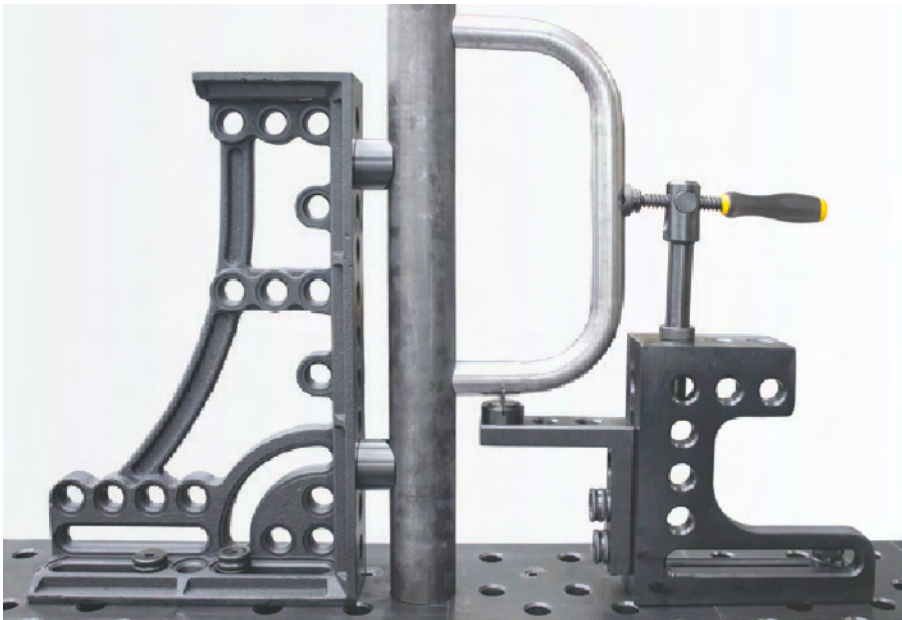
Flat Angles provide a broad and adjustable stopping surface and an alternative, method of creating compact right angle fixtures.





Squares

Angle Squares can be used in the same manner as a Stop or combined with other elements to form more complex fixtures. Slots enable a range of adjustable options.



The Slotted Square and Sliding Base provide heavy duty adjustment options for special applications. The Sliding Base should be bolted to the table with a Low Profile Clamping Bolt to ensure proper clearance between the base and clamping square when sliding.

The Frame Square features boreholes on a 50 mm grid with slots. Available in two versions with stops on either left or right side.



Ball Lock Bolts

All bolts come in short and long versions. Short bolts are designed for connecting two fixturing components together such as a table to a stop or a stop to a square. Long bolts are designed for connecting three components together.



KNURLED HEAD FOR FAST CLAMPING

GROOVE FOR OPTIONAL O-RING (NOT REQUIRED DUE TO LUBRICATED THREADS)

CHAMFERED TIP FOR SMOOTH INSERTION

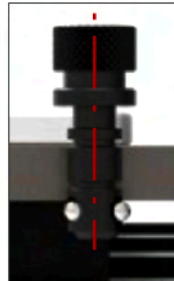


Ball Lock Bolt

An Essential component in Modular Fixturing



Finger tighten the knurled head after inserting.



3 locking steel balls moves out to lock the accessories with the table plate.



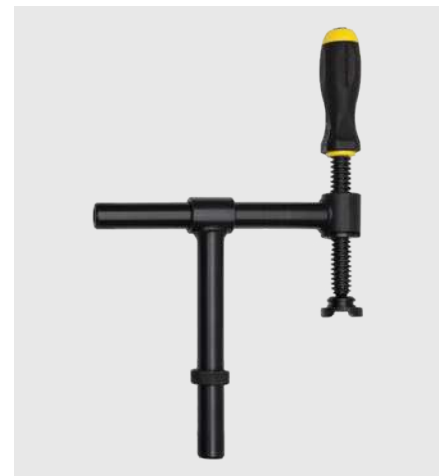


Clamps

The Standard Screw Clamp adjusts by hand along the vertical and horizontal axis for precise placement anywhere on the table and easily set with one hand.



The Basic Bar Clamp is a simplified version of the T-Post Pipe Clamp. The spindle on this clamp does not pivot and this feature is preferred by some users. The clamp arm can be removed from the vertical post to be used as a horizontal clamp.



The T-Post Pipe Clamp features horizontal and vertical adjustment as well as pivoting action at the spindle head. An adjustment ring at the base allows it to sit in a lower profile during welding as the round bar sits below the table or clamping square surface. For horizontal clamping, remove the top arm from the clamp post, and place directly into the tabletop holes.






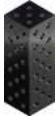









D16 Clamping Accessories

ITEM	IMAGE	CODE
STOP AND CLAMPING SQUARE 75mm x 100mm		A
STOP AND CLAMPING SQUARE 50mm x 100mm		B
STOP AND CLAMPING SQUARE 100mm x 150mm		CA
STOP AND CLAMPING SQUARE 150mm x 100mm X 75mm		P
UNIRVERSAL STOP 150mm		AB
UNIRVERSAL STOP 200mm		AC
UNIRVERSAL STOP 250mm		AD
STOP AND CLAMPING SQUARE 300mm x 150mm X 40mm		EA
STOP AND CLAMPING SQUARE 450mm x 150mm x 40mm		U
STOP AND CLAMPING SQUARE 300mm x 150mm x 100mm		V














D16 Clamping Accessories

ITEM	IMAGE	CODE
<p>CLAMPING STOP AND SQAURE 250mm x 150mm x 90° PAIR OF LEFT AND RIGHT</p>		<p>Q/R</p>
<p>CLAMPING STOP AND SQAURE 250mm x 150mm x 50mm PAIR OF LEFT AND RIGHT</p>		<p>S/T</p>
<p>CLAMPING BLOCK 150mm x 100mm x 50mm</p>		<p>AE</p>
<p>RISER BLOCK 500mm x 150mm x 150mm</p>		<p>AF</p>
<p>RISER BLOCK 200mm x 100mm x 100mm</p>		<p>AA</p>
<p>RISER BLOCK 100mm x 100mm x 100mm</p>		<p>Z</p>
<p>RISER BLOCK 250mm x 50mm x 50mm</p>		<p>Y</p>
<p>RISER BLOCK 200mm x 50mm x 50mm</p>		<p>X</p>
<p>RISER BLOCK 150mm x 50mm x 50mm</p>		<p>W</p>
<p>FLAT SQUARE 200mm x 200mm</p>		<p>AG</p>
<p>EXTENSION CUM REST Ø50mm x H=50mm</p>		<p>AH</p>










D16 Clamping Accessories

ITEM	IMAGE	CODE
90° PRISM		AI
120° PRISM		AJ
ECCENTRIC STOP Ø75mm		AK
ECCENTRIC STOP Ø45mm		AL
VERTICAL CLAMP H = 300mm		AM
ROTARY CLAMP H = 450mm		AN
LOCK BOLT WITH O-RING AND BALLS.		AO
FIXED 90° MAGNET. MAX 20KG HOLDING.		AP
PROTRACTOR TYPE MAGNET MAX 35KG HOLDING		AQ
MULTI ANGLE MAGNET MAX 20KG HOLDING		AR
VERTICAL TOGGLE CLAMP WITH BASE PLATE		OA


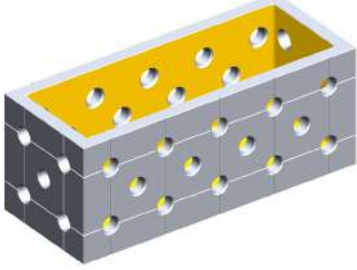
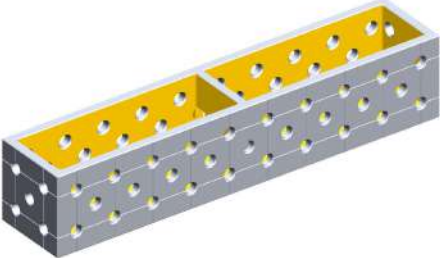

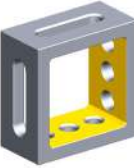
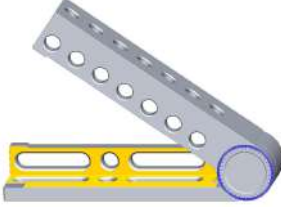


D28 Clamping Accessories

ITEM	IMAGE	CODE
STOP AND CLAMPING SQUARE 75mm x 75mm x 50mm		HY
STOP AND CLAMPING SQUARE 175mm x 75mm x 50mm		HJ
STOP AND CLAMPING SQUARE 175mm x 175mm x 50mm		HK
STOP AND CLAMPING SQUARE 275mm x 175mm x 50mm		HL
STOP AND CLAMPING SQUARE 200mm x 175mm x 50mm		HM
LOCATING SQUARE 225mm x 50mm x 25mm		HN
LOCATING SQUARE 575mm x 75mm x 25mm		HO









D28 Clamping Accessories

ITEM	IMAGE	CODE
<p>FLAT LOCATING SQUARE 250mm x 225mm x 25mm</p>		<p>HP</p>
<p>RISER BLOCK 500mm x 200mm x 200mm</p>		<p>HQ</p>
<p>RISER BLOCK 1000mm x 200mm x 200mm</p>		<p>HR</p>
<p>SUPPORTING ANGLES 300mm x 275mm x 100mm LEFT / RIGHT</p>		<p>HS</p>
<p>CLAMPING BLOCK 200mm x 200mm x 100mm</p>		<p>HT</p>
<p>SWIVELLING FRAME 500mm x 100mm x 100mm</p>		<p>HU</p>



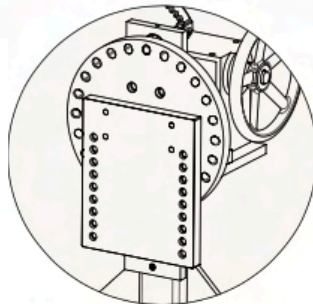
D28 Clamping Accessories

ITEM	IMAGE	CODE
VERTICAL LOCKING CLAMP L=180mm x H=300mm		JQ
ROTARY LOCKING CLAMP L=180mm x H=300mm x 360°		JL
VERTICAL TOGGLE CLAMP WITH FIXTURE BASE PLATE.		GN
STRAIGHT LINE ACTION CLAMP WITH FIXTURE BASE PLATE.		GM
LOCK BOLT WITH O-RING AND BALLS.		JE
LOCKING PIN		JG

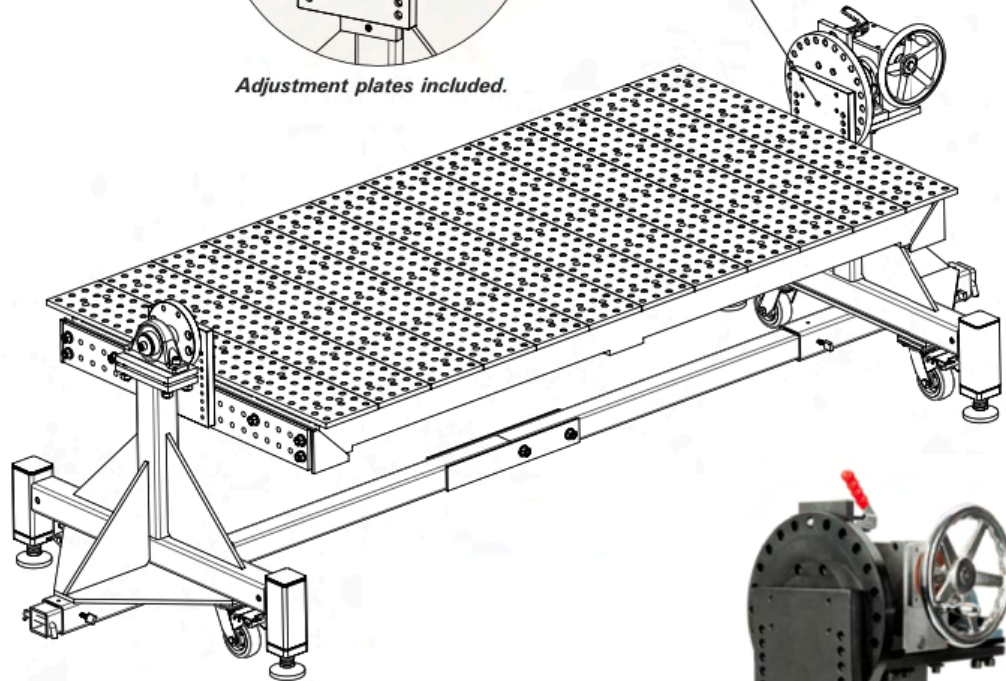


Adjustable legs in horizontal way allow greater stability when working with taller assemblies and can be retracted when not required.

Adjustment plates help shift the centre of gravity when working with tall or heavy parts. This allows smoother rotation of assemblies up to 90° from horizontal.



Adjustment plates included.





Hydraulic Scissor Lift

Effortlessly raise or lower the platform using the foot pedal, allowing you to achieve the perfect working height for your welding projects. This flexibility ensures optimal comfort and efficiency during your welding operations.

- Dimensions: 2400mm x 1200mm
- Tabletop Thickness: 15mm
- Hole Diameter: 16mm
- Grid Pattern: 50mm x 50mm
- Static Load Capacity: 1000kg
- Dynamic Load Capacity: 800kg
- Height Adjustment: 400mm - 900mm



Hydraulic Turntable

The electric hydraulic-powered lift is equipped with lifting capabilities and boasts a 900mm x 900mm tabletop that can rotate a full 360 degrees and tilt up to 45 degrees, providing unparalleled flexibility for your welding and fixturing needs.

- Tabletop Dimensions: 900mm x 900mm
- Tabletop Thickness: 20mm
- Hole Diameter: 16mm
- Grid Pattern: 50mm x 50mm
- Static Load Capacity: 100kg
- Dynamic Load Capacity: 80kg
- Height Adjustment: 900mm to 1200mm





1250mm x
1250mm 2D
Welding Table



1250mm x 1250mm
3D Welding Table



2600mm x 1250mm 2D Welding table



3000mm x 1500mm 3D Welding table



6000mm x 3000mm Welding table



3000mm x 2000mm Welding table



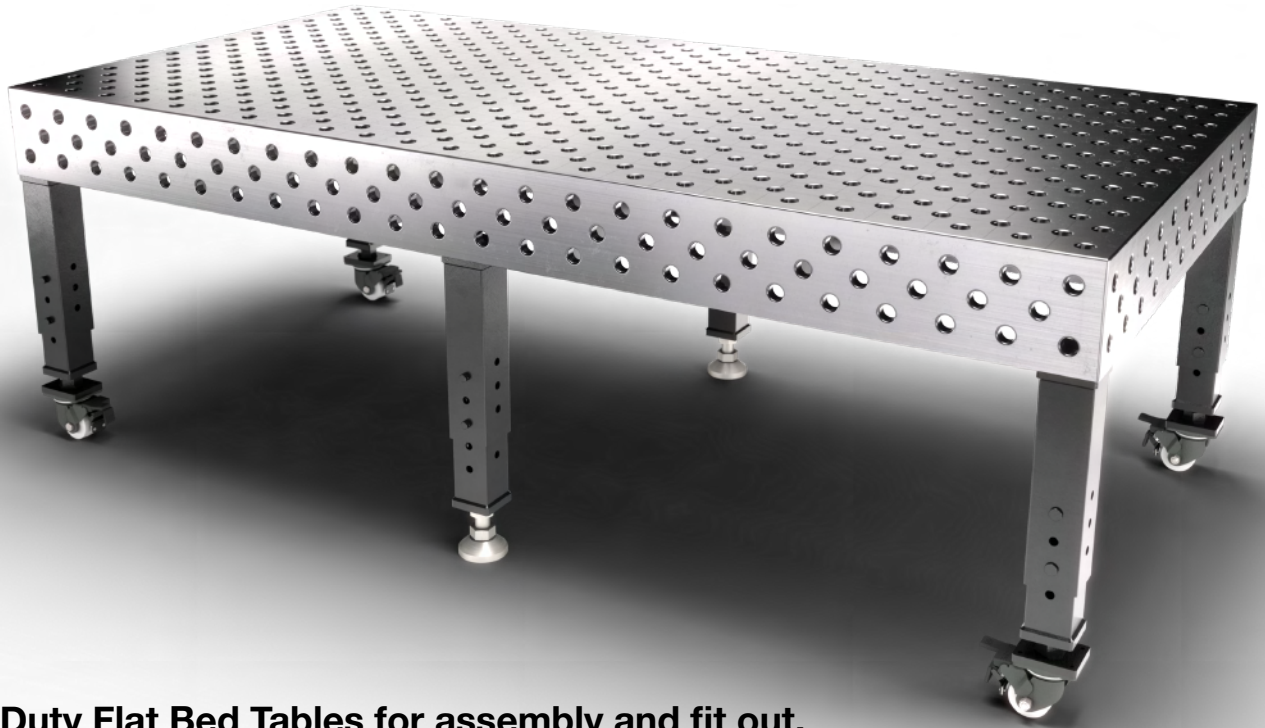
18,000mm x 2,500mm Welding table

18Meter Long x 2.5Meter Wide



Other Tables

Single piece welded tables from 1000mm x 1000mm upto 4000mm x 2000mm.



Heavy Duty Flat Bed Tables for assembly and fit out.
Stainless Steel tables can be manufactured upon request.
Sizes from 1000mm x 1000mm upto 6000mm x 2000mm.





Welding tables are manufactured on CNC milling machines with 4 axis setup and large format bed milling to ensure single setup machining and at-most accuracy of finished welding tables. This facility is dedicated for manufacturing welding tables.



3axis VMC 1500mm x 800mm x 800mm



4axis VMC 4200mm x 2700mm x 1500mm

Each welding table is inspected using portable CMM machine. This ensures flatness, perpendicularity and parallelism of top, sides and frames with respect to each other.

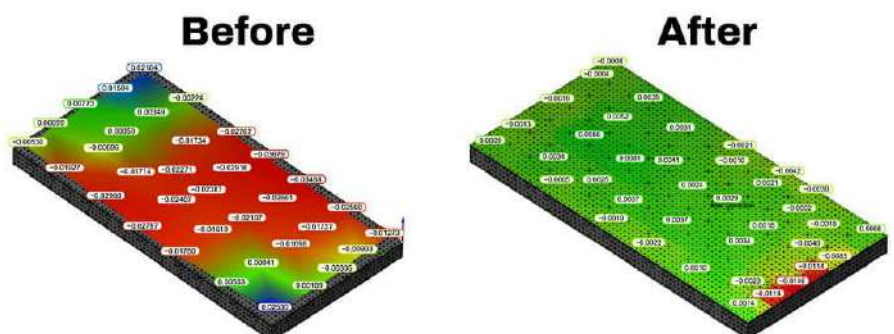


CNC Surface Grinder 1000mm x 300mm x 300mm



FARO Portable CMM Ø3000mm with extendable range of Ø18,000mm

World Class FEA softwares for analysis and simulation of parts and tables. Weldor adopts best softwares and works with best engineers to deliver its products to the world.





CNC PRESS BRAKE



MECHANICAL PRESS BRAKE



CNC PART LEVELLER



HYDRAULIC SHEARING MACHINE



SECTION BENDING MACHINE



WELDING MANIPULATORS

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