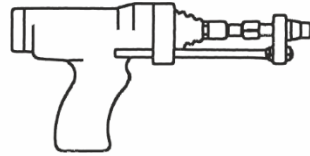
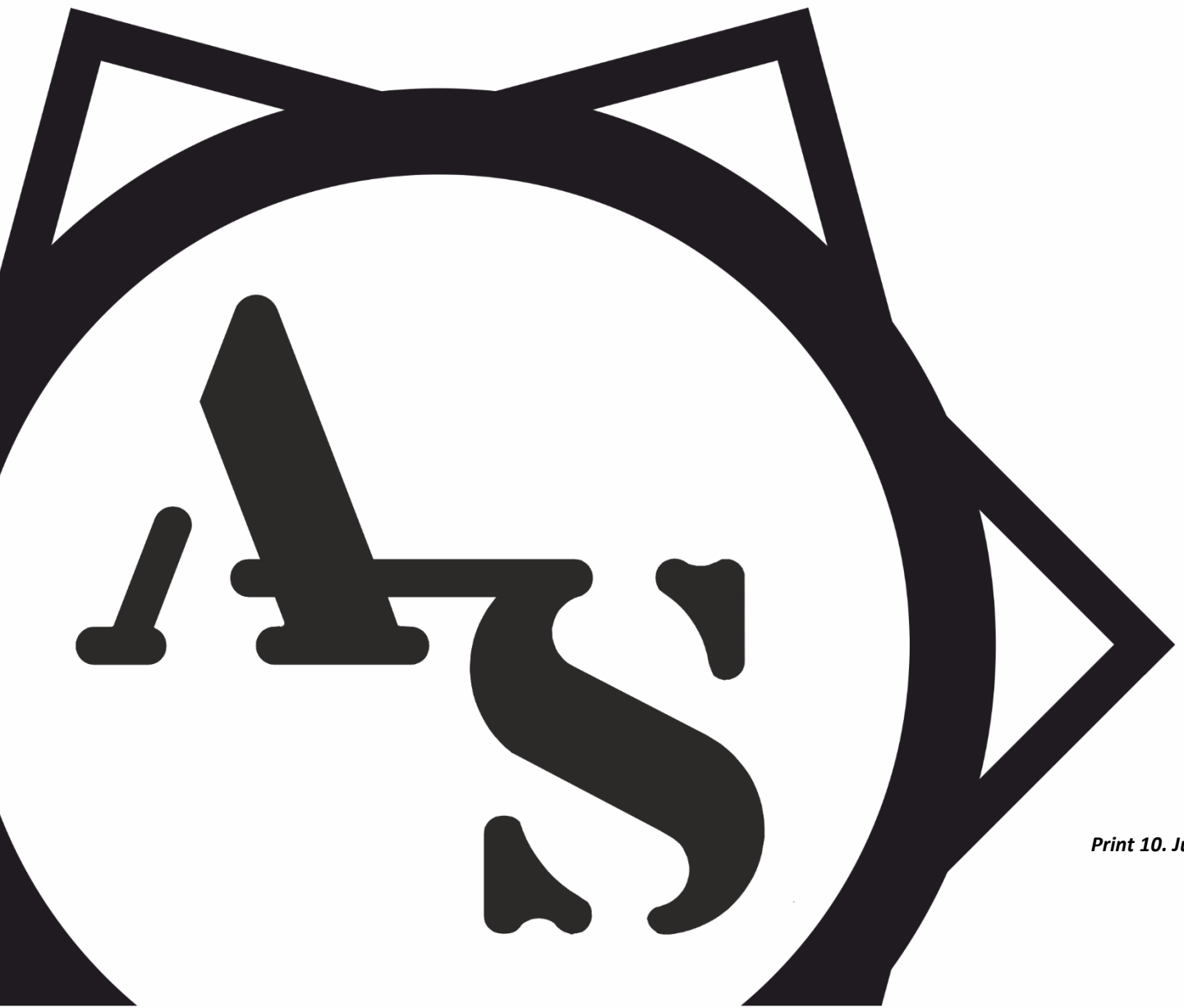


AS equipment for capacitor discharge stud welding



Made in Germany



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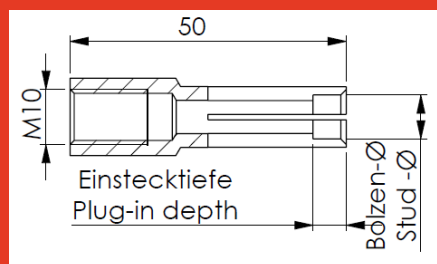
1 Chuck M10 internal thread L 50mm

1.1 Length 50mm (standard)

Chucks are used to hold the welding stud in the welding gun and to position it appropriately. The choice of the chuck in the drawn arc area depends on the length and diameter of the stud. Our chucks are compatible with most manufacturers on the market



Images

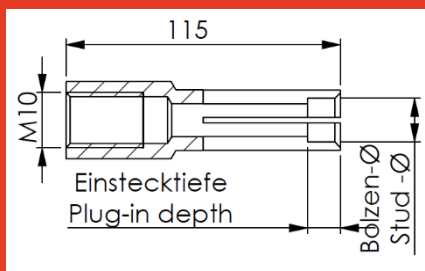







The lengths are divided into SET (standard insertion depth), KET (short insertion depth) and LET (long insertion depth). KET and LET are required when the studs are very small (less than 30mm) or very large in length. This is the case, for example, for applications with very long studs that require an additional guide. The exact application dimensions can be found in the according product description.

Art. Number	Description	equipment for
083 50 004	Stud chucks arc 4x50 SET insertion depth 5	2901 2903 2702
083 50 105	Stud chucks arc 5x50 KET Insertion depth 6	2901 2903 2702
083 50 005	Stud chucks arc 5x50 SET Insertion depth 10	2901 2903 2702
083 50 106	Stud chucks arc 6x50 KET Insertion depth 5	2901 2903 2702
083 50 006	Stud chucks arc 6x50 SET Insertion depth 7	2901 2903 2702
083 50 026	Stud chucks arc 6x50 LET Insertion depth 15	2901 2903 2702
083 50 108	Stud chucks arc 8x50 KET Insertion depth 6	2901 2903 2702
083 50 008	Stud chucks arc 8x50 SET Insertion depth 9	2901 2903 2702
083 50 018	Stud chucks arc 8x50 LET Insertion depth 25	2901 2903 2702
083 50 110	Stud chucks arc 10x50 KET Insertion depth 6	2901 2903 2702
083 50 010	Stud chucks arc 10x50 SET Insertion depth 11	2901 2903 2702
083 50 112	Stud chucks arc 12x55 KET Insertion depth 6	2901 2903 2702
083 50 012	Stud chucks arc 12x55 SET Insertion depth 13	2901 2903 2702

1.2 Length 115mm for shielded gas application

Images



















































Art. Number	Description	equipment for
083 52 005	Stud chuck arc 5x115 KET 4 gas application	  
083 51 005	Stud chuck arc 5x115 SET 6 gas application	  
083 51 006	Stud chuck arc 6x115 SET 7 gas application	  
083 52 008	Stud chuck arc 8x115 KET 6 gas application	  
083 51 008	Stud chuck arc 8x115 SET 9 gas application	  
083 52 010	Stud chuck arc 10x115 KET 4 gas application	  
083 51 010	Stud chuck arc 10x115 SET 11 gas application	  
083 51 012	Stud chuck arc 12x115 SET 13 gas application	  

1.3 Stud holder M10i/ Head bolt/Other

Images

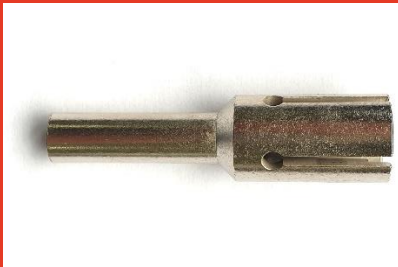


Art. Number	Description	equipment for
083 51 014	Stud chuck arc 13,5x55 LET 15	  
083 50 014	Stud chuck arc 14.6x55 KET 7 SW17	  
083 50 117	Stud chucks arc 16x55mm KET 5	  
083 50 116	Stud chucks arc 16x55mm KET 7	  
083 50 016	Stud chucks arc 16x55mm SET 15	  
083 50 118	Stud chucks arc 18x55mm KET 5	  
083 50 020	Stud chuck arc 20x55mm SET 15	  
083 50 120	Stud chuck arc 20x55mm KET8	  
083 50 028	Stud chuck arc 8x57 brass with inlet slope	  
083 53 006	Stud chuck Arc Ø 13 Head stud Ø 6mm (not in stock)	  
083 50 119	Stud chuck arc Ø19 head stud Ø10mm 19x65 ET9	  
083 53 012	Stud chuck Arc Ø25 Head stud Ø12-13mm	  
083 53 016	Stud chuck Arc Ø32 Head stud Ø16-19mm	  
083 53 019	Stud chuck Arc Ø35 Head stud Ø22mm (not in stock)	  
083 50 100	chuck extension arc 60mm M10	  
192 20 009	chuckset big arc Ø 10,12,16	
192 20 008	chuckset small arc Ø 8,10,12 incl ceramic ring holder	 

1.4 Iso- stud holder

Our range of chucks for insulation application offers a wide range of applications. Here the welding of isonails, bayonet pins, flat pins, ground pins and T-pins is possible.

Images



Art. Number	Description	Equipment for
083 50 002	Stud chuck arc ISO Ø2x 50mm	2901 2903 2702
083 50 003	Stud chuck arc Iso Ø3x50mm SET 25	2901 2903 2702
083 50 030	Stud chuck arc ISO Ø3x 70mm ET45	2901 2903 2702
083 50 040	Stud chuck arc ISO Ø4x 70mm ET40	2901 2903 2702
083 50 050	Stud chuck arc ISO Ø5x 70mm ET40	2901 2903 2702
083 50 060	Stud chuck arc ISO Ø6x 70mm ET40	2901 2903 2702
183 58 005	Stud chuck arc Ø 5x 60mm Bajo steel/vern.	2901 2903 2702
083 54 000	Stud chuck arc flat pins 15x3 (not in stock)	2901 2903 2702
083 66 009	Stud chuck ground stud Ø14.5 x 11 Al-Kapp	2902
083 65 009	Stud chuck ground stud Ø13.5x4 steel (Tucker)	2902
082 51 003	Stud chuck T-pins head Ø5	2902

Due to our many years of experience in the field of stud welding, we have the possibility to manufacture chucks for your special application on request. Here we can draw on a large catalog of already existing special chucks.

2 Ceramic ring holder

Ceramic ring holders are used to hold ceramic rings around the welding area. When selecting the ceramic ring holder, the mounting diameter (AF) of the base plate and the mounting diameter (AK) of the ceramic ring must be taken into account. Furthermore, depending on the application, longer lengths may be required, e.g. for welding through grids. For such applications, the appropriate longer chuck in combination is also required.



Images



Art. Number	Description	equipment for
080 30 112	Ceramic ring holder AF Ø22 Vario stud Ø4-12 standard	Suitable for sled 180 40 170
180 40 108	Ceramic ring holder AF Ø22 Vario stud Ø4-12 100 long	180 40 175
080 30 212	Ceramic ring holder AF Ø22 Vario stud Ø4-12 75 long	
080 30 211	Ceramic ring holder AF Ø22 Vario stud Ø 4-12 50 long	
080 30 312	Ceramic ring holder AF Ø29 Vario stud Ø10-19	Suitable for sled 180 40 176 180 40 171

Vario stud holders can be ordered to match the ceramic ring diameter, or simply adapted to the ceramic ring at hand using pliers. The ceramic should be aligned centrally to the bolt and clamped so far that the ceramic does not fall out of the holder. Due to the larger tolerances of different ceramic productions, the KR holders usually have to be slightly adjusted

180 30 105	Ceramic ring holder MS AF Ø22x25mm conical	Suitable for sled 180 40 170
180 30 106	Ceramic ring holder boiler pin MS AF Ø22x45mm conical	180 40 175

For fast working sequence, boiler pin ceramic ring holders usually have no clamping effect, and center themselves automatically via the inlet chamfer on the special ceramic rings

083 31 010	Ceramic Ring Holder Head stud Ø10mm UF10 Brass AF Ø 29	Matching foot plate 083 40 028
183 31 012	Ceramic ring holder head studs Ø13mm UF13/NF13 AF Ø 44	Matching foot plate 083 40 016
183 31 016	Ceramic ring holder head studs Ø 16 UF16/NF16 Brass AF Ø 44	

3 shielded gas equipment

You need our shielding gas equipment when you want to use the shielding gas function of our studwelder.



Images



Art. Number	Description	equipment for
182 40 534	shielded gas tube with holder Øi32x length 79 stepped with 5m hose	2902

182 40 532	shielded gas tube with receptacle Øi32x length 79 stepped 5m with hose	
------------	--	--

In addition to the normal support function, the shielding gas tube has the possibility of a connection for the shielding gas supply of the welding power source. It also avoids visible arcs and flying sparks.



182 40 533	shielded gas valve for device installation	As 2104 AS 2108 AS 2210 AS 2118 + older devices
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The shielded gas valve is required if you want to use the shielded gas function on one of our devices. For conversion inquiries, please contact one of our employees on our order hotline - this is usually also possible even if you already have a studwelder without the function.



080 40 148	Aluminum tube AF Ø 35 Gas attachment double	Suitable for sled 180 40 172 180 40 174
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The aluminum support tube with gas attachment is required as soon as you want to use the shielding gas function of our studwelder. Due to the double gas supply, it achieves an optimal gas distribution in the tube.

4 Complete slides

The slides of our product range are required for welding applications with iso pins, ceramic rings or shielding gas. The length is adjustable for each stud up to the range of the maximum length of 220mm. When selecting the slide, it is also necessary to take into account the diameter of the base plate (AF) and the size of the studs to be welded.

1: Cover disc \varnothing 8 197 40 531

2: Cover disc \varnothing 9.5 197 40 532

3: Column \varnothing 8 180 08 220 (standard) or
180 08 400

4: Foot plate AF \varnothing 22 197 40 410

5: Ceramic ring according to choice of
application with matching AF

1: Cover disc \varnothing 9.5 197 40 532

2: Cover disc \varnothing 8 197 40 531

3: Column \varnothing 8 180 08 220 (standard) or
180 08 400

4: Foot plate AF \varnothing 29 197 20 410



5: Ceramic ring according to choice of
application with matching AF

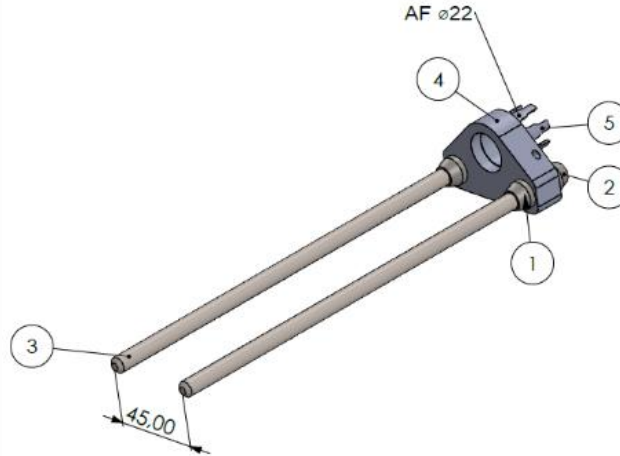
1: Cover disc \varnothing 10 080 40 109



2: Column \varnothing 10 180 10 240 (standard) or
other columns with \varnothing 10 (see under
Columns)

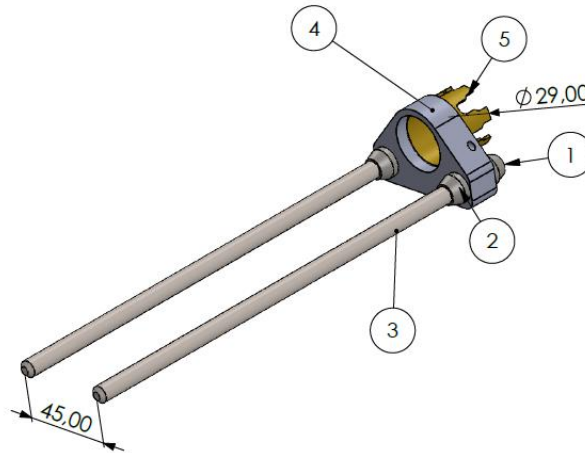
4: Foot plate AF \varnothing 22 180 40 177


5: Ceramic ring according to choice of
application with matching AF

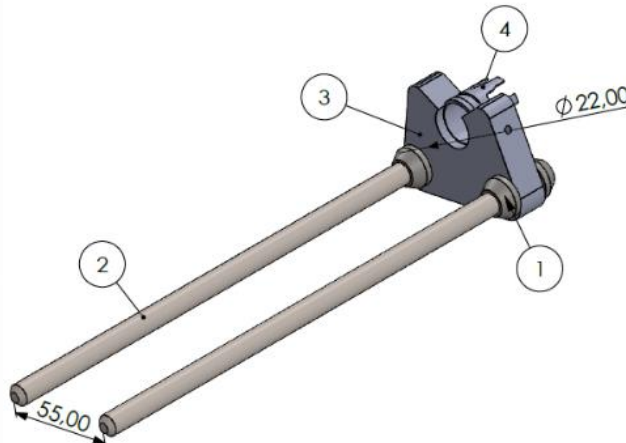
Art. Number	Description	equipment for
180 40 170	Slide 45-KR AF \varnothing 22 (M6-M12)	 



180 40 171	Slide 45-KR AF \varnothing 29 (M12-M16)	 
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180 40 175	Slide 55-KR AF \varnothing 22 (M6-M12)	
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Art. Number **Description**
180 40 176 Slide 55-KR AF Ø29 (M12-M16)

equipment for

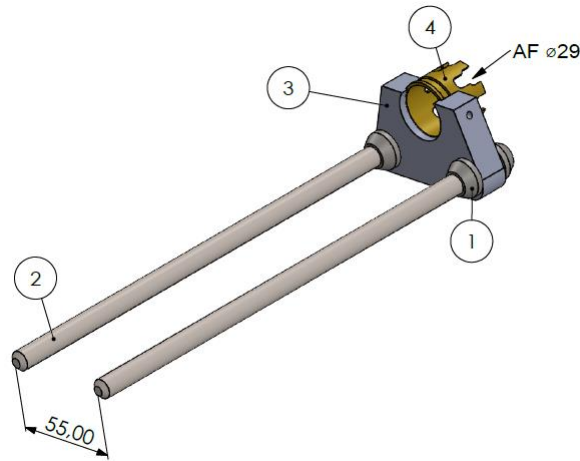


1: Cover disc Ø 10 080 40 109

2: Column Ø 10 180 10 240 (standard) or other columns with Ø 10 (see under Columns)

4: Foot plate AF Ø29 180 20 177

5: Ceramic ring according to choice of application with matching AF



180 40 173 Slide 45-KR AF Ø35 Iso



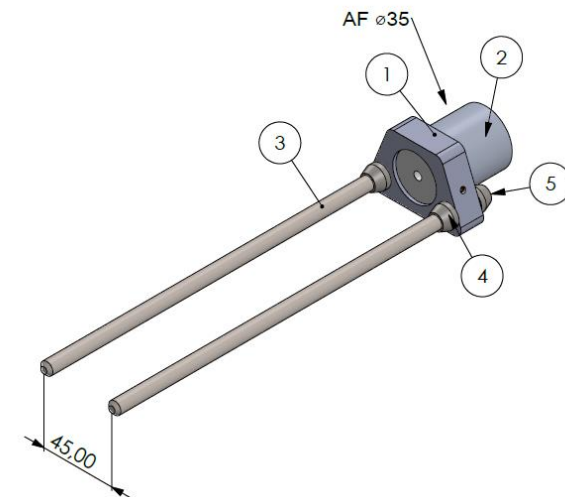
1: Foot plate AF Ø35 197 10 410

2: Aluminum support tube with insert 080 40 149

3: Column Ø 8 180 08 220 (standard) or 180 08 400

4: Cover disc Ø 8 197 40 531

5: Cover disc Ø 9.5 197 40 532



180 40 179 Slide 55-KR AF Ø35 Iso

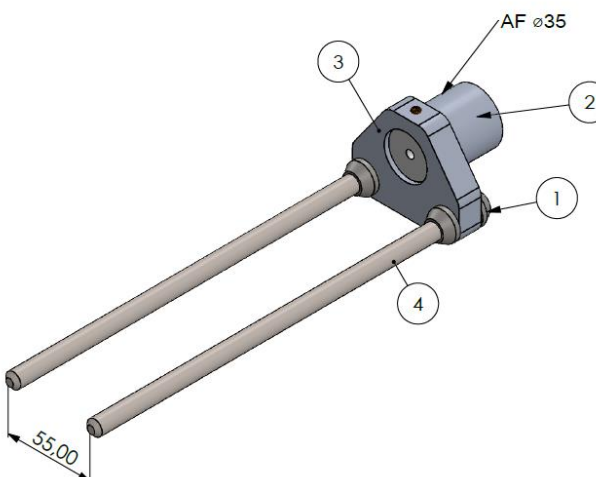




1: Cover disc Ø 10 080 40 109

2: Aluminum support tube with insert 080 40 149

3: Foot plate AF Ø35 180 10 112

4: Column Ø 10 180 10 240 (standard) or other columns with Ø 10 (see under Columns)



Art. Number	Description	equipment for
180 40 172	Slide 45-KR AF Ø28 Gas	 
180 40 174	Slide 45- KR AF Ø30 Gas	

1: Aluminum support tube Gas attachment 080 40 150

2: Gas attachment 080 40 148

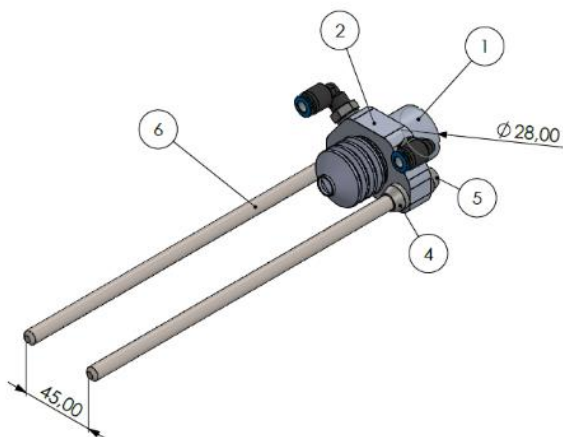
4: Cover disc Ø 8 197 40 531

5: Cover disc Ø 9.5 197 40 532

6: Column Ø 8 180 08 220 (standard) or

180 08 400

To use the shielded gas function, you need a studwelder with this function.



5 equipment for slides

5.1 Foot plates

The base plate is a component of the stand and serves as a mounting base. When selecting the footplate, pay special attention to the application and the acquisition diameter (AF), depending on which attachment is to be used.



Images



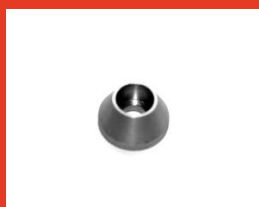
Art. Number	Description	equipment for
180 40 177	Foot plate large 55-KR AF Ø22	Slide 180 40 175
180 20 177	Foot plate large 55-KR AF Ø29	Sled 180 40 176
180 10 112	Foot plate large 55-KR AF Ø35 for aluminum support tube	Sled 180 40 179
197 40 410	Foot plate small AF 45-KR Ø22	Slide 180 40 170
197 20 410	Foot plate small AF 45-KR Ø29	Slide 180 40 171
197 10 410	Foot plate small AF 45-KR Ø35 for aluminum support tubes	Slide 180 40 173
180 50 177	Foot plate large 45-KR AF Ø22 Three-point support	Slide 180 40 175 Sled 180 40 176
180 60 177	Foot plate 45-KR large AF Ø29 three-point support	
197 50 410	Foot plate small 45-KR AF Ø22 Three-point support	Slide 180 40 170
<p><i>With the three-point support, even inexperienced workers are able to weld on a stud at 90° to the sheet metal</i></p>		
083 40 016	Foot plate AF Ø 44 Head stud	
083 40 028	Foot plate AF Ø 29 Head stud	
197 30 411	Base plate gas small 45-KR AF Ø28 shielding gas	Spare part for gas attachment 080 40 148

5.2 Columns, cover discs and tubes

Columns are part of the stand. By using different column lengths in the slides. It is possible to use different lengths of studs beyond the standard length of 220mm



Images



Art. Number	Description	equipment for
180 08 220	Column 8 x 220 mm (standard)	For all small footplates
180 08 400	Column 8 x 400 mm	
180 10 240	Column 10 x 240 mm (standard)	For all large footplates
180 10 250	Column 10 x 250 mm (not from stock)	
180 10 300	Column 10 x 300 mm (not from stock)	
180 10 350	Column 10 x 350 mm (not from stock)	
180 10 400	Column 10 x 400 mm	
180 10 500	Column 10 x 500 mm	
080 40 109	Cover disc Ø10	For Ø10 columns
197 40 531	Cover disc Ø8	For Ø8 columns
197 40 532	Cover disc Ø9.5	For screws side
080 40 150	Aluminum tube Ø28x60mm gas attachment	For foot plate 197 30 410 180 30 177
080 40 149	Aluminum support tube Ø35x45mm with insert	For foot plates 197 10 410 180 10 112

Is needed when welding iso nails and has a supporting effect

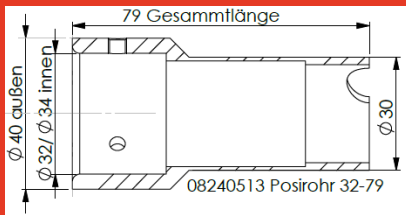
080 40 097 Column guide Ø 32



Used to hold the slide on the gun.

6 Posi tubes for short time pistol

Images



Art. Number

Description

equipment for

082 40 513	Positioning tube i32x79 mm standard
182 40 011	Positioning tube i32x90 mm
082 40 008	Positioning tube i32x95 mm



The posi tube is used for straight positioning of the gun and the welding stud on the workpiece. It also reduces the flying sparks. It is possible to work in sheet metal templates with a hole diameter of 30mm.

082 40 015	Noise protection tube i32x79 mm Al
------------	------------------------------------





The noise protection tube has a sound-absorbing effect in addition to the normal support functions. This item is recommended for customers who have very noisy welding processes in their application. It also avoids the flying sparks

7 Foot rings and equipment for short time gun

Images



Art. Number	Description	equipment for
180 40 373	Foot ring iØ32 mm	
<p><i>The foot ring with matching feet also fulfills the support function for straight positioning. Unlike the support tube, the workpiece can be seen exactly at the welding point.</i></p>		
180 40 049	Foot CD 6x49mm M4	Foot ring 180 40 373
180 40 060	Foot CD long 6x76,5mm M4 (foot for longer studs)	
092 40 010	Spacer ring 15 mm	Foot ring 180 40 373
<p><i>The spacer ring is used to extend the foot ring with feet for bolt lengths greater than 40mm and is mounted between the foot ring and feet. It can be used several times on top of each other and extends by 15mm each.</i></p>		
080 40 145	Foot ring TK38 i Ø32 mm	
<p><i>The foot ring with matching feet provides increased stability and safety</i></p>		
080 40 077	Foot conical Ø10x41mm TK38 M5	Foot ring 80 40 145 Foot ring 80 40 143

8 Accessories for a fast workflow

For fast and accurate work, the gun stand is recommended in manual mode.

Images



Art. Number	Description	equipment for
000 00 350	Gun stand with hand drive incl. adapter	suitable for all pistols with foot ring

The gun stand enables precise setup of the gun for workpieces in a fixture

Pneumatic or manual clamps for mass transfer on request depending on the application.

180 50 190	Foot switch	for automatic processes
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9 Mass equipment

Images








Art. Number	Description	equipment for
192 40 013	Ground cable 2,5m 25qmm complete with grip pliers DIX 50qmm plug (spigot diameter of welding cable plug Ø13)	All welders of the range
192 40 016	Ground cable 5m 50qmm complete with grip pliers DIX 50qmm plug (spigot diameter of the welding cable plug Ø13)	
	As special variant also with plug or socket for Ø 9mm on request for older devices or other manufacturers	
180 10 062	Grip pliers 10" large	All welders of the range
180 10 061	Grip pliers 7" small	
	Without ground cable	
080 50 067	Welding cable extension 10m (special sizes 5m or 15m)	All drawn arc welders of the range

For different sizes, the intended use should be discussed with a member of our team. Advice is available from our order hotline

Images



Art. Number	Description	equipment for
180 40 085	10.1 Socket wrench CD To tighten the sleeve/clamping nuts	
000 00 220	10.2 Automatic center punch <i>Automatic center punching for consistent grit depth for tip ignition studs.</i>	
085 00 010	10.3 Allen wrench Allen key SW 2.5 L112x18	
085 00 011	Allen key SW 3 L126x20	
085 00 012	Allen key SW 4 L142x25	
085 00 013	Allen key SW5 L160x28	
000 00 215	10.4 Case for equipment Inner dimensions 420x275mm	All equipment for all welding guns in the range


Images






**Art.
Number**




Description

equipment for

- | | | |
|------------|--------------------------------------|---|
| | 10.5 Damper for ARC procedure |  |
| 180 40 825 | Damper ARC MF10 | |
| 180 40 826 | Damper ARC MF12 | |

Used for large studs. The damper dampens the movement in the welding process and thus achieves better results.

- | | | | | |
|------------|---|---|---|---|
| | 10.6 Double open end wrench |  |  |  |
| 000 00 290 | Double open-end wrench SW 17-14
DIN895 | | | |
| 000 00 289 | Double open end wrench SW 17-19
DIN895 | | | |
| 000 00 288 | Double open end wrench SW 19-22
DIN895 | | | |

- | | | | | |
|------------|---------------------------|---|---|---|
| | 10.7 Double nipple |  |  |  |
| 080 40 412 | Double nipple small | | | |

- | | | | | |
|------------|---------------------|--|--|--|
| 080 40 105 | Double nipple large | | | |
|------------|---------------------|--|--|--|