



Spirit

Stud Welding Unit

The HBS Insulation Welder - for CD stud welding (capacitor discharge welding) according to current standards

Welding range	#4 to 1/4", 14 ga to 1/4" (M3 to M6, dia. 2 to 6); cupped head pins dia. 14 ga to 10 ga (dia. 2 to 3.1 mm)
Welding material	Mild steel, stainless steel
Welding rate	12 to 30 studs/min (depending on application and stud dia.)
Capacitance	66,000 µF
Welding time	4 to 7 msec
Energy	1,600 Ws
Charging voltage	60 to 220 V (stepless voltage regulation)
Primary power	115/230 V, 50/60 Hz, 10 AT
Power source	Capacitor
Protection class	IP 21
Operational and storage conditions	According to current standards
Dimension L x W x H	13.78" x 7.48" x 9.45" (350 x 190 x 240 mm) without handle
Weight	44.09 lbs (15 kg)
Order No.	92-12-0110

Application

Especially suitable for thin sheets (at least 0.5 mm)

ISO – especially suitable for welding on insulation pins with flange and ignition tip

Process variants

Contact welding - special designed for welding capacitor discharge welding elements and cupped head pins with same adjustment, no spring pressure adjustment, no change of spring (one welding gun for two applications)

Features

Microcontroller – for precise process times, optimal functional reliability and maximum operating convenience

Function monitoring – automatic function test following power-up; monitoring of all internal system functions

Display of error codes – on LED displays

Structure

Extremely easy to operate

Compact

Robust – metal housing withstands rough treatment in shop and on site

Safety

With integrated **mains filter** (protection against voltage peaks)

Optimal for construction sites with large mains voltage fluctuations – use even with critical voltage supply (- 25% + 20%)

EMC test

High-voltage test with log

Retriggering lock-out – prevents welding on a welding element that has already been set

Thermal monitoring of transformer – automatic shutdown in case of overheating

Optimal protection against external interferences

Welding

Display – infinitely adjustable power setting; easy monitoring of all functions via LED displays

Powerful – built-in power reserves

Trouble-free changing of welding voltage polarity possible by reconnecting welding current and ground cables

Use of special capacitors (developed for stud welding)

Suitable welding guns

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