



# PKA-500

# PHA-500

# PHA-500-6



**PHA-500-6**  
 AUTOMATIC STUD WELDING GUN  
 FOR SHORT CYCLE AND  
 DRAWN ARC STUD WELDING



**PKA-500**  
 AUTOMATIC STUD WELDING GUN  
 FOR CAPACITOR DISCHARGE  
 STUD WELDING  
 (CONTACT METHOD)



**PHA-500**  
 AUTOMATIC STUD WELDING GUN FOR CAPACITOR  
 DISCHARGE, SHORT CYCLE  
 AND DRAWN ARC STUD  
 WELDING

## INTEGRATED TRAVEL MEASURING SYSTEM



- » MEASURING OF STUD PROTRUSION BEFORE THE WELD AS WELL AS STUD TRAVEL (LIFT, IMMERSION DEPTH, IMMERSION SPEED AND SHORT-CIRCUIT TIME) DURING THE WELD
- » MEASURED VALUES ARE SHOWN IN THE DISPLAY OF THE STUD WELDING UNIT\*

\*Only in connection with series PRO-I, PRO-D, PRO-S and PRO-C units.



- » ADVANTAGES:

### MONITORING OF WELDING QUALITY

- » Comparison of actual values to set values for each weld  
 → in case of variances a warning is displayed or the unit is locked for further welds
- » storage of the last ten welding parameter sets in the stud welding unit  
 optional: welding parameter memory for 24500 welding parameter sets



### COMFORTABLE, EXACT AND FAST ADJUSTING OF AUTOMATIC WELDING GUN

- » Correctly adjusted stud protrusion and lift are key factors for a high-quality stud weld.  
 → As the adjusted values are shown in the display of the unit time-consuming manual measuring is no longer necessary.

## TECHNICAL DATA AND CHARACTERISTICS

	PKA-500	PHA-500	PHA-500-6
<b>Welding method</b>			
Capacitor discharge (contact)	x		
Capacitor discharge (gap)		x	
Short cycle		x	x
Drawn arc		x	x
<b>Welding range (Ø mm)<sup>1)</sup></b>			
Capacitor discharge (contact)	3-8		
Capacitor discharge (gap)		3-8	
Short cycle		3-8	3-8
Drawn arc		3-8	3-8
<b>Welding material</b>			
Steel	x	x	x
Stainless steel	x	x	x
Aluminium		x	
Brass		x	
<b>Stud feeding</b>			
automatic	x	x	x
semi-automatic (manual insertion)	x	x	x
<b>Spring pressure adjustable</b>	x		
<b>Lift adjustable</b>		x	x
<b>Integrated travel measuring system</b>		o	
<b>Automatic length compensation</b>			x
<b>Piston guide</b>			
Slide-bearing	x	x	x
<b>Welding cable</b>			
-cross-section (mm <sup>2</sup> )	25	25	25
-length (m)	6,5	3	5
<b>Control cable plug</b>	7-pin	7-pin (12-pin <sup>2)</sup> )	7-pin
<b>Housing from impact resistant plastics</b>	x	x	x
<b>Protection of piston guidance from welding spatters</b>	x	x	x
<b>Dimensions</b>			
Width (mm)	60	60	60
Height (mm)	172	172	172
Length (mm)	235	290	335
Weight without cable (kg)	1,1	1,6	1,7

x – Standard, o – Option

<sup>1)</sup> Other diameters on request.

<sup>2)</sup> with integrated travel measuring system



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