



F 400

CNC STUD WELDING MACHINE



STUD WELDING TECHNOLOGY BY



STUD WELDING



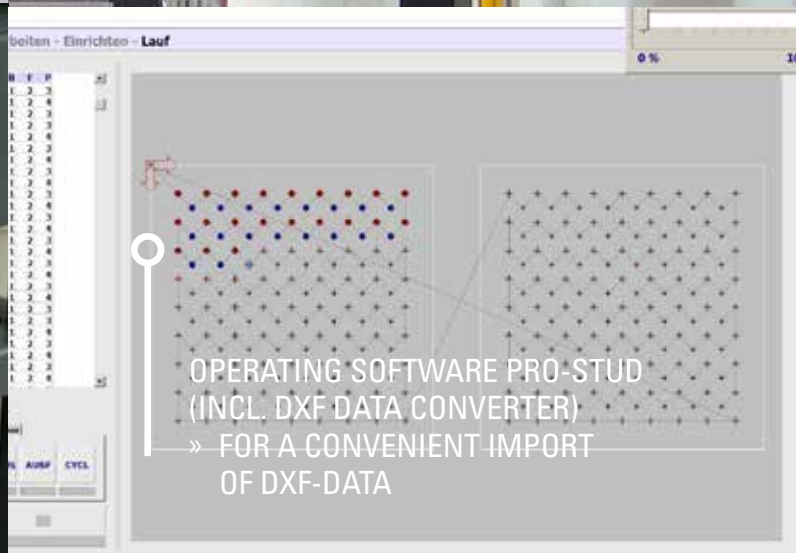
PROGRAMMING NETBOOK WITH OPERATING SOFTWARE i1STUD
 » ENABLES PROGRAMMING REGARDLESS OF LOCATION (E.G. BY PRODUCTION PLANNING/CONSTRUCTION)



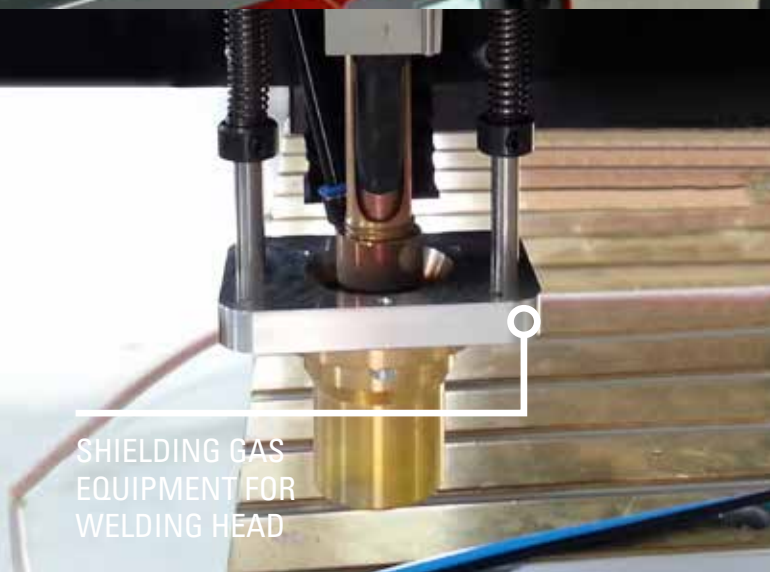
OPTIONAL:
 OPERATING TERMINAL WITH INDUSTRIAL PANEL PC WITH OPERATING SOFTWARE PRO-STUD



FAST AND EASY OPERATION BY CONTROL INTEGRATED IN THE FRAME WITH OPERATOR CONTROL PANEL



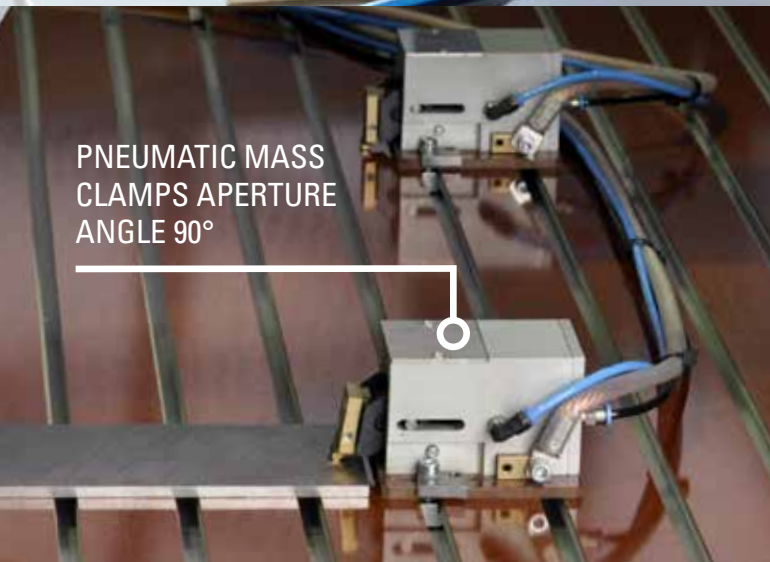
OPERATING SOFTWARE PRO-STUD (INCL. DXF DATA CONVERTER)
 » FOR A CONVENIENT IMPORT OF DXF-DATA



SHIELDING GAS EQUIPMENT FOR WELDING HEAD



MANUAL STUD INSERTION



PNEUMATIC MASS CLAMPS APERTURE ANGLE 90°



MECHANIC MASS CLAMPS MOUNTED ON WELDING HEAD

HOUSING WITH LIGHT CURTAIN OR DOOR

COMPACT AND INTELLIGENT DRIVE ENGINEERING

ROBUST AND WARP RESISTANT WELDED STEEL MACHINE FRAME

WORKING AREA X/Y (MM):
400 X 400

OPTIONAL: ROBUST WELDED STEEL UNDERFRAME WITH UNDERSHELF

SUITABLE FOR ALL STUD WELDING METHODS

PNEUMATIC WORKING LIFT

OPTIONAL: FLUID SPRAYING DEVICE FOR AUTOMATIC STUD WELDING HEAD

INTEGRATED WELDING PARAMETER MONITORING (OPTIONAL: WELDING PARAMETER MEMORY)



TECHNICAL DATA AND CHARACTERISTICS

	F 400
Working area X/Y (mm)	400 x 400
Welding range¹⁾ stud diameter (mm)	3-8
Max. number of stud welding heads	1
Max. operating speed X-/Y-axis (m/min)	6
Positioning accuracy of the welded studs +/- (mm)	0,2
Operation and programming	
Compact control with operator control panel, programming netbook with operating software i1stud	x
Operating terminal with industrial panel PC with operating software PRO-STUD (incl. DXF data converter)	o
Welding parameter monitoring²⁾	
Welding parameter monitoring	x
Welding parameter memory with USB-interface for data transmission to a PC	o
Automatic stud feeding	x
Options	
Fluid spraying device for welding head	o
Pneumatic single stud feeding, manual stud insertion	o
Stud switch	o
Pneumatic mass clamps standard	o
Pneumatic mass clamps aperture angle 90°	o
Mechanic mass clamps on welding head	o
Pneumatic mass clamps on welding head	o
Workpiece downholder for welding head	o
Shielding gas equipment for welding head	o
Protection devices	
Housing with light curtain	x
Housing with door ³⁾	o
Motor technology/drive	
Step motors	x



	F 400
Pneumatic working lift/welding head (mm) <small>(mechanic adjusting range 50 mm)</small>	80
Machine frame	
Welded steel construction	x
Suitable stud welding units⁴⁾	
PRO-C 1000	x
PRO-C 1500	x
PRO-I 1300	x
PRO-I 2200	x
PRO-D 1600	x
Suitable automatic stud welding heads⁴⁾	
KHA-200F <small>with integrated travel measuring system</small>	x
KKA-200F	x
Dimensions	
Width (mm)	910
Depth (mm)	910
Height (mm)	2000
Weight (kg)	200
Connection values	
electrical <small>(mains supply, mains fuse external)</small>	230 V/50 Hz, 16A
pneumatical	≥ 6 bar <small>unoiled, dry, clean</small>

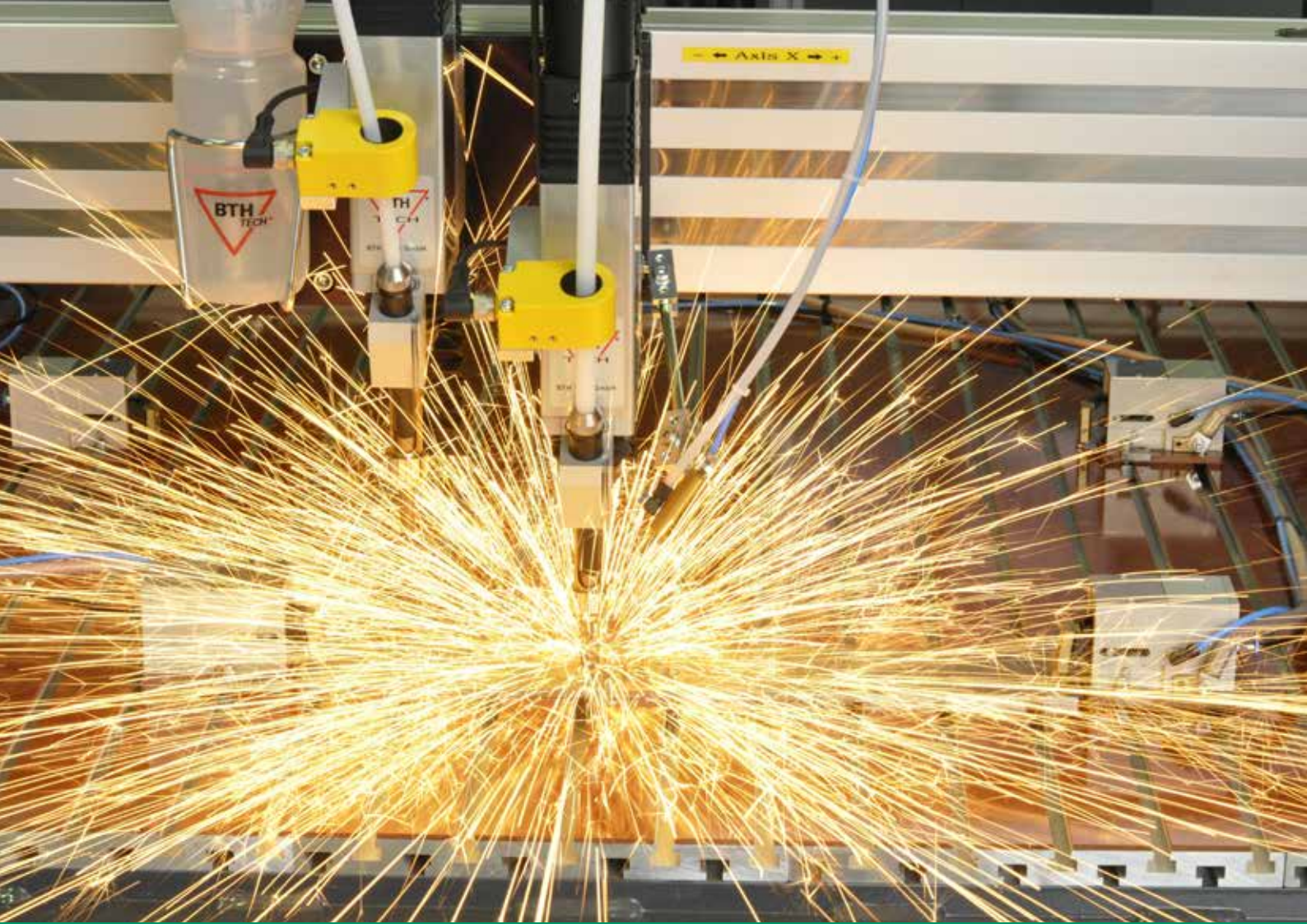
x – Standard, o – Option

¹⁾ Other diameters as well as special welding elements on request as special production.

²⁾ By stud welding units PRO-C/PRO-I/PRO-D. For further details see product data sheets **PRO-C**, **PRO-I** and **PRO-D**.

³⁾ Design as sliding door. Optional: Housing with closed top as sound insulation housing.

⁴⁾ The machine is suitable for all stud welding methods. PRO-C 1000/1500 = capacitor discharge (contact and gap method), PRO-I 1300/2200, PRO-D 1600 = drawn arc and short cycle, KHA-200F = capacitor discharge (gap and contact method), drawn arc and short cycle, KKA-200F = capacitor discharge (contact method)



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