



F 400

CNC STUD WELDING MACHINE



STUD WELDING TECHNOLOGY BY



STUD WELDING



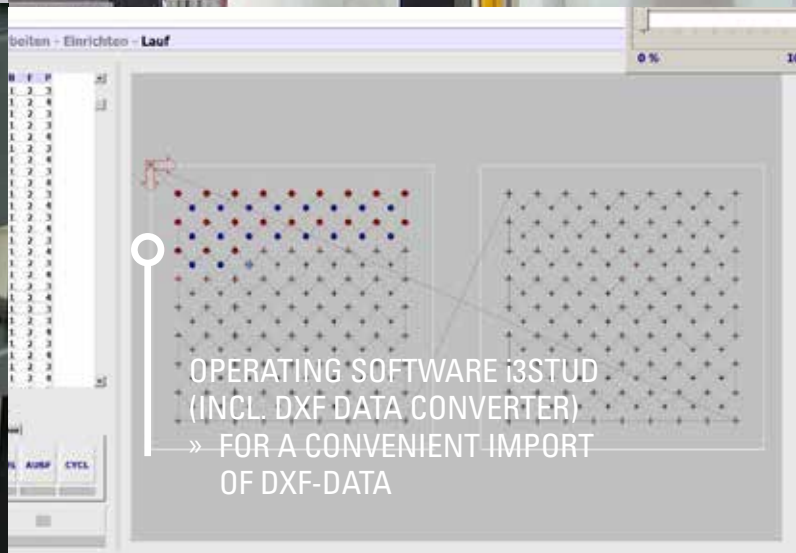
PROGRAMMING NETBOOK WITH OPERATING SOFTWARE i1STUD
 » ENABLES PROGRAMMING REGARDLESS OF LOCATION (E.G. BY PRODUCTION PLANNING/CONSTRUCTION)



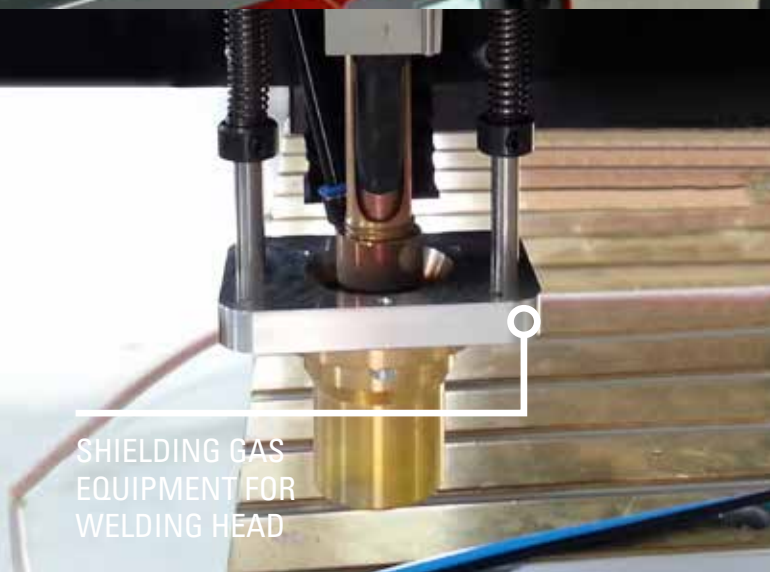
OPTIONAL:
 OPERATING TERMINAL WITH INDUSTRIAL PANEL PC WITH OPERATING SOFTWARE i3STUD



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



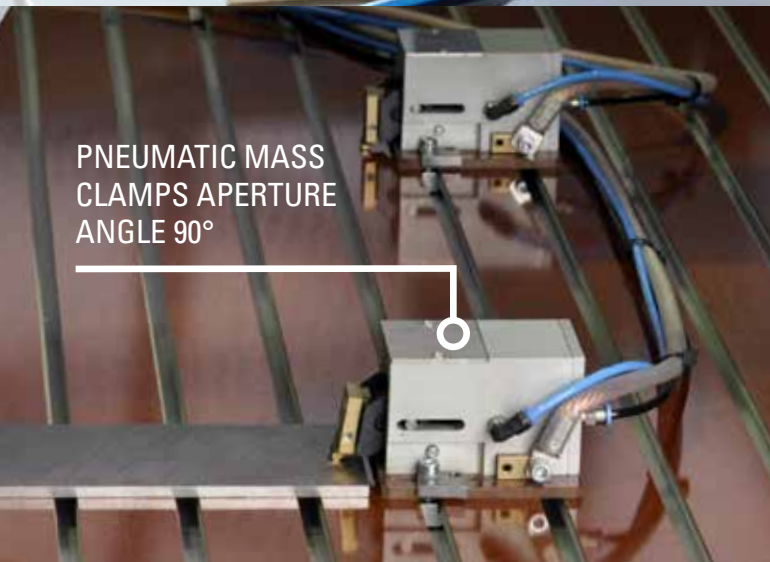
OPERATING SOFTWARE i3STUD (INCL. DXF DATA CONVERTER)
 » FOR A CONVENIENT IMPORT OF DXF-DATA



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⁾	Ø 3-8 mm
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 i3stud (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
Robust welded steel underframe	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) (mechanic adjusting range 50 mm)	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 1200	x
PRO-D 1600	x
Suitable automatic stud welding heads⁴⁾	
KHA-200F with integrated travel measuring system	x
KKA-200F	x
Dimensions	
Width (mm)	910
Depth (mm)	910
Height (mm)	2000
Weight (kg)	200
Connection values	
electrical (mains supply, mains fuse external)	230 V/50 Hz, 16A
pneumatical	≥ 6 bar unoiled, dry, clean

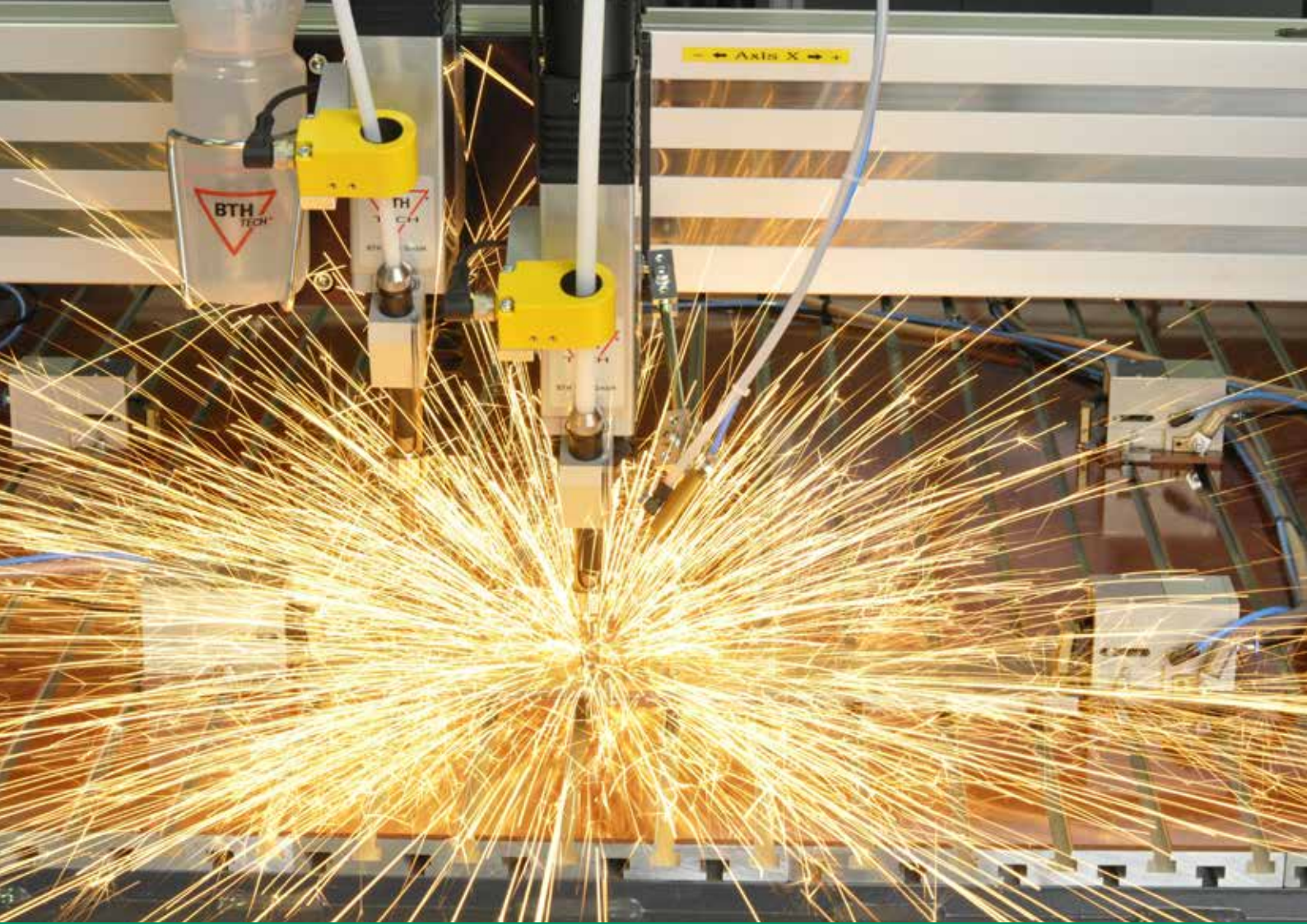
x – Standard, o – Option

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 and PRO-D 1200/1600 = 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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