

Pressed Inserts.

Inserts can work loose, crack paint and leave stains. Holes need to be punched then deburred in parent material, weakening it. The reverse side is not always left flat, and the insert is visible and unsightly. The resulting joint cannot always be guaranteed leak-proof

Drilling & Tapping

Drilling and Tapping are very slow processes, requiring thicker parent material to achieve full joint strength. Drills and taps get broken and fasteners can vibrate loose. Through drilled holes need sealing and blind holes need clearing out.

Back Welds

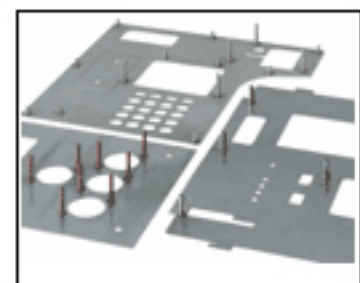
Back Welding is a slow, messy and inaccurate process. Holes are required, into which the fastener must be precisely positioned. The biggest disadvantage is having to grind or polish off excess material or burn marks on the reverse side.

Through Bolting.

Through Bolting is not tamper-proof, and is a cumbersome and slow process requiring two-handed assembly with access from both sides. Holes weaken the parent material and leakage stains from the unsightly bolt heads are common.

Projection and Resistance.

Welding means taking a component to fixed equipment, replacing electrodes, and high power consumption costs. Solder and Brazing Requires clamping and causes distortion. Riveting is untidy, irreversible, requires holes and works loose. All of these processes are slow, unsightly, require reverse access and need cleaning and finishing.



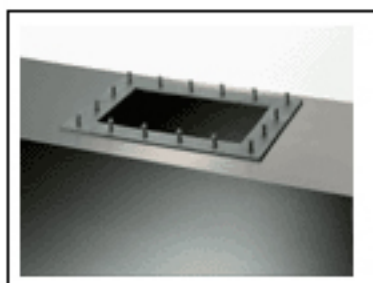
Replacing Inserts.

Studwelding replaced inserts in these applications, resulting in faster productions and stronger joints. Thinner sheets could now be used, and with no reverse marking. Corrosion was eliminated as moisture ingress was prevented.



Replacing Drilling & Tapping.

Studwelding allowed this manufacturer to speed up production considerably. Previously he had to leak test every through drilled and tapped hole. An alternative solution of using thicker flanges would have resulted in additional time and cost implications



Replacing Through Bolting

One component became tamper-proof, a clean design was the biggest benefit on another. One a third part, the gauge was reduced and leakage was prevented. Finally studwelding solved the problem of loose bolts and inaccessibility to the bolt head after assembly.



Replacing Back Welding

Here production increased tenfold when studwelding replaced a backwelding process. With no need to grind the top surface flat and polish off excess material and burn marks, time saved was significant? Reject components were eliminated with additional cost saving



Replacing Resistance Welding.

removed a bottleneck by not having to take the biggest component to a large resistance welding machine. Replacing soldering cured a corrosion problem caused by a solder flux. Some components which were previously brazed sustained damage because of the long heat cycle.

There are three types of studwelding:

Capacitor Discharge (CD)..... Short Cycle (SC)..... Drawn Arc (DA)

They are complimentary and should not be regarded as alternatives.

With each method, a weld stud is held in a handtool or production head-then presented squarely to the workpiece.

The three process's work as follows.....



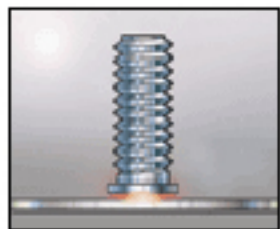
Capacitor Discharge M2.5 to M10 dia

Energy is stored in a bank of capacitors charged to a pre-set voltage determined by a type of stud and parent material.

When triggered, energy discharges as a high current pulse, melting the tip to produce an arc.

Spring pressure forces the stud onto the molten surface to ensure complete fusion across the flange.

Weld duration under 4 milliseconds.



Short Cycle M2.5 to M8 dia

A transfer rectifier supplies a fixed current power source.

Triggering produces a pilot arc and the stud lifts to a pre-set height.

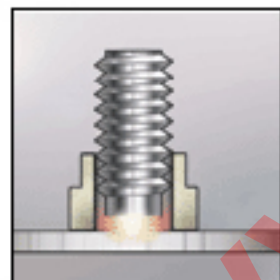
The main arc melts the end of the stud, producing a molten pool in the parent material.

Return spring pressure then forces the stud into the pool.

Using a shrouding gas reduces weld spatter especially with stainless steel.

Weld duration: 10 to 100 milliseconds

Click Images to view process



Drawn Arc M5 to M25 dia

Current level, and duration are determined by the stud diameter.

Triggering produces a pilot arc and the stud lifts to a pre-set height.

The main arc melts the end of the stud, producing a molten pool in the material.

Return spring pressure forces the stud into the molten pool.

A ceramic ferrule contains and shapes the weld fillet, this arc shield is not re-usable.

Weld duration: 100 to 10000 millisecond



The stud pip is placed in contact with the work sheet

Upon triggering, the stored energy is discharged as a high current pulse melting the pip & producing an arc.

Return spring pressure forces the stud into the molten surface area to give complete fusion across the flange.

The Stud is welded in place. No back-marking, or burn discolouration

The Process

Parent Material

Equipment

Advantages

CD is ideal for thin gauge; cold rolled sheet where reverse marking can be minimised or eradicated. Penetration into the workpiece is minimal.

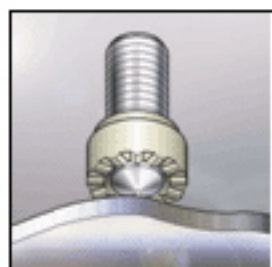
For CD the sheet can be as thin as 0.7mm. Mild Steel, Stainless Steel, Aluminium Alloy and Lead Free Brass. Sheet surfaces should be clean and flat. Stud weld end must have precise pip and cone

CD controllers are lightweight and hand portable. Lower cost than SC and DA. Single phase 230/110 volt 50HZ

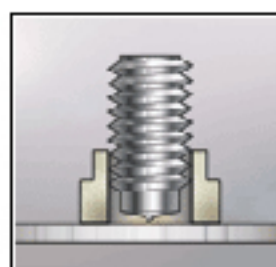
Low stud costs, Low cost equipment. The fast process Ideal for production systems from simple bench mounted to high speed automatic CNC. Easy to jig, no ferrules, No shrouding gas-Clean welds. No finishing required.

THE DRAWN ARC PROCESS

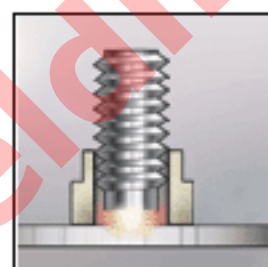
Current and weld time is pre-set to suit the diameter to be welded. The stud is then placed on the plate. Upon triggering a pilot arc occurs as the stud lifts to a pre-set height. The main arc then melts in the weld end of the stud and creates a molten pool in the plate.



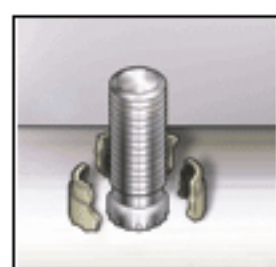
Current and weld time is pre-set to suit the diameter to be welded



The stud is then placed on the plate. Upon triggering a pilot arc occurs as the stud lifts to a pre-set height.



The main arc then melts in the weld end of the stud and creates a molten pool in the plate.



Return spring pressure forces the stud into the molten pool. The ferrule contains the molten metal and shapes the fillet.

Process

Very strong penetrative welds are achieved with this process. Ferrules required to contain and shape molten metal. Weld end of stud is fluxed

Stud / Material / Power

Stud Diameter 3mm to 30mm
Material thickness 2mm & above
Power Requirements 3 Phase 230/380/415V

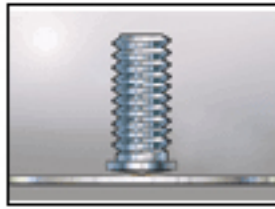
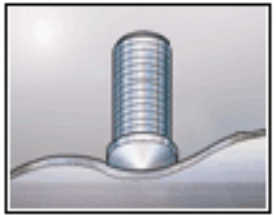
Advantages

Burns through parent material laminations tolerates surface curvature and imperfections, e.g. light rust, scale grease and some coatings. Gives neat and controlled weld fillet.

The only method of studwelding large diameters. This process also lends itself to multiple applications.

This process is the same for Drawn Arc (DA) but operates over a much shorter time period - up to 100 milliseconds.

Ceramic arc shields (Ferrules) are not required with this process but shrouding with gas can improve weld fillet formation especially when welding Stainless Steel studs. Capacitor Discharge studs may be used.



A transfer rectifier supplies a fixed current power source

Triggering produces a pilot arc and the stud lifts to a pre-set height.

Return spring pressure then forges the stud into the pool.

Using a shrouding gas reduces weld spatter especially with stainless steel.

The Process

Parent Material

Equipment

Advantages

Short Cycle gives greater penetration into the workpiece that CD.
When the surface is uneven, and DA would burn through the parent material, then SC should be used.

The sheet thickness for SC should be greater than 1.5mm. Can also be used with Stainless Steel. More suitable than CD where surface is uneven, coated with oxide, mill scale or dirt.

Medium weight & hand portable controllers.
Lower cost than DA but more than CD.
Three phases
380/415 volt 50HZ

Low cost studs. Greater stud design flexibility due to no pip required on the weld end. Equipment can be bench mounted and automated. Tolerates surface irregularities. Easy to jig. No ferrules.

ELECTRONICS:

Control and Security Equipment, Mechanical Instruments, Office Automation, Data Transmission, Communications, Test Equipment.

MECHANICAL:

Material Handling and Conveyors, Lifts, Metal Furniture, Transportation, Construction and General Machinery

HEATING AND VENTILATION:

Domestic and Industrial Boilers, Air Conditioning and Ventilation Units, Refrigeration Systems.

DECORATIVE AND COMSUMER:

Signs, Nameplates, Panels, Badges, Emblems, Jewellery, Kettles, Saucepans

MISCELLANEOUS INDUSTRIAL:

Catering and Food Processing, Insulation and Fireproofing.

THE APPLICATIONS:

ELECTRICAL:

Mounting components on panels and in cabinets.

Earthing components. Bonding doors and panels.

Fixing wiring looms.

ELECTRONICS:

Fixing fascia panels. Mounting switches, push buttons and instruments. Mounted printed circuit boards.

MECHANICAL:

Fixing cover plates and maintenance inspection hatches. Attaching machinery guards.

Fixing fluid and air lines.

Mounting handles and other components.

HEATING AND VENTILATION:

Attaching flanges, covers and hatches.

Mounting fluid chambers. Fixing burners and heating elements.

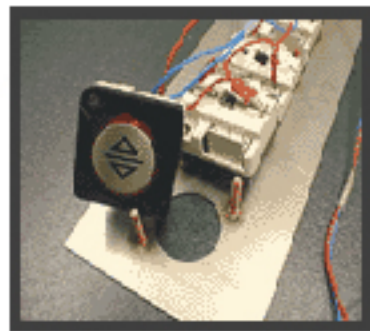
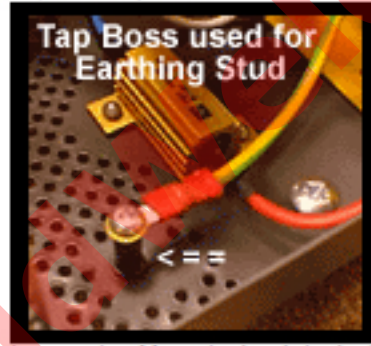
Securing pipes and insulating material.

DECORATIVE AND COMSUMER

Fixing of signs, plates, panels and badges.

Attaching pins, findings and clasps to jewellery.

Attaching feet to kettles and handles to pans.



MISCELLANEOUS INDUSTRIAL:

Hygienic fixing of legs, brackets and stiffener strips to counter and table tops.

Securing acoustic insulation.

Fixing fireproofing material.

- Shipbuilding
- Light Industry
- Insulation Industry
- Machine Construction
- Switchgear Transformers
- Automotive Industry
- Environmental Engineering
- Fabricators
- Construction Industry

The CD 200 series is the latest addition to our UK manufactured quality Stud Welding equipment range.

The CD200 has the facility to adjust voltage up and down and can operate on any voltage from 100 to 240 volts without the need for internal changes.

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The CD200 has the facility to adjust voltage up and down and can operate on any voltage from 100 to 240 volts without the need for internal changes.

The CD200 uses state of the art inverter technology resulting in a much more efficient Studwelding machine than before. Faster charge rates and a rapid welding action substantially reduce weld time. Lightweight and easily portable.

The CD200 around half the all up weight of many other conventional stud welding equipment.



CDM CAPACITOR DISCHARGE STUDWELDING EQUIPMENT RANGE

Compact, portable Capacitor Discharge equipment designed to weld up to 10mm diameter studs.

With its simple and robust construction the CDM range offers an economic and reliable method of fixing Mild Steel, Stainless Steel, Aluminium and Brass studs.

Fast and accurate, the CDM range gives you better weld results. Designed and built to exacting standards and meets all required standards, the CDM range is CE marked.

CDM RANGE – CONTROLLER FEATURES

- Compact, lightweight portable machine.
- Strong, robust construction.
- Rapid welding action reduces weld time.
- Super fast recharge time improves profitability.
- Easy adjustment of capacitor voltage.
- LED displays allow easy monitoring of functions.
- Welds Mild Steel, Stainless Steel, Aluminium and Brass.
- Quality and reliability from Taylor Studwelding Systems Ltd.



The CDM Range of Capacitor Discharge Studwelding Equipment is compatible with our whole range of CD Handtools.

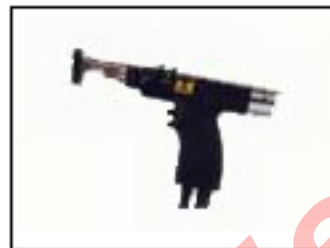
Capacitor Discharge Handtools



Lift Gap



Contact



c/w Extension Leg



Mini & Macro

Auto Feed Handtool CD and DA



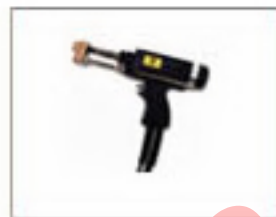
Auto Feed

DA8 also for SC



DA8

Drawn Arc Handtools



DA7



DA1



DA9

We stock a comprehensive range of accessories and attachments to compliment and add versatility to your Stud Welding System.



HANDTOOL FEATURES

- Designed for lightness and balance.
- Comfortable to use, minimises operator fatigue.
- Made from impact resistant, high strength Vertron.
- Fitted with long hydraulic damper for shear connector welding.
- Accessories - various accessories and attachments are available to solve specific problems.
- Extensions are available for both handtool and earth cables.



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TAYLORMADE
TO YOUR REQUIREMENTS



The LIFT GAP HANDTOOL

This hand tool should be considered for non-ferrous applications where there is no requirement to weld through coatings.

Very fast welds are achieved by electronically controlled shaft lift and tip ignition firing on its return. Can reduce reverse marking effects on certain gauges of material where the non-welded side is painted or coated



A wide range of Accessories and Attachments are available

The CONTACT HANDTOOL

CONTACT HANDTOOL

No other hand tool should be considered for welding through electro-galvanized or oxidized coatings.
Used in the majority of stud welding applications.
A variable plunge rate adjuster will allow the operator to alter the hand tool for slow welds onto coated steels and fast welds onto Aluminium.
The bearing surface for the shaft has been maximized to improve alignment and reduce play.
Nose cone may be fitted in applications where templating is required.



A wide range of Accessories and Attachments are available

Contact Handtool c/w Extention Leg Assembly

Standard Contact Handtool fitted with sliding extention leg assembly.
Fully adjustable to cater for varying nail lengths or for applications requiring length changes on a regular basis.

Typical applications include using long studs i.e. CD nails.

Used as "standard" in fire protection insulation.

The Front End Cap is easily replaced by an adjustable extended leg assembly.



A wide range of Accessories and Attachments are available



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TAYLORMADE
TO YOUR REQUIREMENTS



The MINI welding attachment is used in restricted access applications. Generally supplied with a fixed nose cone as shown here. For particularly difficult locations, special designs may also be manufactured.



The MINI and MICRO Handtools

The MICRO welding head attachment is used in conjunction with the contact hand tool. Offers a solution to those applications where access is minimal and the mini hand tool is too big to use

A wide range of Accessories and Attachments are available

AUTOMATIC PISTOLS TYPE AP1 AND 2 FEATURES

- Robust and ergonomically designed.
- Designed for lightness and balance.
- Weighs only 1.4kg (plus cables).
- Size : 262 x 145 x 42mm.
- Welding range M3 to M8 as standard. Other diameters possible.
- Welding lengths 6mm to 35mm as standard. Other lengths possible.
- Material - Mild Steel, Stainless Steel, Brass and Aluminum Alloy.
- Type AP1 for Capacitor Discharge contact welding.
- Type AP2 for Capacitor Discharge lift gap and Drawn Arc Short Cycle welding.



AUTOMATIC PISTOL AND STUD FEEDING SYSTEMS FOR CAPACITOR DISCHARGE AND SHORT CYCLE STUDWELDING.

A Taylormade automatic hand held studwelding system to weld up to 8mm diameter studs



DA TTC12 Equipment



DA 1200 & 1200E Equipment



DA 1700 Equipment



DA 2200 Equipment



DA 2700 Equipment

To view equipment details, click on text or image. Having viewed a sample of the information available on the presentation, you may wish to contact our Sales Team to discuss your requirements.

The images are not to scale.



751 Short Cycle Equipment

Controller Features - System TTC12

Source of power	= 2 phase 400v / 50H (other voltages available)
Connected loads	= 65KVA
Welding time	= from 0.1 - 0.5 adjustment Infinite
Current range (10% duty cycle)	= 200-1000AMP
Welding range:	= 3mm - 12mm diameter Full Base
Welding rate:	= 20 - 4 studs / minute
Controller weight.	= 90kg
Dimensions (excluding handles and eyebolts) L x W x H	640 x 325 x 535mm

SYSTEM TTC12 - CONTROLLER FEATURES

- Robust and compact design housing all components in one cabinet.
- Mounted on 4 castors making the machine easily manoeuvrable.
- Soak tested components used.
- All systems undergo extensive durability tests.
- Infinitely variable time.
- Infinitely variable current.
- Recessed front and back panels protect controls and weld sockets.
- Twist and lock weld plugs and sockets.
- Handtool can use any UK and European chucking system.



SYSTEM TTC12

Compact manoeuvrable Drawn Arc equipment designed to weld up to 12mm diameter studs. With its simple robust construction the TTC12 offers an economic and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate, the System TTC12 gives you better weld results.

Designed and built to exacting standards and meets all required standards, the System TTC12 is CE marked

Controller Features - System 1200

Source of power:	= 3 phase 400v / 50Hz (other voltages available)
Connected loads:	= 65KVA
Dimensions:	= (excluding handles and eyebolts) L x W x H 710 x 630 x 460mm
Welding time:	= from 0.1 - 1.0 adjustment Infinite
Current range:	= 200-1200AMP (10% duty cycle)
Welding range:	= 3mm - 16mm diameter Full Base
Welding rate:	= 20 - 6 studs / minute
Controller weight:	= 151kg

- Robust and compact design housing all components in one cabinet.
- Mounted on 4 wheels making the machine easily manoeuvrable
- Front 2 swivel wheels are fitted with brakes.
- Soak tested components used.
- All systems undergo extensive durability tests.
- Infinitely variable time.
- 5 Step current adjustment.
- Thermostatically controlled air cooling.
- Recessed front and back panels protect controls and weld sockets.
- Twist and lock weld plugs and sockets.
- Handtool can use any UK and European chucking system.
- Gun lift test facility.
- Chuck saver circuit fitted.
- Quality and reliability from Taylor Studwelding Systems Ltd.

Please Note:

All Controllers are externally identical, compare and consider most suitable specification for your requirements.



SYSTEM 1200DA - CONTROLLER FEATURES

Compact manoeuvrable Drawn Arc equipment designed to weld up to 16mm diameter studs. With its simple robust construction the 1200 DA offers an economic and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate, the System 1200 gives you better weld results. Designed and built to exacting standards and meets all required standards, the System 1200 is CE marked.

Controller Features - System 1200E

Can be used with with Short Cycle studs
When the DA 8 Handtool is fitted.

Model 1700DA

Welding stud range:	= 5-20mm
Input voltage:	= 400
Fusing:	= 63
Max. KVA rating:	= 55
Welding current:	= 200-1700
Welding time:	= 50-1500
Weld rate:	= 5 at 20mm (pieces / minute)
No-load voltage:	= 75
Class protection:	= IP23
Cooling:	= Fan
Transformer Ins. Class:	= H
Dimensions:	= L x W x H 980 x 620 x 750mm
Controller weight:	= 313kg

- Microcomputer controlled.
- Infinitely adjustable welding current.
- Constant current control.
- Infinitely adjustable welding time.
- Solid state switching.
- Robust and compact design housing all components in one cabinet.
- Forced air cooling by fan.
- Gun lifting test facility.
- Chuck saver circuit fitted.
- Visual current and time display.
- Current and time reporting procedure.
- Mounted on 4 castors making the machine easily manoeuvrable.
- Recessed front and back panels protect controls and weld sockets.
- Twist and lock weld plugs and sockets.
- Handtool can use any European chucking system.

Please Note:

All Controllers are externally identical, compare and consider most suitable specification for your requirements.



SYSTEM 1700DA CONTROLLER FEATURES

Robust maneuverable Drawn Arc equipment designed to weld large studs up to 25mm in diameter. With their simple construction, this range of large equipment offers an economical and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate this range of heavy duty equipment gives you better weld results.

Designed and built to exacting standards and meets all required standards, this range of Drawn Arc studwelding equipment is CE marked

Model 2200DA

Welding stud range:	= 5-22mm
Input voltage:	= 400
Fusing:	=100
Max. KVA rating:	= 85
Welding current:	= 300-2200
Welding time:	= 50-1500
Weld rate:	= 6 at 22mm (pieces / minute)
No-load voltage:	= 95
Class protection:	= IP23
Cooling:	= Fan
Transformer Ins. Class:	= H
Dimensions:	= L x W x H 1200 x 720 x 900mm
Controller weight:	= 439kg

- Microcomputer controlled.
- Infinitely adjustable welding current.
- Constant current control.
- Infinitely adjustable welding time.
- Solid state switching.
- Robust and compact design housing all components in one cabinet.
- Forced air cooling by fan.
- Gun lifting test facility.
- Chuck saver circuit fitted.
- Visual current and time display.
- Current and time reporting procedure.
- Mounted on 4 castors making the machine easily manoeuvrable.
- Recessed front and back panels protect controls and weld sockets.
- Twist and lock weld plugs and sockets.
- Handtool can use any European chucking system.

Please Note:

All Controllers are externally identical, compare and consider most suitable specification for your requirements.



SYSTEM 2200DA CONTROLLER FEATURES

Robust maneuverable Drawn Arc equipment designed to weld large studs up to 25mm in diameter. With their simple construction, this range of large equipment offers an economical and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate this range of heavy duty equipment gives you better weld results.

Designed and built to exacting standards and meets all required standards, this range of Drawn Arc studwelding equipment is CE marked.

Model 2700DA

Welding stud range:	= 6-25mm
Input voltage:	= 400
Fusing p:	= 125
Max. KVA rating:	= 120
Welding current:	= 400-2700
Welding time:	= 100-1500
Weld rate:	= 8 at 22mm (pieces / minute)
No-load voltage:	= 95
Class protection:	= IP23
Cooling:	= Fan
Transformer Ins. Class:	= H
Dimension L x W x H:	= 200 x 720 x 900mm
Controller weight:	= 515kg

- Microcomputer controlled.
- Infinitely adjustable welding current.
- Constant current control.
- Infinitely adjustable welding time.
- Solid state switching.
- Robust and compact design housing all components in one cabinet.
- Forced air cooling by fan.
- Gun lifting test facility.
- Chuck saver circuit fitted.
- Visual current and time display.
- Current and time reporting procedure.
- Mounted on 4 castors making the machine easily manoeuvrable.
- Recessed front and back panels protect controls and weld sockets.

Please Note:

All Controllers are externally identical, compare and consider most suitable specification for your requirements.



Robust maneuverable Drawn Arc equipment designed to weld large studs up to 25mm in diameter. With their simple construction, this range of large equipment offers an economical and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate this range of heavy duty equipment gives you better weld results.

Designed and built to exacting standards and meets all required standards, this range of Drawn Arc studwelding equipment is CE marked.

Hand tool Features – DA2

Welding range	3mm – 16mm Full Base
Stud length range - with standard legs - with extended legs	100mm Any length stud Any length stud
Weight (less cable)	1.9kg
Cable length	5 metres
Dimensions L x W x H	240 x 55 x 155mm

- Designed for lightness and balance.
- Comfortable to use, minimises operator fatigue.
- Made from impact resistant, high strength Verton.
- Accessories – various accessories and attachments are available to solve specific problems.
- Extensions are available for both hand tool and earth cables



DA 2 Drawn Arc Hand Tool

Used in the majority of DA stud welding applications
Ideal for welding studs 6-16mm diameter
This is a ring lift hand tool and is supplied fully damped for better weld control.

Specially designed shaft improves alignment and minimises play. Accuracy of +/- 0.5mm can be achieved using quality jigging systems.

Model	DA3
Welding range	3mm – 20mm
Stud length range - with standard legs - with extended legs	100mm Any length stud
Weight (less cable)	2kg
Cable length	5 metres
Cable size	70mm ²
Dimensions L x W x H	250 x 70 x 260mm
Under Sling length	n/a

- Designed for lightness and balance.
- Comfortable to use, minimises operator fatigue.
- Made from impact resistant, high strength Verton.
- Accessories – various accessories and attachments are available to solve specific problems.
- Extensions are available for both hand tool and earth cables



DA 3 Drawn Arc Hand Tool

Used in the majority of DA stud welding applications
Ideal for welding studs 3 - 20mm diameter
This is a ring lift hand tool and is supplied fully damped for better weld control.

Specially designed shaft improves alignment and minimises play. Accuracy of +/- 0.5mm can be achieved using quality jiggling systems.

Model	DA 4
Welding range	6mm – 25mm
Stud length range	
- with standard legs	100mm
- with extended legs	Any length stud
Weight (less cable)	2kg
Cable length	5 metres
Cable size	DA4 - 70mm ² DA5 - 95mm ² DA6 - 120mm ²
Dimensions L x W x H	250 x 70 x 260mm
Under Sling length	100mm

- Designed for lightness and balance.
- Comfortable to use, minimises operator fatigue.
- Made from impact resistant, high strength Verton.
- Accessories – various accessories and attachments are available to solve specific problems.
- Extensions are available for both hand tool and earth cables



DA 4 Drawn Arc Hand Tool

Used in the majority of DA stud welding applications
 Ideal for welding studs 6-25mm diameter

This is a ring lift hand tool and is supplied fully damped for better weld control.

DA 8 Drawn Arc Hand Tool



Lightweight small fixed mini pistol.
Used to weld Short Cycle studs.
Possible to weld up to 12mm standard Drawn Arc.
Supplied to weld with gas if required.

All DA handtools are designed for lightness, balance, comfort and are easy to use thereby minimising operator fatigue.

The 751 DA (Short Cycle) Equipment

Compact design, houses all components in one cabinet.

- Strong and reliable construction yet easily movable.
- Soak tested components used.
- All systems undergo extensive durability tests.
- Uniform loading of 3 phase supply.
- Infinitely variable time control.
- Short time facility available.
- Adjustable 5 step weld current control.
- Gas optional.
- Thermostatically controlled air cooling.
- Recessed front panel protects controls.
- Recessed front panel protects weld sockets.
- Twist and lock weld plugs and sockets.
- Gun lift test facility.

The 501 and 750 Series of Short Cycle Equipment can be fitted with any of the DA Handtools. *In Short Cycle mode the equipment uses the DA 8 Mini Pistol*



[Click Here:-HANDTOOLS](#)

UNIVERSAL STUD FEEDER UNIT FEATURES

- Designed to automatically feed studs into the automatic pistol.
- Easily adjustable for different sizes of stud.
- Operating range - M3 to M8 as standard. Other diameters possible.
- Operating stud length - 6mm to 35mm as standard. Other lengths possible.
- Speed - up to 40 studs / minute.
- Size : 380 x 280 x 410mm.
- Weight : 38kg.



- 2 Axis Machine.
- Full automatic stud feed via bowl feed mechanism.
- Patented "In Line " feed system.
- Accuracy +/- 0.15mm.
- Productivity with versatil
- Built to high quality standards.
- Fully automatic welding of studs from 3mm - 10mm diameter
- and in lengths from 6mm - 35mm.
- Fast and highly economic method of stud welding
- Easy programming and "quick change" facilities.
- Ideal for both long and short production runs.
- Manufactured to meet specific production line requirements.
- Welds a number of components simultaneously.
- Can be programmed off-line from any suitable computer system.
- Available with component delivery and exit systems.
- Level of accuracy better than +/- 0.15mm.
- Automatic doors, light guards and soundproofing.
- Up to 4 welding heads per system.
- Dual controllers increase weld speeds.
- Welding rates of up to 60 studs/minute maximum.
- Systems will shut down if welding process is interrupted.
- Available with stepper or servo driven motors depending upon level of accuracy and the speed a customer requires.

CNC Systems custom designed to suit your needs.



THE CNC RANGE

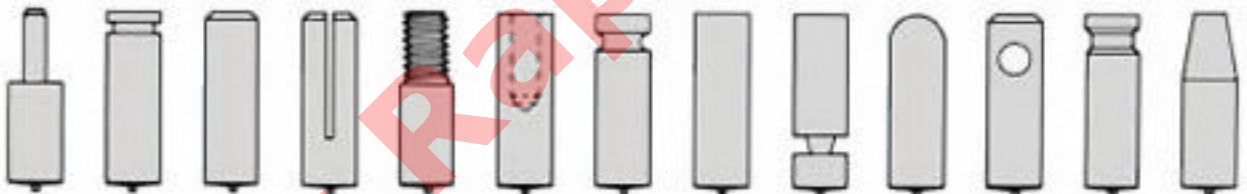
Built to high quality standard, the CNC controlled automatic stud feed production unit is a fast and economic method of studwelding.

- Easy programming and a quick change system make it ideal for both long and short production runs.
- Construction - Rigid open Aluminium frame with "T" slot profile
- Fitted with linear encoders to give high positional accuracy (Servo systems only)
- Fully guarded.
- Available with either PC or PLC control.
- Supplied with heavy duty Servo or Stepper motors to suit customer requirements.
- Accuracy better than $\pm 0.15\text{mm}$.
- Up to 4 axis systems available.
- Weld areas up to 3000 x 2000mm.
- Systems will weld threaded, unthreaded and internally threaded studs in Mild Steel, Stainless Steel, Aluminium Alloy and Brass from M3 to M8 diameter and 6mm to 35mm length as standard. Other diameters and lengths available.



We have wide variety stud types & configuration available and can also manufacture to customer specifications

								
De-Flanged CD Studs	Threaded CD Studs	CD Plain Pins	Insulation CD Nail	Tapped CD Bosses	CD Tags & Brackets	CD Chucks	DA Tapped Bosses	Shear Connectors
								
Threaded DA Studs	Rectangular DA Studs	DA Plain Pins	BI Metallic Pins	Drawn Arc Chucks	Foot Adaptors	Ferrule Grips	Speedfix Washers	Cuphead Pins



We also manufacture "specials" to customer requirements.



Drawn Arc Studs

As a distributor of selected quality products, we are able to respond to the most urgent requirements of our customers, offering not only Standard Weld Studs but also Special Design Studs & Fasteners. In an emergency, you will find our service is second to none. We offer technical advice and pre-production samples.



Mild Steel DA Weld Studs are manufactured from high quality weldable grade Carbon Steels, with certification available on request.

All threads are mid rolled, ensuring that the flow line of the material is not interrupted. The surface quality is considerably improved, and the strength doubled. In addition, the thread offers better resistance in terms of both contusion and wear. Metric thread forms comply with BS3643 pt2. Medium fit 6G.

In bar form, the material has strength designation of 4.7 rot BS6392. The U.T.S. increases slightly after thread rolling. Stainless Steel conforms to BS970 part 3 - either 316S11 or 304S11, depending on requirements.

All Drawn Arc Weld Studs are fluxed. The type and amount used is an essential factor in ensuring consistent and high quality welds. DA Weld Studs feature a pointed flux ball. This aids accurate and swift location of the stud to the parent material. Suitable ceramic ferrules are included with all Drawn Arc Studs.

Sizes range from M4 up to M30, in either self-colour or anti-corrosion plate (including Zinc, Copper, Nickel plate and Galvanisation).

"Tapped Bosses" are available with internal threads ranging from M3, through to M20

As with our Standard Drawn Arc Studs, Bosses and Plain Studs are available as self-colour or plated. Range includes sizes between 3mm and 8mm diameter, threaded or plain.

Available in a range of materials including Mild & Stainless Steels.



Some of the many Add-On's, Accessories and Spares Available to compliment your Studwelding System



DA Handtool Slide
and Foot Adaptors



Centre Jig for CD Chucks



Tool Kit



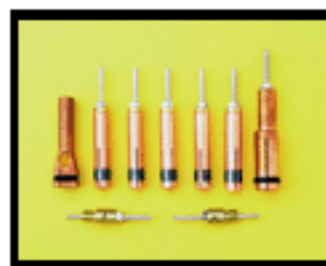
Gas Nozzle



Various Size DA Chucks.



Cable & Panel Connecting
Plugs & Sockets



Various Size CD Chucks



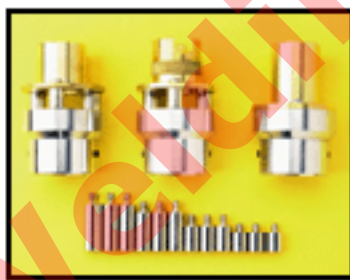
Front End Cap 22mm
Split Nose Cone

Part of the many Accessories and Adaptors designed to assist clients overcome production requirements which may fall outside the scope of standard equipment.

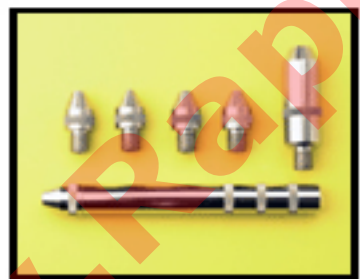
Accessories, Add-On's and Consumables



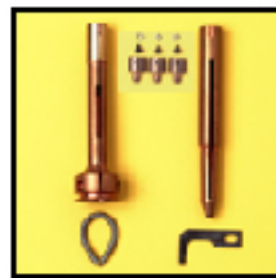
Assorted Cable and Panel Plugs & Sockets



Front End Caps with Various Nose Cones



Weld Test Bending Bar with Nozzles



Automatic Chucking System

Although all Accessories are designed to fit the our TAYLORMADE Equipment, most can be adapted to fit other makes.

Please call our office if you need further information