

KHA-200F ▪ KKA-200F ▪ KHA-50 ▪ KKA-50

Automatic stud welding heads for capacitor discharge (contact and gap method), short cycle and drawn arc stud welding

- welding range: \varnothing 2-12 mm
- welding materials: steel, stainless steel, aluminium, brass
- highest stud positioning accuracy and welding reproducibility
- highest operational reliability, excellent welding quality
- quick and simple retooling
- new quick-change system for changing welding heads quickly
- individually adaptable for different welding tasks
- simple handling
- suitable for semi-automatic (manual stud feeding) and automatic use (automatic stud feeding by stud feeding system VBZ)
- automatic transport of studs from loading tube into chuck
- can be used on CNC stud welding machines, roboters, handling systems, stationary machining centres and conventional stud welding units
- high service life through high-grade mechanical components
- robust housing as protection against welding spatters and dirt
- precision guidance protected from welding spatters
- connections pluggable (for quick assembly and easy maintenance)
- welding and control cable can be easily accessed for service
- compact dimensions
- low weight (can be used on light robots and bearing systems)



Technical Data

	KHA-200F	KKA-200F	KHA-50	KKA-50
Welding range (other Ø on inquiry)	Ø 2-12 mm	Ø 2-10 mm	Ø 2-8 mm	Ø 2-8 mm
Welding material	steel, stainless steel, aluminum, brass	steel, stainless steel	steel, stainless steel, aluminum, brass	steel, stainless steel
Stud length (other lengths on inquiry)	8-40 mm	8-40 mm	8-30 mm	8-30 mm
Welding methods (acc. to DIN EN ISO 14555)	capacitor discharge (gap method), short cycle, drawn arc	capacitor discharge (contact method)	capacitor discharge (gap method), short cycle, drawn arc	capacitor discharge (contact method)
Characteristics	<ul style="list-style-type: none"> ▪ lift adjustable ▪ lift display ▪ zero-play ball linear bearing for guiding the welding piston ▪ slim design ▪ CE conformity 	<ul style="list-style-type: none"> ▪ spring pressure continuously adjustable ▪ spring pressure display ▪ zero-play ball linear bearing for guiding the welding piston ▪ very well suited for welding on problematic surfaces (e.g. zinc, tinder) ▪ slim design ▪ CE conformity 	<ul style="list-style-type: none"> ▪ lift adjustable ▪ precise slide-bearing guide of welding piston ▪ CE conformity 	<ul style="list-style-type: none"> ▪ spring pressure continuously adjustable ▪ precise slide-bearing guide of welding piston ▪ very well suited for welding on problematic surfaces (e.g. zinc, tinder) ▪ CE conformity
Options	<ul style="list-style-type: none"> ▪ centring device for very precise stud positioning ▪ inert gas device ▪ adaptation to special welding elements ▪ automatic length compensation system (Liftcontrol) for the adjustment to unevenness in workpieces and for welding different stud lengths without retooling (only KHA-50) 			
Dimensions (WxHxL)	50x385x110 mm	50x385x110 mm	80x160x300 mm	80x160x300 mm
Weight	2,2 kg	2,2 kg	2 kg	2 kg
Compressed-air supply	6 bar	6 bar	6 bar	6 bar
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