

## Cutlass Fasteners, Inc.

83 Vermont Ave., Unit 6, Warwick, RI 02888

Tel: (401) 732-6333 Fax: (401) 732-6336

cutlass-studwelding.com

### Stud Welding...

- Fasteners
- Equipment
- Service

## PHA-500 & PKA-500 AUTOMATIC STUD WELDING HAND GUNS



### PHA-500

CD (Gap)  
Short Cycle  
Drawn Arc



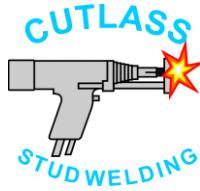
### PKA-500

CD (Contact)

For automatic stud welding, Cutlass offers two handguns, the PHA-500 and PKA-500. The PHA-500 may be used in Capacitor Discharge Gap, Drawn Arc, or Short Cycle mode, while the PKA-500 offers continuously adjustable spring pressure and proficiency in Capacitor Discharge Contact welding on problematic surfaces.

### Standard features include:

- ◆ highest stud positioning accuracy through precise slide-bearing guide of gun spindle
- ◆ highest operational reliability, excellent welding quality
- ◆ quick and simple retooling
- ◆ 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 weld chuck
- ◆ high service life through high-grade mechanical components
- ◆ ergonomic design
- ◆ robust housing made from impact resistant, full-insulating plastics
- ◆ welding and control cable as well as pneumatic connections protected by special hose
- ◆ precision guide bush protected from welding spatters
- ◆ welding and control cable as well as pneumatic connections easily accessible for service
- ◆ low weight, compact construction (can be operated in hard-to-access places)



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## PHA-500 & PKA-500 AUTOMATIC STUD WELDING HAND GUNS

### TECHNICAL DATA

	PHA-500	PKA-500
<b>Welding Range</b> (other Ø on inquiry)	Ø 1/8" - 5/16" (3mm - 8mm)	Ø 1/8" - 5/16" (3mm - 8mm)
<b>Welding Material</b>	steel, stainless steel, aluminum, brass	steel, stainless steel
<b>Stud Length</b> (other lengths on inquiry)	5/16" - 1.3/16" (8mm - 30mm)	5/16" - 1.3/16" (8mm - 30mm)
<b>Welding Methods</b> (acc. to DIN EN ISO 14555)	capacitor discharge (gap method), short cycle, drawn arc	capacitor discharge (contact method)
<b>Characteristics</b>	<ul style="list-style-type: none"> <li>◆ lift adjustable</li> <li>◆ precise slide-bearing guide of welding spindle</li> <li>◆ CE conformity</li> </ul>	<ul style="list-style-type: none"> <li>◆ spring pressure continuously adjustable</li> <li>◆ precise slide-bearing guide of welding spindle</li> <li>◆ very well suited for welding on problematic surfaces (e.g. zinc, tinder)</li> <li>◆ CE conformity</li> </ul>
<b>Options</b>	<ul style="list-style-type: none"> <li>◆ centering device for very precise stud positioning</li> <li>◆ inert gas device</li> <li>◆ adaptation to special welding elements</li> <li>◆ automatic length compensation system (Liftcontrol) for the adjustment to unevenness in workpieces and for welding different stud lengths without retooling (PHA-500 only)</li> </ul>	
<b>Welding Cable</b>	10' (3m) highly flexible, #4 (25mm <sup>2</sup> )	20' (6.5) highly flexible, #4 (25mm <sup>2</sup> )
<b>Dimensions</b> (W x H x L)	2.23/64" x 6.49/64" x 11.27/64" (60mm x 172mm x 290mm)	2.23/64" x 6.49/64" x 9.1/32" (60mm x 172mm x 235mm)
<b>Weight</b>	3.5lbs (1.6kg)	2.4lbs (1.1kg)
<b>Part Number</b>	90-10-4013	90-10-4021

### STUD WELDING is our BUSINESS.

We manufacture and stock over **8 million** weld studs and distribute a complete range of CAPACITOR DISCHARGE, SHORT CYCLE and DRAWN ARC stud welding products.

For additional information call Cutlass toll free on **1-800-536-6333**

Cutlass reserve the right to improve designs and/or change technical specifications without prior notice.

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