



CNC STUD WELDING MACHINE F400

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F400
Approv. Dir.
CERTIFIED COMPANY QUALITY SYSTEM
UNI EN ISO 9001:2008 REG.3023-A

CNC stud welding machine F 400



The cost-effective entry-level model.

- working area X/Y (mm): 400 x 400
- fast and easy operation and programming by control integrated in the frame and operating software i1stud
- optional: control by operating terminal with industrial panel PC and operating software i3stud (inkl. DXF data converter)
- integrated welding parameter monitoring (optional: welding parameter memory)
- housing with door or light curtain
- compact and intelligent drive engineering
- robust and warp resistant welded steel machine frame
- optional: robust welded steel underframe with undershelf
- suitable for all stud welding methods

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with robust underframe (optional)

Suitable stud welding components

Stud welding units series PRO-C and PRO-D



Automatic stud welding heads KHA-200F and KKA-200F, automatic stud feeder VBZ





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- Technical data and characteristics -

	F 400
Working area X/Y (mm)	400 400
Welding range¹⁾	
Stud diameter (Ø)	3-8
Stud length (mm)	6-50
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	
- Software i1stud - compact control Xemo R integrated in the frame	x
- software i3stud (incl. DXF data converter) - operating terminal with industrial panel PC - control Xemo M	o
Welding parameter monitoring²⁾	
Welding parameter monitoring	x
Welding parameter memory with USB-interface for data transmission to a PC	o
PRO-xDataLog software for real-time transmission of the welding parameter sets recorded by the stud welding unit to a PC	o
Automatic stud feeding	x
Options	
Fluid spraying device for the 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 mounted on welding head	o
Pneumatic mass clamps mounted on welding head	o
Workpiece downholder for the welding head	o
Shielding gas module for the welding head	o
Robust welded steel underframe	o
Protection devices	
Housing with door ³⁾	x
Housing with light curtain	o
Motor technology/drive	
Servo motors	x
Pneumatic working lift/welding head (mm) (mechanic adjusting range 40 mm)	80



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Machine frame	
Welded steel construction	x
Suitable stud welding units⁴⁾	
PRO-C 1000	x
PRO-C 1500	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 unolied, dry, clean

x - Standard

o - Option

¹⁾Other diameters and lengths as well as special welding elements upon request as special production.

²⁾By stud welding units PRO-C/PRO-D. For further details see product data sheet **stud welding units - capacitor discharge stud welding** and **stud welding units - drawn arc stud welding** as well as product data sheet **welding parameter memory PRO-x and PRO-xDataLog**.

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-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)



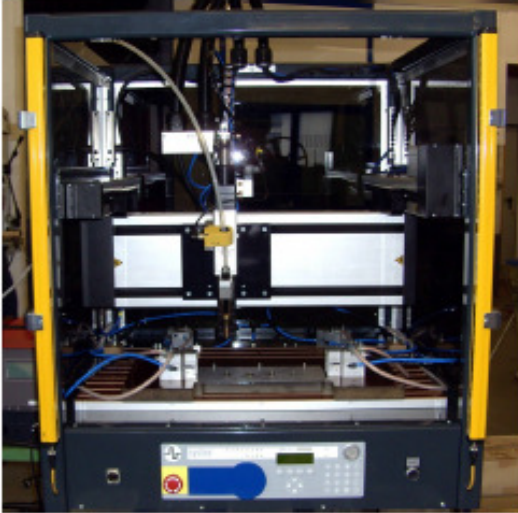
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- Examples for options and accessories -



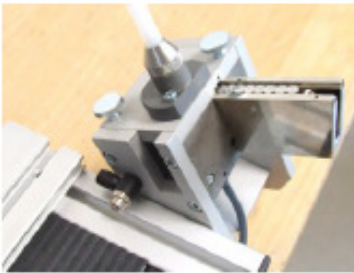
housing with light curtain



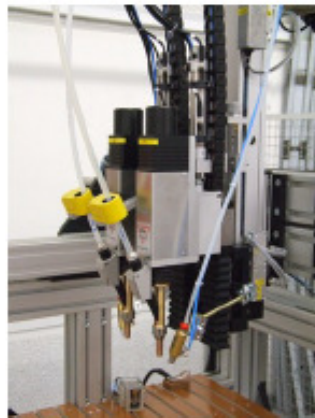
fluid spraying device
for automatic stud welding head



operating terminal with
industrial panel PC and
software i3stud (with
DXF data converter)



pneumatic single stud feeding
through manual insertion



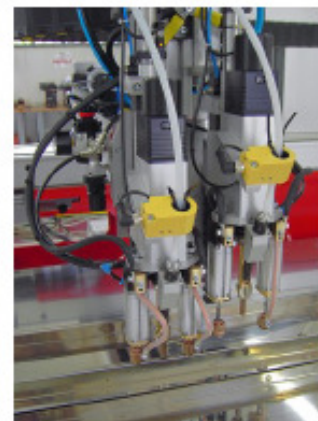
pneumatic working lift
AHP-080



pneumatic mass clamp
aperture angle 90°



pneumatic mass clamp standard



grounding by pneumatic
mass clamps mounted on
welding head