



PKA-500 PHA-500 PHA-500-6

STUD WELDING



PHA-500-6
AUTOMATIC STUD WELDING GUN
FOR SHORT CYCLE AND
DRAWN ARC STUD WELDING



PKA-500
AUTOMATIC STUD WELDING GUN
FOR CAPACITOR DISCHARGE
STUD WELDING
(CONTACT METHOD)



PHA-500
AUTOMATIC STUD WELDING GUN FOR CAPACITOR
DISCHARGE, SHORT CYCLE
AND DRAWN ARC STUD
WELDING

INTEGRATED TRAVEL MEASURING SYSTEM



- » MEASURING OF STUD PROTRUSION BEFORE THE WELD AS WELL AS STUD TRAVEL (LIFT, IMMERSION DEPTH, IMMERSION SPEED AND SHORT-CIRCUIT TIME) DURING THE WELD
- » MEASURED VALUES ARE SHOWN IN THE DISPLAY OF THE STUD WELDING UNIT*

*Only in connection with series PRO-I, PRO-D, PRO-S and PRO-C units.



» ADVANTAGES:

MONITORING OF WELDING QUALITY

- » Comparison of actual values to set values for each weld
→ in case of variances a warning is displayed or the unit is locked for further welds
- » storage of the last ten welding parameter sets in the stud welding unit
optional: welding parameter memory for 24500 welding parameter sets



COMFORTABLE, EXACT AND FAST ADJUSTING OF AUTOMATIC WELDING GUN

- » Correctly adjusted stud protrusion and lift are key factors for a high-quality stud weld.
→ As the adjusted values are shown in the display of the unit time-consuming manual measuring is no longer necessary.

TECHNICAL DATA AND CHARACTERISTICS

	PKA-500	PHA-500	PHA-500-6
Welding method			
Capacitor discharge (contact)	x		
Capacitor discharge (gap)		x	
Short cycle		x	x
Drawn arc		x	x
Welding range (Ø mm)¹⁾			
Capacitor discharge (contact)	3-8		
Capacitor discharge (gap)		3-8	
Short cycle		3-8	3-8
Drawn arc		3-8	3-8
Welding material			
Steel	x	x	x
Stainless steel	x	x	x
Aluminium		x	
Brass		x	
Stud feeding			
automatic	x	x	x
semi-automatic (manual insertion)	x	x	x
Spring pressure adjustable	x		
Lift adjustable		x	x
Integrated travel measuring system		o	
Automatic length compensation			x
Piston guide			
Slide-bearing	x	x	x
Welding cable			
-cross-section (mm ²)	25	25	25
-length (m)	6,5	3	5
Control cable plug	7-pin	7-pin (12-pin ²⁾)	7-pin
Housing from impact resistant plastics	x	x	x
Protection of piston guidance from welding spatters	x	x	x
Dimensions			
Width (mm)	60	60	60
Height (mm)	172	172	172
Length (mm)	235	290	335
Weight without cable (kg)	1,1	1,6	1,7

x – Standard, o – Option

¹⁾ Other diameters on request.

²⁾ with integrated travel measuring system



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