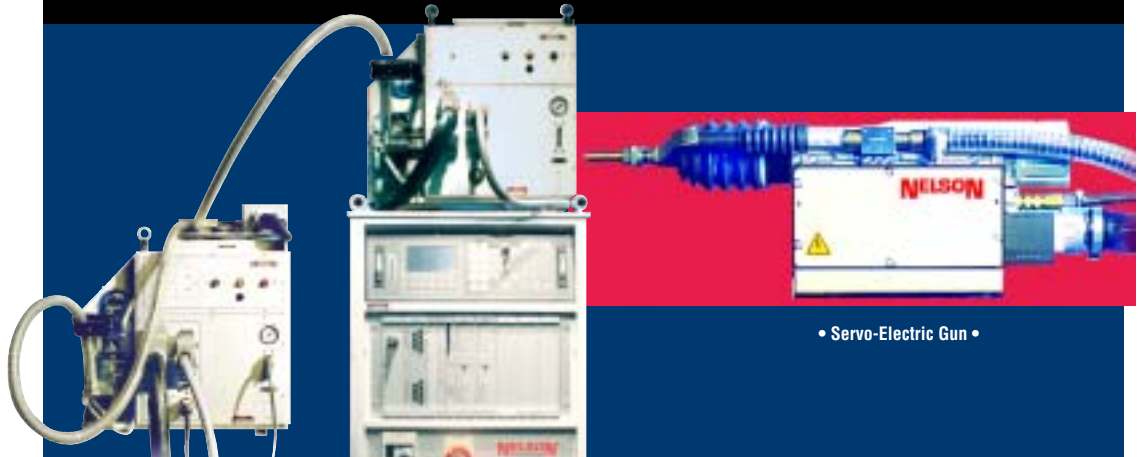


Nelson Servo-Electric
Stud Welding System

KSE 100



• Servo-Electric Gun •

Nelson Servo-Electric Stud Welding System eliminates the need for a stop pin, resulting in increased application speed, improved access to tight weld locations, better weld consistency, and more accurate stud placement.

A position feedback system and servo-electric drive in the weld gun precisely controls arc length, lift and plunge velocity, and depth penetration of each stud weld. The KSE100 servo-operated weld gun is designed for all common stud types from 3mm to 8mm shank diameter. Set-up and maintenance are simplified with the elimination of the stand-off pin and the reduction in the number of weld gun components.

The KSE100 system also features a fully programmable *pulse-welding mode* to enhance welding of aluminum studs. This pulse-welding mode produces a square-wave that alternates between two weld current amplitudes.

KSE100 Specifications

General:

Stud Range	ø3mm to ø14mm weld base
Input voltage	400/460/480/575V 3 Phase
Power drop rating	60A
Cabinet size	590mm W x 590mm D x 1,210mm (23" W x 23" D x 48" H)
Weld controller weight	340 Kg (750 Lb) approximately
Lift settings	0.5mm to 5.0mm in steps of 0.1mm
Plunge settings	0.2mm to 5.0mm in steps of 0.1mm

Standard weld mode:

Weld current settings	300A to 1500A in steps of 10A
Weld time settings	6mS to 100mS in steps of 1mS

Pulse weld mode:

Number of pulses	2 to 20 in steps of 1
Even numbered pulse current	100A to 1500A in steps of 10A
Even numbered pulse time	1mS to 30mS in steps of 1mS
Odd numbered pulse current	100A to 1500A in steps of 10A
Odd numbered pulse time	1mS to 30mS in steps of 1mS

Features & Benefits

- Better access to tight weld locations
- Reduced set-up time
- Precise servo-control gun shaft positioning
- Available closed-loop stud feeding
- Pulse-welding mode feature for aluminum
- Simplified maintenance with elimination of stand-off pin and pneumatic slide
- Consistency and accuracy

NELSON
STUD WELDING

7900 West Ridge Road, Elyria, OH 44036-2019
Telephone: 800.635.9353 • Fax: 440.329.0492
Web: www.NelsonStudWelding.com
e-mail: Nelson.Sales@NelsonStud.com