

AS 1200 made in Germany



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Bolzenschweissen

your new next generation stud welder.
with maximum expansion* to 3.2 kW the most powerful unit on the market

ü scalable for any application

- robust front panel design
- extended voltage range up to 220VDC for even more power reserve
- up to 15.000 amps !
- graphical operator display
- daily or job counter
- easy-Setup parameter database with 16 individual USER memory locations
- dirt-repellent Easy Touch operating keys for industrial use
- 33-132mF switchable capacitor power can be optimized for your application
- High welding sequence: 1 sec per weld (M3) - 4 sec per weld (M8) **30% time saving**
- robust 13mm welding cable connections as standard
- compatible with common welding guns (AS 1801-AS1804, AS1811)
- extremely short welding times 0.5-4ms depending on the gun for lowest backside marks
- low power-to-weight ratio
- full temperature monitoring of inverter and thyristor for reliable protection
- switchable capacitance levels, 33/99mF, optional 66/99mF or 66/132mF for even more power reserve.
- optional weld data monitoring
- optional CNC Ready with AS Unibus interface (presetting of welding data from CNC)
- optional automatic control of automatic stud feeder and feed gun

*132mF at 220V

heavy duty
Inverter



contact gun



Auto-Lift gun



mico gun

CD

all procedures!

- ü capacitor discharge contact welding
- ü capacitor discharge gap welding



Ref:10

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220V load voltage for more power

clear usable graphic display

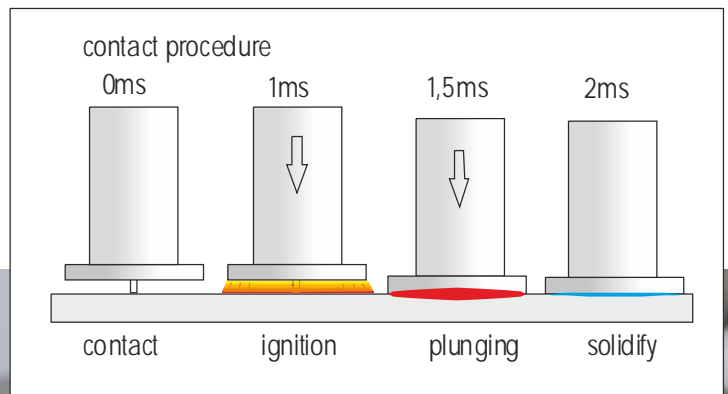


Easy Touch gloves usable

up to 50% energie saving by capacity switching



feeder interface



technical data:

- Ü99mF 33/99 switchable, optional 66/99
- Üload voltage 40-220V DC
- Ümains: 230V AC 50Hz
- Ütemperature controlled fan

weldrange on base of used gun

- mild/stainless steel: Ø2-8, 10mm depends on appl.
- aluminium : Ø2-6, 8mm depends on appl.
- brass : Ø2-8

- ÜM3: 40 studs/min. in steady use
- ÜM8: 15 studs/min. in steady use
- short term higher speed possible

weight: 14,8kg

dimension: DxWxH 420x240x280mm



Order numbers:

AS1200	33/99mF switchable :	191 21 200
AS1200V	66/132mF switchable :	191 21 281
AS1200CNC	33/99mF switchable :	191 21 282
AS1200AT	33/99mF switchable :	191 21 283

Options:

Capacity expansion to 132mF:	191 21 290
auto feeder control:	191 21 291
CNC interface:	191 21 292
weld data monitoring:	191 21 293

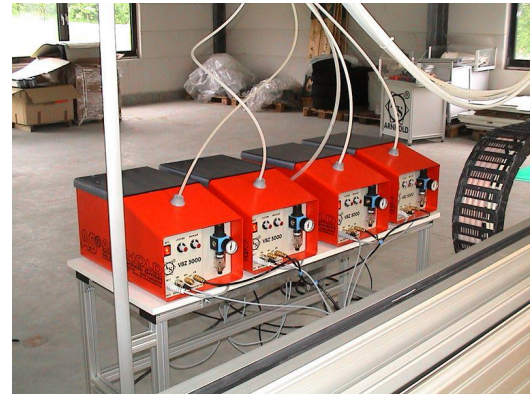
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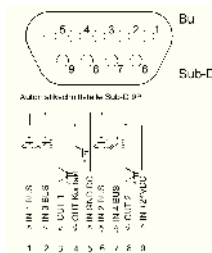
automated feeding interface (can be added):

The feeding interface allows the use of a fully automatic stud feeder. The automatic stud welding gun is usually provided suspended above the workstation by a balancer. This enables the operator to work quickly and with low fatigue in maximum cycle times. The positioning of Hand-guided automatic guns is usually carried out using templates. For the control of an automatic gun, plunger and magnet can be controlled reliably. Parameters such as feed time for different stud sizes can be optimized by the user. For the control of a feeding device the signals "push" and "blow" are available at a 5-pin connector at the rear.



CNC interface (can be added):

With the AS CNC interface, you can now have the stored user welding parameters automatically selected by the higher-level control. With this feature it is now possible to react different workpiece conditions without having to manually adjust the welding data. For this purpose, a bit pattern is transmitted via the 4-bit bus. This universal interface can be implemented on almost any PLC or CNC. Bus connections such as Ethercat, Profibus, etc. are available on request. Additional outputs like "workpiece contact", "finished" and "error" can be evaluated by the control.



Weld data monitoring (can be added):

The welding data monitoring gives the possibility to monitor the welding process 100% in the running production and to react on errors. For this purpose, the welding current, welding voltage and, in the case of equipped guns, the stud travel are recorded, compared with a "good weld" and the result is finally recorded on an SD card. You can select whether the operator must acknowledge an error or whether it is only displayed. In this case, the current values are output to SD, and a note in which range the deviation occurred. 100% logged. Later you have the used data ready to hand for your customer at any time.

