CEREST
Ingénierie Industrielle - Machines spéciales



Stud welding machine

with automatic loader

Mechanical engineering **Realizations** **Cabling** **Machines**

This machine **allows the resistance welding of 6 studs** on a part of revolution.

Each stud is welded individually **to ensure the correct current flow and thus guarantee the quality of the product.**

An automatic loader feeds the top electrode one by one.

This loader is itself fed by a tray equipped with a separator. This solution replaces the much more expensive vibrating bowl principle.

The feeder is easily adjusted in **all 3 directions by millimetre adjustment** and compensates for electrode wear.

The magazine can hold up **to 36 studs**, which allows a significant production flexibility.

A semi-automatic mode allows manual loading of the electrode in the event of a feed system failure or the **recovery of a failed stud.**

The orientation of the bottom at the beginning of the cycle is ensured by a positioning fork which takes as a reference 2 previously welded tubes.

The 60° spacing between each stud is guaranteed by the use of **a fast and precise mechanical indexer**.

The whole system is enclosed in a **light curtain** enclosure and controlled by a **SIEMENS PLC** with a **touch screen**.

A **cooling control** allows an optimal operation of the welding part.

SPECIFICATIONS :

- **Repeatable machine cycle time of 22s/part**
- **Welding force up to 1380 daN**
- **Welding current up to 63 kA**

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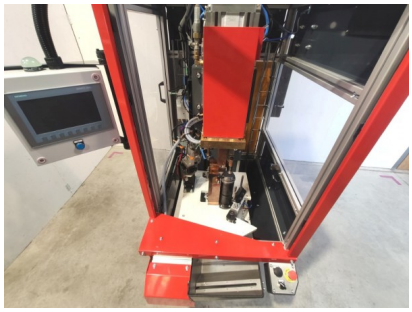

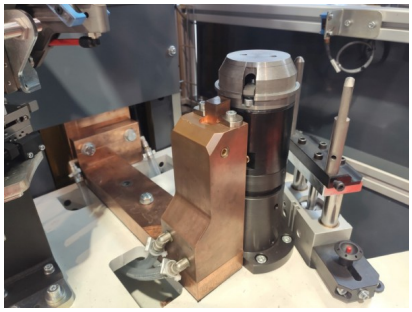

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