

STUDWELDING EQUIPMENT

Drawn Arc from 400Amp to 5000 Amp (Ø1 to 50 mm)
CAPACITOR DISCHARGE UP TO M10



DABOTEK

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TSK 310



TSG 310-H

TS306

Compact Capacitor Discharge Stud Welder after DIN 32500.

Working Area.

The maximum flexibility in use, are assured by an Inverter charging through a Microprocessor, which guarantees a fast and exact charging. The welding voltage can be adjusted by a potentiometer. The applicator adjusts itself to supply voltages of 110V to 220 VAC. LED's show unit ready for welding stud has contact with the steel and failure in the unit. Weight only 10 kg. Welding stud on mild steel, stainless, aluminium, copper and brass.

Welding pistol:

A small handy Welding pistol is delivered as a contact pistol, with pipe or three legs for accurate positioning. Extra: Gab pistol with pipe or three legs and adaptor for welding corners. Application for welding coppered head weld pin

Note:

BS 306 are without any change ready for both systems. The digital voltmeter indicates your working voltage, fast charging, inverter technology changes automatically between gab or contact pistol, the BS306 machine is getting air ventilation through a medical filter. With the Microprocessor control charging systems, BS306 is ready to work under big change in Power supply voltage.

TECHNICAL SPECIFICATIONS :

Application	: Contact pistol, (gab pistol can deliv.)
Power source	: Capacitor 44.000 uF
Welding time	: Ca. 3 mS.
Welding area	: M3 til M8.
Materials	: Steel, stainless-steel, aluminium, copper, brass
Welding speed	: min. 13 studs/min.
Power Supply	: 110-240 V AC, 50-100 Hz, 600VA.
Dimension (mm)	: H220, B 190, D430
Weight	: About 10 kg.

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TSK 310



TSG 310

BS310

Compact Capacitor Discharge Stud Welder after DIN 32501.

Working Area.

The maximum flexibility in use, is assured by an Inverter charging, which guaranties a fast and exact charging. Weight only 10 kg. Welding stud on mild steel, stainless steel, aluminium, cobber and brass up to 10 mm.

Welding pistol:

A small handy Welding pistol is delivered as a contact pistol with three legs for accurate positioning. Extra: Gap pistol with nose cone assembly or tripod leg assembly and adaptor for welding corners.

Note:

BS 310 equipment is without any change ready for both systems. The digital voltmeter indicates your working voltage, fast charging, inverter technics change automatically between gap or contact pistol, the BS310 machine is getting all air ventilation through a medical filter. With the inverter technics the charging system is ready to work under big change in Power supply voltage

TECHNICAL SPECIFICATIONS :

Application	: Contact pistol, (gap pistol can deliv.)
Power source	: Capacitor. 88.000 uF
Welding time	: Ca. 3 mS
Welding area	: M3 til M10
Materials	: Steel, stainless-steel, aluminium, cobber, brass
Welding speed	: min. 20 studs/min
Power Supply	: 110-240 V AC, 50-100 Hz, 600VA.
Dimension(mm)	: H220, B 190, D430
Weigth	: About 10 kg.

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DT 410

Compact equipment for drawn arc studwelding in accordance with DVS 0902

FIELD OF APPLICATION

Handy, heavy-duty studwelding equipment for universal use. Sturdy and compact; ideal for assembly work, since it only weighs 25 kg. Studwelding elements in accordance with DIN 32500 and DIN 32501; specially designed metal components made of alloy and non-alloy steel. Special concept for insulation and heat resistant work.

THE WELDING PISTOL

Ample possibilities for fitting out the welding pistol. Depending on the assignment, a dampened or undampened pistol is used that features columns, baseplate and ceramic holder, or columns, baseplate equipped for short-time welding, or a fixed, non-adjustable tube.

PLEASE NOTE:

Simple, reliable and service-friendly - optimum safety during welding by means of "instant shift" to current-free circuit on the machine in the case of operating faults - using LED display; thermally controlled fan.

TECHNICAL DATA:

Field of application	:.drawn arc.
Current source	:.transformer with rectifier.
Welding current	:.400 A.
Welding time	:.20-200 mS, infinitely variable
.Welding range	:.diameter 3- 8 mm..
Material	:.steel, stainless steel, heat-resistant steel.
Welding speed	:.depends on use; up to 20 studs/min..
Power connection	:.380 V, 50/60 Hz, 25 A.
Dimensions	:.195 x 265 x 390 (W x H x L).
Weight	:.25 kg

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DT 710

Compact stud welding unit for drawn arc stud welding BH 100/BH 10 according to DVS 0902

Applications

Handy, powerful stud welding unit for universal application, compact and robust, ideal for field use. Welding elements according to DIN 32500 and DIN 32501 and special metallic shaped parts of alloyed and unalloyed steel. As an option, the unit can be provided with an inert-gas control, so that no ferrule for welding is necessary.

Welding guns

Welding guns for specific applications. Depending on the particular application, damped or undamped guns with suitable ferrule support, inert-gas support or support for short-cycle welding and guns with or without automatic length compensation are used.

Features

Reliable, safe to operate and service-friendly, optimal safety when welding due to immediate isolation of the unit in the event of malfunction. Monitoring and indication of all important functions via LED displays. Digital display of preselected welding time, thermally controlled fan.

Technical data

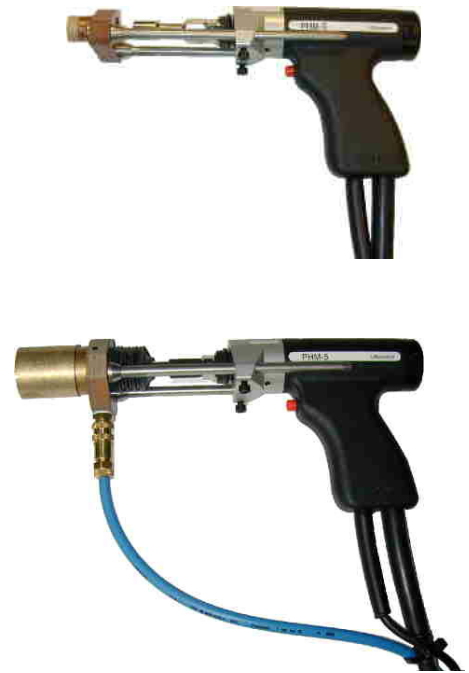
Welding process	: Drawn-arc ignition
Power source	: Transformer/Rectifier
Welding current	: 690 A
Welding time	: 6-960 ms, infinite
Welding range	: Dm. 2-12 mm, M 3-MR 14
Material	: Steel, stainless steel, heat resisting steel
Welding sequence	: Depending on application up to 25 studs per minute
Dimensions	: 275 x 220 x 430 (W x H x L)
Power requirement	: 380 V, 50/60 Hz, 32 A
Weight	: 37 kg.

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DT 910

Compact stud welding unit for drawn arc stud welding BH 100/BH 10 according to DVS 0902

Applications

Handy, powerful stud welding unit for universal application, compact and robust, ideal for field use. Welding elements according to DIN 32500 and DIN 32501 and special metallic shaped parts of alloyed and unalloyed steel. As an option, the unit can be provided with an inert-gas control, so that no ferrule for welding is necessary.

Welding guns

Welding guns for specific applications. Depending on the particular application, damped or undamped guns with suitable ferrule support, inert-gas support or support for short-cycle welding and guns with or without automatic length compensation are used.

Features

Reliable, safe to operate and service-friendly, optimal safety when welding due to immediate isolation of the unit in the event of malfunction. Monitoring and indication of all important functions via LED displays. Digital display of preselected welding time, thermally controlled fan.

Technical data

Welding process	: Drawn-arc ignition
Power source	: Transformer/Rectifier
Welding current	: 900 A
Welding time	: 6-960 ms, infinite
Welding range	: Dm. 2-14 mm, M 3-MR 16
Material	: Steel, stainless steel, heat resisting steel
Welding sequence	: Depending on application up to 25 studs per minute
Dimensions	: 275 x 220 x 430 (W x H x L)
Power requirement	: 380 V, 50/60 Hz, 32 A
Weight:	39 kg.

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DT 1200i – Inverter Power Source

Now includes Seahorse Corrosion Protection against humidity, moisture and dust.

The DT1200i product line is designed for use in harsh environments including construction shipbuilding, boiler manufacturing and equipment fabrication. Studhorse power sources weigh 80 pounds, feature a built-in circuit breaker, and provide 5-zones of thermal protection to make this machine ideal for companies and contractors using 400 ,480 or 575 Volts AC for primary power Designed for 1200A using 50 ft. 2/0 cable or 75 ft. of 4/0 cable.



Product Specifications are subject to change without notice. Visit the website for information on updates and changes. Additional information is available at www.dabotek.com

Benefits

- Lightweight, Portable
- Regulated Output
- Welds Wide Range of Sizes
- Reliable SCR Inverter
- Rugged Fiberglass Case
- • Pilot Current
- Kick Start
- After Burn
- Short-Circuit Protection
- High Power Efficiency
- 5-Zones of Thermal Protection

Features

- Drawn Arc Stud Welding at 1200 Amps
- Welds full-base Studs from 1/8" (3mm) to 3/4" (18mm)
- Complete systems available with gun and cables
- Digital Start/Stop replaces mechanical Contactor
- Bright, easy to read, panel-mounted digital display on DT1200i model
- Extra-thick skids on the bottom of the case for protection
- Step-less 0.05 to 1.00-second Time and Power Control
- DIGITAL METER - WELD CURRENT AND WELD TIME
- THERMOSTAT CONTROLLED VENTILATION
- **CIRCUIT BREAKER (POWER ON/OFF)**
- 400V, 480V, or 575V three-phase input voltage; 35/30/25A time-delay fusing



Product number: 93-60-1208

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DT 1200E

Compact manoeuvrable Drawn Arc equipment designed to weld up to M16 diameter studs. With its simple robust construction the DT1200E offers an economic and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate, the DT1200E gives you better weld results.

Designed and built to exacting standards and meets all required standards, the DT1200E is CE marked.

**Product number: SDT1200E-DA2 (with DA 2 welding gun)
SDT1200E-DA3 (with DA 3 welding gun)**



CONTROLLER FEATURES

- Robust and compact design housing all components in one cabinet.
 - Mounted on 4 wheels making the machine easily manoeuvrable (front 2 swivel wheels are fitted with brakes).
 - Soak tested components used. All systems undergo extensive durability tests.
 - Microcomputer controlled.
 - Infinitely adjustable welding current.
 - Constant current control.
 - Infinitely adjustable welding time.
 - Solid state switching.
 - Visual current and time display.
 - Current reporting procedure.
 - Thermostatically controlled air cooling.
 - Recessed front and back panels protect controls and weld sockets.
 - Twist and lock weld plugs and sockets.
 - Hand tool can use any UK and European chucking system.
 - Gun lift test facility.
 - Chuck saver circuit fitted.
 - Fitted with gas facility.
- Welds Short Cycle Drawn Arc.

DA2/DA3 HANDTOOL FEATURES

- Designed for lightness and balance.
- Comfortable to use, minimises operator fatigue.
- Made from impact resistant, high strength Verton.
- Accessories – Various accessories/attachments are available to solve specific problems.
- Extensions are available for both hand tool and earth cables.
- Damped with oil.

TECHNICAL SPECIFICATION	
Welding Stud Range	3mm – 14.6mm
Input	3ph. 400v 50Hz (other voltages available)
Fusing	65A
Max. KVA Rating	65KVA
Welding Current	200 – 1200 (10% cycle)
Welding Time	20 – 1500 (m/sec)
Welding Rate	20 – 3/min
No-load Voltage	95 Volt
Class Protection	IP23
Cooling Fan	
Transformer Insulation	Class H
Dimensions (L x W x H) (mm)	550 x 400 x 560
Weight	108 kg

Welding gun:	DA2	DA 3
Material	Verton	Verton
Welding Range	3mm – 16mm	3mm – 20mm
Stud Length -		
standard legs	100mm	100mm
extended legs	any length stud	any length stud
Cable Length	5 metres	5 metres
Cable Size	50mm	70mm
Weight (less cable)	1.9kg	1.9kg
Dimensions (L x W x H) (mm)	250 x 60 x 160	250 x 60 x 160



DA2 & DA3



DA4, DA5, DA6

DABOTEK Stud welding Systems is a specialist in the design, manufacture and supply of Stud welding Equipment and studs. Within our range of European built equipment we will have the system to suit your requirements.

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DT 1600E

Compact manoeuvrable Drawn Arc equipment designed to weld up to M20 diameter studs. With its simple robust construction the DT1600E offers an economic and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate, the DT1600E gives you better weld results.

Designed and built to exacting standards and meets all required standards, the DT1600E is CE marked.



**Product number: SDT1600E-DA2 (with DA 2 welding gun)
SDT1600E-DA3 (with DA 3 welding gun)**

CONTROLLER FEATURES

- Robust and compact design housing all components in one cabinet.
 - Mounted on 4 wheels making the machine easily manoeuvrable (front 2 swivel wheels are fitted with brakes).
 - Soak tested components used. All systems undergo extensive durability tests.
 - Microcomputer controlled.
 - Infinitely adjustable welding current.
 - Constant current control.
 - Infinitely adjustable welding time.
 - Solid state switching.
 - Visual current and time display.
 - Current reporting procedure.
 - Thermostatically controlled air cooling.
 - Recessed front and back panels protect controls and weld sockets.
 - Twist and lock weld plugs and sockets.
 - Hand tool can use any UK and European chucking system.
 - Gun lift test facility.
 - Chuck saver circuit fitted.
 - Fitted with gas facility.
- Welds Short Cycle Drawn Arc.

DA2/DA3 HANDTOOL FEATURES

- Designed for lightness and balance.
- Comfortable to use, minimises operator fatigue.
- Made from impact resistant, high strength Verton.
- Accessories – Various accessories/attachments are available to solve specific problems.
- Extensions are available for both hand tool and earth cables.
- Damped with oil.

TECHNICAL SPECIFICATION	
Welding Stud Range	3mm – 20,0mm
Input	3ph. 400v 50Hz (other voltages available)
Fusing	65A
Max. KVA Rating	65KVA
Welding Current	200 – 1600 (10% cycle)
Welding Time	20 – 1500 (m/sec)
Welding Rate	20 – 4/min
No-load Voltage	95 Volt
Class Protection	IP23
Cooling Fan	
Transformer Insulation	Class H
Dimensions (L x W x H) (mm)	810 x 470 x 620
Weight	151 kg

Welding gun:	DA2	DA 3
Material	Verton	Verton
Welding Range Stud Length -	3mm – 16mm	3mm – 20mm
standard legs	100mm	100mm
extended legs	any length stud	any length stud
Cable Length	5 metres	5 metres
Cable Size	50mm	70mm
Weight (less cable)	1.9kg	1.9kg
Dimensions (L x W x H) (mm)	250 x 60 x 160	250 x 60 x 160



DA2 & DA3



DA4, DA5, DA6

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DT 2000E

Compact manoeuvrable Drawn Arc equipment designed to weld up to 22 mm diameter studs. With its simple robust construction the DT2000E offers an economic and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate, the DT2000E gives you better weld results.

Designed and built to exacting standards and meets all required standards, the DT2000E is CE marked.



Product number: SDT2000E-DA3 (with DA3 welding gun)
SDT2000E-DA4 (with DA4 welding gun)
SDT2000E-DA5 (with DA5 welding gun)

CONTROLLER FEATURES

- Robust and compact design housing all components in one cabinet.
 - Mounted on 4 wheels making the machine easily manoeuvrable (front 2 swivel wheels are fitted with brakes).
 - Soak tested components used. All systems undergo extensive durability tests.
 - Microcomputer controlled.
 - Infinitely adjustable welding current.
 - Constant current control.
 - Infinitely adjustable welding time.
 - Solid state switching.
 - Visual current and time display.
 - Current reporting procedure.
 - Thermostatically controlled air cooling.
 - Recessed front and back panels protect controls and weld sockets.
 - Twist and lock weld plugs and sockets.
 - Hand tool can use any UK and European chucking system.
 - Gun lift test facility.
 - Chuck saver circuit fitted.
 - Fitted with gas facility.
- Welds Short Cycle Drawn Arc.

DA2/DA3 HANDTOOL FEATURES

- Designed for lightness and balance.
- Comfortable to use, minimises operator fatigue.
- Made from impact resistant, high strength Verton.
- Accessories – Various accessories/attachments are available to solve specific problems.
- Extensions are available for both hand tool and earth cables.
- Damped with oil.

TECHNICAL SPECIFICATION	
Welding Stud Range	3mm – 22mm
Input	3ph. 400v 50Hz (other voltages available)
Fusing	100A
Max. KVA Rating	85KVA
Welding Current	200 – 2000 (10% cycle)
Welding Time	50 – 1500 (m/sec)
Welding Rate	30 – 4/min
No-load Voltage	95 Volt
Class Protection	IP23
Cooling Fan	
Transformer Insulation	Class H
Dimensions (L x W x H) (mm)	1000 x 610 x 840
Weight	313 kg

Welding gun:	DA2	DA4 , DA5, DA6
Material	Verton	Verton
Welding Range Stud Length - standard legs	3mm – 16mm	3mm – 20mm
extended legs	100mm	100mm
	any length stud	any length stud
Cable Length	5 metres	5 metres
Cable Size	50mm	70mm ² - DA4 95mm ² - DA5 120mm ² - DA6
Weight (less cable)	1.9kg	1.9kg
Dimensions (L x W x H) (mm)	250 x 60 x 160	250 x 60 x 160



DA2 & DA3



DA4, DA5, DA6

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DT 2400E

Compact manoeuvrable Drawn Arc equipment designed to weld up to 25 mm diameter studs. With its simple robust construction the DT2400E offers an economic and reliable method of fixing Mild Steel and Stainless Steel studs. Fast, accurate and easy to operate, the DT2400E gives you better weld results.

Designed and built to exacting standards and meets all required standards, the DT2400E is CE marked.

**Product number: SDT2400E-DA4 (with DA4 welding gun)
SDT2400E-DA5 (with DA5 welding gun)
SDT2400E-DA6 (with DA6 welding gun)**



CONTROLLER FEATURES

- Robust and compact design housing all components in one cabinet.
 - Mounted on 4 wheels making the machine easily manoeuvrable (front 2 swivel wheels are fitted with brakes).
 - Soak tested components used. All systems undergo extensive durability tests.
 - Microcomputer controlled.
 - Infinitely adjustable welding current.
 - Constant current control.
 - Infinitely adjustable welding time.
 - Solid state switching.
 - Visual current and time display.
 - Current reporting procedure.
 - Thermostatically controlled air cooling.
 - Recessed front and back panels protect controls and weld sockets.
 - Twist and lock weld plugs and sockets.
 - Hand tool can use any UK and European chucking system.
 - Gun lift test facility.
 - Chuck saver circuit fitted.
 - Fitted with gas facility.
- Welds Short Cycle Drawn Arc.

DA2/DA3 HANDTOOL FEATURES

- Designed for lightness and balance.
- Comfortable to use, minimises operator fatigue.
- Made from impact resistant, high strength Verton.
- Accessories – Various accessories/attachments are available to solve specific problems.
- Extensions are available for both hand tool and earth cables.
- Damped with oil.

TECHNICAL SPECIFICATION	
Welding Stud Range	3mm – 25mm
Input	3ph. 400v 50Hz (other voltages available)
Fusing	125A
Max. KVA Rating	85KVA
Welding Current	200 – 2400 (10% cycle)
Welding Time	50 – 1500 (m/sec)
Welding Rate	30 – 6/min
No-load Voltage	95 Volt
Class Protection	IP23
Cooling Fan	
Transformer Insulation	Class H
Dimensions (L x W x H) (mm)	1000 x 610 x 840
Weight	385 kg

Welding gun:	DA3	DA4 , DA5, DA6
Material	Verton	Verton
Welding Range Stud Length -	3mm – 20mm	6mm – 25mm
standard legs	100mm	100mm
extended legs	any length stud	any length stud
Cable Length	5 metres	5 metres
Cable Size	70mm	70mm ² - DA4 95mm ² - DA5 120mm ² - DA6
Weight (less cable)	1.9kg	2,0kg
Dimensions (L x W x H) (mm)	250 x 60 x 160	250 x 70 x 260



DA2 & DA3

DA4 & DA5 & DA6

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CDK1 with supporting tube or legs CDK1S with legs assembly, (Old Name TSK310)

The compact stud welding gun CDK1 (TSK310 with legs or supporting tube) is designed for capacitor discharge stud welding (contact method). It guarantees optimum welding results and repeatability and is very easy to use. CDK1 or CDK1S stands out through its robust construction and high reliability. It is ergonomic design and low weight assures tireless working. A Linear ball bushing in the welding gun ensures high positioning accuracy. Easy conversion from supporting tube to legs. A large range of supporting tubes and legs makes it easy to create templates for welding of studs. See accessories.

- Very well suited for welding on problematic surfaces (e.g. zinc, tinder).
- Spring pressure adjustable. Turning the cab back on the welding gun will adjust the spring pressure.
- Indication of adjusted spring pressure in sight window
- Highest operational repeatability, high welding quality, high reliability
- Highest stud positioning accuracy through precise linear ball bushing guide of gun piston
- Simple handling
- Quick and simple retooling.
- All stud types weld able (special chuck might be required)
- High service life through high-grade mechanical components
- Robust housing made from impact resistant, full-insulating plastic VERTON
- Precision guidance protected from welding spatters
- Ergonomic design
- Compact construction
- Low weight
- A wide range of accessories.

Technical data:

Welding range:	Ø 2-10 mm
Welding material:	Steel material, Stainless Steel, mild steel, aluminium and brass
Stud length:	5-35 mm (With accessories up to 120 mm)
welding method:	Acc. DIN EN ISO 14555 - capacitor discharge (contact method)
Welding cable:	5,0 m, 35 mm ² , (Extension cable can be connected)
Control cable pluck:	Standard with 12-pin, (other pluck can be mounted ex. 4 pol or 7 pol)
Dimension (WxHxL):	40x130x170 mm
Weight (without cable):	0,5 kg

Basic rules:

Observe the following basic rules for stud welding with capacitor discharge.
 The steel must be free of oil or fat and should be clean.
 Coatings such as zinc, scale, paint, anodizing etc. have a negative effect on weld quality or do not allow welding.
 Base metals must be suitable for welding.
 Steel with high carbon content or cutting steel is not recommended for stud welding.
 Use quality "pip" on the bolts. The accuracy of the arc at the pip has a direct impact on weld quality
 Always test welds, before production begins.

Part no.:

86190612	CDK1 with 12 pol pluck (Old name - TSK310) Delivered without legs and supporting tube.
86190604	CDK1 with 4 pol pluck. Delivered without legs and supporting tube.
86190607	CDK1 with 7 pol pluck. Delivered without legs and supporting tube.
86200612	CDK1S with 12 pol for legs assembly - Delivered without (legs, footbaseplate, chuck)
86200604	CDK1S with 4 pol for legs assembly - Delivered without (legs, footbaseplate, chuck)
86200607	CDK1S with 7 pol for legs assembly - Delivered without (legs, footbaseplate, chuck)
Accessories:	(most important)
40197093	Supporting tube length 63 mm - out Ø20
40197085	Supporting tube length 63 mm - out Ø25
40197085	Supporting tube length 63 mm - out Ø30
40197094	Supporting tube length 70 mm - out Ø30
40197095	Supporting tube length 75 mm - out Ø30
4019938	3-FOD (leg) Complete - L49 on the legs (49mm)



CDH1 with supporting tube or legs CDH1S with legs assembly, (Old Name TSG310H)

The compact stud welding gun CDH1 (TSG310H with legs or supporting tube) is designed for capacitor discharge stud welding (gab method). It guarantees optimum welding results and repeatability and is very easy to use. CDH1 or CDH1S stands out through its robust construction and high reliability. It is ergonomic design and low weight assures tireless working. A Linear ball bushing in the welding gun ensures high positioning accuracy. Easy conversion from supporting tube to legs. A large range of supporting tubes and legs makes it easy to create templates for welding of studs. See accessories.

- Very well suited for welding on problematic surfaces (e.g. zinc, tinder).
- Spring pressure adjustable. Turning the cab back on the welding gun will adjust the spring pressure.
- Indication of adjusted spring pressure in sight window
- Highest operational repeatability, high welding quality, high reliability
- Highest stud positioning accuracy through precise linear ball bushing guide of gun piston
- Simple handling
- Quick and simple retooling.
- All stud types weld able (special chuck might be required)
- High service life through high-grade mechanical components
- Robust housing made from impact resistant, full-insulating plastic VERTON
- Precision guidance protected from welding spatters
- Ergonomic design
- Compact construction
- Low weight
- A wide range of accessories.

Technical data:

Welding range:	Ø 2-10 mm
Welding material:	Steel material, Stainless Steel, mild steel, aluminium and brass
Stud length:	5-35 mm (With accessories up to 120 mm)
welding method:	Acc. DIN EN ISO 14555 - capacitor discharge (Gab method)
Welding cable:	5,0 m, 35 mm ² , (Extension cable can be connected)
Control cable pluck:	Standard with 12-pin, (other pluck can be mounted ex. 4 pol or 7 pol)
Dimension (WxHxL):	40x130x170 mm
Weight (without cable):	0,5 kg

Basic rules:

Observe the following basic rules for stud welding with capacitor discharge.
 The steel must be free of oil or fat and should be clean.
 Coatings such as zinc, scale, paint, anodizing etc. have a negative effect on weld quality or do not allow welding.
 Base metals must be suitable for welding.
 Steel with high carbon content or cutting steel is not recommended for stud welding.
 Use quality "pip" on the bolts. The accuracy of the arc at the pip has a direct impact on weld quality
 Always test welds, before production begins.

Part no.:

86190612	CDH1 with 12 pol pluck (Old name - TSK310) Delivered without legs and supporting tube.
86190604	CDH1 with 4 pol pluck. Delivered without legs and supporting tube.
86190607	CDH1 with 7 pol pluck. Delivered without legs and supporting tube.
86200612	CDH1S with 12 pol for legs assembly - Delivered without (legs, footbaseplate, chuck)
86200604	CDH1S with 4 pol for legs assembly - Delivered without (legs, footbaseplate, chuck)
86200607	CDH1S with 7 pol for legs assembly - Delivered without (legs, footbaseplate, chuck)
Accessories:	(most important)
40197093	Supporting tube length 63 mm - out Ø20
40197085	Supporting tube length 63 mm - out Ø25
40197085	Supporting tube length 63 mm - out Ø30
40197094	Supporting tube length 70 mm - out Ø30
40197095	Supporting tube length 75 mm - out Ø30
4019938	3-FOD (leg) Complete - L49 on the legs (49mm)

CDKi – For insulations with cup headed pins

The compact stud welding gun CDK1 is designed for capacitor discharge stud welding for welding cup headed pins (contact method). It guarantees optimum welding results and repeatability and is very easy to use. CDKi stands out through its robust construction and high reliability. It is ergonomic design and low weight assures tireless working



Wide range of magnets and copper washers for protection makes it sure for all applications. Easy to change supporting tubes. Program for Ø30 mm and Ø38 mm Cup headed pins. See our accessories program.

- Very well suited for welding on problematic surfaces (e.g. zinc, tinder).
- Highest operational repeatability, high welding quality, high reliability
- Simple handling
- Quick and simple retooling.
- High service life through high-grade mechanical components
- Robust housing made from impact resistant, full-insulating plastic VERTON
- Precision guidance protected from welding spatters
- Ergonomic design
- Compact construction
- Low weight
- A wide range of accessories
- A wide range cup headed pins
- 10 Meter cables on the welding gun

Technical data:

Welding range	Ø 2-4 mm
Welding material cup headed pins	Steel material, Stainless Steel, mild steel 15-200 mm
welding method	Acc. DIN EN ISO 14555 - capacitor discharge (contact method)
Welding cable	10 m , 16 mm ² , (Extension cable can be connected)
Control cable pluck	Standard with 12-pin, (other pluck can be mounted ex. 4 pol or 7 pol)
Dimension (WxHxL):	40x130x170 mm
Weight (without cable):	0,4 kg
Order no.:	86230612 (12Pol) 86230604 (4 Pol) 86230607 (7 Pol)

Basic rules:

Observe the following basic rules for stud welding with capacitor discharge.

The steel must be free of oil or fat and should be clean.

Coatings such as zinc, scale, paint, anodizing etc. have a negative effect on weld quality or do not allow welding.

Base metals must be suitable for welding.

Steel with high carbon content or cutting steel is not recommended for stud welding.

Use quality "pip" on the bolts. The accuracy of the arc at the pip has a direct impact on weld quality

Always test welds, before production begins.



DAH1 – DAH1G and DAH1S Handy DA welding gun up 12 mm weldingstuds

The compact stud welding guns DAH1, DAH1G or DAH1S is designed for drawn arc stud welding for stud with ceramic ferrules or with welding studs together with gas. Our DAH1S has build in a oil damping systems. All DAH1 guns are set lift guns, where you can adjust the lift of the studs by turning the cap back on the gun.

All guns are equipped with linear ball bushing guide of gun piston, - which give very high accuray of the positions of the stud

These guns will always give an optimal welding.

The guns work in all weather conditions. General is the DA series well famous for the strong construction and high reliability design.

It guarantees optimum welding results and repeatability and is very easy to use. Their ergonomic design and low weight for heavy guns in spite of the strong design makes it comfortable to work with. Simple conversion to other studs diameters.

- Very well suited for welding on problematic surfaces like black steel, (e.g. zinc, tinder).
- Very well suited for shipbuilding, constructions', welding of shear connectors' etc.
- Works on extreme
- Highest operational repeatability, high welding quality, high reliability
- Simple handling
- Quick and simple retooling.
- All stud types weld able (special chuck might be required)
- High service life through high-grade mechanical components
- Robust housing made from impact resistant, full-insulating plastic VERTON
- Precision guidance protected from welding spatters
- Ergonomic design
- Works for many years
- Compact construction
- A wide range of accessories.

Technical data:

Welding range:	Ø 3-12 mm
Welding materiel:	Steel material, Stainless Steel, mild steel, aluminium and brass
Stud length:	15-500 mm
Welding method:	Acc. DIN EN ISO 14555 – Drawn Arc
Welding cable:	35 mm ² , (Extension cable can be connected)
Control cable pluck:	Standard with 4-pin, (other pluck can be mounted ex. 7 pol)
Dimension (WxHxL):	250x240 mm
Weight (without cable):	0,7 kg
Order Nummer.:	DAH1: (5 Meterx35 mm2), DAH1G: (5 Meterx35 mm2) DAH1S: (5 Meterx35mm2)

Gas equipment can be delivered to the gun. For stud diameter from 8 to 14 mm in Aluminium DABOTEK can deliver equipment for gas and ceramic ferrule. I.e. we use ceramic ferrule and gas simultaneously for welding bigger diameter in aluminium.

Ceramic holder is here fitted with retainer can be springs. This ensures optimum contact with the ceramic ring and the steel. A large program of accessories for welding guns for all weld able items found. See our catalogue for accessories for welding guns. DAH1S stud welding gun has hydraulic damping of the movement



DA2 – DA3 Ringlift welding gun for stud welding

The compact stud welding guns DA2 and DA3 is designed for drawn arc stud welding for stud with ceramic ferrules.

Our DA – welding guns are ringlift guns, which mean they lift the anchor inside the guns by help from a ring. This is the most proved systems and will compensate for tolerances in the studs and the surface of the steel

The guns work in all weather conditions. General is the DA series well famous for the strong construction and high reliability design.

It guarantees optimum welding results and repeatability and is very easy to use. Their ergonomic design and low weight for heavy guns in spite of the strong design makes it comfortable to work with. Simple conversion to other studs diameters.

- Very well suited for welding on problematic surfaces like black steel, (e.g. zinc, tinter).
- Very well suited for shipbuilding, constructions', welding of shear connectors' etc.
- Works on extreme
- Highest operational repeatability, high welding quality, high reliability
- Simple handling
- Quick and simple retooling.
- All stud types weld able (special chuck might be required)
- High service life through high-grade mechanical components
- Robust housing made from impact resistant, full-insulating plastic VERTON
- Precision guidance protected from welding spatters
- Ergonomic design
- Compact construction
- A wide range of accessories.

Technical data:

Welding range:	Ø 2-19 mm (Ø16 for DA2)
Welding material:	Steel material, Stainless Steel, mild steel, aluminium and brass
Stud length:	15-500 mm
Welding method:	Acc. DIN EN ISO 14555 – Drawn Arc
Welding cable:	50 -90 mm ² , (Extension cable can be connected)
Control cable pluck:	Standard with 4-pin, (other pluck can be mounted ex. 7 pol)
Dimension (WxHxL):	55x155x240 mm
Weight (without cable):	1,9 kg
Order Number.:	DA2: 99-101-022 (50mm ²), DA3: 99-101-023 (70mm ²)

Gas equipment can be delivered to the gun. For studdiameter from 8 to 14 mm in Aluminium DABOTEK can deliver equipment for gas and ceramic ferrule. I.e. we use ceramic ferrule and gas simultaneously for welding bigger diameter in aluminium.

Ceramic holder is here fitted with retainer can be springs. This ensures optimum contact with the ceramic ring and the steel. A large program of accessories for welding guns for all weld able items found. See our catalogue for accessories for welding guns. DA-stud welding guns, all hydraulic damping of the movement



DA4 – DA6 Heavy Duty ringlift stud welding gun

The compact stud welding guns DA4, DA5 and DA6 is designed for drawn arc stud welding for stud with ceramic ferrules. Our Heavy duty DA – welding guns are ringlift guns, which the anchor inside the guns by help from a ring. This is the most proved systems and will compensate for tolerances in the studs and the surface of the steel. These systems will always give an optimal welding

The guns work in all weather conditions. General is the DA series well famous for the strong construction and high reliability design.

It guarantees optimum welding results and repeatability and is very easy to use. Their ergonomic design and low weight for heavy guns in spite of the strong design makes it comfortable to work with. Simple conversion to other studs diameters.

- Very well suited for welding on problematic surfaces like black steel, (e.g. zinc, tinder).
- Very well suited for shipbuilding, constructions', welding of shear connectors' etc.
- Works on extreme
- Highest operational repeatability, high welding quality, high reliability
- Simple handling
- Quick and simple retooling.
- All stud types weld able (special chuck might be required)
- High service life through high-grade mechanical components
- Robust housing made from impact resistant, full-insulating plastic VERTON
- Precision guidance protected from welding spatters
- Ergonomic design
- Works for many years
- Compact construction
- A wide range of accessories.

Technical data:

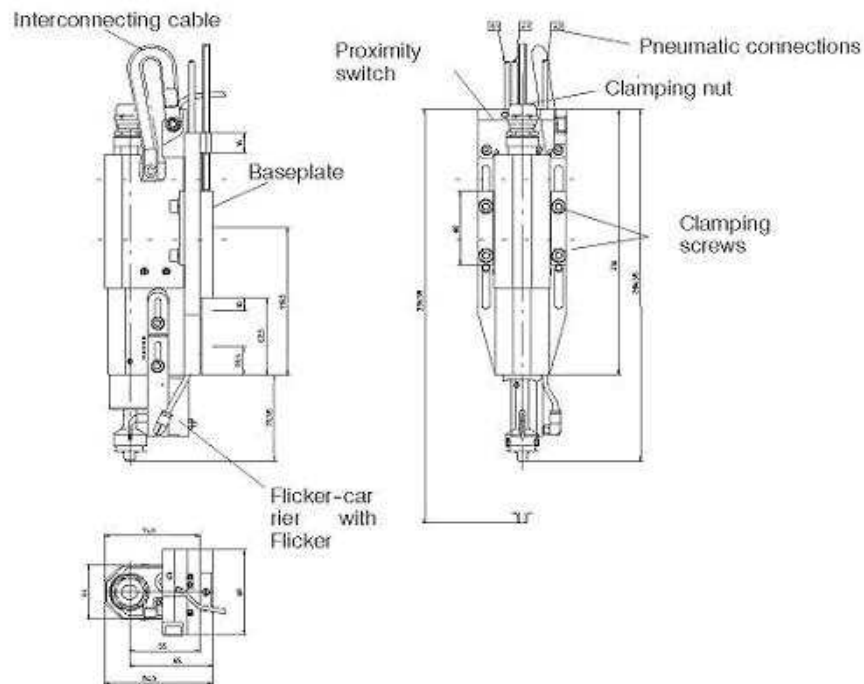
Welding range:	Ø 10-25 mm
Welding materiel:	Steel material, Stainless Steel, mild steel, aluminium and brass
Stud length:	15-500 mm
Welding method:	Acc. DIN EN ISO 14555 – Drawn Arc
Welding cable:	75 -125 mm ² , (Extension cable can be connected)
Control cable pluck:	Standard with 4-pin, (other pluck can be mounted ex. 7 pol)
Dimension (WxHxL):	55x155x240 mm
Weight (without cable):	2,0 kg
Order Nummer.:	DA4: 99-101-024 (75 mm ²), DA5: 99-101-025 (95 mm ²) DA6: 99-101-026 (120mm ²)

Gas equipment can be delivered to the gun. For stud diameter from 8 to 14 mm in Aluminium DABOTEK can deliver equipment for gas and ceramic ferrule. I.e. we use ceramic ferrule and gas simultaneously for welding bigger diameter in aluminium.

Ceramic holder is here fitted with retainer can be springs. This ensures optimum contact with the ceramic ring and the steel. A large program of accessories for welding guns for all weld able items found. See our catalogue for accessories for welding guns. DA-stud welding guns, all hydraulic damping of the movement

Welding head SIK 2

The welding head SIK2 can be used in machines and devices with automatic or semi-automatic stud feeding. It is a simple and strong construction.



Technical data

Weight: 1.5 kg without power cable
Guide: shaft hardened and grinded
Guidelement: 2 bearing bushes free from clearance
Drive: pneumatic cylinder
Welding stroke: 50mm

Technical changes reserved

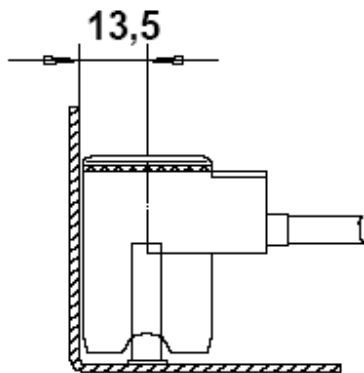
Welding head Mini HSK

Welding head to weld with a minimum stud distance to a wall and minimum gap of the workpiece.



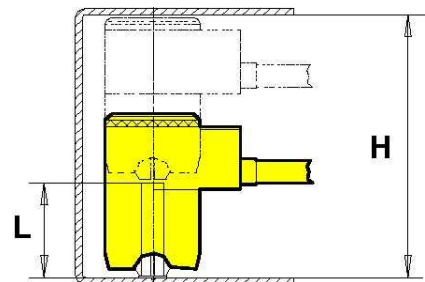
Technical data

Connection:	to all BS / TS stud welding appliances
Stud diameter:	M3 - M8 x 30mm
Power cable grip:	3m 25mm ²
Power cable MHSK:	1m 16mm ²



$$H = 53 + L$$

L= Stud length
H= Gap



Technical changes reserved

Inexpensive CNC machine

The entry into the world of automation

- Can be equipped with different stud welding heads.
- Complete machine control system integrated in the machine body.
- Axis drives with low wearing AC-servomotors.
- Simple programming and operation.
- Fully enclosed machine according to machinery directive 98/37/EC.

Applications:

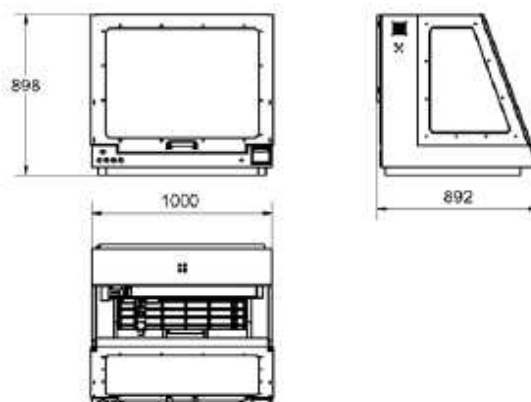
All stud welding methods.

Design features:

- The machine can be equipped with different stud welding heads, power supply units and stud feeding systems.
- Positioning control with PLC.
- Y-axis electrically insulated T-slot table, travel 300 mm.
- X-axis portal (welding head); travel 500 mm.
- Table machine in plate steel construction
- optional with stand.

Technical data:

- | | |
|---|--|
| - Work range X-/Y-axis: | 500 x 300 mm |
| - Work table size: | 710 x 360 mm |
| - Travel speed | 0,4 m/s |
| - Positioning accuracy of welded studs: | ±0,15 mm depending on the welding head |
| - Repeatability: | ±0,1 mm |
| - Air supply: | 6 bar filtered, not lubricated |
| - Power supply: | Tip ignition 230V 50 Hz
Drawn arc 3x 400V 50 Hz ±10 % |
| - Drive X-/Y-axis: | AC-servomotors |
| - Controller and drives: | Omron |
| - Prepared for operation of an optional pneumatic Z-axis (valves available) | |



Technical changes reserved

CNC cross X-Y table 500 mm × 700 mm with servomotors

Description:

It is possible to get on the machine all pneumatic strokes, welding heads and stud feeding systems.



Technical data:

Clamping surface: 1260 mm × 800 mm
T-slot board

Working area X-axis: 700 mm
Working area Y-axis: 500 mm
Apurtenance axis: ball screw,
servomotors

Pneumatic Z axis

Positionining speed

X-axis: v max. = 0,3 m / sek.
Y-axis: v max. = 0,3 m / sek.

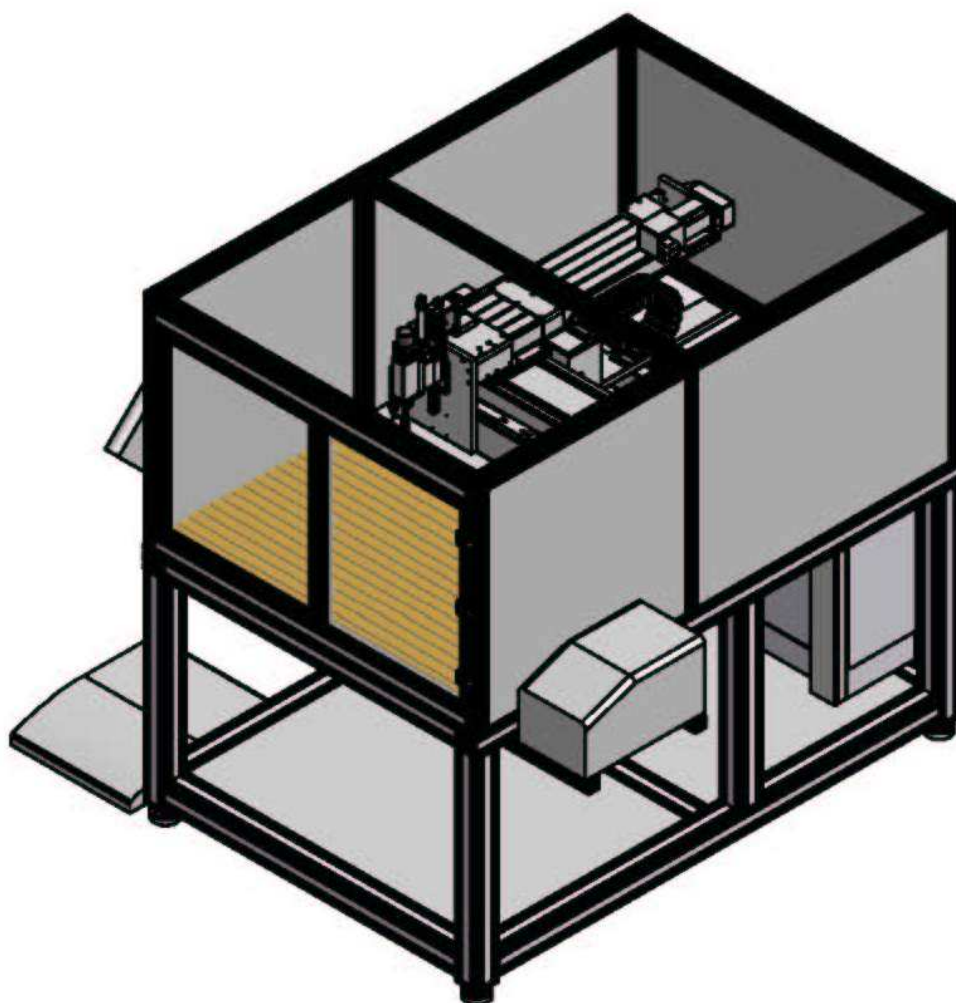
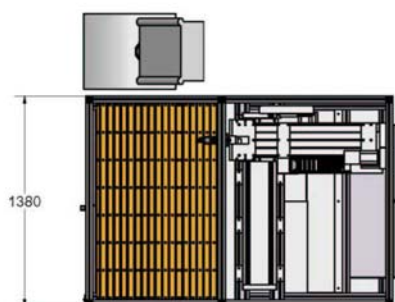
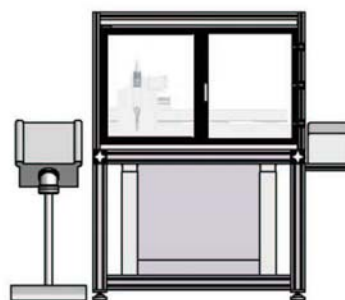
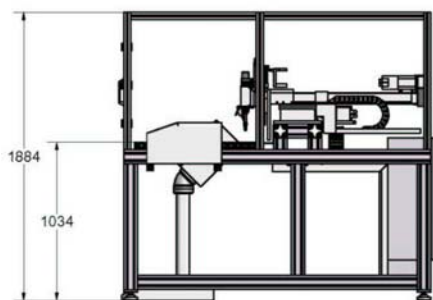
**Repeating accuracy
mechanical components:** ± 0,05 mm

Control: Siemens S7

Safety: With full housing is the machine conform
with EU-directive on machinery
98/37/EG (CE and so on)
Manuel opening folding door
Optional with light barrier or
pneumatic driven door

Technical changes reserved

**CNC cross X-Y table 500 mm × 700 mm
with servomotors**



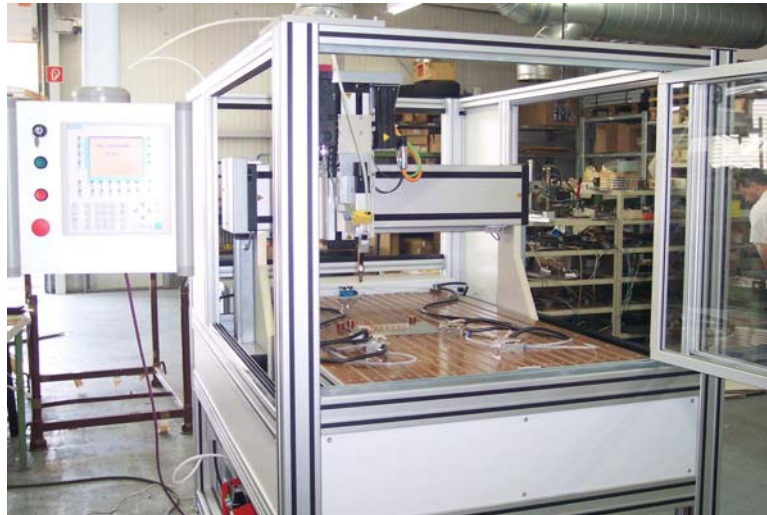
Technical changes reserved

CNC X-Y table 600mm x 1000mm

with servomotors

Description:

It is possible to get on the machine all pneumatic strokes, welding heads and stud feeding systems.

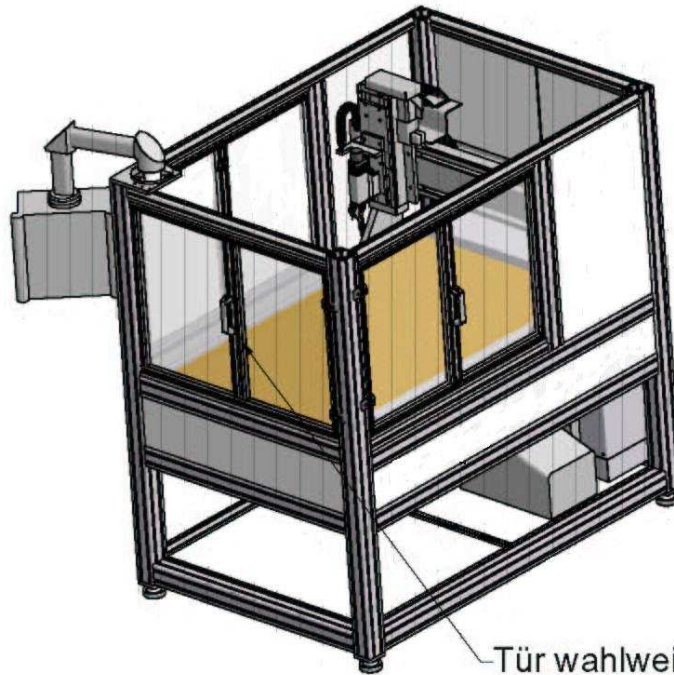


Technical data:

Clamping surface:	900 mm × 1100 mm T-slot board
Working area X-axis:	600 mm
Working area Y-axis:	1000 mm
Z-axis:	200 mm (more than 1 Z-axis possible)
Apurtenance axis:	ball screw, servomotors
Positionining speed	
X-axis:	v max. = 0,3 m / sek.
Y-axis:	v max. = 0,3 m / sek.
Repeating accuracy mechanical components:	± 0,05 mm
Control:	Siemens S7
Safety:	With full housing is the machine conform with EU-directive on machinery 98/37/EG (CE and so on) Manuel opening folding door Optional with light barrier or pneumatic driven door

Technical changes reserved

CNC X-Y table 600mm x 1000mm
with servomotors



Tür wahlweise rechts,
links oder vorne

**Door optional right side,
left side or in front**



Technical changes reserved