

NORMANDY FASTENERS

LBS Studwelders

Capacitor Discharge Stud Welding Units



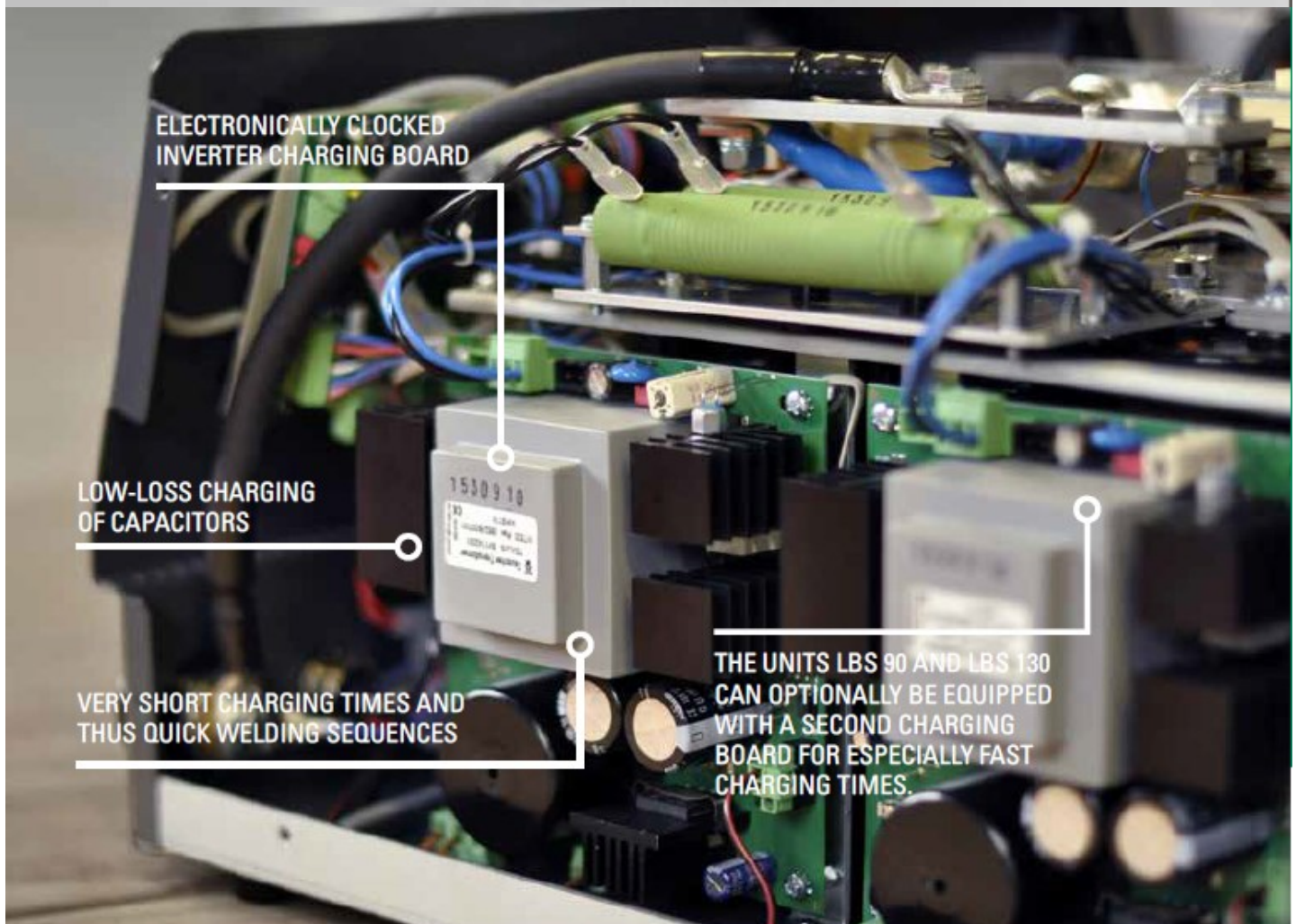


COMPACT AND ROBUST CONSTRUCTION

CHARGING VOLTAGE CONTINUOUSLY ADJUSTABLE

INDICATION OF ALL FUNCTIONS BY CLEARLY ARRANGED LED

VERY EASY OPERATION



ELECTRONICALLY Clocked INVERTER CHARGING BOARD

LOW-LOSS CHARGING OF CAPACITORS

VERY SHORT CHARGING TIMES AND THUS QUICK WELDING SEQUENCES

THE UNITS LBS 90 AND LBS 130 CAN OPTIONALLY BE EQUIPPED WITH A SECOND CHARGING BOARD FOR ESPECIALLY FAST CHARGING TIMES.



HIGHLIGHTS AND SPECIAL EQUIPMENT



ELECTRONICALLY CLOCKED INVERTER CHARGING BOARDS

- » ensure very short charging times and thus quick welding sequences
- » ensure energy-efficient charging of capacitors
- » The units LBS 90 and LBS 130 can optionally be equipped with a second charging board for especially fast

charging times. Thus, extremely quick welding sequences (e.g. for automatic applications) can be achieved.



AUTOMATIC STUD FEEDING

- » An automatic module enables the connection of the automatic stud feeder VBZ and an automatic welding gun.

**VERY SHORT CHARGING TIMES!
QUICK WELDING SEQUENCES!**

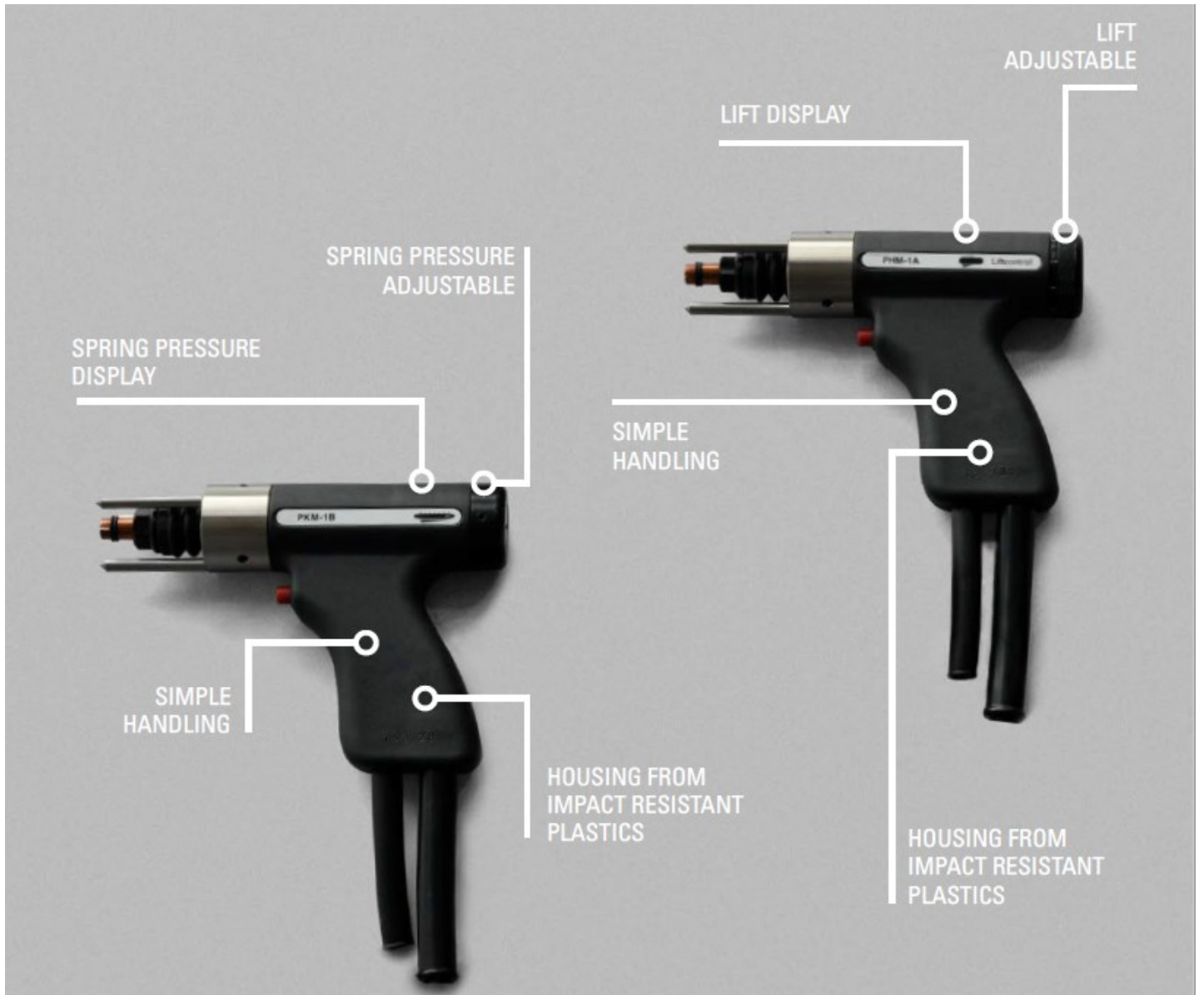
Technical Data and Characteristics

	LBS 75	LBS 80
Max. welding diameter (mm)	8	10
Capacitance (µF)	66000	90000
Charging voltage (V)	60 - 200	60 - 200
Welding time (mS)	1 - 3	1 - 3
Electronically clocked inverter charging boards		
1 charging board	x	x
2 charging boards		
Operation		
Repeat cycle lock	x	x
Electronic function control	x	x
Self diagnosis system	x	x
Automatic function test	x	x
Automatic stud feeding		
Error diagnosis systems		
Excess temperature	x	x
Damage on welding/control cable	x	x
Damage on solenoid	x	x
Thermic controlled ventilator		x

	LBS 75	LBS 80
Robust, powder-coated metal housing	x	x
Dimensions		
Width (mm)	195	195
Height (mm)	260	260
Length (mm)	400	400
Weight (kg)	11	13,5
Electric connection		
Mains supply (V) at 50/60 Hz	230 (115)	230 (115)
Mains fuse external	≥ 10 AT	≥ 10 AT
Protection	IP 21	IP 21
Control cable socket for welding guns	7-pin	7-pin
Suitable welding guns		
PKM-1B	x	x
PHM-1A	x	x
PIM-1B	x	0
PKA-500		
PHA-500		



CD Guns & Accessories



TECHNICAL DATA AND CHARACTERISTICS

	PKM-1B	PHM-1A
Welding method		
Capacitor discharge (contact)	x	
Capacitor discharge (gap)		x
Welding range (Ø mm)	2-10	2-10
Welding material		
Steel	x	x
Stainless steel	x	x
Aluminium		x
Brass		x
Spring pressure adjustable	x	
Spring pressure display	x	
Lift adjustable		x
Lift display		x
Piston guide		
Slide-bearing	x	x
Linear ball track	o	o
Welding cable		
-cross-section (mm ²)	25	25
-length (m)	6,5	3,5
Control cable plug	7-pin	7-pin
Housing from impact resistant plastics	x	x
Protection of piston guidance from welding spatters	x	x
Dimensions		
Width (mm)	40	40
Height (mm)	130	130
Length (mm)	183	183
Weight without cable (kg)	0,7	0,7

Positioning Tube

For welding in jigs and on tubes



Ø	Length	Part Number
30	79	B-90-50-1012
30	100	B-90-501112

Centring Device



- | | | | |
|---|-----------------|---|-------------------------|
| 1 | Centring Tube | 5 | Centring Disc |
| 2 | Flange | 6 | Cylinder Bolt |
| 3 | Distance Bolt | 7 | Chuck Extension |
| 4 | Foot Ring 38/32 | | 12.5mm with length stop |

Intermediate Ring 16mm



Offset Chuck

For welding close to edges



For welding of studs at a distance of up to 8.5mm

To angled sheets