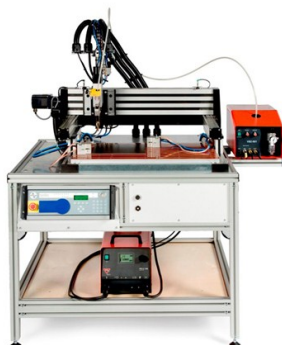


## CNC stud welding machines - series MOD

The modular design of the CNC stud welding machines enables the individual configuration and equipment, e.g.:

- customer-specific choice of the size of the working area within the minimum and maximum dimensions  
(The entire working area can be reached through each welding head.)
- configuration 1-axis (X-axis), 2-axis (X-/Y-axis) or 3-axis (X-/Y-/Z-axis)
- number of welding heads
- suitable for different welding methods: capacitor discharge, short cycle and drawn arc stud welding

Due to the flexible conception further customer-specific adjustments are possible.



**MOD 800**  
CNC stud welding machine



**MOD 1500**  
CNC stud welding machine



**MOD 3000**  
CNC stud welding machine



**STUD WELDING TECHNOLOGY BY**  **SCHÖLER + BOLTE**

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## CNC stud welding machines - series MOD

### - Technical data and characteristics -

	MOD 800	MOD 1500	MOD 3000
<b>Working area (mm)</b> [can be reached through each welding head]			
X-axis	300-800	800-1500	2000, 2500, 3000
Y-axis	300-600	600-1000	1000, 1250, 1500
Z-axis	200	200	200
<b>Machine frame</b>			
Aluminium profiles	o	o	
Welded steel construction	x	x	x
<b>Motor technology/drive</b>			
Step motors	x		
Servo motors	o	x	x
<b>Number of welding heads</b>			
1 welding head	x	x	x
2 welding heads	o	o	o
3 welding heads		o	o
4 welding heads		o	o
<b>Welding parameter monitoring</b>			
Welding parameter monitoring	x	x	x
Welding parameter storage with RS232-interface for data transmission to a PC	o	o	o
<b>Automatic stud feeding</b>	x	x	x
<b>Safety housing</b>			
Housing with folding door	o		
Housing with pneumatic lift door	o	o	
Housing with light curtain	o	o	
Safety fence with light curtain	o	o	o
Sound insulation housing	o	o	o
<b>Operation and programming</b>			
- software i1stud - compact controller Xemo R in desktop housing	x		
- software i1stud - control desk - compact controller Xemo B		x	x
- software i3stud (incl. DXF data converter) - operating terminal with industrial panel PC - controller Xemo M	o	o	o
<b>Options</b>			
Single stud feeding through manual insertion	o	o	o
Fluid spraying device	o	o	o
Milling head with suction device for simple milling operations	o	o	o
Pneumatic mass clamps	o	o	o
Workpiece downholder for welding head	o	o	o

## CNC stud welding machines - series MOD

### - Technical data and characteristics -

	MOD 800	MOD 1500	MOD 3000
Stud switch	o	o	o
Adaption of customer-specific handling systems	o	o	o
Multidirectional balls table	o	o	o
<b>Suitable stud welding units</b>			
PRO-C 1000	x	x	x
PRO-C 1500	x	x	x
PRO-D 1200	x	x	x
PRO-D 1600	x	x	x
<b>Suitable automatic stud welding heads</b>			
KHA-200F optional with travel measuring system	x	x	x
KKA-200F	x	x	x

x - Standard

o - Option

### Applicable stud welding components

Stud welding machines series PRO-C and PRO-D



Automatic stud welding heads KHA-200F and KKA-200F



Automatic stud feeder VBZ



**CNC stud welding machines - serie MOD**  
**- Examples for options and accessories -**



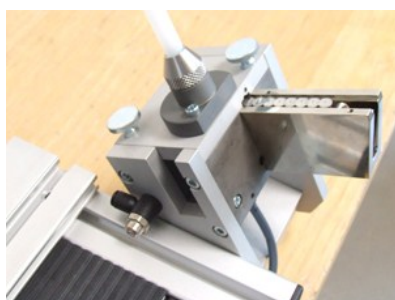
Motor-driven Z-axis



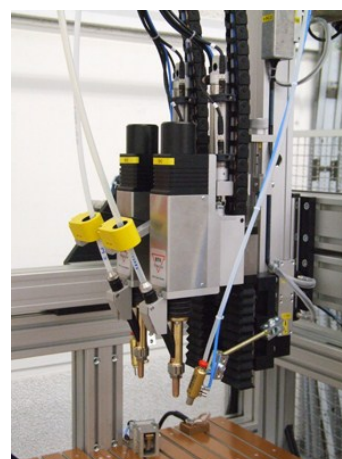
Operating terminal with industrial panel PC and software i3stud (with DXF data converter)



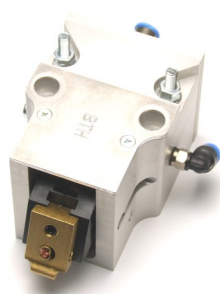
Fluid spraying device for automatic stud welding head



Pneumatic single stud feeding through manual insertion



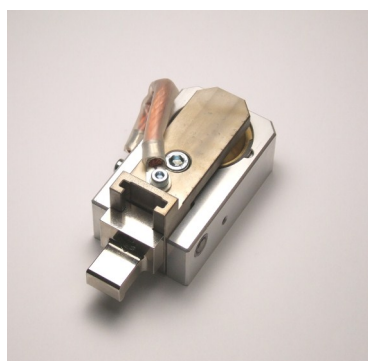
Working lift AHP-080



Pneumatic swing clamp aperture angle 90°



Multidirectional balls table



Pneumatic clamp standard



Grounding by pneumatic cylinders mounted on welding head