

THE NEW
CLASS OF PERFORMANCE



KÖCO Compact Stud Welding System

INOTOP

Highlights:

- Stud welding gun "ELECTRONIC" integrated in the control loop of the power source
- Pre-selection and storage of current, time, lift, damping and shielding gas pre-flow time via foil-protected keyboard
- LC-display, various language options available
- Standard welding programmes pre-set
- Additional welding programmes available
- Key protection for welding parameters
- High-performance process control
 - variable tolerance limits
 - stud counting device
 - printout facility
 - storage on memory card
- Self-diagnostic system for power source, gun and extension cables

Functions tested:

 - temperature
 - phase failures
 - pilot current
- mains undervoltage
- short circuits in the control cable
- Interfaces:
 - for connection to line printers
 - for automatic components
 - for remote control
 - for data export (welding parameters) into Windows software
 - for connection to an external modem
 - for connection to external terminals
- Interface programmes:
 - for exchange of data with work scheduling systems
 - for data transfer to quality assurance programmes
 - for data transfer to spread sheet programmes
- Twin-gun systems (systems for two operators) available
- Connection of mechanical stud welding guns possible



THE FULLY INTEGRATED STUD WELDING SYSTEM



INOTOP COMPACT STUD WELDING SERIES

SERIES INOTOP

Technical data	1004	1704	2004	3004
Stud welding with ceramic ferrule				
Weldable stud range ø (mm)	3 - 14	3 - 20	3 - 22	6 - 25
Short cycle stud welding				
Weldable stud range ø (mm)	3 - 10	3 - 12	3 - 12	6 - 12
Stud welding with shielding gas				
Weldable stud range ø (mm)	3 - 12	3 - 16	3 - 16	3 - 16
Max. current (A)	1100	1800	2300	3500
Current setting range (A)	120 - 1000	160 - 1600	200 - 2000	260 - 2600
Time setting range (ms)	20 - 1000	20 - 1500	20 - 1500	20 - 2000
Max. stud/min. at ... ø (mm)	49/3 4/14	50/3 2/20	52/3 4/22	50/6 6/25
Self-diagnosis: overheating	●	●	●	●
short circuit control	●	●	●	●
mains phase failure	●	●	●	●
malfunction of pilot arc	●	●	●	●
Fully controlled thyristor bridge	●	●	●	●
Microprocessor control	●	●	●	●
Constant current regulation	●	●	●	●
Repeat cycle lock	●	●	●	●
Mains connection 50/60 Hz 3-phase (V)	230/400	230/400	230/400	230/400
Mains connection special voltages (V)	○	○	○	○
Mains plug at 400 V (A)	32	63	63/125	125
4-wire mains cable at 400 V (m/mm ²)	5/4	5/10	5/16	5/16
Mains fusing time-lag at 230/400 V (A)	50/35	100/63	160/80	200/125
Mains power consumption at ...%				
duty cycle (kVA)	2,5/7/100 73/43/12	2,25/9/100 121/59/17	2,5/7/100 156/93/25	8/13/100 187/145/52
Tolerance range mains voltage (%)	-15/+6	-15/+6	-15/+6	-15/+6
Dust and moisture protection of control unit	●	●	●	●
Class of protection	IP 23	IP 23	IP 23	IP 23
Cooling	F	F	F	F
Steel housing, powder-coated	●	●	●	●
Housing dimensions (L x W x H) mm	700x450x770	700x450x770	960x600x830	1150x610x830
Swivel castors/ fixed castors	2/2	2/2	2/2	2/2
Handle	1	1	1	1
Lifting eye	2	2	2	2
Weight (abt. kg)	90	160	290	380
Shielding gas equipment	●	○	○	○
Stud counter	●	●	●	●
Twin-gun systems (for 2 operators)	-	-	○	○
Interface for automatic components	○	○	○	○
Stud welding guns:				
ELECTRONIC KE 22	●	●	○	○
ELECTRONIC KE 24	○	○	●	○
ELECTRONIC KE 26	-	-	-	●
Classic Series (mechanical)	○	○	○	○

● = standard, ○ = optional, - = not available

Ⓢ Welding under increased electrically hazardous conditions permissible, CE-Labeling according to EN 60974-1 etc.

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Köster & Co GmbH
Spreeler Weg 32
D-58256 Ennepetal
Deutschland



Tel. + 49 (0)23 33 83 06-0
Fax + 49 (0)23 33 83 06 38
E-Mail koeco@bolzenschweisstechnik.de
Internet www.bolzenschweisstechnik.de

