



AS 1266 series

easy and flexible usage ✓

HMI with integrated parameter database ✓

CD - procedure

The AS 1266 series



Now available: product video on



number	AS studwelder advantages
1	highest safety standards
2	digital operator interface
3	easy Touch buttons (useable with gloves)
4	infinitely variable welding voltages
5	labeled connections for flawless handling
6	robust welding and control cable connections



Anwendungs Video jetzt auf



- ✓ Even more power reserves :
Maximum current of 15000A
charging voltage range 40-220V
- ✓ complet digitalized interface
- ✓ Capacities of 66mF or 78mF available
(individuelle depending on application)
- ✓ Re-activation lock on welded studs
- ✓ Day / job counter
- ✓ intuitiv parameterselection by
integrated database
- ✓ Individual storage of 16 welding-
parameters
- ✓ robust case structure | dirt- proof
control panels | and low power-to-
weight ratio (14,2kg)
- ✓ High welding sequence at continuous operation
(M3: 15 studs/min / M8: 7 studs/min)
- ✓ Minimal back imprints due to extremely short welding
times in the gap process (0,5-4ms depending on gun)
- ✓ Contact- and gap procedure. Studwelder can
recognize automatically which gun is connected.
- ✓ reliable protection through temperature monitoring
of the inverter and thyristor
- ✓ Self-test at start and digital monitoring of the
contact to the workpiece

upgrading options for studwelder

- capacity extension on 78mF (reinforcement)

Versions of the AS 1266 series

AS 1266 (standard)

Art.-Nr. 19121200 technical data

Welding applications steel/stainless steel: Ø2-8
aluminium : Ø2-6
brass : Ø2-6
**Isolation [steel/stainless steel/ aluminium/
galvanized steel] : 2/3/2,7**

Welding performance M3: 15 stud/min.
M8: 7 stud/min.
(Guideline values: Deviations depending on gun/
operating application)

technology capacitor (CD)

welding voltage 40-220V

capacity 66mF

dimensions L W H 420 x 240 x 280mm

weight 14,2kg

electrical connections 230V 50Hz



AS 1266V

Art.-Nr. 191 21 281 technical data

welding applications steel/stainless steel: Ø2-8 und 10*
aluminium: Ø2-6 und 8*
brass: Ø3-8
*depending on the application, beyond the DIN range
possible (no procedural review)

capacity 78mF



Versions of the AS 1266 series



AS 1266L (travel version)

travel version with voltage switch between 115V and 220V. Capacity of 66mF

Art Nummer: 191 21 295

1802D



1803D



1804D



1901



1811

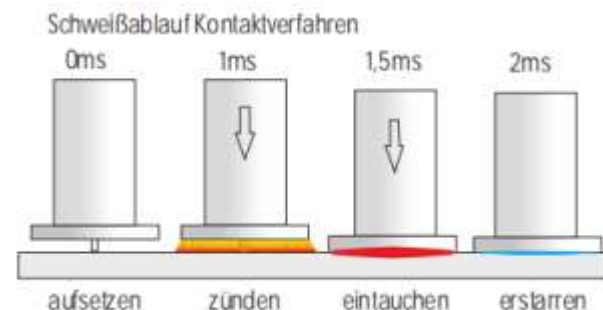


procedure of tip ignition

contact procedure

In the process of "contact welding", the stud is welded by pressing the welding gun onto the workpiece against a spring force. As a result, there is electrical contact between the stud ignition tip and the workpiece. When the welding process is triggered by the operator or the automation controlling unit the ignition tip melts and there is a small arc between the stud flange and the workpiece. This produces a weld pool. The stud now moves due to the spring force by the distance of the ignition tip length towards the workpiece. After the final penetration of the stud, the pool solidifies.

Due to the stronger joining force and the longer welding time the contact process is suitable for steel, stainless steel, aluminium sheets and galvanized sheet metal.



gap procedure

When stud welding by the "gap procedure", the stud is pretensioned against a spring by a magnetic force. This creates a gap between the stud and the workpiece. This gap can be continuously adjusted on the welding gun.

After the welding height has been reached, the magnetic coil is released and the stud is accelerated by the spring towards the workpiece. As soon as the electrical contact is achieved, an arc is created during the forward movement of the stud.

The arc creates the welding pool where the stud is joined under the spring force. When the stud arrives at the surface of the workpiece the arc is blown off and the stud is finally connected to the workpiece.

Due to the shorter welding time, the gap process is suitable for steel and stainless steel, as well as for aluminum sheets. Due to the lower joining force, the gap process is usually used in automated systems and where you want to create less imprint at the back side.



More information about the CD procedures at www.bolzenschweissen.de

welding guns for AS 1266 series



1802D



Art Nr: 197 10 012

1803D



Art Nr: 197 10 009



The AS 1802D is a welding gun for contact procedure. It is suitable for welding steel or stainless steel also on difficult workpiece surfaces.

The AS 1803D is a high quality welding gun for the gap procedure. It is suitable for welding steel and stainless steel and due to an improved mechanic also for aluminium. Due to the backlash free ball guidance system there is the highest level of precision and reproducibility.



1901



**Art Nr:
197 10 003**

The AS 1901 is the gap procedure welding gun. It is suitable for welding steel, stainless steel and aluminium at thin work sheets. Due to the short welding time there is a reduction of the reflective imprints on the back side of thin workpieces.



1811



**Art Nr:
197 10 008**

The AS 1811 is a contact procedure welding gun for applications in the isolation sector. Based on the 1803D this welding gun is specially used for welding disc pins or isolation nails. A welding cable of 10m enables the highest welding radiation.

For more power, options, quality assurance and interfaces for Industry 4.0 take a look at AS 1200 series



1804D



Art Nr: 197 10 007

The AS 1804D is a mini welding gun for gap procedure. It has a length of 120mm and is suitable for welding steel and stainless steel in narrow areas.

