4

PERNI A SALDARE
WELDING STUDS
SCHWEISSBOLZEN

FIXI

ISTRUZIONI PER LA SALDATURA A SCARICA DI CONDENSATORI

WELDING INSTRUCTIONS FOR CAPACITOR DISCHARGE
SCHWEISSANLEITUNG FÜR SPITZENZÜNDUNG

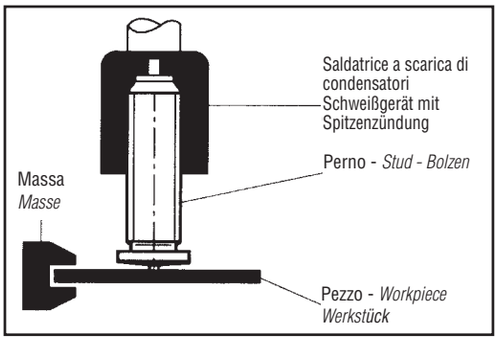
● **OK**
❍ **+ / -**
– **NO!**

MATERIALE DEL PRIGIONIERO *STUD MATERIAL*	**Materiale della base /** *Workpiece Material*								
	ACCIAIO fino a C35 *STEEL MAX C35*	**ACCIAIO fino a C60** *STEEL MAX C60*	**ACCIAIO ZINCATO** *STEEL ZINC PLATED*	**ACCIAIO INOX** *STAINLESS STEEL*	**OTTONE** *BRASS*	**RAME** *COPPER*	**Al 99,5**	**Al Mg3**	**Al Mg5**
ACCIAIO 4.8 RAMATO *STEEL 4.8 COPPER PLATED*	●	–	❍	❍	❍	❍	–	–	–
ACCIAIO INOX A2-50 *STAINLESS STEEL A2-50*	●	❍	❍	●	❍	❍	–	–	–
ALLUMINIO AlMg3 *ALUMINIUM AlMg3*	–	–	–	–	–	–	❍	●	❍
OTTONE *BRASS*	●	–	●	❍	●	●	–	–	–

PERNI FILETTATI A SALDARE A SCARICA DI CONDENSATORI

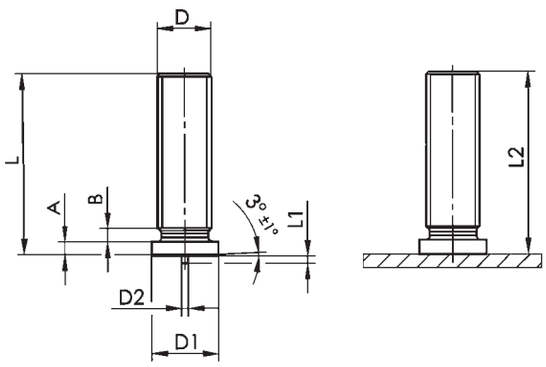
CAPACITOR DISCHARGE STUDS WITH EXTERNAL THREAD
GEWINDEBOLZEN FÜR SPITZENZÜNDUNG

DIN EN ISO 13918



MATERIALI / MATERIALS / WERKSTOFFE

ACCIAIO 4.8 RAMATO	ACCIAIO INOX A2-50	ALLUMINIO AlMg3	OTTONE
STEEL 4.8 COPPER PLATED	*STAINLESS STEEL A2-50*	*ALUMINIUM AlMg3*	*BRASS*
STAHL 4.8 VERKUPFERT	*ROSTFREIER STAHL A2-50*	*ALUMINIUM AlMg3*	*MESSING*

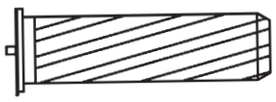


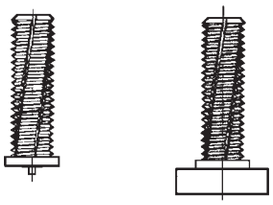
D	L + 0,6	D1 ± 0,2	D2 ± 0,08	L1 ± 0,05	A	B max.	L2
M3		4,5	0,60	0,55	1,4 -0.7	1,5	- L - 0,3
M4		5,5	0,65				
M5		6,5	0,75	0,80	1,4 -0,6	2	
M6		7,5					
M8		9,0		0,85		3	
* M10		11,0					- 0,6
* M12		12,6 ± 0 1			1,8 -0,6		

PERNO PER LA VERNICIATURA A RICHIESTA

STUD FOR PAINTING ON REQUEST

LACKBOLZEN AUF ANFRAGE

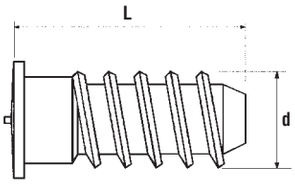




PERNO SPECIALE A SCARICA DI CONDENSATORI
SPECIAL CAPACITOR DISCHARGE STUD
SONDERBOLZEN FÜR SPITZENZÜNDUNG

MATERIALE- *MATERIAL - Werkstoff*

ACCIAIO 4.8 RAMATO - *STEEL 4.8 COPPER PLATED*
Stahl 4.8 verkupfert



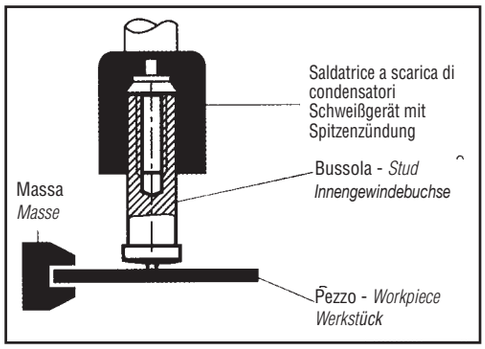
D x L
d. 5 x 9
d. 5 x 14,2
d. 5 x 18
d. 5 x 25

BUSSOLE FILETTATE A SALDARE A SCARICA DI CONDENSATORI

CAPACITOR DISCHARGE STUDS WITH INTERNAL THREAD

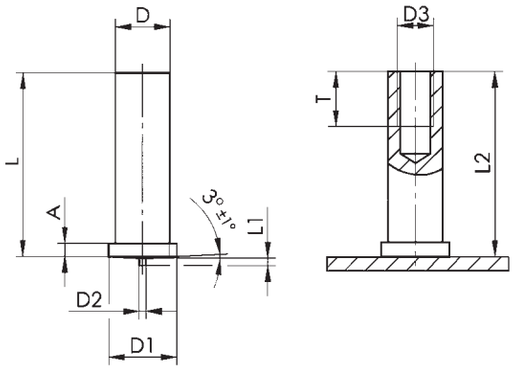
INNENGEWINDEBUCHSEN FÜR SPITZENZÜNDUNG

DIN EN ISO 13918



MATERIALI / MATERIALS / WERKSTOFFE

ACCIAIO 4.8 RAMATO *STEEL 4.8 COPPER PLATED* *STAHL 4.8 VERKUPFERT*	ACCIAIO INOX A2-50 *STAINLESS STEEL A2-50* *ROSTFREIER STAHL A2-50*	ALLUMINIO AlMg3 *ALUMINIUM AlMg3* *ALUMINIUM AlMg3*	OTTONE *BRASS* *MESSING*



D ± 0,1	L + 0,3	D1 ± 0,2	D2 ± 0,08	L1 ± 0,05	A	D3	T + 0,5	L2
ø5		6,5	0,75	0,80	1,4 -0,7	M3	5	~ L - 0,3
ø6		7,5				M4	6	
ø7,1		9		0,85	1,4 -0,6	M5	7,5	
* ø8						M6		
* ø10,8		12,6 ± 0,1			1,8 -0,6	M8	10	

PERNI LISCI A SALDARE A SCARICA DI CONDENSATORI

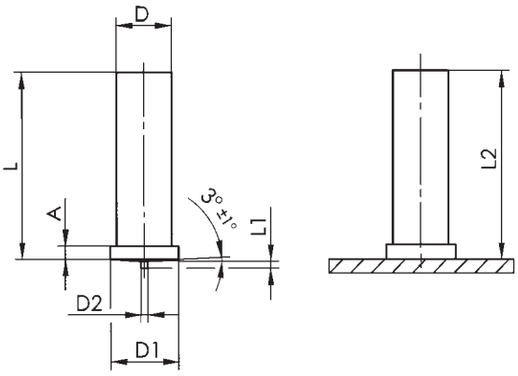
CAPACITOR DISCHARGE STUDS NOT THREADED - STIFTE

STIFTE FÜR SPITZENZÜNDUNG

DIN EN ISO 13918

MATERIALI / MATERIALS / WERKSTOFFE

ACCIAIO 4.8 RAMATO *STEEL 4.8 COPPER PLATED* *STAHL 4.8 VERKUPFERT*	ACCIAIO INOX A2-50 *STAINLESS STEEL A2-50* *ROSTFREIER STAHL A2-50*	ALLUMINIO AlMg3 *ALUMINIUM AlMg3* *ALUMINIUM AlMg3*	OTTONE *BRASS* *MESSING*



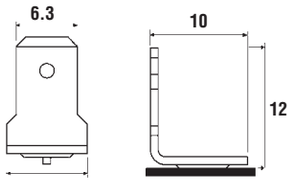
D ± 0,1	L + 0,6	D1 ± 0,2	D2 ± 0,08	L1 ± 0,05	A	L2
ø3		4,5	0,60	0,55	1,4 -0,7	~ L - 0,3
ø4		5,5	0,65			
ø5		6,5	0,75	0,80		
ø6		7,5				
ø7,1		9,0		0,85	1,4 -0,6	
ø8						
* ø9		11,0				-0,6
* ø10,8		12,6 ± 0,1			1,8 -0,6	

FIXI

FASTON A SCARICA DI CONDENSATORI
CAPACITOR DISCHARGE FASTON
FLACHSTECKER FÜR SPITZENZÜNDUNG

FASTON SINGOLO
SINGLE FASTON

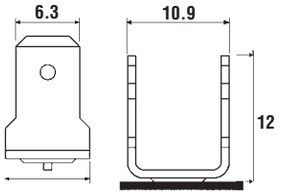
FLACHSTECKER



ACCIAIO 4.8 RAMATO
STEEL 4.8 COPPER PLATED
STAHL 4.8 VERKUPFERT
ALLUMINIO AlMg3
ALUMINIUM AlMg3
ALUMINIUM AlMg3
ACCIAIO INOX A2-50
STAINLESS STEEL A2-50
EDELSTAHL A2-50
OTTONE
BRASS
MESSING

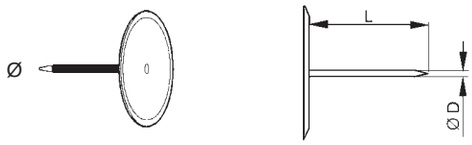
FASTON DOPPIO
DOUBLE FASTON

DOPPEL FLACHSTECKER

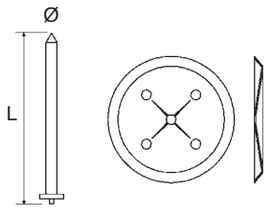


ACCIAIO 4.8 RAMATO
STEEL 4.8 COPPER PLATED
STAHL 4.8 VERKUPFERT
ALLUMINIO AlMg3
ALUMINIUM AlMg3
ALUMINIUM AlMg3
ACCIAIO INOX A2-50
STAINLESS STEEL A2-50
EDELSTAHL A2-50
OTTONE
BRASS
MESSING

CHIODI PER ISOLAMENTO A SCARICA DI CONDENSATORI
INSULATION PINS
TELLERSTIFTE MIT ISOLIERUNG



L. mm.	Ø mm D	Rondella *Washer* *Teller*
9.5 - 54	2	30
9.5 - 152	2.7	38

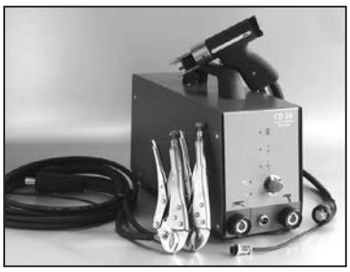


L. mm.	Ø mm	Rondella *Washer* *Teller*
20 - 150	2	38
20 - 150	3	38 - 60
30 - 150	2,6	38

SALDATRICI A SCARICA DI CONDENSATORI
CAPACITOR DISCHARGE WELDERS
SCHWEISSGERÄTE FÜR SPITZENZÜNDUNG

33

UTILIZZO **M3 - M4 - M5 - Ferro /** *Steel / Stahl*
CAPACITY **M3 - M4 Inox e Alluminio**
ANWENDUNGS BEREICH - Stainless steel and Aluminium
Edelstahl und Aluminium
ALIMENTAZIONE *230 V - 50 Hz - 33.000 µF (Microfarad)*
POWER SUPPLY / NETZANSCHLUSS
TEMPO MAX. RICARICA *5,5”*
MAX RECHARGE TIMING / MAX AUFLADEZEIT
PESO / DIMENSIONI *12,5 Kg. 16x42x23 Cm.*
WEIGHT / DIMENSION - GEWICHT/ MASSE



66

UTILIZZO **M3 - M4 - M5 - M6 - M8 Ferro /** *Steel / Stahl*
CAPACITY **M3 - M4 - M5 - M6 Inox e Alluminio**
ANWENDUNGS BEREICH - Stainless steel and Aluminium
Edelstahl und Aluminium
ALIMENTAZIONE *230 V - 50 Hz - 66.000 µF (Microfarad)*
POWER SUPPLY / NETZANSCHLUSS
TEMPO MAX. RICARICA *8,5”*
MAX RECHARGE TIMING / MAX AUFLADEZEIT
PESO / DIMENSIONI *14 Kg. 16x42x23 Cm.*
WEIGHT / DIMENSION - GEWICHT/ MASSE

66 2T

Disponibile la versione 66 2T con N. 2 pistole
Available 66 2T version with two guns
VERFÜGBAR VERSION 66 2T MIT 2 SCHWEIßPISTOLEN
PESO / DIMENSIONI *21,5 Kg. 30x36x24 Cm.*
WEIGHT / DIMENSION - GEWICHT/ MASSE

99

UTILIZZO **M3 - M4 - M5 - M6 - M8 Ferro /** *Steel / Stahl*
CAPACITY **Inox e Alluminio**
ANWENDUNGS BEREICH - Stainless steel and Aluminium
Edelstahl und Aluminium
ALIMENTAZIONE *230 V - 50 Hz - 99 µF (Microfarad)*
POWER SUPPLY / NETZANSCHLUSS
TEMPO MAX. RICARICA *5,5”*
MAX RECHARGE TIMING / MAX AUFLADEZEIT
PESO / DIMENSIONI *17 Kg. 16x38x18 Cm.*
WEIGHT / DIMENSION - GEWICHT/ MASSE

99 2T

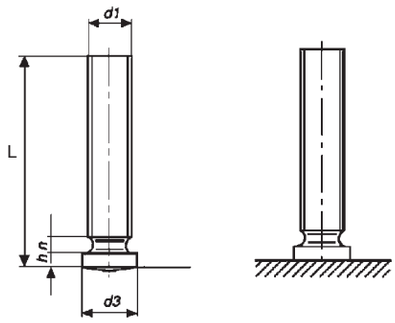
Disponibile la versione 99 2T con N. 2 pistole
Available 99 2T version with two guns
VERFÜGBAR VERSION 99 2T MIT 2 SCHWEIßPISTOLEN
PESO / DIMENSIONI *21,5 Kg. 30x36x24 Cm.*
WEIGHT / DIMENSION - GEWICHT/ MASSE

ACCESSORI */ ACCESSORIES / ZUBEHÖRTEILE*

Porta perni / *Chuck M3 - M10* *BOLZENHALTER* 	**Porta perni per faston** *Chuck for faston* *BOLZENHALTER* *FÜR FLACHSTECKER* 	**Angolare** *Corner cantilever* *WINKELTRÄGER*

PERNI AD ARCO CORTO SENZA FERULA IN CERAMICA / *DRAWN-ARC STUDS*

HUBZÜNDUNG BOLZEN OHNE KERAMIKRING

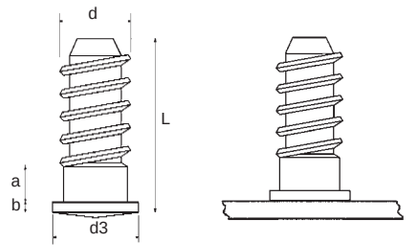


Prima della saldatura
Before welding
VOR DEM SCHWEIßEN

Dopo la saldatura
After welding
NACH DEM SCHWEIßEN

MATERIALE - *MATERIAL - WERKSTOFF*
ACCIAIO 4.8 RAMATO *STEEL 4.8 COPPER PLATED / STAHL 4.8 VERKUPFERT*
ACCIAIO INOX A2-50
STAINLESS STEEL A2-50 / EDELSTAHL A2-50

d1	M3	M4	M5	M6	M8	M10
d3 +/- 0.2	4	5	6	7	9	11
h	0.7 - 1.4		0.8 - 1.4			
n max	1.5		2			
L +0.6 /- 0	6 - 30 mm	6 - 40 mm	8 - 45 mm	8 - 55 mm	10 - 55 mm	16 - 60 mm



Prima della saldatura
Before welding
VOR DEM SCHWEIßEN

Dopo la saldatura
After welding
NACH DEM SCHWEIßEN

MATERIALE - *MATERIAL - WERKSTOFF*
ACCIAIO 4.8 RAMATO
STEEL 4.8 COPPER PLATED
STAHL 4.8 VERKUPFERT

d +/- 0.1	5	5	5	5	5	5
d3 +/- 0.3	6	6	6	6	6	6
b +/- 0.15	0.7					
a max	2.3	3				
L + /- 0.3	9.2	12	14.2	16.5	18.5	25

SALDATRICE AD ARCO - *ARC WELDER - SCHWEISSGERÄT FÜR HUBZÜNDUNG*

550

UTILIZZO **M4 - M10 Alluminio - Ferro - Inox**
CAPACITY *Aluminium - Steel - Stainless steel*
ANWENDUNGS BEREICH *Aluminium / Stahl / Edelstahl*

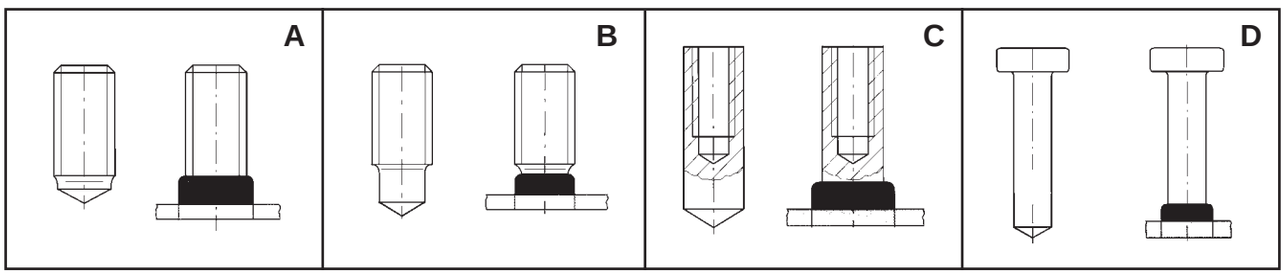
PREDISPOSIZIONE PER IL GAS M4 - M10
GAS ARRANGMENT / SCHUTZGAS BETRIEB AUSSRÜSTUNG

ALIMENTAZIONE *400 V - 50 Hz - 3 fasi*
POWER SUPPLY / NETZANSCHLUSS

PESO / DIMENSIONI *41 Kg. 28x52x29 Cm.*
WEIGHT / DIMENSION / GEWICHT/ MASSE

PERNI A SALDARE AD ARCO CON FERULA IN CERAMICA - *ARC WELDER*

HUBZÜNDUNG BOLZEN MIT KERAMIKRING



FIXI

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Giugno 2014