



PH-4L Stud Welding Gun



The PH-4L stud welding gun allows studs of larger diameters to be welded on metallic workpieces at lightning speed using ceramic ferrules or a gas shroud as aids.



PH-4L SOYER drawn arc stud welding gun with ceramic ferrule equipment

Description:

The newly developed, robust and ergonomically designed PH-4L stud welding gun is especially suitable for larger stud diameters from 12 mm onwards, welded in series production at high continuous welding sequences under hardest conditions and requirements. A new type of manual oil damping system regulates the plunging speed which is absolutely necessary when stud diameters of ≥ 12 mm are applied. Together with easy and practical operation, the PH-4L stud welding gun offers a maximum of technical performance features for producing high-quality welding joints. (For innovative special features, please see over).

Technical data:

Welding range:

Studs and pins from M6 - M20 and/or $\varnothing 6 - 19$ mm

Material:

Steel, stainless steel and heat-resistant steel

Welding and control cables:

5 m highly flexible

Total length with ceramic ferrule equipment:

approx. 350 mm up to approx. 560 mm (depending on the length of studs and support legs)

Total height above grip:

215 mm

Total width:

80 mm

Weight:

2.1 kg without cables and ceramic ferrule equipment

Subject to technical changes

Innovative Special Features of the PH-4L Stud Welding Gun

The new PH-4L SOYER stud welding gun is a top-line product with precision mechanics and long-term quality. The invariably high-quality performance of this stud welding gun is an important step towards the quality assurance in stud welding processes. All important setting parameters can be easily and rapidly adjusted by hand without requiring any tools.

Additional performance features of the PH-4L stud welding gun include:

- ▶ Development and production are in compliance with all prescribed safety targets such as
 - the latest safety and accident prevention regulations (Act on the Safety of Technical Working Equipment)
 - electromagnetic compatibility (EMC Act)
 - European regulations (EU Directives on Machinery)
- ▶ Stable, impact- and break-proof whole-body synthetic housing
- ▶ Optimum protection against weld spatters, dirt and other contamination
- ▶ Automatic and maintenance-free length compensation system for differing welding stud lengths and positioning conditions
- ▶ New and manually adjustable oil damping system to regulate the plunging speed
- ▶ Easy replacement of the standard baseplate with ceramic ferrule equipment by a baseplate with gas shroud
- ▶ Easily adjustable support legs for differing stud lengths
- ▶ Fine hand adjustment of lift in defined steps of 0.5 mm by means of a special notched turning knob at the gun's end
- ▶ Scale for measuring the lift
- ▶ Spirit level at the gun's end to guarantee vertical welding positions
- ▶ High positioning accuracy owing to backlash-free motional sequences in ball bearings, and long service life owing to high-quality mechanical components

SOYER top-of-the-range products awarded the following prizes for



Production



Quality



Technology



Design



Quality Management



International Approval



Safety



EC Conformity