

TC SERIES



**20mm DIAMETER INTEGRATED
STUD WELDING FASTENER SYSTEM**

TC20 • 4HT • TC16

CROMP • ARC

HAWKER ■ SIDDELEY

CROMP • ARC TC20 • 4HT • TC16

The CROMP-ARC TC SERIES is an integrated system of stud welding machines capable of welding drawn-arc studs from 3mm through to 20mm diameter. Up to four handtools operate via the 4HT unit, which is an option for both the TC20 and TC16. Full base diameter welds of 20mm are offered by the TC20 and 16mm by the TC16.

FEATURES

The system provides:

Reliability assured by full electronic control.

Protection for operator and equipment by safety circuits.

Manoeuvrability compact and fitted with wheels.

Visual Weld Controls "at a glance" LED indication of diameter and energy settings, having continuously variable adjustment.

Versatility up to four independent handtools or production heads with automatic change-over.



APPLICATIONS

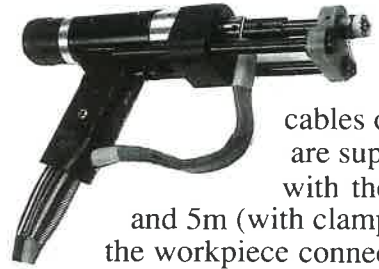
High strength mechanical fastenings are precisely welded by the drawn-arc process. A reserve of power means welds in difficult situations are easily achieved. A full welding range of 3mm to 20mm diameter (or equivalent cross section) is set by controls which are simple to understand and operate. Volume production, fabrication shop, and site situations are all within the capabilities of the flexible TC SERIES system.

A weld parameter acquisition and analysis facility is an option.

Standard handtool is a lightweight tool which can be used in any position.

Air damping and a sophisticated slider/clutch are features of this well proven equipment. Studs of up to 85mm are accommodated with longer legs available optionally.

STANDARD HANDTOOL



Weld cables of 7m are supplied with the tool and 5m (with clamp) for the workpiece connection.

The production head is specifically designed for machine tool slides, jigs and fixtures.

TECHNICAL DATA

	TC20	TC16
Weld current	1800Amps	1250Amps
Weld rate/minute (diameter)	6(20mm) 20(12mm)	6(16mm) 20(8mm)
Stud diameter	3 - 20mm (Full and reduced base)	3 - 16mm
Stud length	5 - 85mm (Unlimited with options)	5 - 85mm
Supply; 3 phase;	415/380/240/220V	415/380V
Recommended HRC fuses	60/100/150/150A	40/60A
Weight	245kg	220kg
Dimensions	W:640mm H:865mm D:875mm (H overall: 1,405mm with 4-HT)	

CROMP ARC products also include drawn-arc equipment for diameters less than 16mm and shear connectors up to 30mm diameter, as well as controllers and transformer rectifiers. Capacitor discharge (CD) equipment from hand portable units to full production autofeed systems are designed, produced and supported.

Crompton Stud Welding also manufacture a full range of CD and drawn-arc studs in mild steel, stainless steel and aluminium alloy.

Continual product development is a policy of the Company: the right to amend any specification is reserved

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