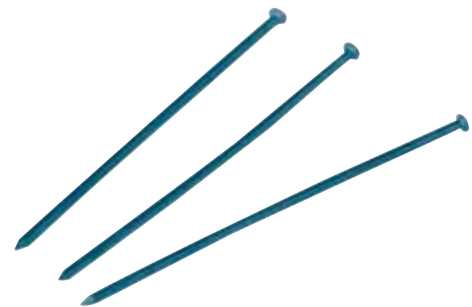


Welding studs to fasten insulation material onto metal surfaces using a special welding gun

2.5.2 MEZ-RIP-PIN

- Welding studs made of galvanised special steel with spherical head and Diamond tips, Ø 2/2,2 mm

Art.-Nr.	Material	Length mm	VPE	Weight kg/VPE
380/019	Galv. steel	19	1000	0,650
380/025	Galv. steel	25	1000	0,860
380/032	Galv. steel	32	1000	1,070
380/042	Galv. steel	42	1000	1,460
380/051	Galv. steel	51	1000	1,710
380/063	Galv. steel	63	1000	2,060
380/076	Galv. steel	76	1000	2,430
380/089	Galv. steel	89	1000	2,810
380/095	Galv. steel	95	1000	3,230
380/105	Galv. steel	105	1000	3,330
380/114	Galv. steel	114	1000	3,590
380/125	Galv. steel	125	1000	3,990
380/140	Galv. steel	140	500	2,300



12.4.1 WELDING GUN PW33

- Portable spot-welding machine, that welds deep into the steel sheets thereby providing very dependable joints
- Delivery in easy to handle steel boxes



Art.-Nr.	Product code	VPE units	Weight kg/unit
748	PW - 33 - 220V	1	4,000

Technical specifications:

- Mains connection: 220 V - 1 Ph - 50/60 Hz
- Circuit breaker: Minimum 16 A
- Cable length: 3.70 m
- Weight: 4 kg
- Cable section for extension: 3 x 2.5 mm
- This piece of equipment complies with all instructions and directives of the EU

Tips:

PW 33 is a resistance welder with an integrated timer that through a single grip decides on the welding time. It adapts itself to the thickness of the steel sheet, thereby guaranteeing optimum welding. This ensures a reduction in the unnecessary over-heating of the welder.

2.5.2 MEZ-RIP-PIN Accessories

Lock washer CL -1

- Made of galvanised spring steel
- Slanted outer edges
- External diameter 30 mm

Art.-Nr.	Lock washer	Ø mm	VPE units	Weight kg/VPE
381/001	CL - 2 - 30	30	1000	2,400
381/002	CL - 2 - 40	38	500	2,200



Nylon protective cap NSC-2

- To cover the residual stud points
- Delivery in easy to handle packs of ten

Art.-Nr.	Product code	VPE units	Weight kg/VPE
381/003	NSC - 27	1000	0,500



Workmanship and Assembling:

1. Insert RIP-PIN welding stud in the magnetic tip PW-33
2. Set the timer as per the steel sheet thickness
3. Press the welding gun head at right angles to the steel sheet and press the trigger
4. Put insulation material onto the studs
5. Fasten using the lock washer
6. When required, cover the residual stud points with nylon protective cap

Tip:

To avoid overheating of the equipment, weld a maximum of 6 - 8 studs per minute

Assembling suggestions for insulation-welding studs:

Insulation material		Number of studs per sq. m at			
Tightness kg/m	Thickness mm	23°C	40°C	60°C	80°C
20	25	4	4	4	4
20	50	4	4	4	4
20	100	4	4	4	4
40	25	4	4	4	4
40	50	4	4	4	6
40	100	4	4	6	8
80	25	4	4	4	6
80	50	4	4	6	8
80	100	4	6	8	16
120	25	4	5	6	8
120	50	5	6	8	12
120	100	6	8	12	24

