

• **CD 1000** **Technical Data Sheet**



HBS Power Unit

for tip ignition studwelding (capacitor discharge welding)
according to DIN EN ISO 14555



Type:	CD 1000		
Welding range:	M3 to M6 (#4 to 1/4")	dia. 2 to 6 mm (14 ga to 1/4")	CHP dia 2 to 3.1 mm (14 ga to 10 ga)
Welding material:	Mild steel, stainless steel, brass		
Welding rate:	6 to 15 studs/min. (depending on application and stud dia.)		
Capacitance:	66.000 µF		
Welding time:	4 to 7 msec.		
Energy:	1.600 Ws		
Charging voltage:	60 to 220 V (stepless voltage regulation)		
Power source:	Capacitor discharge		
Primary power:	230/115 V, 50/60 Hz, 10 AT		
Insulation class:	IP 21		
Dimensions:	350 x 190 x 240 mm (13.78" x 7.48" x 9.45") (LxWxH) (without handle)		
Weight:	15 kg (33.06 lbs)		
Order no:	92-10-0100		

Description:

- Cost effective standard stud welding unit
- Suitable for tip ignition with contact (CD studs and cupped head pins)
- Compact and very strong metal housing to withstand rough conditions
- Operation at high voltage fluctuations (-25 % up to +20 %)
- With integrated mains filter
- High-Tech microcontroller to guarantee precise process control, safest operating conditions and highest operating comfort
- Stepless voltage regulation
- Error code indication by LED indications
- Easy control of all functions by LED indications
- Easy change of polarity of welding voltage by interchanging welding current cable and ground cable (only if required)
- Temperature control of transformer – automatic shut off at overheat
- Highest safety standard by automatic control of thyristor (SCR) and contact to work piece
- EMC-tested
- Recorded high voltage test
- Special designed for welding CD studs and cupped head weld pins with same adjustment, no spring pressure adjustment, no change of spring (one gun for two applications)