



Nelweld[®] N1500i[™] Auto-Feed Systems

Low-cost short-cycle fastener welding with semiautomatic hand-gun or automated weld head

This portable auto-feed stud welding package is ideal for quality-minded fabricators in need of boosting fastener welding productivity. N1500i can deliver up to 1500 amps for short-cycle drawn-arc fastener welding, and FFL100M feeder can feed stud pneumatically to a hand-held PFL901 gun or a KFL901 robot-held weld head. N1500i features a friendly user interface with 10+ weld program presets, bright alpha-numeric displays; graphic gun and weld quality indicator. Its simplicity reduces set-up time, operator training, and error. The features and benefits include:

- **Weld Monitor[™]** built-in process monitor to detect suspect welds and send alarm
- **Gun Monitor[™]** built-in gun watchdog to match gun speed and adaptively compensate for gun wear
- **Cable Monitor[™]** built-in weld cable and connector watchdog to detect cable wear and loose connector
- **Stud Expert[™]** choose setting from stud diameter and can be re-programmed by user spreadsheet
- **Pulse Waveform** reduces heat input, cuts surface contaminants and stabilizes arc in difficult conditions
- **Plunge Current[™]** saves electricity, reduces cable wear, and maintains arc energy despite gun wear
- **Cold Plunge Prevention[™]** extends arc time when stud plunge is slowed down
- **Eco Escape[™]** saves up to 62% compressed air in stud feed and associated energy (optional)
- **Silent Sort[™]** segment arm quietly and gently sorts the studs with minimal moving parts
- **Nelware[™]** production weld quality record keeping for SPC and arc signal oscilloscope PC software

The welding system carries a 2 year or 1,000,000 weld warranty.

Applications

- Automotive manual repair work
- Automotive manual production
- Automated production with robot or hard automation
- Short cycle welding of wide top (large flange), fir tree, threaded studs and trim studs

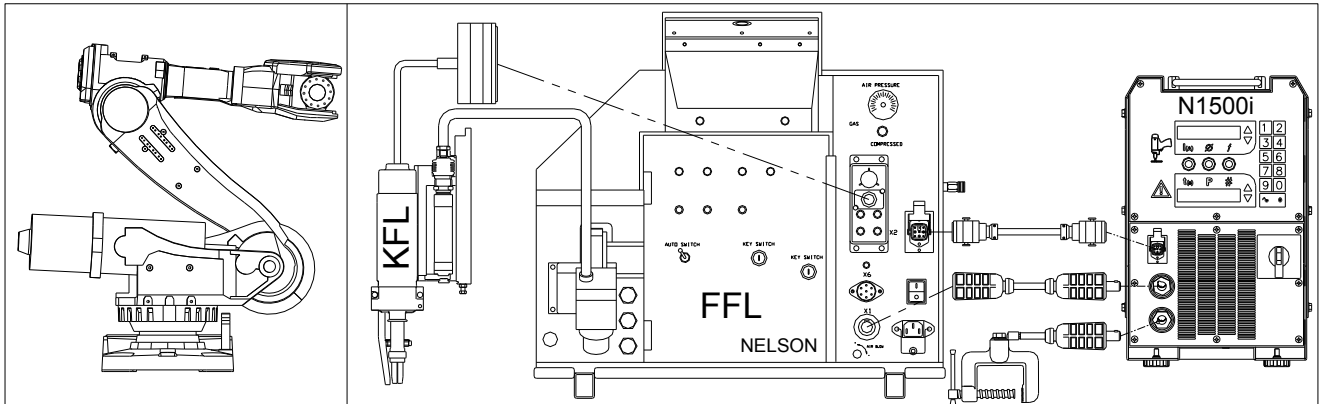
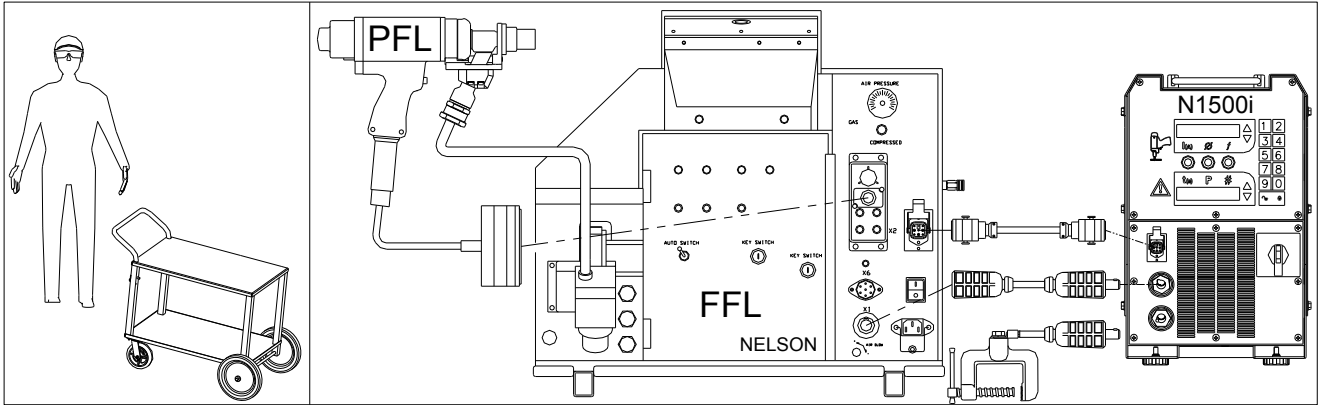
N1500i Auto-Feed

Technical Data

Auto-feed Inverter Stud Welding

High performance, productivity, user friendly

N1500i Auto-Feed with FFL

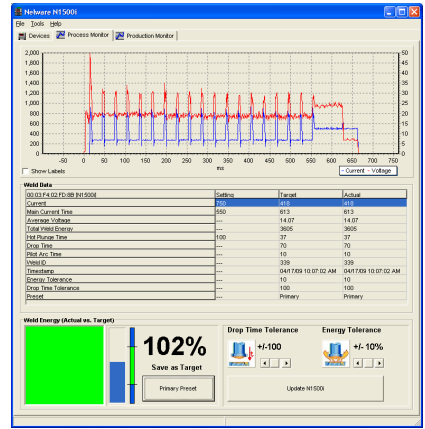
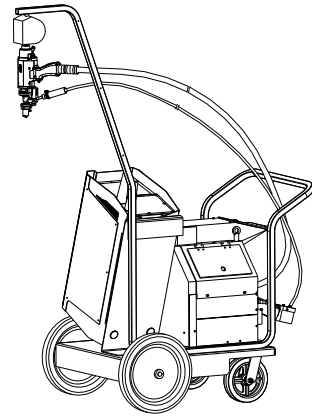


Weld Current	50A-1500A continuously adjustable
Weld Time	5 – 100 ms
Dimensions	27 cm X 42 cm X 71 cm for N1500i 56 cm X 56 cm X 56 cm for FFL 32 cm X 19 cm X 8 cm for PFL 41 cm X 17 cm X 11 cm for KFL
Weight	36 kg for N1500i 60 kg for FFL, 80 kg with studs 2.5 kg for PFL, 7.0 kg with tube 5.4 kg for KFL without tube
Welder Input	3 phase 208-240V, 50/60 Hz @ 60A 3 phase 400-460V, 50/60 Hz @ 30A 3 phase 575V, 50/60 Hz @ 25A 1 phase 200-220V, 50/60 Hz @ 60A

Feeder Input	single phase 100-240V, 50/60 Hz
Feed Rate	Max. 45 / min.
Stud Capacity	Approximate 7,500 studs (SC-Z 5x14.2mm)
Air pressure	4.5 bar to 5.5 bar
Base Material	Steel, stainless steel, aluminum, heat-resistant steel, advanced high strength steel
Gun or Head	PFL hand gun, or KFL weld head
Insulation	IP23S for welder, IP20 for feeder, IP30 for guns

Options

- Cart with boom
- Gas control kit
- Eco Escape™ stud escapement on FFL feeder
- Nelware™ PC production monitor data recording



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