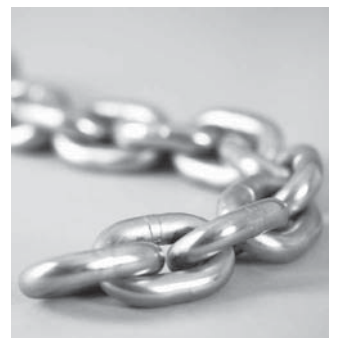


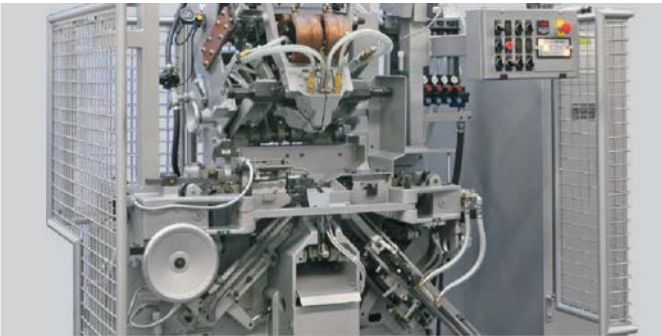
Chain Welding Machines for Resistance Butt Welding of Round Steel Chains



KEH Series

KEH Series

▼ KEH 3



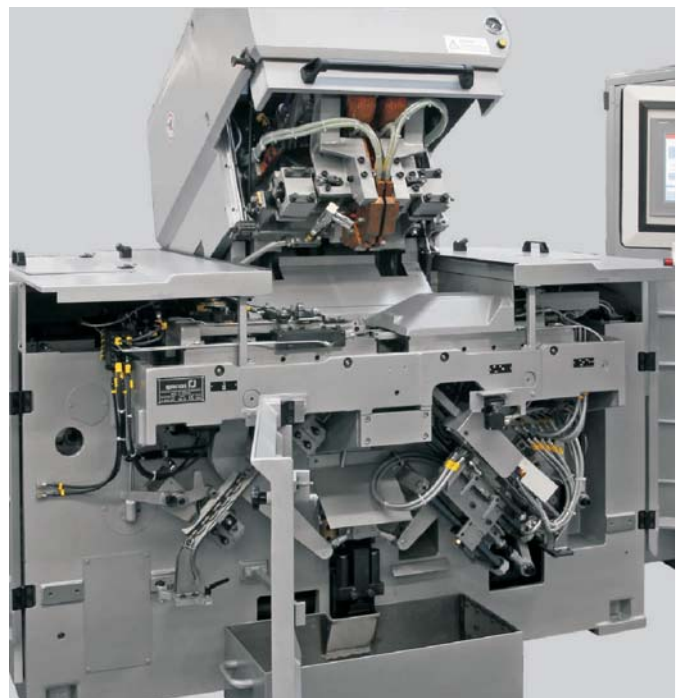
▼ KEH 8



Our Accomplishments for your Benefit

- Robust machine design for the production of high-strength chains over a long period of time
- Continuous welding of all chain links in one cycle
- Complete deburring of welding burr
- Greater output because of individually adjustable rpm numbers for welding, deburring, and transport (KEH 41 and KEH 51)
- The welding current is controlled relative to the continuously recorded upsetting force (KEH 41 and KEH 51)
- Frequently copied but never matched

▼ KEH 41



Design Features

- Drive system:
 - Three-phase brake motor (KEH 3 and KEH 7)
 - Servomotor (KEH 41, KEH 51, and KEH 8)
- Complete deburring of welding burr takes place in two cycles: transverse deburring and longitudinal deburring. This ensures an optimum chain link surface without deburring residue.
- Safety devices for protecting tools and machine parts.
- Upper part of the machine can be swiveled backward to ensure optimum tool accessibility.

Quality, Reliability, and Efficiency

WAFIOS KEH – Chain Welding Machines

Application

KEH-series chain welding machines are used for the resistance butt welding of bent round steel chains with notching on the chain link ends. The welding burr on the chain link is completely deburred by the chain welding machine.



▲ Set of tools for KEH 51

Quality

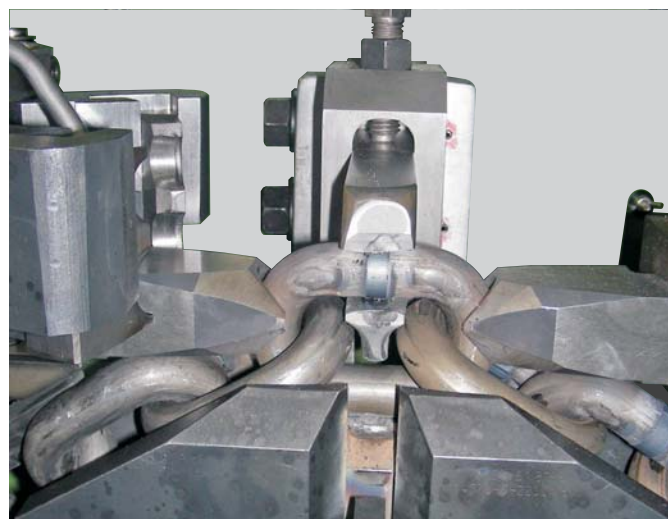
For more than 100 years, the name of WAFIOS has been synonymous with highest quality, safety standards, and technical innovations in the German machine manufacturing industry.

Reliability

Strict quality controls, state-of-the-art production systems, and many years of experience guarantee that your investment is safe in our hands. Our global service network ensures high availability of WAFIOS machinery.

Efficiency

High production output and a long service life will save money and shorten the amortization time of your investment.



▲ Set of tools for KEH 8

Technical data	KEH 3 S	KEH 3	KEH 41	KEH 51	KEH 7	KEH 8
Wire dia. (mm)	3.0 - 5.0	3.0 - 6.0	5.0 - 10.0	8.0 - 13.0	10.0 - 16.0	13.0 - 20.0
Pitch / inside link length of welded link (mm)	9.0 - 31.0 min. 2.7 x d	9.0 - 39.0 min. 2.7 x d	14.0 - 65.0 min. 2.7 x d	22.0 - 80.0 min. 2.7 x d	28.0 - 100.0 min. 2.7 x d	32.0 - 130.0 min. 2.7 x d
Output (links/min)	90 - 84	75 - 65	75 - 50	55 - 34	35 - 20	27 - 14
Power installed (KW)	2.2	2.2	3.0	3.0	5.5	27.4
Welding transformer: rated power at 50% duty cycle (kVA)	30	40	100	150	200	315
Welding transformer: connected load (kVA)	45	60	150	220	300	450
Compressed air requirement (l/cycle at 6 bar)	6	6	8	11	25	0,5
Cooling water consumption (l/min at 3 bar)	15	15	20	25	30	35 at 4 bar
Hydraulic system tank contents l	---	---	---	---	3	630
Space required L x W x H (mm)	abt. 2,560 x 2,400 x 2,300	abt. 2,560 x 2,400 x 2,300	abt. 4,100 x 3,100 x 2,300	abt. 4,400 x 3,300 x 2,500	abt. 3,720 x 2,900 x 2,400	abt. 5,500 x 4,000 x 2,750
Net weight in kg:						
Machine	abt. 2,000	abt. 2,000	abt. 3,800	abt. 5,100	abt. 5,400	abt. 9,000
Switch cabinet	abt. 400	abt. 400	abt. 400	abt. 400	abt. 400	abt. 400
Hydraulic system	---	---	---	---	---	abt. 1,700



Our product range includes a wide variety of high-quality chain machines.

- Chain bending machines, KEB.1 series
- Chain bending machines, KER series
- KBA 601 chain bending machine with WED 601 conductive blank heating or with IEW 601 inductive blank heating
- Chain welding machines, KSH series
- Chain calibrating machines, KPH series
- KBS 4.1 combined chain bending and welding machine

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Precision Machinery for Wire and Tube