



KM-CFK **Compacting Station (Resistance Welding)**

- Reliable compacting of stripped wire ends / strands
- Short cycle times
- Easy changeover for different wire cross sections
- Quality assurance with automatic data storage (PC-based controller)
- Power amplifiers for mid- and high frequency available

STATIONS

KM-CFK

Concept

With the Strunk KM-CFK compacting station, stripped wire ends from 0.5 up to 6 mm² (20 – 10 AWG) are compacted with a resistance welding process on fully automatic crimping machines of the CrimpCenter 6x series. The system includes the KM-CFK station, a separate control unit and a separate (optional) cooling unit. The stripped wire end is positioned in the tooling of the compacting station by the swivel arm of the CrimpCenter. Then the individual strands are compacted between vertically installed electrodes. On both sides, ceramic plates determine the compacting width. Change-over of electrodes and ceramic plates for different wire cross sections is easy and fast. Welding parameters can be monitored during the entire process and saved for quality checking when using the optional PC control unit.

The standard KM-CFM compacting station includes the following items:

- KM-CFK compacting station with base frame
- Transformer 50 Hz
- 50 Hz power section (thyristor based) or inverter for mid- / high-frequency
- Board-based controller
- Electrode kit for one wire cross section

Applications

Possible machine configurations and combination with crimping, sealing or other processes depend on the number of available stations of the CrimpCenter 6x model.

Compacting one or both wire ends

- CrimpCenter 64
- CrimpCenter 67
- CrimpCenter 67 HD16

Options

- Power amplifier mid- / high-frequency
- PC control unit
- Compaction measurement system for quality assurance
- Cooling units (either 50 Hz or 60 Hz) for fully automatic processing

Technical specifications	
Conductor Cross-Section	0.5 – 6 mm ² (20 – 10 AWG)
Electrode Force	1800 N (400 lbs.)
Welding Powe	104 kVA
Sec. Off-Load Voltage	4 V
Welding Current	20 kA
Sec. Short Circuit Current	26 kA
Power Supply	3 L/N/PE AC 400V, 50 Hz (60 Hz optional), 32 A or 63 A
Compressed Air Connection	Min. 6 bar (90 psi), filtered and oil free
Dimensions (L x W x H)	KM-CFK: 660 x 180 x 470 mm (26 x 7.08 x 18.50") Control unit: 600 x 550 x 220 mm (23.62 x 21.65 x 8.66") Cooling unit: 600 x 500 x 320 mm (23.62 x 19.69 x 12.6")
Weight	KM-CFK: approx. 90 kg (200 lbs.) Control unit: approx. 22 kg (50 lbs.) Cooling unit: approx. 42 kg (92.59 lbs.)
CE-Conformity	The KM-CFK installed on CrimpCenter fully automatic machines complies with all CE and EMC equipment guidelines relative to mechanical and electrical safety and electromagnetic compatibility.
Important Note	Schleuniger strongly recommends that wire samples be submitted for qualification of the compacting process. Please provide wire samples for evaluation.