The Leader in Metal Working Technologies

WELDING STUDS | FASTENERS | STUD WELDING SYSTEMS
Welcome to Keystone Fastening Technologies
For Uncompromising Fastening Results

With an extensive range of Stud Welding and related Metalworking products, Keystone is the expert when precision, reliability and efficiency is expected. Keystone delivers the extremely precise fastening tolerances that are required in the most demanding applications. Whether it’s our Weld Studs or Stud Welding Systems, our products exhibit uniformly precise welding, durability and long term reliability.

Welding Studs and Equipment
Capacitor Discharge Stud Welding & Drawn Arc Stud Welding Products
Welding Studs
Stud Welding Systems
Stud Welding Consumables
Automation

Specialty Fasteners
Wire Tie Clips
(Work with Welding Studs)
Cap Nuts
Acorn Nuts
Grounding Studs
Cable Management Products
Tagging Products
Custom Cold Headed Parts
Custom Screw Machine Parts

Accessories
Welder Carts
Welding Consumables
Tool Balancers
Torque Tools

Service & Support
Application Engineering
R&D Assistance
Complete Repair Service
Parts Support
Contract Stud Welding

Contact sales or visit our website for specific size and material requirements.
keystonefastening.com • Ph. 800-659-5972
## Capacitor Discharge

<table>
<thead>
<tr>
<th>Weldable Materials</th>
<th>Mild Steel, Stainless Steel, Aluminum, Brass, Copper, Titanium &amp; other alloys</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weldable Stud Range</td>
<td>2-56 thru 3/8&quot; (M2 - M10)</td>
</tr>
</tbody>
</table>

- Flanged and Non Flanged
  - External Thread
  - Internal Thread
- Pin Studs - Unthreaded
- Insulation Pins
- Annular Pin Studs
- Collar Studs
- Keyhole Studs
- Knock off Studs
- Ground Space Terminal Studs
- Cable Management Accessories
- Material Tagging Systems

## Drawn Arc

<table>
<thead>
<tr>
<th>Weldable Materials</th>
<th>Mild Steel, Stainless Steel, Aluminum, &amp; other alloys</th>
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<tbody>
<tr>
<td>Weldable Stud Range</td>
<td>1/8&quot; thru 1&quot; (M3 - M25)</td>
</tr>
</tbody>
</table>

- External Thread
  - Full, Partial
- Reduced Base
- Internal Thread - Tap Pads
- Pin Studs - Unthreaded
- Collar Studs
- Shoulder Studs
- Annular Pin Studs
- Cable Hangers
- Deformed Bars
- Headed Concrete Anchors
- Shear Connectors
- Rectangular Studs
- Refractory Anchors
- Fir Tree Studs
- Grounding Studs
- Short Cycle

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Sophisticated Technology, Predictable Performance

Capacitor Discharge Stud Welding Systems

Keystone Capacitor Discharge Stud Welding Systems are Precision Engineered for Long Term Durability and Performance. Our Unique Technology allows operators to achieve Exceptional Weld Quality and Unparalleled Consistency. Units feature Pre Programmed Voltage Adjustability with a Digital Readout, Fault Protection Circuitry and Dual Grounds to ensure optimal results. Most units are Fully Compatible and Combinable with Keystone Automated Systems.

<table>
<thead>
<tr>
<th>Weldable Materials</th>
<th>TS 306</th>
<th>TS 308</th>
<th>TS 318</th>
<th>BS 308</th>
<th>BS 318</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weldable Stud Range</td>
<td>Mild Steel, Stainless Steel, Aluminum, Brass, Copper, Titanium &amp; other alloys</td>
<td>2-56 thru 1/4” (M2.5 thru M6)</td>
<td>2-56 thru 5/16 - 16 (M2.5 thru M8)</td>
<td>2-56 thru 5/16 - 18 (M2.5 thru M8)</td>
<td>2-56 thru M10 (M2.5 thru M10)</td>
</tr>
<tr>
<td>Weld Rate</td>
<td>Up to 30 studs per min</td>
<td>Up to 30 studs per min</td>
<td>Up to 30 studs per min</td>
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<td>Up to 30 studs per min</td>
</tr>
<tr>
<td>Input Power</td>
<td>100 VAC to 250 VAC, 50/60Hz, 3A</td>
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</tr>
<tr>
<td>Compatible Guns</td>
<td>HP-TSK 310, HP-TSK 150</td>
<td>HP-TSK 310, HP-TSG 310, AH-TSG 310 Automatic, SIK-2 Automatic</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Capacitor Discharge Guns

Using Genuine Keystone parts and accessories will ensure performance and long term durability.

CD Accessories (Contact us for full range of Accessories)

Tapered Base Chucks
B-Collets
B-Collet Stops & Inserts
Adapters & Foot pieces

Consumables for other Industry Equipment Brands also Available
Drawn Arc Stud Welding Systems

Developed for professional use, Keystone Stud Welding Systems effortlessly respond to the toughest workplace demands. Our Proprietary Microprocessor and Current Regulation Technology allows operators to achieve Exceptional Weld Quality and Unparalleled Consistency. Our D Series Systems feature a Digital Interface that offers Programmable Voltage and Time Parameters allowing for repeatable operator performance and weld quality. All of our ARC systems are shielding gas capable.

### Drawn Arc Guns

<table>
<thead>
<tr>
<th></th>
<th>HP 314</th>
<th>HP 319 with Dampening</th>
<th>HP 1022 - Heavy Duty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weldable Stud Range using ceramic ferrules</td>
<td>1/8” – 1/2” (3 – 14 mm)</td>
<td>1/8” – 3/4” (3 – 19 mm)</td>
<td>3/8” – 1” (10 mm – 25 mm)</td>
</tr>
<tr>
<td>Weldable Stud Range using short-cycle</td>
<td>1/8” – 3/8” (3 – 10 mm)</td>
<td>1/8” – 3/8” (3 – 10 mm)</td>
<td>N/A</td>
</tr>
<tr>
<td>Weldable Stud Range using shielding gas</td>
<td>1/8” – 3/8” (3 – 10 mm)</td>
<td>1/8” – 5/8” (3 – 16 mm)</td>
<td>N/A</td>
</tr>
</tbody>
</table>

### Drawn Arc Accessories (Contact us for full range of Accessories)

**English & Metric Sizes**

- Headed Anchor Chucks
- Tapered Base Chucks
- Thru-deck Accessories
- Ferrule Grips & Shielding Gas Kits
- Refractory Anchor Chucks & Accessories

Consumables for other Industry Equipment Brands also Available
Stud Welding Automation

Efficiency through Automation

Keystone offers a wide range of semi and fully automated stud welding solutions customized for your specific application. Our welding automation provides competitive advantages such as higher quality and repeatability, increased capacity, and higher productivity, all of which help reduce your manufacturing costs.

- Time Savings - Welds up to 40 studs per minute
- Accurate, Precise and Repeatable
- Capacitor Discharge & Drawn Arc Stud Welding Systems
- Durable and Dependable
- Keystones Auto Feed Quality Studs Ensure Weld Quality & Feeding Consistency