

Optimal Resistance Spot Welding

► With cutters and holders for tip dressers

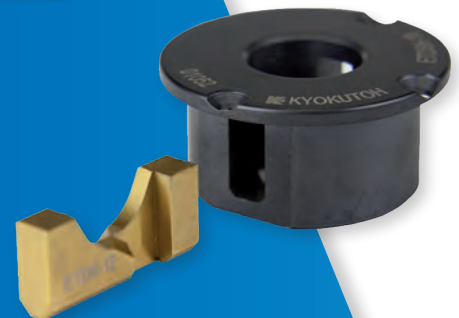
Tip dressing helps ensure consistent and high-quality welds. With more than 30 years of experience, KYOKUTOH supplies tip dressing solutions for a wide variety of applications.

KYOKUTOH's cutters and holders are designed to improve the spot welding process. Our customers benefit from optimal dressing results, as well as a longer lifetime with our cutter and cutter holder technology.



Advantages

- More than 2,000 types of cutters and cutter holders
- Shaped dressing for maximum reliability
- Compatible with different fastening systems
- Single cutter design
- OPTIONAL: Patented "breaker" technology to avoid clogging
- Cost effective
- High availability with short delivery times



► Standard KYOKUTOH 50/45 mm bayonet cutters and holders

The standard single-blade cutter holder, with a big opening for chips, is an optimal solution for shaped dressing. The bayonet locking system allows for easy and fast assembly. Different mo-

dels of cutters with special properties help customize the tip dressing process for your needs.

► Standard cutter holders and cutters for Europe

For tip dressers with bayonet seat (Type T3)

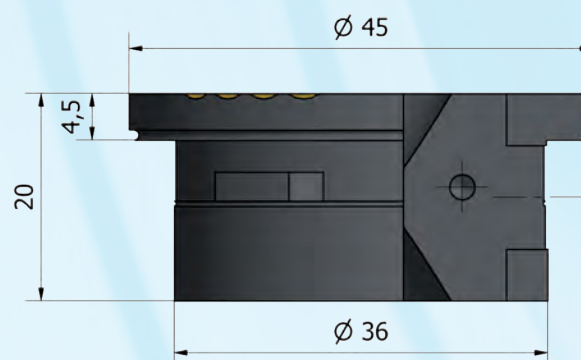
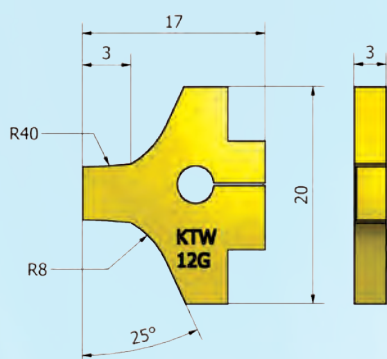
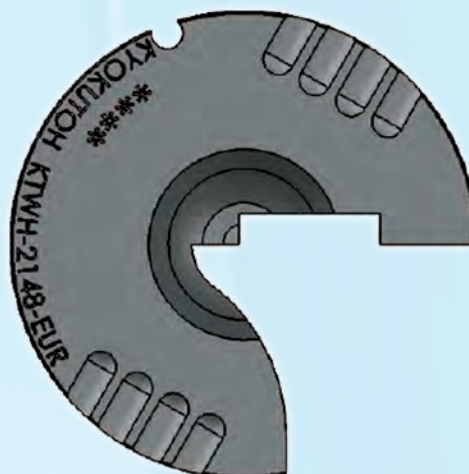
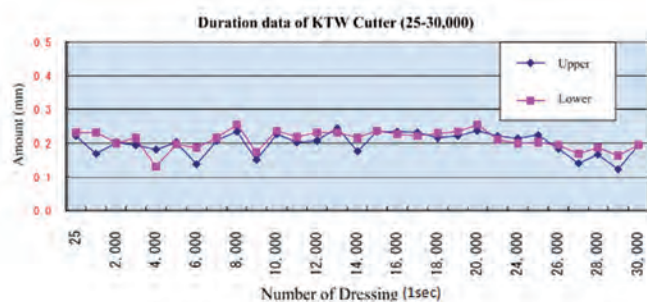
- Bayonet mount for quick change
- Cost effective
- Large chip relief
- Longer lifetime
- Standard, best-selling cutter in Europe



KTWH-12G-EUR holder
with KTW-12G cutter



Possible Tool Life



► Standard cutters and holders for special applications

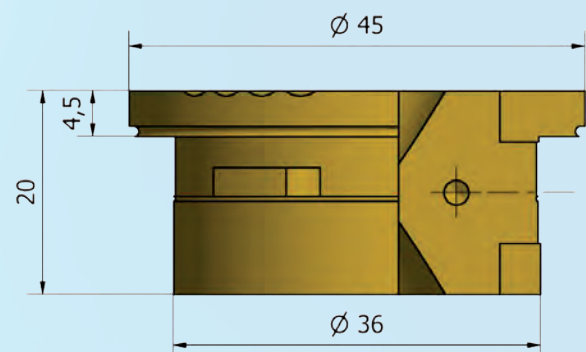
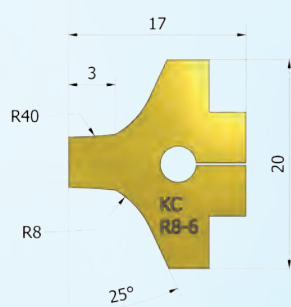
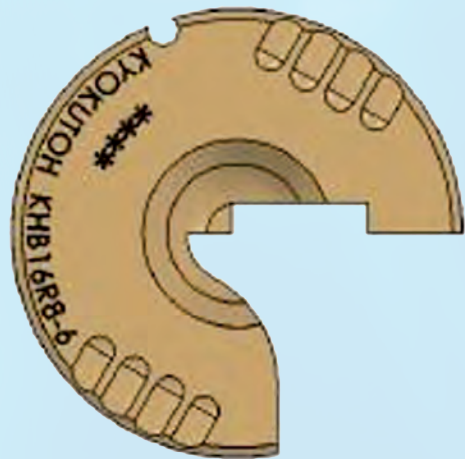
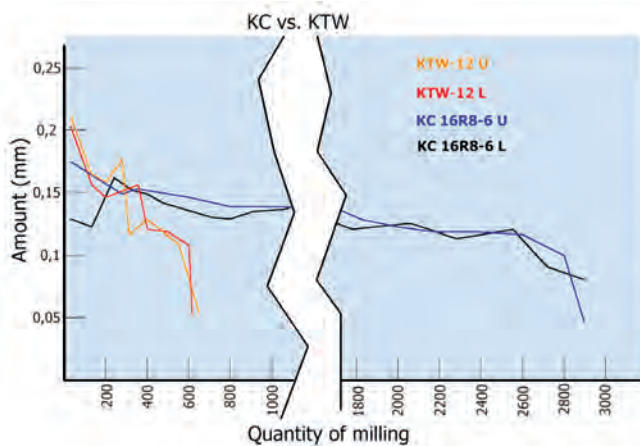
- Best suited for high-strength materials (Usibor®/Aluminum)
- Increased cutter life, up to 8x standard cutters and holders
- Chip breaker technology prevents a blocking of the holder
- Electrode life is 2–3 times greater than dressing with standard cutters



With chip breaker to prevent clogging



Tool Life Comparison



► Custom application possibilities

We will match the best cutter and holder combination for your welding application.

► Your perfect cutter and cutter holder...

...needs custom specifications to meet your requirements?
We supply cutters and holders for every application:

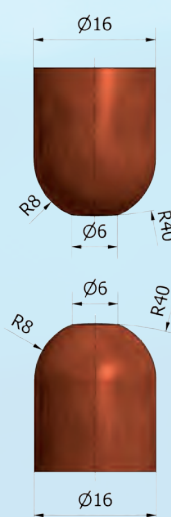
- **Type of material:**
Non-galvanized material, galvanized material, aluminum, Usibor®, high-strength steel
- **Types of welding guns:**
C-gun or x-gun, servo-pneumatic guns, pneumatic guns, guns with tilted shafts
- **Custom parameter requirement examples:**
Minimal weld force, recommended weld force, dressing time, intervals between dressings, dressing speed, etc.

Please contact us with any questions.

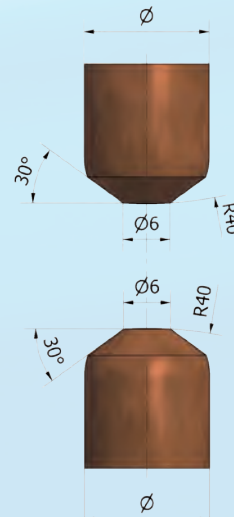
Cap Shapes ISO 5821



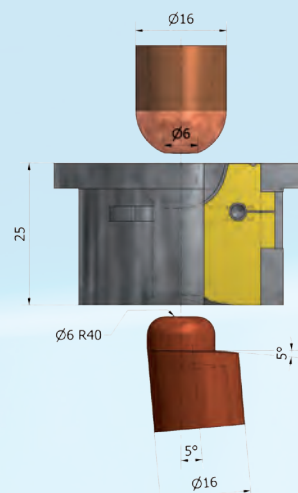
Shaped dressing



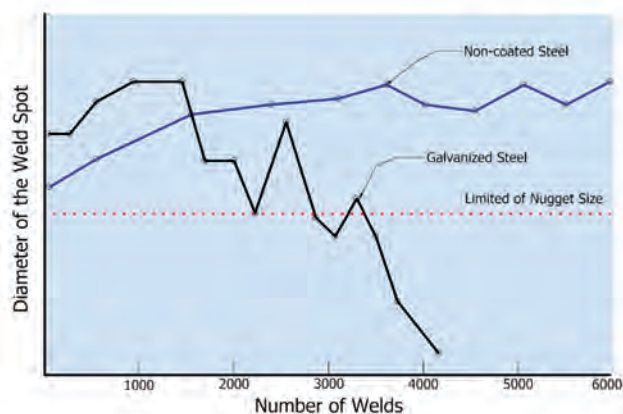
Outline dressing



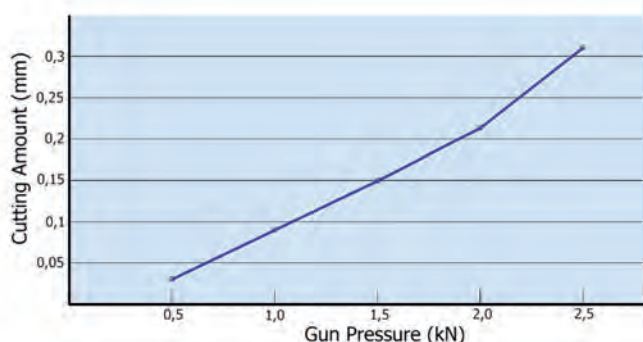
Special solution



Material Influence



Graph of Pressure and Dressing



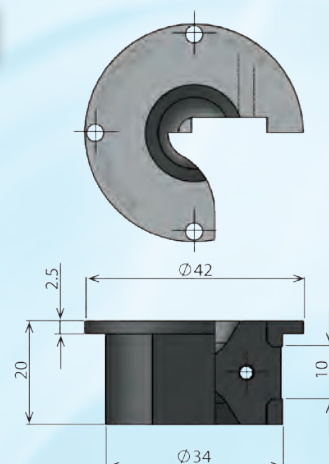
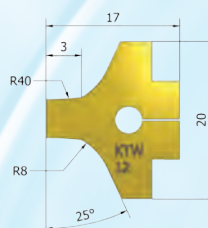
► More cutters and holders

Single-blade cutter holders without the bayonet mount for the American and Asian market with our approved technology.

► Cutter holder and cutter KYOKUTOH 42 mm screw-fastened

- Fastened with 3 screws
- Large relief for chips
- Variety of shapes/styles
- Best-selling cutter/holder in U.S. and Asia

KTWH-12 holder
with KTW-12 cutter

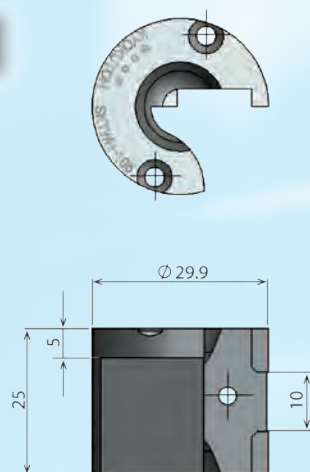
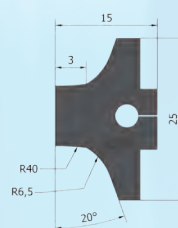


► Cutter holder and cutter KYOKUTOH 30 mm screw-fastened

For small weld guns

- Fastened with 2 screws
- Large relief for chips
- Small dimensions

Holder and cutter SKTW

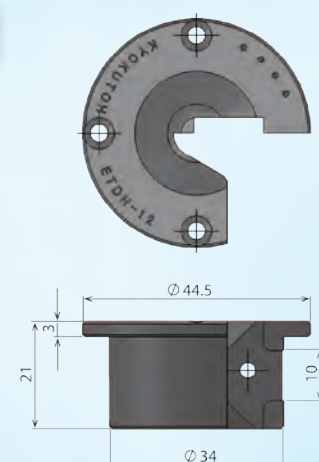
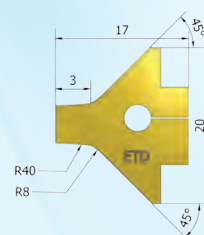


► Cutter holder and cutter KYOKUTOH 45 mm screw-fastened

For manual and pneumatic tip dressers

- Fastened with 3 screws
- Variety of shapes/styles
- Individually customised

Holder and cutter ETD



► We can find the right cutters and holders for your application

Select the options that meet your requirements

- **Diameter of the electrode cap**
13 mm, 16 mm, 20 mm, special types
- **Standard "EUR"**
Bayonet, Ø 45 mm, single cutter, 20 mm height
- **Special "EUR"**
Bayonet, snap ring groove
Ø 45 mm or 50 mm, single cutter or double cutter
Height > 20 mm
- **Guide for electrode caps**
Upper guide, lower guide, without guide
- **Angled X-Guns**
15° standard, wider angles on request
- **Rotation control**
without, upper holder rotation control,
lower holder rotation control

Examples:



Adaption for competitors' dressers,
snap ring groove, upper holder
rotation control



Height greater than 20mm



Adaption for competitors'
dressers, with face holes



Customized adaption
for competitors' dressers

In order to find the best suiting cutter please send us the following information:

1. **Type of electrode caps**

upper

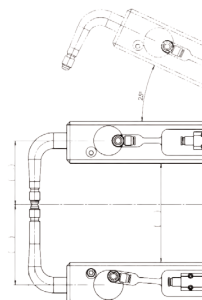
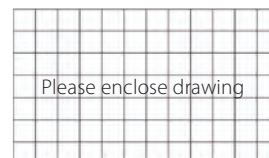
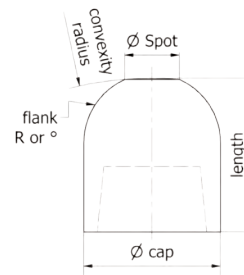
lower
 2. **Spot face**
Diameter and radius:

upper

lower
 3. **Side angle or radius (R or °)**

upper

lower
 4. **Type of seat**
e.g. Bayonet 45 mm
 5. **Rotation control**
 6. **Welding material**
 7. **Welding gun type**
C-Gun or X-Gun
- When using angled X-Guns:
- upper angle
- lower angle



Please attach a drawing for special
welding guns or guns with very short shanks

KYOKUTOH
Europe GmbH
 info@kyokutoh.de
 www.kyokutoh.de

Office München
 Radtkoferstraße 2
 81373 München/Germany
 Tel. +49-89-74 11 85-313
 Fax +49-89-74 11 85-315

Office Unna
 Max-Planck-Straße 4
 59423 Unna/Germany
 Tel. +49-2303-979 37 92
 Fax +49-2303-979 36 04