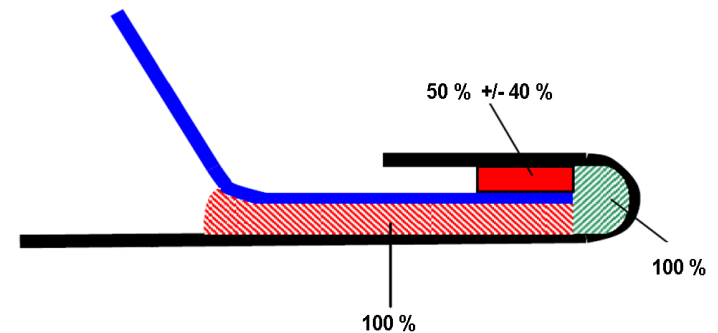
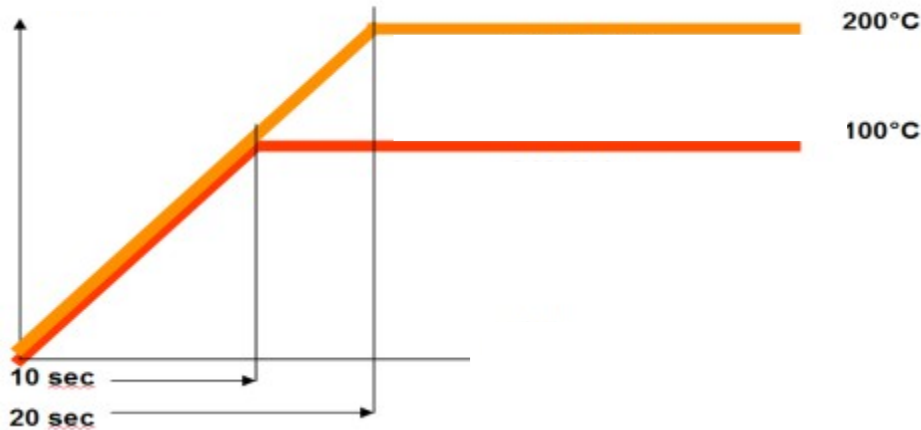


Process tasks

- Heat treatment of structural adhesives in add-on components
- Achievement of pre-fixation of internal and external sheet metal (handling stability for subsequent process steps)
- Corrosion protection (sealing) by means of polymerisation of adhesive
- Reduction of component distortion and safeguarding of the final component shape



Process requirements



	Full Ring Steel One component	Full Ring ALU One Component	Spot steel / ALU Two Components
Temperature	160 – 210°C	140 – 180°C	100 – 110°C
Heating time	6 – 20 s	30 - 45 s	5 - 10 s
Hold time	20 - 40 s	20 - 45 s	20 - 30 s

Circumferential heating 1 - Habiflex®

- 1 component applications with steel- or aluminium components (190°C)



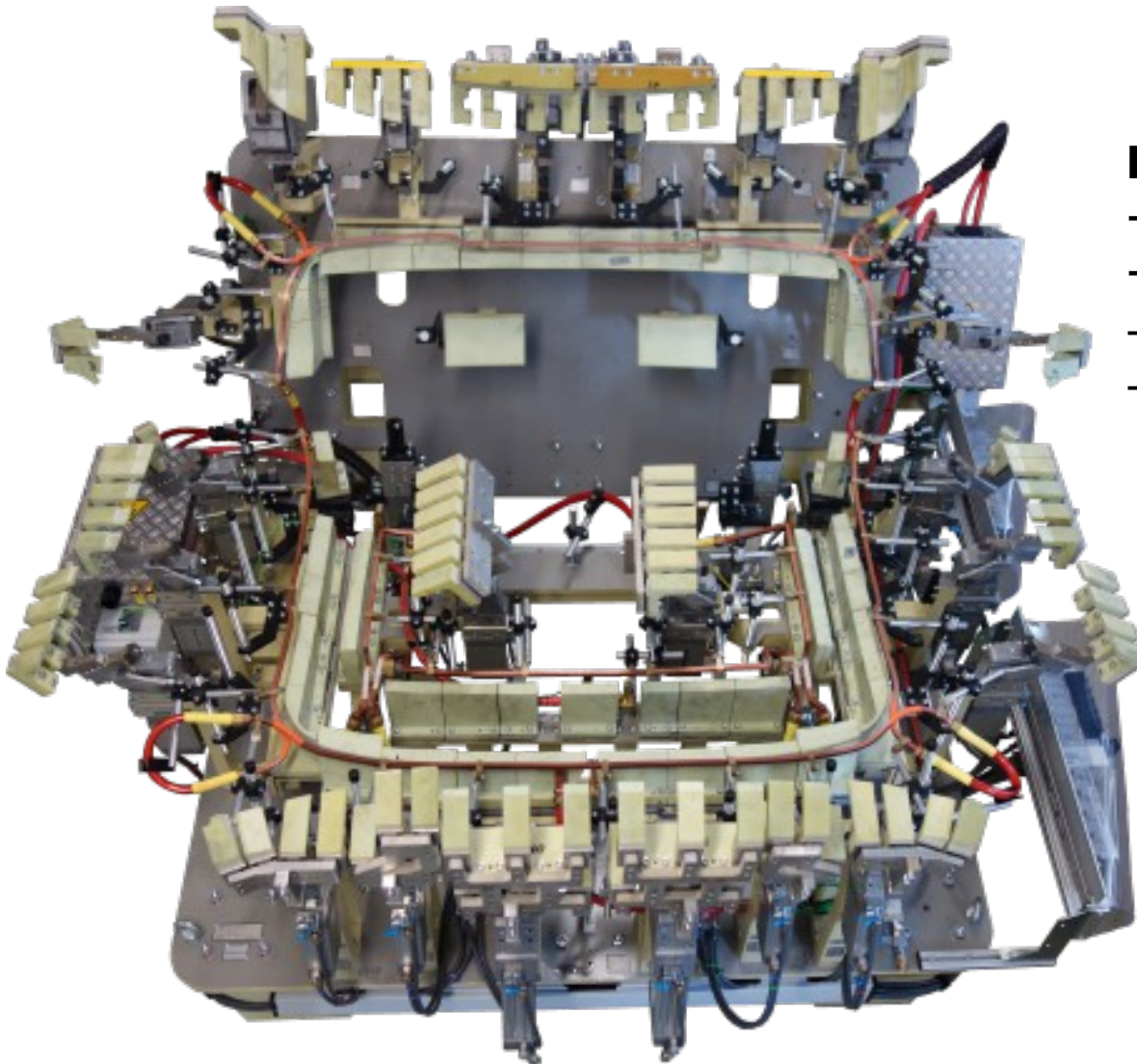
Habiflex® inductor

- + standard spare parts
- + easy to install and to adjust
- high risk of deformation in case of a crash
- limited MF-current



Circumferential heating 2 – rigid copper

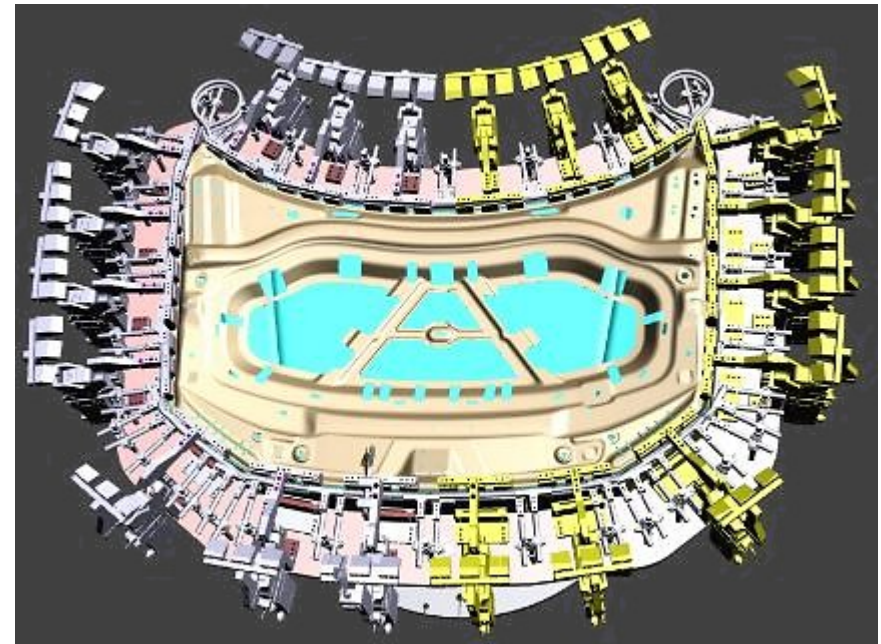
- 1 component applications with steel- or aluminium components (190°C)



- Rigid copper inductor**
- + high MF-current
 - + robust design
 - higher installation effort
 - customer-specific spare parts (when needed)

Design circumferential heating I

generator 30-60 kW with chilling unit
(water/air or water/water)



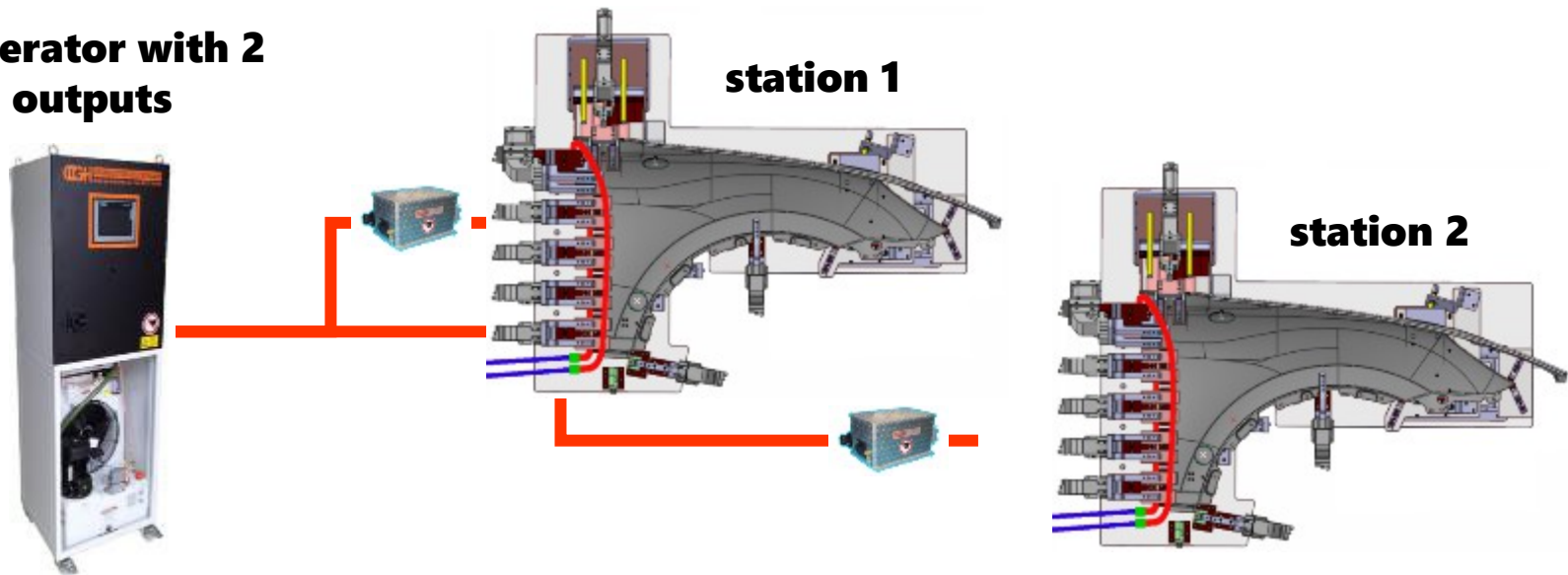
Curing station
with inductor



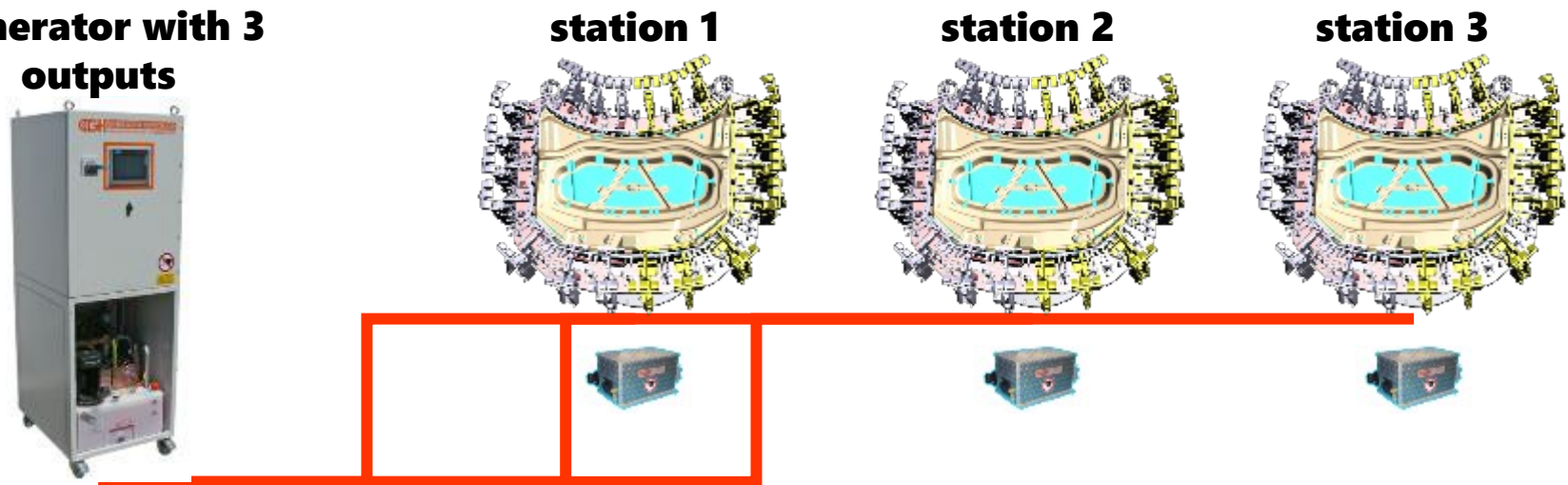
Resonant-circuit unit on curing frame

Design - circumferential heating II

Generator with 2 outputs

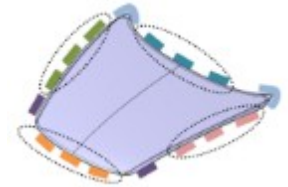
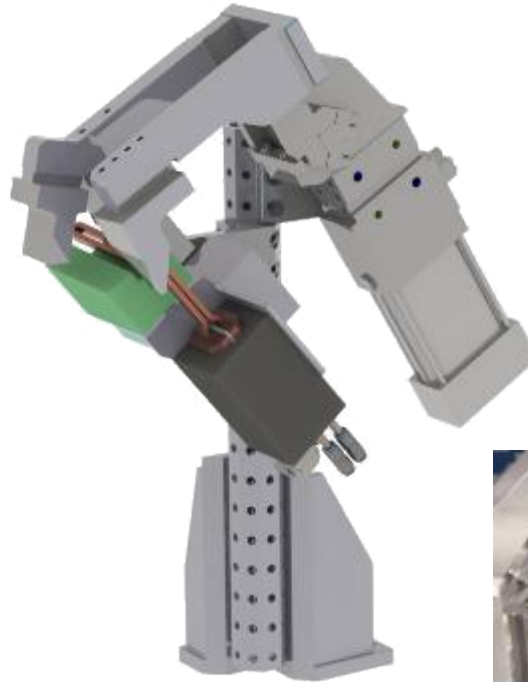


Generator with 3 outputs



Multispot heating

- 2 component applications with aluminium components (120°C)
- energy-efficient unit

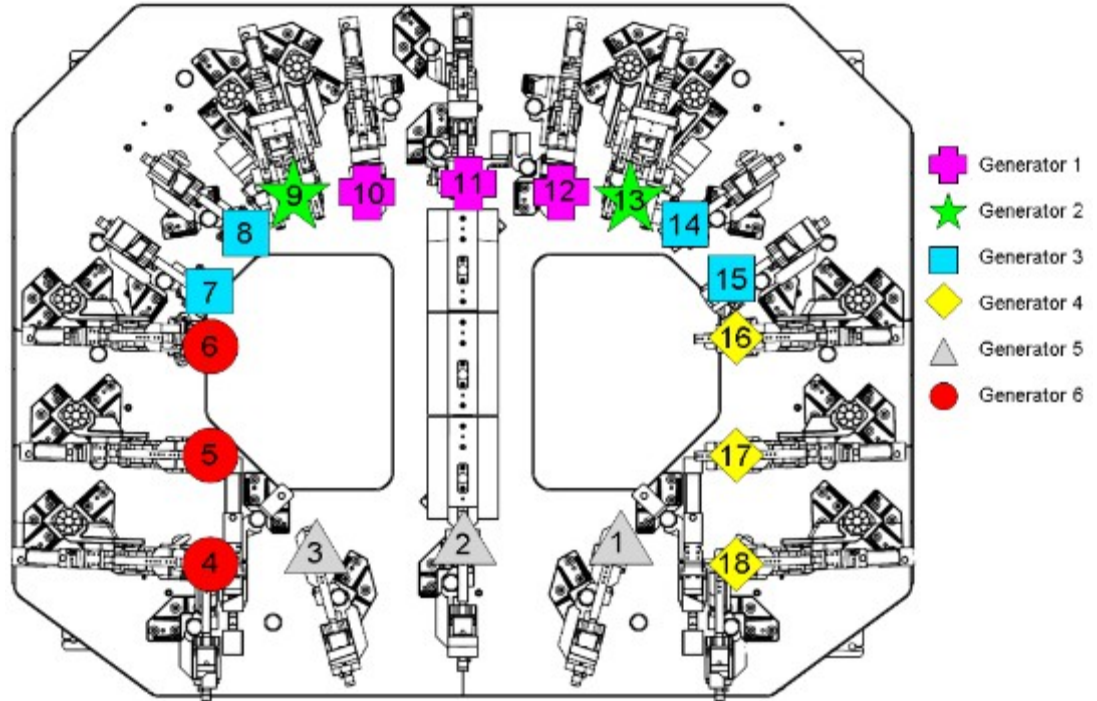


Multispot technology

- + minimised high-current pathes, thus reduced losses and high efficiency.
- + Separate power adjustment
- Higher material costs

Design – circumferential heating

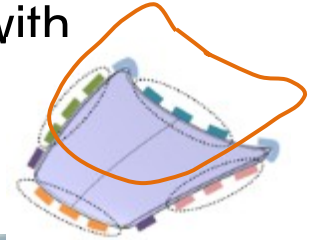
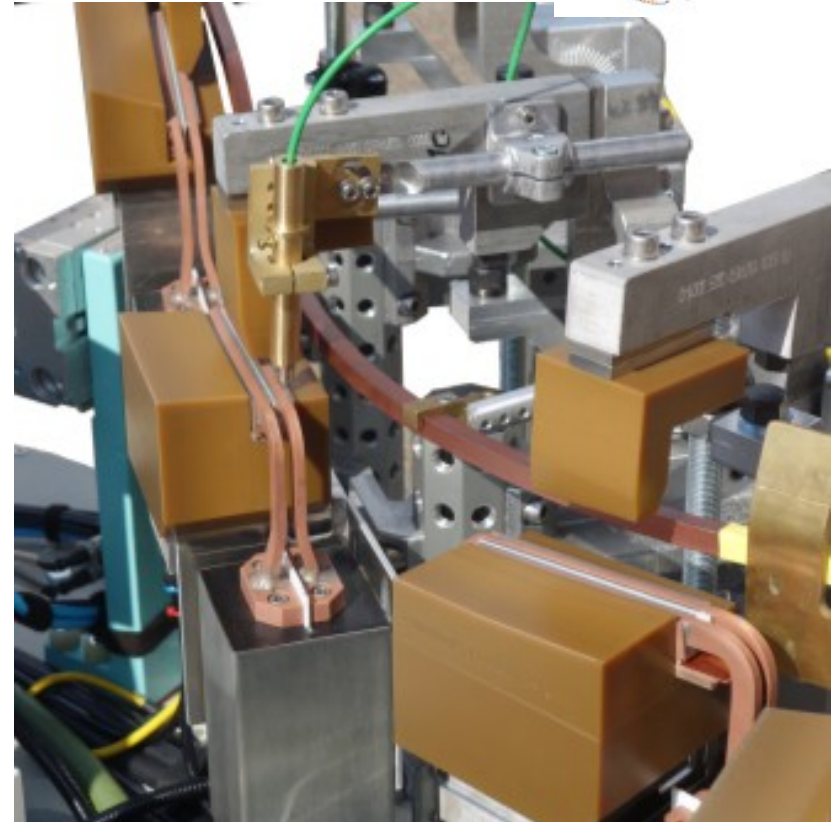
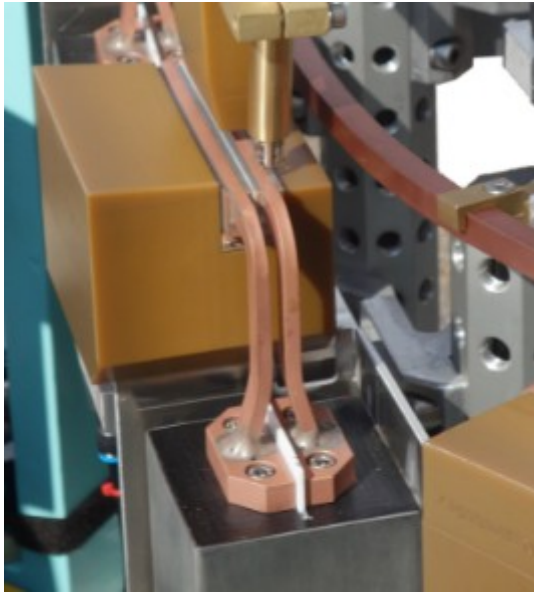
Generator with 6 outputs
à 5 kW with chiller unit



Resonant-circuit unit on curing frame

Hybrid Bonding

- 2 component applications with aluminium components with hot-melt components (120°C)

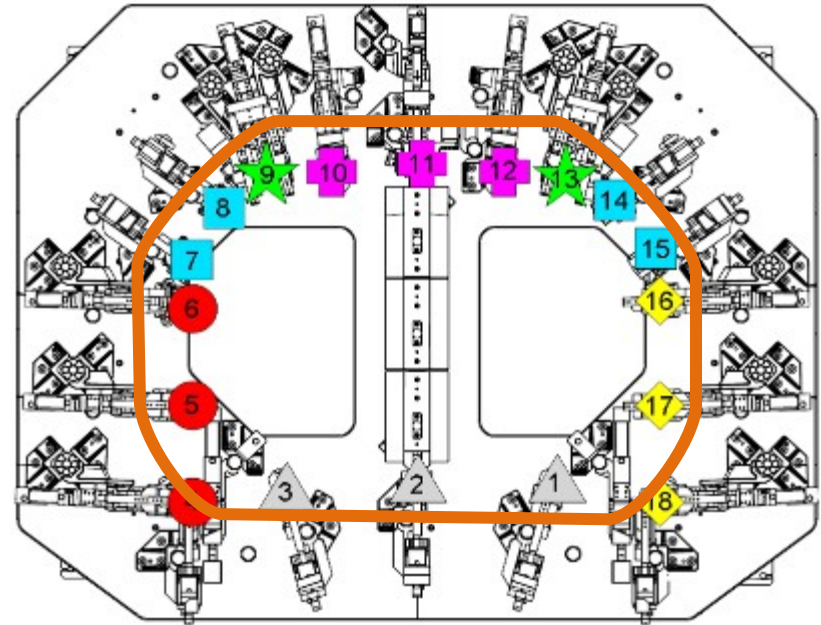
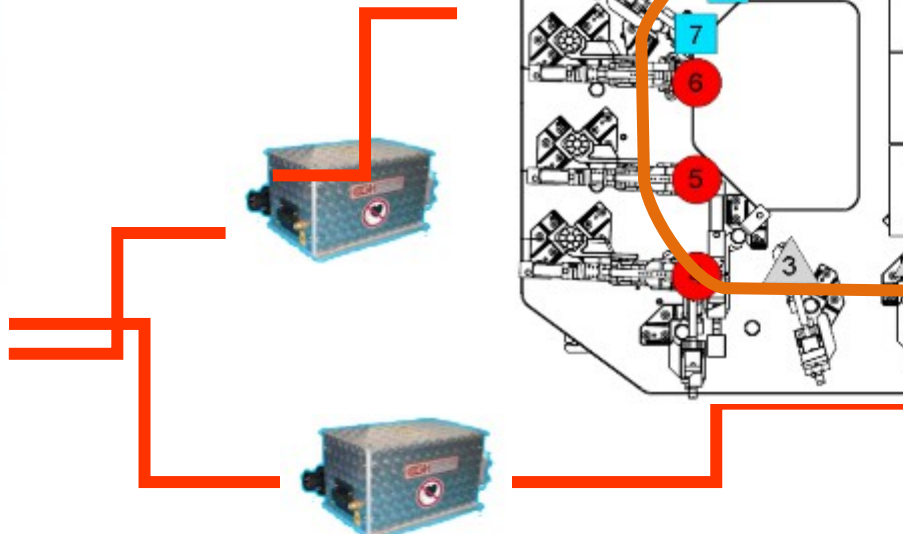


Hybrid bonding technology

- + combined advantages of spot and circumferential heating
- + complete heating for reception of hotmelt lubricants
- higher material costs

Design - hybrid bonding

Generator with up to 5 outputs
4 x 5 kW (spots)
1 x 30 kW (circumferential)
with chiller unit



Resonant-circuit unit on curing frame

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