

Installation of clamp mounted coils on EFD (Elva) welders

EHE clamp mounted coils use a machined copper clamping system to attach coils to the welder coil termination assembly. This system facilitates rapid coil changes by eliminating the need to remove or loosen nuts on the inaccessible lower side of the Elva busbar.



Installation instructions

The machined copper clamps supplied with these coils are designed for use only with standard EFD Elva busbars, which are 28mm (1.125") thick. If your busbars are worn, or have a different thickness, custom machined clamps will be required in order to provide a proper electrical connection. PTFE shims may be used between the two coil plates to ensure a flat contact area.

Because of the very high currents involved with solid state welders, the contact area must be as large as possible, and must be kept flat & clean. Both the clamps and the contact area of the coils are silver plated to reduce contact resistance, however the clamps must be correctly installed to ensure that pressure is evenly applied over the entire contact area.

The clamping force required for good electrical contact is provided by nuts & epoxy/glass threaded rods. Do not over tighten the nuts as this may damage the threads on the epoxy/glass studs. We recommend using a torque wrench set at no more than 10 ft. pounds.

These coils are intended for right to left mill operation, as shipped. For left to right mills, the coil should be inverted. The clamping nuts should face upwards for easy access when changing coils.

The Micarta™ blocks are used to prevent damage during transportation & must be removed prior to installation.