

1-2-3 EASY SET-UP GUIDE TO GAP WELDING

Refer to Figures 1, 2 and 3 to the right.

Figure 1 depicts the optimal set-up for the fastener in the chuck. To set the stud in the chuck, loosen the backstop until the fastener extends approximately $\frac{1}{8}$ inch from the front of the chuck. Tighten the back-stop locking nut to preserve this setting. For fasteners longer than 1- $\frac{1}{2}$ inch, back the stop all the way out to obtain as much engagement in the chuck as possible.

If you are welding to aluminum, the set-up of the gun will be as depicted in Figure 2. First follow the directions for Figure 1. Then fully insert the chuck into the gun and tighten the chuck-locking nut. Loosen the two legs by releasing the four (4) set screws in the faceplate. Adjust the legs so that only the flange (approximately $\frac{1}{32}$ inch) of the fastener is observed beyond the brass ring. Tighten the four (4) set screws in the legs. Finally, adjust the spring pressure at the slot screw in the rear of the gun. The pressure should be set to 3.

If you are welding to mild (carbon) or stainless steel, the set-up of the gun will be as depicted in Figure 3. First follow the directions for Figure 1. Then fully insert the chuck into the gun and tighten the chuck-locking nut. Loosen the two legs by releasing the four (4) set screws in the faceplate. Adjust the legs so that approximately $\frac{3}{32}$ inch of the fastener is observed beyond the brass ring. Tighten the four (4) set screws in the legs. Finally, adjust the spring pressure at the slot screw in the rear of the gun. The pressure should be set to 1. The gun set-up is now complete.

Make sure all cables are securely fastened to avoid arcing at the control unit. Set the control voltage using the up/down arrow keys to the desired setting as indicated on the front control panel table.

