

ALUMINIUM STUD WELDING AND HOW TO USE YOUR ALU-PIN-PULLER.

INNOVATION IN ALUMINIUM AUTOBODY REPAIRS - FROM FAN.



WORKING WITH THE ALU-PIN-PULLER

Preparing the stud welder

Screw in the earth cables and clamp them to the damaged aluminium sheet (2 cables).

Screw in the pistol cable + monitoring jack.

Preparing the aluminium sheet

Remove the paint from the damaged area.

Clean the contact area for the earthing clamp, and fasten the clamp.

Roughen the aluminium surface with a steel brush.

Switch on the ALU-PIN-PULLER (230 V)

Screw the correct fixing head into the pistol head.

Insert the aluminium stud to be welded –

Caution: Ignition tip must not be damaged.

Place the pistol down - straight - on the dent, and quickly press the trigger all the way. The ignition at the tip - with a 'bang' - welds the stud to the aluminium.

Screw on a FAN pull-stud.

Mount the Powerlifter, with the back-claw – attach the crossbar and pull.

Caution: Always pull the aluminium stud upwards - never to one side

Troubleshooting

Aluminium dent not properly cleaned.

Contact surface on earthing clamps not properly cleaned.

Aluminium stud has no ignition tip.

Incorrect settings - observe guideline values: 4 mm stud = Setting n° 4; 5 mm stud = Setting n° 5, always change with +/-.

Caution: Different aluminium alloys require different settings (always do a trial weld before starting work).

TECHNICAL DATA

ALU-PIN-PULLER

Power source	Capacitor
Input voltage	230 V/50 Hz; 115 V/60 Hz; (± 10 %)
Charging capacity	max. 66,000 µF
Welding range	M2 - M8
Open-circuit voltage	< 30 V
Dimensions L x W x H	380 x 165 x 290 mm
Weight	12.5 kg
Fuse	F1 and F4: 4 A (medium-slow); F2: 1 A (quick-blow)
Degree of protection	IP 23
Safety class	1
Mains cable	3 m
Cross-sectional area of cable	3 x 1.5 mm ²
Temperature range	0° C - + 35° C

FAN welding pistol

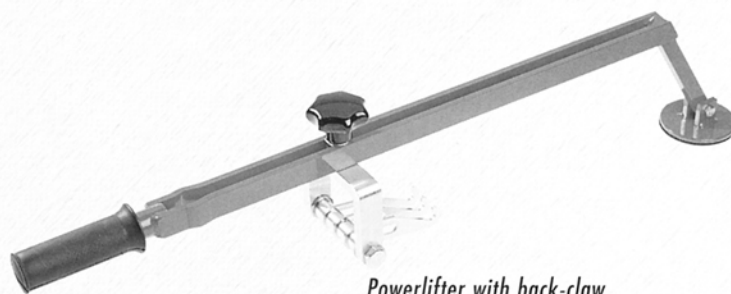
Control voltage	90 V (± 10 %)
Weight	(without cable) 0.6 kg
Welding range	diam. < 10 mm
Welding cable	3 m
Cross-sectional area	25 mm ²
Control cable	3.2 m
Cross-sectional area	5 x 0.5 mm ²



Stainless-steel pins



Pull-studs



Powerlifter with back-claw



Unit 4
Ladford Covert Industrial Park
Seighford
Stafford
ST18 9QL
Tel: 01785 282864
Fax: 01785 282819
email: info@tri-sphere.co.uk
web: www.tri-sphere.co.uk