

SAFETRACK®
S101 Heavy Duty
Electronic Pinbrazing unit

User´s Manual
IN-002-01



Read the instructions carefully before using the pinbrazing unit.

1. Check that all parts are received.

SAFE 9064 Delivered with:

Gun S4, automatic, SAFE 9102
Battery cassette, SAFE 9067
Earthing device, SAFE 8089
2 pcs of Tool boxes, SAFE 9054

SAFE 9060 Delivered with:

Gun S4, automatic, SAFE 9102
Battery cassette, SAFE 9067
Earthing device, SAFE 8089
2 pcs of Tool boxes, SAFE 9054
3 pcs of High power, sealed Batteries, SAFE 8036
Grinding machine 36 V DC, SAFE 8005

Technical specification

Voltage	36V DC
No. of brazings/charge	60-100
Unit weight incl.batteries	50 Kg
Dimensions LxWxH (mm)	800x350x380

Accessories:

High Power batteries, sealed 26 Ah SAFE 8036
Grinding machine 36 V DC, SAFE 8005
Battery charger, stationary use, SAFE 8050
Extension cables



Guarantee: Units 12 months, batteries 6 months. Valid only when using original parts, batteries and chargers supplied or approved by **SAFETRACK®**. The guarantee will expire if the equipment was used or has been used with non-original spare parts, consumables or not used in accordance with the instructions.



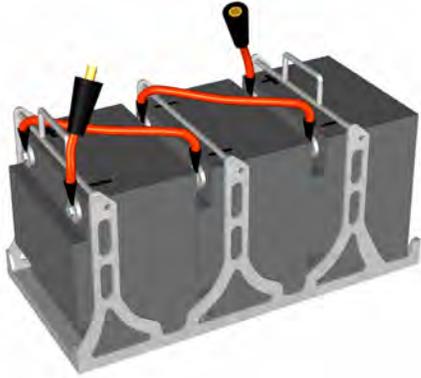
SAFETRACK Baavhammar AB

L.Möllerberga 245 93 Staffanstorp, Sweden
Tel. +46 (0)40 44 55 51 Fax. +46 (0)40 44 55 53

www.safetrack.se

Sales@safetrack.se

2. Charging the batteries.



Sealed batteries

- Connect the batteries in series in the battery cassette.
- **Important! The connectors should be twisted hard to each other.**
- Be sure it is a good ventilated room you are using as a charging room.

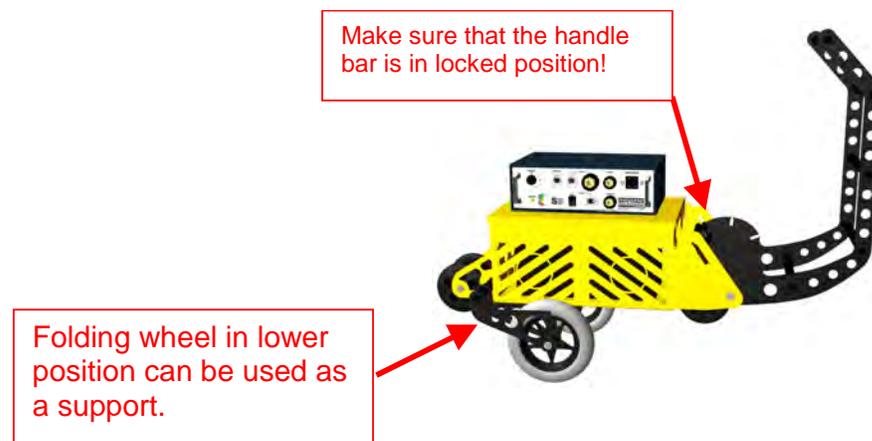
- Connect the battery **charger** to the **grinder outlet** on the pin brazing unit then to the mains. When removing from charging remove from the mains first then from the unit.

- Charging is ready after about 5-8 hours. See the specific instructions for the charger you are using. Normally the charger when blinking is indicating charging completed.

Warning! The charger may not be placed over the batteries while charging! In case of formation of gases.

Note: Use only battery charger specially made for pin brazing unit S101 (36 V DC) delivered or approved by SAFETRACK.

The pin brazing unit is prepared with a generator outlet. See the instruction for the generator for more information.



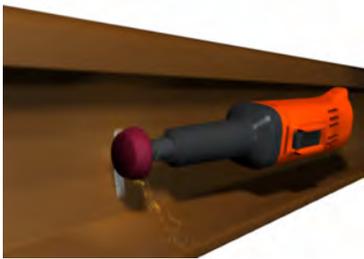
3. Brazing instruction.

Warning! Use always eye protectors when grinding and brazing!

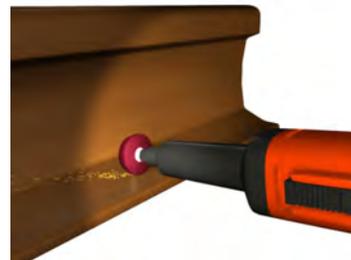
- Connect the brazing gun, power and trigger cable to the unit.
The power cable must be inserted and then be twisted hard to the wall socket on the unit and on the gun.
- Connect the earthing device to the unit.
Very important that the cable is inserted and twisted hard to the wall socket on the unit.
- Connect the grinder to the unit.

Note, use only SAFETRACK's grinding wheel specially made for brazing, other type of wheels will leave a surface not suitable for brazings. Keep the grinding wheel clean and free from oil etc.

- Grind the brazing and earthing area until you have an even and clean surface.



Move the grinder up and downwards.



Even the surface also for the earthing.

- Adjust the right pin type, the power will automatically be switched on.

<u>Brazing pin</u>	<u>Adjustment</u>	
8 mm std.	1	
8 mm extra / threaded pins	2	(2+ when more energy is needed in a spec. case)
9,5 mm	3	(3+ when more energy is needed in a spec. case)

IMPORTANT!

Switch off the unit after use. Battery life can be reduced if allowed to go completely flat.

- Load the gun with brazing pin and ferrule.



- Make sure to braze in the top of the hole when brazing to a vertical surface.

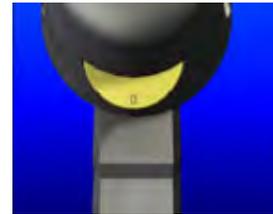
Setting the right lift

- Press carefully the gun with the cable shoe, the ferrule and the brazing pin to the work piece, with an even but not hard pressure.

height.

Using S4-Automatic gun.

- Set the wheel in position "0" at the back of the gun. The gun will automatically adjust the right lift level every time you braze. (Position + and – are for specific cases when appropriate.)



Using S3-Manual gun.

- Adjust the right lift height with the adjustment on the back of the gun. The inner rod should be in the same level as the outer ring.



Brazing.

- Hold the gun firmly with both hands as shown and pull the trigger just once. The electronics will by it self finish the braze.

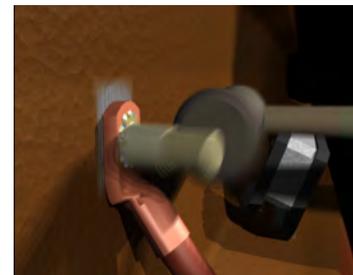


- Hold the gun in place for 3-4 sec after the brazing while the braze solidifies.

- Remove the gun **straight** backwards without pulling the trigger!

Knock off the shank of the brazing pin.

The brazing is completed.



NOTE! When the indicator shows a red light, the batteries are low and the unit must be charged at once. Otherwise the batteries could be damaged.

BATTERIES

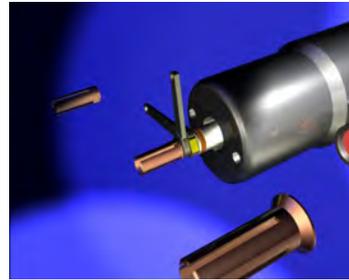
Check that:

- The cables are tight and intact. The male connector on the power cables (for connecting the batteries, gun and earthing device) should always be inserted and TWISTED hard to the female connector.
- The terminals are free of oxide.
- The batteries are fully charged.

If you are using extra battery cassette, try to use it as much as the other and do always keep it fully charged.

CHANGE PINHOLDER

- Separate the ringholder from the gun with your hands.
- Hold the nut closest to the pinholder with a 10mm key.



- Screw the pinholder off.
- When replacing the new pinholder, hold the nut, closest to the pinholder even now.

EQUIPMENT

- Check the cables from time to time, so damages has not arised.

BRAZING PINS AND FERRULES

- Keep them clean and dry. Always put the lid on the tin after use.

Trouble shooting



In order to perform this trouble shooting you will need : voltmeter, 8 mm and 10 mm spanners, hexagon spanner 3 mm, 4mm and 5 mm, control instrument to check lift height for S4 pistol. Optional :- battery load meter.

Working material Are the bonds in good condition - no breaks, clean ?
Are the pins of the correct type ?

Grinding wheel Is the grinding wheel the approved type ?
The Tyrolit is a silicon free wheel.
You can use a steel carbide wheel.
No other wheels are allowed.

Batteries **Sealed cells**
Check voltage:
36V DC battery need to be charged
39V DC battery is fully charged

Open cell batteries
Check that:
-The acid level is more than 5mm above the tops of the separators. If not, fill with distilled water.
-The specific gravity of the acid is 1.28. When the batteries are fully charged. The spec. gravity level should be equal in all cells.
Check all cells (18 pcs).

Pistol S3 Check cables, plugs.
Does axle move easily with pin and ring fitted ?
Are the pin and ring holders bent ?

S4 Check cables, plugs.
Does axle move easily with pin and ring fitted ?
Are the pin and ring holders bent ?
Unscrew the front of the gun and open carefully.
Smell if there is burning, otherwise clean and replace
Check the lifting height with the control instrument.

Earthing magnet (Ground) Is the magnet broken (between the plates) ?
Is the plug well screwed in ?
Even the plates with a file. It is recommended to replace the magnet when it starts to look weared.

Electronic units

Check cables and connections for play.

Fuse	Function
30 A	Generator
15 A	Grinder / Charger
5 A	External fan
5 A	Control box

Are the contact on the cables damaged ?
Are the knobs loose ?
Are the fuses whole ? (inside on S 101)
Open the panel, check for a burnt smell, (the breaker may have burnt out)
Check that cables are attached correctly.
Make a full optical control.

Battery Charger Measure with a voltmeter under load that the unit is working



DECLARATION OF CONFORMITY

according to ISO/IEC Guide 22 and EN 45014

Manufacturers name: **Safetrack Baavhammar AB**

Manufacturers adress: **Safetrack Baavhammar AB
L.Mölleberga
245 93 STAFFANSTORP
SWEDEN**

declares that following products:

Product: **Pinbrazing unit**
Model number: **S10, S30, S50, S100, S101**

conforms to:

Safety: **IEC 950 (1991) / EN 60950 (1988) / EN 60204-1**

EMC: **EN 55022 (1988) class B/CISPR 22 (1985) class B
IEC 801-2 (1991) / EN 55101-2 (1990):8kV CD,15kVAD**

The products also conforms with Low Voltage Directive 73/23/EEC, EMC Directive 89/336/EEC and 89/392/EEG, 91/368/EEG. The products has been tested in a typical configuration.

Staffanstorp, Sweden 98-12-13

Torsten Bävhammar
President



In case of a modification of the products which has not been agreed on with us or The guarantee will expire if the equipment was used or has been used with non-original spare parts, consumables or not used in accordance with the instructions. Then this declaration becomes null and void and the warranty expires.

SAFETRACK BAAVHAMMAR AB
L.Mölleberga
245 93 Staffanstorp
SWEDEN

Tel. +46 (0)40 44 55 51
Fax. +46 (0)40 44 55 53
VAT No. SE556342145101
Sales@safetrack.se
www.safetrack.se



Thank You for choosing a guaranteed SAFETRACK product!
TERMS OF WARRANTY

Safetrack offer an additional year warranty (beside the ordinary 12 month) when you return this form. We will within the warranty period exchange or repair the product free of charge* since...

- ✓ ... the product is returned complete to Safetrack Baavhammar AB or official service agent.
- ✓ ... the product has not been misused or carelessly handled.
- ✓ ... previous repairs have only been attempted by Safetrack Baavhammar AB or approved service agents.
- ✓ ... proof of purchase date is produced when the goods are handed in or sent for repair.
- ✓ ... we have only used original Safetrack spare parts and consumables.

Tack för att Du valt en garanterad SAFETRACK produkt!
GARANTIVILLKOR

Safetrack reparerar eller byter ut produkten utan kostnad* om fel uppstår inom 24 månader från köptillfället om ni registrerar produkten (annars 12 månader från köptillfället) eftersom...

- ✓ ... vi levererat utrustningen komplett till Safetrack Baavhammar AB eller auktoriserad servicepartner.
- ✓ ... produkten ej har varit utsatt för vanvård eller felaktigt användande.
- ✓ ... tidigare gjorda reparationer är utförda av Safetrack Baavhammar AB eller auktoriserad servicepartner.
- ✓ ... köpehandlingen för produkten medföljer leveransen.
- ✓ ... vi endast har använt Safetrack originaldelar och arbetsmaterial.

* (Except consumption parts and batteries)

* (Gäller ej förslitning/ förbrukningsmaterial eller batterier)

Serial no:	_____
Product no:	_____
Part no:	_____

Keep this part / Behåll denna del.



Please, complete form after purchase.

Vänligen fyll i formulär och skicka in efter köp.

Warranty registration / Garantiregistrering



Note! Extended warranty only valid after signing up within 6 months after purchase.
Observera! Den förlängda garantin gäller bara vid registrering inom 6 mån från köp.
Send in by mail, fax or use www.safetrack.se for registration.

Date of Purchase

Inköpsdatum

Serial number

Serienummer

Equipment

Utrustning

<input type="checkbox"/>	S30 XC Pin brazing unit <i>S30 XC Pinlödningsaggregat</i>	<input type="checkbox"/>	S4 Pinbrazing gun <i>S4 Pinlödningspistol</i>
<input type="checkbox"/>	S101 Pin brazing unit <i>S101 Pinlödningsaggregat</i>	<input type="checkbox"/>	S300 Pin brazing unit <i>S300 Pinlödningsaggregat</i>
<input type="checkbox"/>	X250 Pin brazing unit <i>X250 Pinlödningsaggregat</i>	<input type="checkbox"/>	Heaty 300/600 <i>Heaty 300/600</i>
<input type="checkbox"/>	Safebond unit <i>Safebondaggregat</i>		

Company

Företag

First name

Förnamn

Surname

Efternamn

Address

Adress

Country

Land

Phone

Telefon

E-mail

E-mail

Distributor:

Köpt av distributör:

Visit us at www.safetrack.se



SAFETRACK BAAVHAMMAR AB, L.Molleberga 245 93 Staffanstorp, Sweden

Phone: +46(0)40-44 53 00, Fax +46(0)40-44 55 53 sales@safetrack.se