

IN064-01

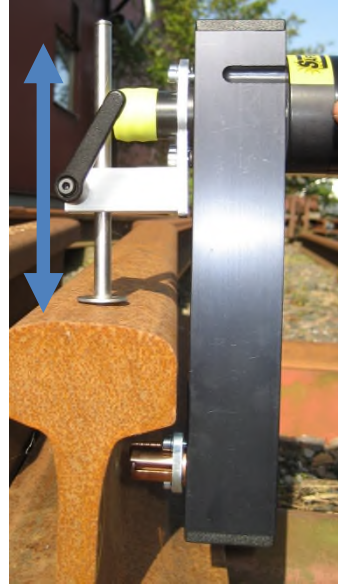
S15-Angle Head Brazing Gun



SAFETRACK®
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S15-Angle Head Brazing Gun

Adjust the height of the gun with the adjustable rod and lock it.



Periodically maintenance of S4-Angle Head Brazing Gun

B1. Check that all cables and lugs are tight always twist the plug in to the outlets on the units

B2. Check that the right pin holder is fitted in the gun.

SAFE No.	For brazing pin	Mark
9211	8-9,5 mm	A
9213	M8 threaded	B
9215	M10 threaded	C
9217	M12 threaded	D

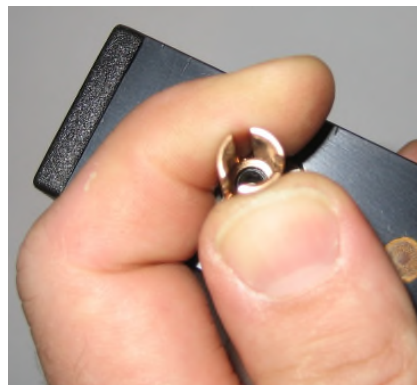
Make sure that pin holder is tight to the gun.

Spanner 8mm and 10mm for 8-9,5 mm and M8 pin holders.

Two paces of spanner 10mm for M10 and M12 pin holders.

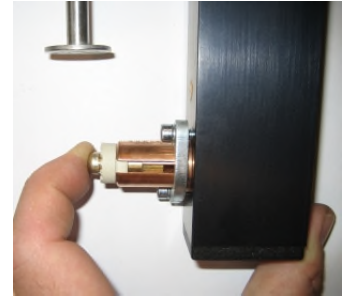
If the pinholder isn't tight a spark can destroy the axle.

The brazing pin should not go too loose in the pin holder, when it does push together with your fingers. Otherwise you can have a contact fault or a spark can arise.



B3. Check that the ring holder is the right type.

B4. Load the gun with a 8mm pin and ferrule.
Check that the axle move easily with the pin and ferrule fitted when moving back and forward.
If not, change either pin holder or ring-holder.
If it still doesn't move easily the axle is damaged
And the gun must be sent for repair.



IMPORTANT! The normal lift height is 2mm (setting 0) this is very important for the arc and energy amount. Too high lift height increase the risk of a “cold brazing”, too low lift height reduce the time and increase misfires.

B.5.1. Insert this end in to the gun.



B.5.2. Turn on the unit and
Important! Press the tool completely against the gun then pull the trigger. Otherwise the gun may be damaged!
Important! Hold the gun so the tool is horizontal.

B.5.3. The lift level is calibrated when the inner rod, made of brass, on the tool is in same level as the outer plastic sleeve.
Tolerance $\pm 0,2$ mm.

If the gun is not calibrated see separate instruction for adjusting of the gun.

*Advanced maintenance work
Adjusting the lift level.*

B.6. Reset correct lift height on a S4 gun.
Only when to reset a maladjusted gun.

B.6.1. Fit the instrument SAFE 91245 on the gun as in B.5.

B.6.2. Connect the cables to the Pinbrazing unit and switch on the power.

B.6.3. Take off the plastic plug with the needle in the upper small hole in the front of the gun.

IMPORTANT, never adjust in the hole where the big plug is!

B.6.4. When lift height is too **low**.
Use the 3mm hexagon spanner and adjust the screw in the small hole **anti-clockwise** about 1/4 of a turn then check with the instrument as in B.5.

B.6.5. When lift height is too **high**.
Use the 3mm hexagon spanner and adjust the screw in the small hole **clockwise** about 1/4 of a turn then check with the instrument as in B.5.

If all is ok, fit the plug in the hole again.
If not ok, send for repair.

