

## Pin Welder Do's & Don'ts

### DO'S

- Connect welder to standard 115V AC power
- Use extension cables at all times
- Twist all connectors to lock or snap into place
- Make sure gun is set up accurately for your application
- Tighten all set screws (collet, protectors, legs, etc.)
- Use legs and foot if possible
  - Fastener should extend 1/8" past foot**
- Connect ground clamp tightly to clean surface
- Connect gun to negative (or gun) port unless welding to paint, galvanization or rust
- Apply **LIGHT, CONSISTENT** pressure during the weld (1/8")
- Use proper gun spring or spring tension for material
- Cuphead Pins-use pins 1/8" longer than material depth and use paper washers if welding through foil-faced material
- Expect unit to "hum" after each weld
- Observe **ALL** electrical codes, fire codes and rules of common sense

### DONT'S

- Coil up cables in one area
- Automatically turn unit all the way up to highest voltage setting to solve welding problems
- Remove cover from unit for any reason with power cord connected
- Lubricate gun, gun shaft or any part of unit
- Push gun down until gun spring "bottoms out" on any type of pin
- Use a collet or chuck that will not grip the fasteners snugly or that shows burn signs
- Look directly at weld area during welding
- Move gun during weld
- Stand in water to weld, sit unit or cables in water or weld with wet or damp clothing
- Weld near flammables or other potential explosive hazards
- Weld overhead without proper eye and body protection

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