The chart settings shown below are “reference” settings to be used as starting points. Actual voltage settings may vary depending upon the conditions or each application and use.

<table>
<thead>
<tr>
<th>Pin/Study Type</th>
<th>Pin/Study Dia</th>
<th>Pin/Study Mat'l</th>
<th>Voltage Setting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Insulation Pin</td>
<td>12 GA, 10 GA</td>
<td>Mild Steel or Stainless</td>
<td>75-85, 85-95</td>
</tr>
<tr>
<td></td>
<td>12 GA, 10 GA</td>
<td>Aluminum</td>
<td>110-120, 120-130</td>
</tr>
<tr>
<td>Weld Studs</td>
<td>#10 or 3/16&quot;</td>
<td>Mild Steel or Stainless</td>
<td>120-130, 145-155</td>
</tr>
<tr>
<td>(Flanged)</td>
<td>1/4&quot;</td>
<td>Aluminum</td>
<td>120-130, 130-140</td>
</tr>
</tbody>
</table>

CD STUD WELDING ACCESSORIES SPECIFICATION GUIDE

SET-UPS

- **STANDARD**
  - Adjustable and with spark shield, for Pins or Studs.

- **COLLET PROTECTOR**
  - Fixed, for Pins.

- **CUP HEAD CHUCK**
  - For all Cup Head Pins.

- **TEMPLATE ADAPTOR**
  - For precise location of studs.

Quick Startup Guide

Solid State — Capacitor Discharge
Pin Welding System

MIDWEST FASTENERS, INC.

800-852-8352 • Fax: 937-866-4174
www.midwestfasteners.com
Eagle Components

Controller
CDSW-005-00

Weld Gun
CDWG-201-06T

Ground Cable
CDGC-200-15

Remove the controller, cables and weld gun from the shipping packaging.

Connect the Cable connectors to the controller as marked: “GROUND” or “GUN”.

NOTE: All cables should be laid out straight or in a random fashion.

CD-2 WELD GUN SETUP

WELD PINS

1. Seat weld pin firmly against stop.
2. Loosen these adjustment screws.
3. Slide the Leg / Foot assembly until weld pin flange extends 1/8" - 3/16" beyond foot (or spark shield).
4. Retighten adjustment screw.

CD-2 WELD GUN SETUP

INSULATION PINS WITH COLLET PROTECTOR

1. If “B” Stop is used, seat weld pin firmly against stop.
2. Loosen these adjustment screws.
3. Slide the Leg / Foot assembly until weld pin flange extends 1/8" - 3/16" beyond foot.
4. Retighten adjustment screw.