Top 10 Do’s for pin welding

1. Connect Welder to **proper incoming AC Power** [110volt for most systems]
2. Connect **Weld Gun to Negative, Ground to Positive** receptacles ["Straight" polarity] and twist, or properly “lock”, all Connections into place before Welding.
3. Connect Ground **tightly, firmly and cleanly** to work surface assuring “connection” to all weld points.
4. Use the complete system: including **ALL Cables and ALL accessories** for your application.
5. Make sure **Gun is set up** for your specific application, and do so properly by tightening all hold-downs, set-screws, and accessory components. Understand and use proper accessories and ‘technique’ for pin in use.
6. Use proper pin for weld surface material. **Aluminum to aluminum ONLY.**
7. **Observe “1/8’s”:** no more than 1/8” of pressure to the pin, any type, during welding AND when welding Cuphead, or Mini-Cup, Pins: **use a pin at least 1/8” longer than material depth.**
8. Paper Washer, or **insulated, Cuphead MUST be used on foil-faced**, FSK, material to prevent arcing to facing and produce full and proper welds.
9. Expect unit to “hum” during each charge cycle.
10. **Observe ALL fire and electrical codes plus rules of common sense.**

**See the LIST of Don’ts for Pin Welding, too!**
Top 10 Don’ts for pin welding

1. DON’T Remove cover from unit, for any reason, WITH power connected.
2. Stand in water to weld, sit unit or cables in standing moisture, or weld with wet-or-damp clothing.
3. Weld near flammables or explosive hazards without proper precautions.
4. Weld overhead without proper eye and body protection, or look directly at weld area during weld.
5. DON’T Lubricate Gun, Gun Shaft, or any part of Unit.
6. Use a collet or chuck that will not grip the fastener snugly or shows lack of grip.
7. Move gun during weld cycle before weld is complete.
8. Push Gun down until Spring in Gun “bottoms” out on any type weld pin.
9. Automatically turn unit all the way up to Max power to solve weld quality problems.
10. DON’T Coil up cables in loops in one area, especially near point of weld.

**... (don’t) forget to See the LIST of Do’s for Pin Welding, too! **