# Voltage Settings

Adjust the weld voltage setting according to the chart below and your current welding application, using the up (+) or down (-) pushbuttons on the control panel on the front of the Controller.

<table>
<thead>
<tr>
<th>Pin/ Stud Type</th>
<th>Pin/ Stud Dia</th>
<th>Pin/ Stud Mat’l</th>
<th>Voltage Setting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cuphead Pin</td>
<td>12 GA</td>
<td>Mild Steel</td>
<td>80-90</td>
</tr>
<tr>
<td></td>
<td>10 GA</td>
<td>Mild Steel or Stainless</td>
<td>65-75, 80-90</td>
</tr>
<tr>
<td>Insulation Pin</td>
<td>12 GA</td>
<td>Aluminum</td>
<td>75-85, 80-90</td>
</tr>
<tr>
<td></td>
<td>10 GA</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Weld Studs (Flanged)</td>
<td>#8</td>
<td>Mild Steel or Stainless</td>
<td>85-95, 90-100, 125-135</td>
</tr>
<tr>
<td></td>
<td>#10 or 3/16&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1/4&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>#10 or 3/16&quot;</td>
<td>Aluminum</td>
<td>80-90, 120-130</td>
</tr>
</tbody>
</table>

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*FOR ACCESSORIES AND SPARE PARTS SEE:*

*FOR MORE INFORMATION, VISIT:*

www.midwestfasteners.com

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**SURE SHOT**

UltraLight – Capacitor Discharge
Welding System

Quick Start Guide
Unpack components shown below and untie all cable assemblies.

**SURE SHOT II STUD WELDING SYSTEM**  
(P/N: CDSW-002-01)

- **Controller**  
  CDSW-002-00
- **Power Cord**  
  110 VAC CDAC-002-110  
  220 VAC CDAC-002-220
- **Weld Gun**  
  CDWG-201-20
- **Ground Cable**  
  CDGC-200-15

**SURE SHOT II CABLE CONNECTIONS**

- **Power Cord**  
  Plug into 110 VAC power source,  
  (or wire to 220 VAC as required by your model.)
- **Controller**
- **Weld Gun**
- **Ground Cable**

Connect the cables to the controller as shown below.

**SURESHOT II GUN SETUP**

**CUPHEAD PINS**

1. Place magnetic chuck in gun shaft and retighten set screw. No other accessories are required.
2. Place Cuphead Pin on magnetic chuck.
3. When welding, maintain correct pressure on gun (approximately 1/8" of gun spring.)

*NOTE: When welding cuphead pins to foil-faced (FSK) material - always use insulated cupheads.*

**SURESHOT II GUN SETUP**

**INSULATION PINS / COLLET PROTECTOR**

1. If a 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 (or spark shield).
4. Retighten adjustment screw.