

# ***Top 10 Do's*** ***for pin welding***



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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***



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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! \*\***