



Tec-Spot Welder



Tec-Spot Welder for use in the Professional Bodyshop

Before You Start:

It is the operator's responsibility to comply with the following:

- Inspect all power supply leads, plugs and all electrical connections for wear and | or damage.
- An RCCB (Residual Current Circuit Breaker) should be incorporated in the main distribution board; we also recommend that an RCD (Residual Current Device) is used with all electrical products.
- Before use, inspect the insulation on the appliance cable and check the appliance and plug before connecting to the mains supply.
- Also regularly inspect power supply sockets, extension leads and connectors.
- Ensure that the voltage marked on the appliance is the same as the electrical power supply to be used.
- Do not carry the appliance by its power lead.
- Do not pull the power plug from the socket by the power lead.
- Extension lead reels: when a cable extension lead reel is used it should be fully unwound before connection. We recommend the cable reel has an RCD fitted. Be sure that the capacity of the cable reel is suitable for the product.
- Wear safety goggles and welding gauntlets.
- Ensure there are no flammable materials near the area of work.
- The welder creates strong magnetic fields; this may interfere with certain watches and similar devices. If you have a pacemaker, consult a doctor before using the stud welder or approaching the area where the stud welder is in use.
- Make sure the welder does not get wet or is used in wet conditions. Must only be used inside.
- Do not let the welder be used by untrained persons.
- When not in use, stud welder should be stored in a dry, secure location.

If in any doubt about electrical safety, consult a qualified electrician.

The Stud Welder

Welder support strap and fittings

Welder Electrodes:

- A** Nail electrode
- B** Washer and bit electrode
- C** Bit outer extension earth
- D** Squiggly wire electrode
- E** Shrinking Diode for single spot tips

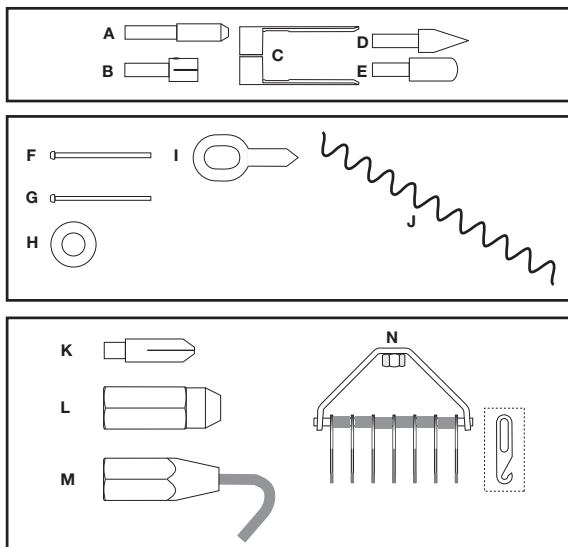
Welder consumables:

- F** Nails 2.50 mm (100)
- G** Nails 2.00 mm (100)
- H** Washers (50)
- I** Straight bits (50)
- J** Squiggly wires (20)

Multi-function slide-hammer

Slide-hammer fittings:

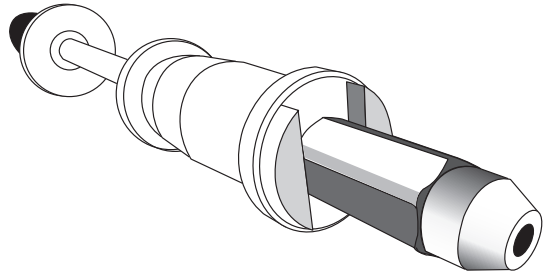
- K** Nail lock (inner)
- L** Nail lock (outer)
- M** Bit pulling head
- N** Multi-hook head



The Power-TEC Stud welder 92314 is supplied as a kit that contains the stud welder, a slide hammer and various electrodes and fittings. It is designed for fast, efficient body repair, removing dents quickly, and works from the outside, thus can be used on double-skinned panels and without the need to remove interior trim and fittings.

The Tec-Spot Welder will shut down automatically once the temperature of the transformer has reached 120°C.

Generally this will be when approximately 20-25 nails have been used continuously



Instructions:

Select a nail, washer, bit or wavy-wire, depending on accessibility and the shape of the damage, is welded to the damaged area on the panel. The panel is then pulled back into shape with the slide hammer or other pullers. We recommend that the techniques are practised on a scrap panel before a repair is attempted.

The nail electrode (A) and the washer & bit electrode (B) are magnetised to hold the nail | washer | bit in place prior to welding.

If a straight bit (I) (use either, depending on shape of damage) is required, then extend the outer electrode length by fitting the bit outer extension earth (C).

The multi-hook head (N) is used to grip the squiggly wires (J) which can be welded to a long, thin dent with the squiggly wire electrode (D).

A series of straight or twist bits can also be welded to a long, thin dent. The multi-hook head (N) can then used to grip a bar inserted through the eyes of the straight or twist bits.

Welding:

The panel to be welded must be clean, bright metal, and free from paint, rust or grease.

The electrodes, inner and outer, must be clean and without any defects. If necessary, remove any defects with a fine grade file or abrasive. Note: worn electrodes should be replaced.

Connect the stud welder to the power supply.

Choose the desired electrode | nail | bit combination and fit to the stud welder. The electrodes are a simple push-fit into the electrode mount of the stud welder.

To weld, push the stud welder against the panel surface against the spring pressure of the inner electrode, until the outer electrode is firm against the surface. This completes the electric circuit. Keep the stud welder at 90° to the panel surface to ensure good contact.

Squeeze the trigger to weld. No more than half a second should be necessary, perhaps a little more if welding the wavy-wire.

The shrinking diode end can be used to smooth the surface of the panel after pulling operation.

DO NOT squeeze the trigger and maintain power for longer than advised above as this could burn a hole through the panel and also potentially damage the transformer in the stud welder.

DO NOT release the pressure on the welding surface until you have released the trigger as this causes the circuit to be prematurely broken which leads to a weak weld and excessive sparking.



Safety First. Be Protected.

Using the slide-hammer:

Use the correct fitting on the end of the slide hammer depending on the nail | bit used:

- For pulling a nail, insert the inner nail lock (K) into the end of the slide-hammer shaft. Then attach the outer nail lock over the top of the inner nail lock and screw into place. Do not screw the outer nail lock too tight at this stage, just enough to nip against the inner.
- Place the outer nail lock over the nail to be pulled and slide over the complete length of the nail. To tighten and grip the nail the slide weight is pushed forward to grip the outer nail lock and then turned anticlockwise. Then the dent can be pulled out using the slide action of the hammer.
- To finish, the nail can be removed from the panel by gripping the outer nail lock with the slide weight and twisting, or the nail can be cut off with a pair of side cutters. The remaining stub(s) can be ground off with an angle grinder.
- For pulling a washer, straight or twist bit, assemble the bit pulling head (M) to the slide hammer and hook the end through the washer or bit. Again, the bit pulling head can be tightened to the shaft of the slide hammer by using the slide weight.

Caption: The slide weight is pushed forward to grip the outer nails lock.

After use, allow the stud welder to cool before returning it to the storage case.

Consumable parts:

91293 2mm Panel Pulling Pins

91294 2.5mm Stud nails (500)

91687 Straight Pulling Bits

92139 Twisted Pulling Bits

91333 Squiggly Wire (50)



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