

Operating manual PUK D3



PUK D3

OPERATING MANUAL (translation) "PUK D3" with welding microscope "SM5"

Dear Customer,

This operating manual is intended to familiarize you with the commissioning process and operation of your PUK D3 as well as the associated SM5 welding microscope. Please read the operating instructions carefully and follow the advice given here diligently. Disruptions and operational faults will thus be avoided. Your personal safety, constant availability and long service life can be assured by this.

THE COMMISSIONING OF THE DEVICE MUST ONLY BE UNDERTAKEN BY TRAINED SPECIALISTS AND ONLY WITHIN THE SCOPE OF APPROPRIATE USE. THE MANUFACTURER ACCEPTS NO LIABILITY FOR DAMAGES CAUSED THROUGH INAPPROPRIATE USE AND IMPROPER OPERATION. THE "GENERAL SAFETY REQUIREMENTS" AND "PERSONAL BODY PROTECTION" CHAPTERS MUST BE READ BEFORE COMMISSIONING.

Please keep these operating instructions safe.

The equipment produced by "Lampert Werktechnik GmbH" fulfils the conformity requirements of the CE mark and is constructed in accordance with the VDE guidelines.

The eye protection systems used on the "SM5" welding microscope are tested and certified by DIN-CERTCO (DIN department for eye protection).

Only use original spare parts for maintenance and overhaul work. Our customer service department will naturally be happy to help you.





THE DEVICE MUST ONLY BE OPENED OR MODIFIED BY AUTHORISED CUSTOMER SERVICE PERSONNEL, OTHERWISE ALL GUARANTEES AND WARRANTIES ARE VOID.

November 2017

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1. WARNING AND INFORMATION SIGNS

	<p>Warning!</p> <p>"Warning" identifies a potentially dangerous situation. If this is not avoided, the consequences can be death or severe injuries.</p>
	<p>Caution!</p> <p>"Caution!" identifies a potentially hazardous situation. If this is not avoided, the consequences can be slight or minor injuries as well as property damage.</p>
	<p>Note!</p> <p>"Note" identifies the product at risk from the hazard and possible damage to the equipment.</p>
	<p>Important!</p> <p>"Important!" designates user tips and other especially useful information. This is not a signal word for hazardous or dangerous situations.</p>

2. APPROPRIATE USE (FIELD OF APPLICATION)

- Outdoor operation is impermissible. Use this device only in dry rooms!

- PUK D3: the application of spot welds to all customary dental alloys as well as titanium for the manufacture of new articles and for repairs on dental work.



WELDS INSIDE AND ON THE HUMAN BODY ARE PROHIBITED.



GENERALLY NO LIABILITY IS ACCEPTED FOR THE DURABILITY OF THE WELDING. WE RECOMMEND THAT THE WELDING BE CHECKED IN EVERY CASE.

SM5: Observation and microscopic viewing of objects through the ocular of the microscope and illumination of the working area.

The SM5 unit may only be used for welding if it has been properly connected to a PUK fine-welding device.

3. SAFETY INSTRUCTIONS

3.1 GENERAL SAFETY REQUIREMENTS



PERSONS WHO WEAR ACTIVE IMPLANTS (HEART PACEMAKERS) MUST MAINTAIN A SAFETY DISTANCE OF 20 CM BETWEEN THE WELDING CURRENT CABLE / SOURCE OF THE WELDING CURRENT AND THE IMPLANT



The opening of the device is only permitted when undertaken by an electrician. Before opening remove the mains cable and ensure that the device is de-energised. Discharge any components in the device that could hold electrical charge.

In case of doubt or uncertainty, always consult with a specialist. Our customer support department is naturally always available to assist you with their professional trained personnel, appropriate tooling and equipment.

Always use the original cables and ensure that workpiece clamps are properly attached.

Both the mains and welding currents can be a source of danger.

The device must be isolated from the mains power when undertaking any repair or maintenance work on the power source. The power socket is to be clearly blocked when undertaking any work on the system beyond minor manipulations where it is necessary to leave the workplace, even for brief periods.

The highest and thus the most dangerous voltage in the welding circuit is the no-load voltage. The highest permissible no-load voltages are recorded in the national and international regulations in accordance with the type of welding current, construction of the current source and the extent of the electrical hazard to the workplace.

If it can be assumed that risk-free operation is no longer possible, the unit must be put out of operation and secured against being unintentionally restarted.

It can be assumed that risk-free operation is no longer possible, if

- the equipment shows visible signs of damage,
- malfunctions occur,
- or the equipment is no longer working.

The PUK must, as standard, be operated with a mains voltage of 115 V~.

Yellow-green wire = protective earth terminal (PE). The other wires L1 and N are to be connected to the phase and neutral conductors of the power plug.

The welding device is factory-adjusted to 115 V!

This means that as a result of the tolerance range of +/-10 %, the system can also be operated at 110 V~. Devices configured to voltages other than 115 V will be designated as such by means of a label.

THE DEVICE MUST ONLY BE OPENED BY AUTHORISED SERVICE PERSONNEL!

IF THE DEVICE HAS BEEN CONFIGURED FOR A CUSTOM VOLTAGE, THE TECHNICAL DATA ON THE DEVICE SPECIFICATION PLATE APPLY! MAINS PLUGS MUST CORRESPOND TO THE MAINS VOLTAGE AND POWER CONSUMPTION OF THE WELDING EQUIPMENT (see technical data!)

THE FUSING FOR THE MAINS SUPPLY MUST BE MATCHED TO THE POWER CONSUMPTION OF THE WELDING EQUIPMENT!

ONLY USE THE SUPPLIED MAINS CABLE!



THE PUK D3 IS A PIECE OF ELECTRICAL EQUIPMENT. NATIONAL REGULATIONS ON TESTING INTERVALS AND THE SCOPE OF REQUIRED RECURRING SAFETY-RELATED TESTS MUST BE OBSERVED.

3.2 HAZARDS AND PERSONAL BODY PROTECTION



Protective gloves should be worn on both hands whenever possible when welding, as sparks and spatters can never be completely excluded when welding. The protective gloves must not contain a high proportion of easily melting plastic fibres.

Uncovered areas of the skin are exposed to UV radiation produced during welding, which can cause skin damage.

Wear suitable clothing; do not wear articles of clothing made with synthetic fibres.

The workpiece and electrode tip can become extremely hot during welding operation - risk of burns.

The tip of the electrode fastened into the handpiece can present a risk of injury (stab injuries and scratches e.g. to the hands, face and eyes)

EYE PROTECTION WHEN WELDING:

Never look into the arc without eye protection; always use a welding mask with certified protective glass. (min. protection class 10)

In addition to light and thermal radiation, which can cause dazzling and burning, the electric arc also emits UV radiation. With insufficient protection this invisible ultraviolet radiation causes very painful conjunctivitis, which can first be noticed hours later.

The SM5 welding microscope with its integrated LCD protective welding screen offers reliable protection against these risks and

provides permanent protection from UV / IR rays in both light and dark state. The protective class of the filter is defined such that dazzling by the arc is effectively prevented.

Persons who are nearby to the electric arc and assistants must also be informed of the dangers and equipped with the appropriate protection; if necessary set up protective partition walls.

EYE PROTECTION WHEN OPERATING THE LED ILLUMINATION:

Never look into the LED lamp or its reflections without eye protection; always use a welding mask with certified protective glass (min. protection class 3).

When welding, especially in small spaces, ensure that there is an adequate fresh air supply or use an external extractor fan, as smoke and hazardous gases occur.

It is not permitted to carry out welding on containers that have been used for storing gases, propellants, mineral oils or similar, even if they have been empty for a long time, as there is a risk of explosions caused by residues.

Particular regulations apply to fire and explosion endangered spaces.

3.3 HAZARDS OF SHIELDING GAS CYLINDERS



Observe all applicable safety measures when handling gas cylinders as well as the safety regulations for handling gases. Gas tanks must especially be secured against falling over / falling down

and heat (max. 50°C); it is particularly important to ensure they are not subjected to sunlight for extended periods and that they are protected from severe frost.

3.4 RISK OF ALLERGIC REACTIONS:



Please note that the device's raw materials that could come into contact with the operator's skin

may cause allergic reactions in susceptible people.

4. SETUP AND INSTALLATION

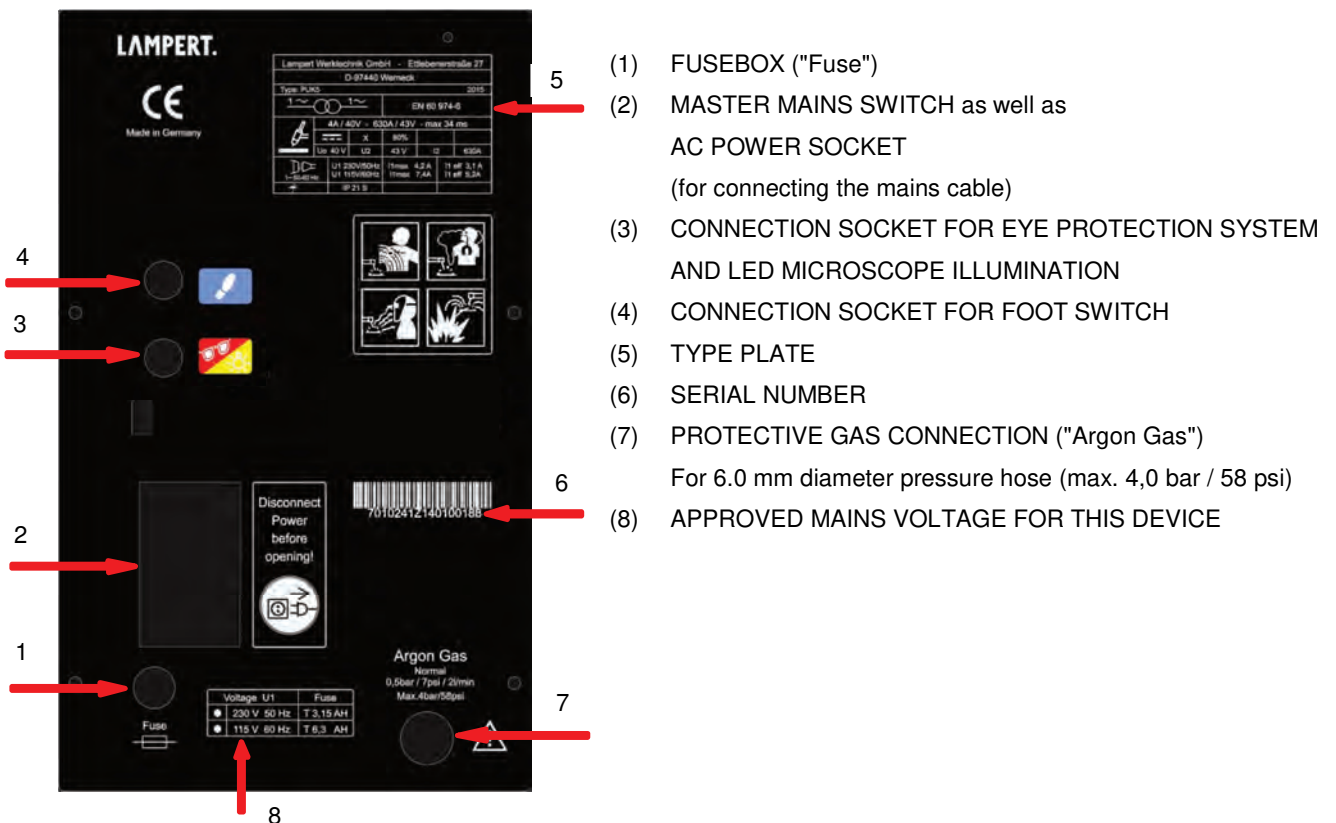
4.1 SET-UP OF THE DEVICE

The system is to be set up so that cooling air is able to reach all of the surfaces of the housing without hindrance. The device may not be covered! The device is to be placed on a non-combustible surface! The device should be set up on a base that is solid, level,

and insulated - ideally on a suitable workbench. Fasten the two hand supports for the microscope with 2 Allen screws using the supplied Allen key by inserting the screws into the designated holes from underneath the microscope baseplate and into the hand supports.

4.2 DESCRIPTION OF THE REAR OF THE DEVICE

(Fig. 2)



4.3 CONNECT EYE PROTECTION AND LED ILLUMINATION OF THE WELDING MICROSCOPE TO THE PUK:

The circular connector for the eye protection system and the LED illumination should be inserted into the connecting socket (3) on the rear of the PUK welding

device (marked in red and yellow colour) and is to be tightened in place with the coupling nut (hand tight)..

WARNING!



ONLY SUITABLE ORIGINAL EYE PROTECTION SYSTEMS FROM LAMPERT MAY BE CONNECTED TO THE WELDING SYSTEM! OTHER EYE PROTECTION SYSTEMS ARE NOT APPROVED AND CAN LEAD TO PERMANENT HEALTH DAMAGE OR DAMAGE TO THE WELDING DEVICE.



ALWAYS OBSERVE THE OPERATING INSTRUCTIONS FOR THE CONNECTED EYE PROTECTION SYSTEM

4.4 CONNECT SHIELDING GAS SUPPLY:

Fasten the suitable flow regulator with the corresponding tool to the shielding gas tank. ATTENTION: In doing so, always observe the enclosed special operating instructions provided. (Where possible, use argon with

min. 99.9 % purity, e.g. "Argon 4.6"). The pressure hose is to be fastened by hand with the help of the quick coupling adapter to the flow regulator as well as the shielding gas connector (7) on the rear of the device.



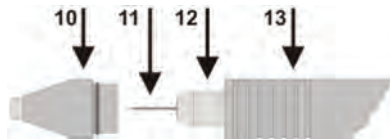
CHECK REGULARLY THAT ALL OF THE HOSE CONNECTIONS AND GAS HOSES ARE IN OPTIMAL CONDITION, ARE PROPERLY FASTENED AND ARE AIRTIGHT!

4.5 INSERTING THE ELECTRODES INTO THE WELDING HANDPIECE:



PLEASE ALWAYS CHECK THAT THE MACHINE IS SWITCHED OFF, PRIOR TO EXCHANGING THE ELECTRODES. THIS PREVENTS UNCONTROLLED TRIGGERING OF THE WELDING PROCESS.

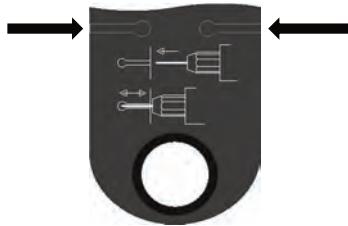
(Fig. 3)



Lightly rotate the nozzle (10) back and forth and in doing so, pull it off of the handpiece (13). It is only pushed-on, not screwed in place.

Release the threaded electrode connection (12), insert a well sharpened tungsten electrode (11) and tighten up (hand-tight – do not use a tool to tighten).

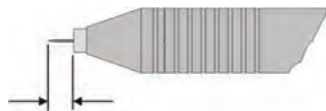
(Fig. 4)



The correct length for the electrode can easily be checked and corrected if necessary by means of the milled marks on the handpiece clamping arm (Fig. 4).

Now replace the nozzle.

(Fig. 5)



The electrode must protrude approx. 4 - 6mm out of the nozzle (Fig. 5).



ONLY USE THORIUM OXIDE FREE ORIGINAL ELECTRODES

Subsequently insert the connector of the handpiece as straight as possible into the socket (23) on the front of the PUK and fasten in place by tightening the coupling

nut hand-tight in a clockwise direction. Insert the connecting cable used into the socket (24) on the front side of the housing.

4.6 CONNECT POWER SUPPLY:

Insert the power cable with the mains connector into the corresponding socket (2) on the rear of the housing and

insert the mains plug into a suitable socket with the correct mains voltage.



CAUTION!

AS SOON AS THE MASTER MAINS SWITCH ON YOUR PUK IS SWITCHED ON, THE VOLTAGE IS APPLIED TO THE CONNECTED CROCODILE CLIPS OR CABLES. IT IS TO BE ENSURED THAT THESE PARTS ARE NOT ALLOWED TO COME INTO CONTACT WITH

ELECTRICALLY CONDUCTIVE OR EARTHED PARTS, SUCH AS THE HOUSING, ETC. IN DOING SO, THERE IS NO RISK FOR THE OPERATOR, WITH THE EXCEPTION OF POSSIBLE CIRCUMSTANCES ARISING FROM OPERATING ERROR.

4.7 CONFIGURATION THE WELDING MICROSCOPE:



ESSENTIAL PRIOR TO THE INITIAL WELDING OPERATION: PRECISE CONFIGURATION OF THE MICROSCOPE OPTICS

FIRST STEPS

Align the handpiece holder so that you are able to comfortably introduce a workpiece with your hands to the tip of the handpiece mounted in the supporting arm. It should be possible to comfortably place both hands and palms on the baseplate hand supports. You also have the option of changing the angle of inclination for the microscope. In order to do so, release the locking screw



(14) on the stand, angle the microscope to the desired position and re-fasten the screw. A metal pin extends from the stand to support the microscope on your working surface.

ADJUSTING THE INTEROCULAR DISTANCE

Look through the two oculars (17) and move the ocular tubes (15) inwards or outwards by holding the prism housing (18) still and moving them in or out. The interocular distance is correct if the range of vision as

viewed through the two oculars is complete and is united into a single image. The interocular distance should be individually set for each user.

FOCUSING



Mount the welding handpiece with clamped electrode into the supporting arm. Rotate the focusing knob (20) to a medium focus range. Adjust the mounting height of the microscope head: Hold the microscope head (19) with one hand, without touching one of the lenses, and use the

other hand to release the screw on the head bracket. The head can now be moved. Look through the oculars and move the microscope head up or down until the object appears focused. The correct distance between the handpiece holder and the microscope head amounts to approx. 6 cm on the stand rod. Now re-tighten the adjusting screw on the head bracket once more. Subsequently use the focusing knob (20) to focus the image.

DIOPTRIC ADJUSTMENT

The sleeve for adjusting the diopter (16) is fitted to the left-hand ocular (17). In the normal position, the lower part of the tube is aligned to the marking on the ocular tube. In the event of differing vision in both eyes: Open the right eye only, look into the right-hand ocular (15) and adjust

the focus using the focusing knob (20). Now look through the left-hand ocular with your left eye and adjust the focus by turning the diopter control (16) on the left tube (17) until the image appears focused.

5. COMMISSIONING

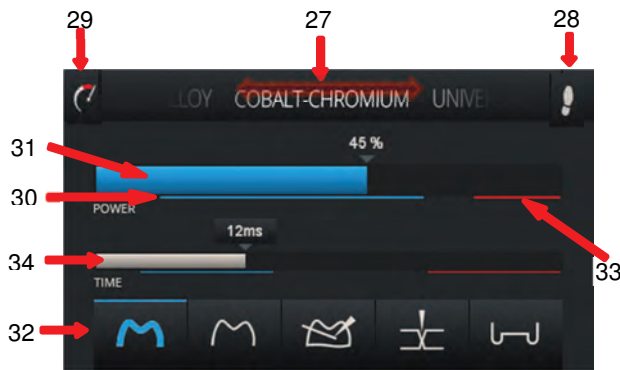
5.1 DESCRIPTION OF THE FRONT-SIDE CONTROLS

(Fig. 1)



- (21) TOUCHSCREEN-DISPLAY with slide function
- (22) CONNECTION SOCKET FOR HANDPIECE (-)
- (23) SOCKET (-)
For connecting the blue contact terminal for fixation welding
- (24) SOCKET (+)
For connecting contact elements such as contact terminals and clamps.
- (25) ROTARY CONTROLLER
Select the welding power/time or switch to the next user level
 - Pressing the rotary controller for short time (< 1 second) switches from the power (POWER) parameter to the pulse duration (TIME) parameter. (It jumps back to power automatically after 1 second)
 - Turning the controller to the left or the right changes the selected parameter.
 - Pressing the controller for longer time (> 1 second) switches to the next user level, see chapter 5.2.

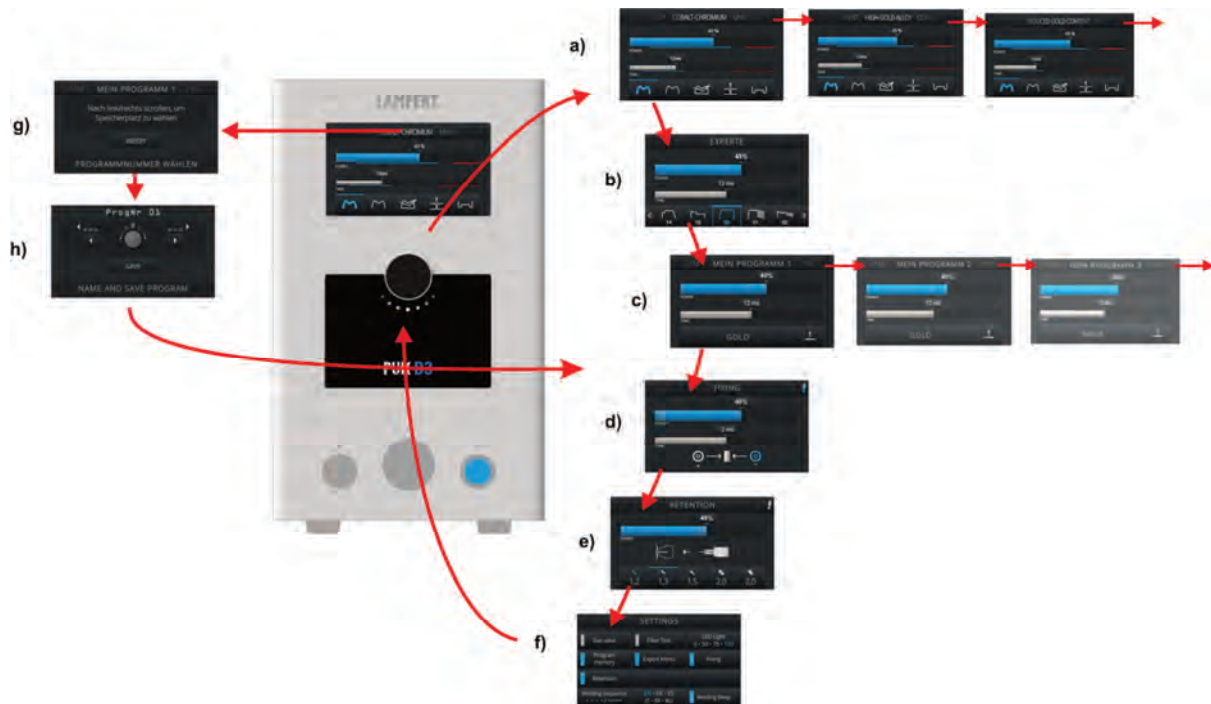
TOUCHSCREEN



- (27) Select the material or welding program (depending on the user level) by sliding to the left or right within the selected user level. Press and hold for 2 seconds to call the memory menu.
- (28) Foot switch activated
- (29) Smoothing mode activated
- (30) Recommended setting range
- (31) Output scale as a percentage (POWER in %)
- (32) Preselect welding situation and pulse shape (depending on user level)
- (33) Red range: In this range the settings no longer make sense and there is a possible risk of damaging the workpiece.
- (34) Pulse duration scale in milliseconds (TIME in ms)

5.2 EXPLANATION / OVERVIEW OF MENUS

(Fig. Schematic diagram of user levels)



ONCE IT IS SWITCHED ON, THE PUK D3 STARTS UP IN ITS START LEVEL (MAIN MENU). THE FOLLOWING USER LEVELS CAN BE NAVIGATED AFTER PRESSING LONGER (> 1 SEC.) THE ROTARY CONTROLLER (25):

- a) Start level (main menu):
Preselection of the material to be welded and preselection of the welding situation with display of the recommended settings range for welding power and pulse duration
- b) Expert level (if activated in the settings)
Arbitrary preselection of the various welding curves
- c) User programs and stored custom settings (if activated in the settings)
- d) Fixation welding (if activated in the settings)

- e) Retention welding (if activated in the settings)
- f) Settings (Language, gas valve, lighting ...)

At the start level and in "Custom Programs", sliding in the header bar on the display scrolls between the different preset materials or stored programs depending on the selected user level.

Beginners using the PUK system are advised to remain within the start level.

PRESSING THE SELECTED MATERIAL (27) IN THE TOP OF THE DISPLAY FOR 2 SEC. CAUSES THE PROGRAMMING MENU TO BE LAUNCHED:

- g) Selection of the memory location and saving the settings (if activated in the settings). Storing custom welding parameters (20 memory slots)


- h) Input and saving of the desired program (if activated in the settings)

5.3 SWITCHING ON THE DEVICE




First, carefully open the gas tank valve. Then switch the master mains switch (2) on the rear of the housing to the "I" position – the display shows the safety prompt regarding eye protection and the operating manual. Confirm your compliance with the safety instructions by pressing the rotary controller or by touching the touchscreen.

5.4 ADJUSTING FOR THE CORRECT GAS FLOW

 The PUK D3 only works with shielding gas connected and sufficient gas flow. If no shielding gas is connected or the gas flow is insufficient, then a

corresponding error message is shown in the display and the device fails to weld in the TIG-mode (starting and expert level, and in the stored custom settings).

 PLEASE CONSIDER THAT GOOD WELDING RESULTS CAN ONLY BE ACHIEVED WITH A CORRECTLY ADJUSTED GAS FLOW.

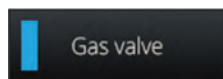
In order to configure the correct gas flow, activate the "Gas valve" in the "Settings" menu (see chapter 5.5). This opens the gas valve in the welding device. Now set the flow regulator to the correct flow rate of approx. 2 - 3

litres/min. In doing so, also observe the instructions provided with the flow regulator. Once the gas volume is correctly adjusted, close again the "Gas valve" function by pressing the corresponding button.

5.5 OPERATING LEVEL "SETTINGS"

The "Settings" user level can be used to modify basic settings and launch various test functions.

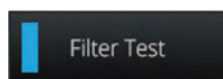
• Gas valve:



Pressing the corresponding button causes the gas valve to be opened. This function is important in order to set the correct gas flow on the flow regulator

(see chap. 5.4). Pressing the button again causes the gas valve to be closed. In addition, any other operation of the device will automatically quit that function.

• Filter-Test:



Pressing this button causes a shading of the eye protection filter. This enables correct function of the

eye protection filter to be checked. Pressing the button again quits the test.

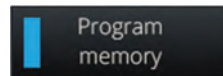
• LED light:



Pressing the button enables the brightness of the LED lamp on the

welding microscope to be adjusted in 3 steps or to be switched off.

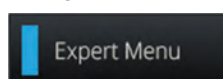
• Program memory:



You can activate or deactivate the saving and calling functions for programs that you created

yourself here. If this menu is activated, it appears as an additional user level. The user levels can be toggled by pressing the rotary controller for 1 second.

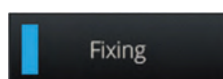
• Expert Menü:



The expert menu can be activated here. If this menu is active, it

appears as an additional user level. The user levels can be toggled by pressing the rotary controller for 1 sec.

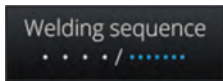
• Fixation:



Pressing this button activates or deactivates the operating menu for fixation welding. If this menu is

activated, it appears as an additional user level. The user levels can be toggled by pressing the rotary controller for 1 sec.

- **Welding sequence:**



You can press the button to preselect a "standard" or "short" basic welding sequence. If you

select "short", a shortened gas pre-flow time results in a shorter time gap for triggering in a series of welding points.

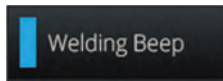
- **Language**



Pressing the button with the country codes enables the system language for the welding device to

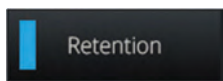
be changed. The system can be toggled between English (EN), German (DE), Spanish (ES), French (FR) and Italian (IT).

- **Welding signal tone:**



Pressing the button activates or deactivates the acoustic signal that notifies the triggering of the weld.

- **Retention welding:**



Pressing this button activates or deactivates the operating menu for welding retentions. When

activated, the corresponding menu appears as an additional user level. The user levels can be toggled by pressing the power regulator.

6. SELECTION OF THE WELDING PARAMETERS AND USER LEVELS

6.1 SELECTION OF THE WELDING PARAMETERS

Pressing for a short time (< 1 second) the rotary controller (25) or touching the POWER or TIME scales on the display switches between the power (POWER) and pulse duration (TIME) parameters. It jumps back to power (POWER) automatically after 1 second. Rotating the rotary controller or sliding the power (POWER) or pulse duration (TIME) scales changes the relevant value.

BASIC INFORMATION ABOUT THE EFFECTS OF WELDING POWER AND WELDING TIME:

POWER:

With the parameter "welding power" the strength of welding energy is set.

The size and intensity of the welding points are controlled in this way, i.e. the higher the power the larger the welding point.

With very thin materials too high a power level can also quickly result in damage, i.e. it makes sense to experiment with samples for beginners with the PUK system to find the optimum power level, starting at a power of 20 % or with very fine welding, even lower. Power settings

between 35 and 50 % are considered medium welding powers.

Most dental alloys can be welded with higher power levels, just as with stainless steel. Power levels above 70 % are only practical in the most unusual circumstances. There is a danger of inhomogeneous welds and only experienced users should move outside this range.

WELDING TIME OR PULSE DURATION:

The welding time setting determines for how many milliseconds the welding power is applied, i.e. a longer pulse duration results in a longer and deeper application of the energy to the workpiece and thus simultaneously a greater development of heat.

With very thin materials or wires it is recommended to use a shorter welding time, primarily when welding near to

acrylic or ceramic parts or other heat-sensitive materials. Welding times of no more than 4 msec are recommended here.

With some cobalt chromium alloys, with silver alloys or other highly conductive metals a longer welding time can be advantageous in order to avoid hot cracks, starting at 10 msec.



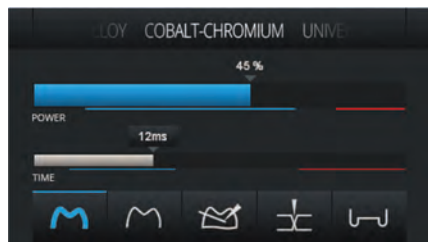
IMPORTANT FOR SUCCESSFUL OPERATION WITH THE PUK:

Welding power and pulse duration must be considered in close context with each other in all cases! The total energy applied to the workpiece is comprised of these two parameter settings together - prior to welding this

must be considered carefully following an in-depth analysis of the welding task, the materials and the workpiece geometry.

SELECTION OF THE WELDING PARAMETERS ON THE PUK D3:

The welding parameters are set in two stages:



1) In the upper area of the display, select the metal to be welded by sliding over the metal names.

2) Pressing one of the 5 buttons on the lower edge of the display selects the given welding situation.

This selection causes numerous settings to be made in the background. The important information for the user is then shown on the display:

- A welding time is preselected and the recommended setting range for the selected welding situation is marked under the scale by means of a blue bar. Settings outside of the recommended blue setting range are always possible, however, they are not recommended for the selected welding situation.
- The power is also preselected and the recommended setting range for the power is marked with a blue bar. Settings outside of the recommended blue setting range are always possible, however, they are not recommended for the selected welding situation.



RED RANGE:

If you move above the predefined values for welding time and welding power, the colour of the cursor and the parameter value displayed changes from white to red from a certain setting. In these ranges, there is a risk of damaging the material being welded, i.e. we expressly advise you against working in these extreme conditions.

DESCRIPTION OF THE WELDING SITUATION WITH ASSOCIATED SYMBOL ON TOUCHSCREEN:

- In the start level, the meaning of the following symbols is always the same for each of the preconfigured materials.
- In The start level shows in addition to the welding power and pulse duration for each stored material also the recommended working range in the respective scales of the touchscreen, highlighted in colour.



Universal setting for material thicknesses from 0.3 mm. This is well suited for most applications (≥ 0.3 mm).



Setting for thin or delicate parts less than 0.3 mm thick. This setting offers very low development of heat, especially in combination with short welding times.



Welding in sharp angles and tight joint situations. Here it is important to use short welding times.



Melting of welding wire. Use identical alloy wire with a diameter of 0.3 to 0.4 mm. Ideal is a diameter of 0.35 mm.



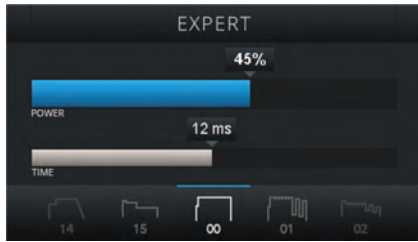
Very low-energy melting for welding (orthodontic) wires or very thin material.



PUSHING/TOUCHING THE RESPECTIVE BUTTON FOR 2 SEC. BRINGS UP AN INFO WINDOW ON THE DISPLAY; SEE ALSO CHAPTER 6.3 "HELP FUNCTION".

6.2 EXPERT MENU

>>>THE EXPERT MENU CAN BE ACTIVATED FROM THE "SETTINGS" USER LEVEL



After activation, the expert mode appears as a separate user level, which can be accessed by pressing the rotary controller for 1 sec. The various welding characteristic curves are stored in the expert mode, which have been developed

and defined in the start level for the preconfigured metals and welding geometries. However, here they are shown without content-related assignment.

This mode is designed for experienced welders who want to experiment with the various stored energy characteristic curves (pulse modulations). In this user level it is possible to choose between the various energy curves and store these together with individual settings for the output and time.



WHEN SWITCHING FROM THE MAIN MENU TO THE EXPERT MENU, THE RELEVANT SETTINGS ARE CARRIED OVER FROM THE MAIN MENU. THIS MEANS THAT THE WELDING CURVES STORED IN THE MAIN MENU CAN STILL BE VIEWED.

6.3 HELP FUNCTION



The buttons on the bottom of the display are provided with accessible info screens in all user levels. Touching / pressing the

button for 2 sec. causes the info screen to appear for the respective button, which contains explanatory information for the button's function. Touching the display button again causes the active user screen to be shown once more.

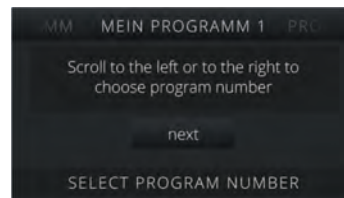
6.4 PROGRAMMING

SAVING CUSTOM PROGRAMS



Pressing the metal name for a longer time (2 seconds) calls the programming menu. In the first step, scroll/slide to the left/right to select the

program slot into which you want to store your custom settings.



Then save your data by pressing the "Next" button. Saved data cannot be deleted. It can only be overwritten.

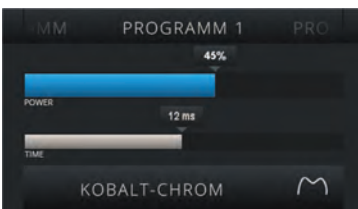


The following screen provides the option of assigning a program name to the stored settings. The program name can comprise upper and lower case

letters and special characters. You can use the arrow buttons on the display to select the active cursor position and you can use the rotary controller (25) to select the desired characters.

Once the name has been entered, confirm your entry by pressing the "Save" button. After saving, you will be returned to the "Custom Programs" user level automatically, and the previously saved data is active.

6.5 LOADING SAVED PROGRAMS AND THE USER LEVEL "CUSTOM PROGRAMS"



All custom stored programs are summarised in the "Custom Programs"

user level. In the upper display area on this user level, select the relevant custom program by sliding to the left or to the right.

6.6 FIXATION WELDING

>>> THE FIXATION WELDING MENU CAN BE ACTIVATED FROM THE "SETTINGS" USER LEVEL.



After activation (see also point 5.5 / Settings), the fixation mode appears as a separate user level, which can be accessed by

pressing the rotary controller several times for 1 sec.

This mode is used for the fixation of two work piece parts. See also Chapter 7.3.1.

For using the fixation mode the tack welding set is required (optional accessory).



PLEASE NOTE: TACK WELDING IS PARTICULARLY WELL SUITED FOR METALS WITH LOW ELECTRICAL CONDUCTIVITY, FOR EXAMPLE: TITANIUM AND STEEL.

6.6 RETENTION WELDING

>>> THE RETENTION WELDING MENU CAN BE ACTIVATED FROM THE "SETTINGS" USER LEVEL.



After activation (see also point 5.5 / Settings), the retention welding mode appears as a separate user

level, which can be accessed by pressing the rotary controller for one second.

This mode is used for the welding of CoCr or NiCr-alloy retention pins using the relevant pin welding adapter (Ø 1.2, 1.3, 1.5 or 2 mm). See also Chapter 7.3 and 7.4.2.

7. WELDING INSTRUCTIONS



NOTE!

PRIOR TO WELDING, ALWAYS CHECK THE FUNCTION OF THE EYE PROTECTION FILTER AS DESCRIBED IN CHAPTER 5.5 "FILTER TEST". IF THE EYE PROTECTION FILTER (SHUTTER) FAILS TO

SWITCH OVER FROM LIGHT TO DARK, THEN IT MUST BE IMMEDIATELY EXCHANGED BY SPECIALIST PERSONNEL.

7.1 WELDING INSTRUCTIONS

- First connect a metallic blank section of the workpiece with the contact clamp.
- Lightly touch the area to be welded with the tip of the electrode until welding begins. In doing so, it is important to remain in the position where initial contact

is made until welding begins, i.e. neither to follow the electrode with the workpiece if it retracts slightly in the handpiece, nor to pull back.

The welding process starts automatically as soon as the electrode touches the workpiece:

- Shielding gas flows around the welding area.
- A signal tone (if activated in the settings) notifies of the arc.
- The welding protection filter is darkened
- The arc is triggered with a slight delay and the electrode partly withdraws into the handpiece.
- The welding protection filter is lightened and the electrode returns to the initial position.
- The shielding gas supply stops or the welding process is started again by touching the workpiece.



WORK ONLY WITH EXTREMELY LIGHT CONTACT AND WITHOUT ANY PRESSURE TO THE TIP OF THE ELECTRODE!

The PUK D3 is equipped with a function to prevent the electrode becoming welded to the workpiece by incorrectly pressing too hard. If a welding point has already been set and is pressed too hard to the workpiece when it comes into contact again, the welding point is not triggered; instead, the eye protection system will be darkened periodically to indicate that the electrode is pressing too hard against the workpiece. The electrode's contact to the workpiece must be stopped for a short time and the welding process must be started again.



THE WELDING PROCESS CAN BE HALTED AT ANY TIME BY MEANS OF LIFTING THE ELECTRODE AWAY FROM THE WORKPIECE.

7.2 WELDING WITH THE SMOOTHING MODE



You can press the "TIME" scale on the display for 2 seconds to activate or deactivate smoothing mode. The

smoothing mode can only be activated on the start level, in the expert menu and on the "Custom Programs" level. Smoothing mode enables a faster welding sequence, e.g. to smooth surfaces or to weld with an increased heat transfer (e.g. to reduce the conductivity of silver). If the user switches to a different user level, smoothing mode must be reactivated if required.

7.3 RETENTION WELDING INSTRUCTIONS

This mode is used for the welding of CoCr or NiCr-alloy retention pins using the relevant pin welding adapter (Ø 1.2, 1.3, 1.5 or 2 mm).



Please switch off the machine prior to exchanging the electrodes or the adapter. This prevents uncontrolled triggering of the welding process. Remove the electrodes, replace the clamping nut and chuck with the pin welding adapter. Work without the clamping nut and nozzle. Then select the diameter of the adapter being used, by pressing the respective button on the display of the PUK D3.

Then connect the workpiece to an area of bare metal, using a contact clamp. Insert a pin of the appropriate diameter into the pin welding adapter. No shielding gas flows during the whole process.

The welding process itself proceeds automatically:

- The 1st light touch of the workpiece pulls back the pin welding adapter, and a continuous tone sounds for approx. 3 seconds.
- The 2nd light touch triggers the welding process (during the continuous tone).

A good welded connection is indicated by a clearly audible welding noise. If the process passes off without making a noise, then the connection is presumably of insufficient strength. Blasting or roughening polished welding points before welding may have a positive effect on welding behaviour for pin welding.

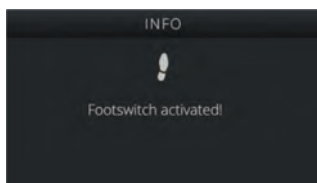
FOR INFORMATION ON RETENTION WELDING USING THE FOOT SWITCH, SEE ALSO CHAPTER 7.4.2.

7.4 WELDING WITH FOOT SWITCH

With the PUK D3 switched off, connect the foot switch to the socket (4) marked with the blue foot switch symbol on the rear of the device. Switch the device on, confirm the

safety prompt by pressing the rotary controller or touching the screen and wait for the self-test to conclude. The device is now ready for operation.

THE FOOT SWITCH CAN BE ACTIVATED BY PRESSING AND HOLDING IT (APPROX. 2 SEC.). AN INFO MESSAGE AND A WHITE SYMBOL APPEAR IN THE DISPLAY.



Connect a metallic blank section of the workpiece with the contact clamp. Now lightly touch the workpiece with the

electrode. The eye protection system starts to turn periodically from its light to its dark setting. If the foot switch is operated in this mode, the welding process will begin automatically as described in chapter 7.1.

PRESSING AND HOLDING THE FOOT SWITCH (APPROX. 2 SEC.) (WITHOUT TOUCHING A WORKPIECE) CAUSES IT TO BE DEACTIVATED AND THE WHITE SYMBOL ON THE DISPLAY DISAPPEARS.

7.4.1 FIXATION WELDING



THE BLUE CONNECTION CABLE MAY ONLY BE CONNECTED AFTER THE MODE HAS BEEN ACTIVATED. AFTER WELDING IS COMPLETE, IT IS VITAL THAT THIS CABLE IS REMOVED AGAIN, BEFORE SWITCHING TO ANOTHER MODE, IN ORDER TO AVOID FAULTY WELDS!

Connect both of the workpieces which are to be fixed at an area of bare metal with a connection terminal, one to the blue one and the other to the black. When the two parts are touching, the welding process can be triggered, using the foot switch. The handpiece is not used during

this process. The required welding power is determined by the strength of the connection desired as well as the workpiece geometry. The welding time setting is of secondary importance in this mode, and can only be varied to a very limited extent.



AFTER WELDING HAS BEEN SUCCESSFULLY COMPLETED, AND BEFORE SWITCHING TO ANOTHER USER LEVEL, PLEASE REMOVE THE BLUE CONNECTION CABLE!



NOTE: DURING FIXATION WELDING, THE FOOT SWITCH IS ALWAYS ACTIVE, AND CANNOT BE DEACTIVATED! DURING FIXATION WELDING THE GAS PROTECTION IS DEACTIVATED!

7.4.2 RETENTION WELDING WITH THE FOOT SWITCH



Please switch off the machine prior to exchanging the electrodes or the adapter. This prevents uncontrolled triggering of the welding process.

Remove the electrodes, replace the clamping nut and chuck with the pin welding adapter. Work without the clamping nut and nozzle. Then select the diameter of the adapter being used, by pressing the respective button on the display of the PUK D3. Then connect the workpiece to an area of bare metal, using a connection terminal. Insert a pin of the appropriate diameter into the pin welding adapter.

- The 1st light touch of the workpiece pulls back the pin welding adapter.
- With the 2nd light touch, the eye protection system (shutter) in the microscope can be clearly seen flickering. Pressing the foot switch at this stage triggers the welding process.

A good welded connection is indicated by a clearly audible welding noise. If the process passes off without making a noise, then the connection is presumably of insufficient strength. Blasting or roughening polished welding points before welding may have a positive effect on welding behaviour for pin welding. No shielding gas flows during the whole process.

PRESSING AND HOLDING THE FOOT SWITCH (APPROX. 2 SEC.) (WITHOUT TOUCHING A WORKPIECE) CAUSES IT TO BE DEACTIVATED AND THE BLUE DOT ON THE DISPLAY DISAPPEARS

7.5 BASICS AND TIPS

IMPORTANT!

- Always work with a well sharpened electrode (see point 7.6 for information about sharpening the electrodes).
- Ensure extremely good contact between the workpiece and the contact clamp, i.e. make contact between the workpiece and the connection cable terminal at a point which is metallically blank.
- Never weld "free hand", i.e. use the hand rests of the microscope SM5. Shaking hands can cause the configured parameters to be falsified.
- Apply only light force to the electrode tip.
- Weld with the correct gas flow of approx. 2 litres per minute and check this regularly.
- With a little experience you will notice that the angle with which you touch the workpiece with tip of the electrode affects the "direction of flow" of the welding point.
- The electrode can easily be clamped in somewhat longer for welding recessed areas.
- The electrode can easily be clamped in somewhat longer for welding recessed areas.

7.6 GRINDING THE ELECTRODES



Please switch off the machine prior to exchanging the electrodes. This prevents uncontrolled triggering of the welding process.

If possible, the electrodes should be sharpened with a diamond disk with fine or medium grain.

The recommended angle of grinding is approx. 15°.



See also the video "[Electrodes](https://www.youtube.com/LampertWelding)" on www.youtube.com/LampertWelding.



8. CARE OF THE SYSTEM COMPONENTS

8.1 CARE OF WELDING DEVICE AND WELDING MICROSCOPE

Your PUK as well as the welding microscope require a minimum of maintenance under normal working conditions. However, it is essential that a few points are observed in order to guarantee the functionality and to keep the spot welding device fully operational for years to come.

- Check the mains plug and cable as well as all welding and connection cables regularly for damage.
- Check that the moving parts of the handpiece move easily.
- If necessary, clean the electrode threaded assembly on the handpiece, in order to ensure optimal contact with the electrodes.
- Clean the device occasionally with a suitable cloth.
- Use the supplied dust cover to cover up the microscope after use.



IF WORK OR REPAIRS THAT ARE NOT DESCRIBED IN THESE OPERATING INSTRUCTIONS ARE NECESSARY THEN CONTACT YOUR DEALER.



WARNING!

IF FUSES REQUIRE EXCHANGING, THEN THEY MUST BE REPLACED WITH FUSES OF THE SAME TYPES AND VALUES. THE GUARANTEE IS VOID IN THE EVENT OF EXCESSIVELY HIGH FUSING!

THE DEVICE MAY ONLY BE OPENED BY A QUALIFIED ELECTRICIAN!

8.2 CARE OF THE OPTICAL COMPONENTS

Do not attempt to disassemble optical components. Please contact the local technical customer service department for repairs which are not covered by this manual.

Remove dust from the lens surface with a special brush prior to cleaning. You can obtain suitable accessories in any photography store.

Cleaning the oculars: Do not remove the oculars (17) from the ocular tubes (15).

Clean the outer surfaces. In doing so, breathe on them. Subsequently dry the lens with suitable cloth or paper for the purpose. Dry the lens with circular movements from

the centre to the outside. Do not wipe over a dried lens as they can easily be scratched.

Cleaning and exchanging the protective glass of the eye protection filter:



Never dismantle the eye protection filter (shutter)!

Only clean the surface. Use a cotton cloth with glass cleaner.

If the protective glass requires exchanging, slide it forwards out of the bracket and insert a new protective glass in the same manner.

9. TECHNICAL DATA

9.1 TECHNICAL DATA WELDING DEVICE

Device suitable for welding in dry rooms

Mains voltage	~115 V / 50 - 60 Hz +/-10 %
Mains fusing	T 6.3 A
Power consumption	400 VA
Closed-circuit voltage	30 – 43 V
No-load voltage	43 V
Duty cycle X	80 %
Max. charging time	0.8 sec.
Shielding gas	min. ARGON 99,996 %
Maximum gas pressure	4 bar / 58 psi
Protection class	I
Insulation class	B
Protection type	IP 21S
Weight	7.8 kg

9.2. TECHNICAL DATA MICROSCOPE

Optical eye protection and illumination unit for exclusive use with PUK fine welding devices.

Use only in dry rooms.

Operating temperature	+5 °C bis +40 °C
Lamp "LED unit"	3 W / 800 mA
Protection class	III
Insulation class	B
Protection type	IP 20
Weight	3.5 Kg

9.3 OPTICAL DATA MICROSCOPE

Lens	1.0
Ocular	10 x
Working distance	140 mm
Magnification factor	10 x
Field of view	20 mm

9.4 TECHNICAL DATA LCD SHUTTER M11 (BL)

Light shade	DIN 3
Dark shade	DIN 11
Switching time	< 50 msec.
UV protection	> UV 11
IR protection	> IR 11









MARKING ON THE LCD SHUTTER: 3/11 LWT 1/1/1/3/379

Protection shade number in open state	3
Protection shade numbers in closed state	11
Manufacturer identification code	LWT
Optical quality	1
Light scattering	1
Homogeneity	1
Angular dependence	3
Number of the standard	379





Notified body for CE testing of the LCD Shutter: DIN CERTCO, Alboinstrasse 56, 12103 Berlin

9.5 TYPE PLATE

Explanation of pictographs::

A	Current	V	Voltage	IP	Protection type	Hz	Hertz
	Alternating current (AC)		Direct current	1 ~ 50-60Hz 	Mains input 1 phase / AC / 50 – 60 Hz		Read operating manual
U₀	No-load voltage	U₁	Mains voltage	U₂	Voltage at nominal load		Tungsten inert gas welding
	Earthing	I₂	Nominal welding current	I_{1max}	Power consumption under max. load	I_{1eff}	Power consumption under nominal load
X	Cyclic duration factor		Single-phase transformer		Keep away from water		

9.6 WARNING NOTICES:

	Breathing welding fumes and gases can be hazardous to your health.
	Welding sparks, hot workpiece, and hot equipment can cause fires and burns.
	Arc rays from the welding process can burn eyes and skin.
	Electro-magnetic fields can affect pacemakers.

10. TROUBLESHOOTING

10.1 WELDING DEVICE

	FAULT	CAUSE	REMEDY
1	No welding current		
	Mains master switch on, display remains off	Mains cable interrupted	Check mains cable and mains voltage
		Device fuse blown	Replace device fuse with identical fuse (same type and value)
2	No welding current		
	Mains master switch on	Welding cable connections interrupted	Check plugged connections
		Poor or zero contact to the workpiece	Establish connection to the workpiece, fasten contact clamps directly to the workpiece
3	No welding current		
	Mains master switch on	Fault due to leakage current	Switch device off and back on again If fault reoccurs, arrange for servicing of device
4	Mains fuse blows or automatic circuit breaker trips	Mains insufficiently fused or incorrect automatic circuit breaker	Fuse mains properly
		Mains protection trips during idling	Arrange for servicing of device
5	Poor welding characteristics	Incorrect shielding gas	Use inert shielding gas (Argon 4.6)
6	Poor ignition characteristics	Electrode clamped loosely in handpiece	Tighten the clamping nut in the handpiece (chap.11, no.38) <u>by hand</u> , however, tighten firmly .
7	Oxidation and rusting	Excessive gas pressure	Reduce flow rate - approx. 2 l/min is recommended
8	Severe oxidation of the welding points	Incorrect shielding gas	Use inert shielding gas (Argon 4.6)
9	Tungsten inclusions in base material	Excessive pressure of the electrodes on the workpiece	Touch workpiece with extremely light pressure.
10	Tungsten electrode welds to workpiece	Excessive pressure of the electrodes on the workpiece	Touch workpiece with extremely light pressure.
11	Tungsten electrode melts off immediately	Electrode sharpened too steeply	Use the recommended angle of grinding (approx. 15°)
12	Static discharge over the surface of the device	Special local conditions	Use special foot mat for the workspace
13	Welding power is not released; the welding process starts, but a weld spot is not produced.	The internal protective circuit has triggered. -> avoid "electrostatic discharges" against the handpiece or housing.	Switch device off and on again.
14	Device begins to weld immediately when touching the workpiece (no gas pre-flow)	Fault	Immediately shut down the device, arrange for servicing.

10.2 MICROSCOPE

PROBLEMS WITH ELECTRICAL COMPONENTS			
A	The LED illumination fails to operate	Cable not connected.	Connect the plug to the connecting socket (3) marked with the red and yellow eye protection and illumination symbol on the PUK.
		LED faulty	Contact authorized customer service
B	Eye protection system (shutter) fails to operate	Cable connected incorrectly	Connect the plug to the connecting socket (3) marked with the red and yellow eye protection and illumination symbol on the PUK.
		Eye protection filter faulty	Arrange to have eye protection unit replaced by qualified personnel
IMAGE QUALITY			
D	Poor resolution	Oculars dirty.	Clean oculars.
E	Marks or soiling in field of vision	Oculars dirty.	Clean oculars.
		Protective glass dirty	Clean or exchange protective glass
* Note: Marks in the field of vision can also be caused by soiling in the interior of the oculars. For this reason, it is recommended to have the lenses cleaned by an authorised customer service engineer			
PROBLEMS WITH MECHANICAL COMPONENTS			
F	Focus is not retained	The sight slides down	Readjust the tension of the focusing knob

REPAIR

If the PUK D3 or the stereo microscope should require a repair or adjustment by qualified personnel, we always

recommend to first contact your dealer or an authorized customer service.



WARNING: THE DEVICE MAY ONLY BE OPENED BY A QUALIFIED ENGINEER!

11. SPARE PARTS LIST, SEE ALSO www.lampertusa.com



Handpiece

(37)	Nozzle (Ø 3 mm)	100 150 K
(38)	Clamping nut	100 152
(39)	Chuck Ø 0.5/0.6 – 0.8 mm	100 15x
(40)	Handpiece complete	100 100 04

Gas hose:

6 x 4 mm, sold by the meter	100 153
-----------------------------	---------



PLEASE NOTE!

Nozzle (37), clamping nut (38), electrodes and clamping tongs (39) are wearing parts and are not covered by the guarantee.

12. CONTACT

Lampert Tools USA, Inc.
67 East Madison, #512
Chicago, IL 60603
Phone: 1-866-478-5111
Fax: 1-312-641-2678
info@lampertusa.com
www.lampertusa.com

Text and illustrations represent the technical status at the time of printing. Subject to change.

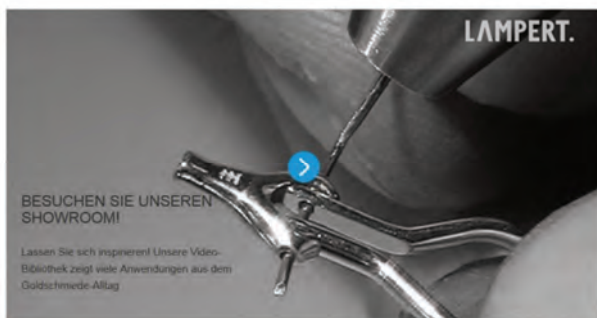
WORKSHOP NEWS

You are interested in the possibilities of use of our fine-welding devices? Or you are searching for one or another tip on working with your PUK? Then just sign up for our newsletter on www.lampert.info!



VISIT OUR SHOWROOM!

Our video library is showing many applications from everyday goldsmith activities, our photo gallery various examples of use. Get inspired on www.lampert.info!



SECTION A: SAFETY PRECAUTIONS – READ BEFORE USING

A-1. ARC WELDING HAZARDS

- ▶ The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard.

The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-4. Read and follow all Safety Standards.

- ▶ Only qualified persons should install, operate, maintain, and repair this unit.
- ▶ During operation, keep everybody, especially children, away.



ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first – double-check connections.
- Frequently inspect input power cord for damage or bare wiring – replace cord immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.
- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

SIGNIFICANT DC VOLTAGE exists after removal of input power on inverters.

- Turn off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.



FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
- If ventilation is poor, use an approved air-supplied respirator.
- Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instructions for metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level.

causing injury or death. Be sure the breathing air is safe.

- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.



ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear a welding helmet fitted with a proper shade of filter to protect your face and eyes when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather and wool) and foot protection.



WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Protect yourself and others from flying sparks and hot metal.
- Do not weld where flying sparks can strike flammable material.
- Remove all flammables within 35ft (10.7m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.



FLYING METAL can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



BUILDUP OF GAS can injure or kill.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



HOT PARTS can cause severe burns.

- Do not touch hot parts bare handed.
- Allow cooling period before working on gun or torch.



MAGNETIC FIELDS can affect pacemakers.

- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near arc welding, gouging, or spot welding operations.



NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



CYLINDERS can explode if damaged.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.

A-2. ADDITIONAL SYMBOLS FOR INSTALLATION, OPERATION, AND MAINTENANCE



FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.



FALLING UNIT can cause injury.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.



OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



MOVING PARTS can cause injury.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



WELDING WIRE can cause injury.

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.



MOVING PARTS can cause injury.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.



H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive elec-tronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

A-3. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd, Miami FL 33126 (phone: 305-443-9353, website: www.aws.org).

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd, Miami, FL 33126 (phone: 305-443-9353, website: www.aws.org).

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (phone: 617-770-3000, website: www.nfpa.org and www.sparky.org).

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1735 Jefferson Davis Highway, Suite 1004, Arlington, VA 22202-4102 (phone: 703-412-0900, web-site: www.cganet.com).

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards

Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3 (phone: 800-463-6727 or in Toronto 416-747-4044, website: www.csa-in-ternational.org).

Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 11 West 42nd Street, New York, NY 10036-8002 (phone: 212-642-4900, website: www.ansi.org).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (phone: 617-770-3000, website: www.nfpa.org and www.sparky.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250 (there are 10 Regional Offices – phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

A-4. EMF Information

Considerations about Welding And The Effects Of Low Frequency Electric And Magnetic Fields.

Welding current, as it flows through welding cables, will cause electro-magnetic fields. There has been and still is some concern about such fields. However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: "The body of evidence, in the committee's judgment, has not demonstrated that exposure to power-frequency electric and magnetic fields is a human-health hazard." However, studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

To reduce magnetic fields in the workplace, use the following procedures:

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.
4. Keep welding power source and cables as far away from operator as practical.
5. Connect work clamp to workpiece as close to the weld as possible.

About Pacemakers: Pacemaker wearers consult your doctor first. If cleared by your doctor, then following the above procedures is recommended.

Born in Germany.