

# OPERATING INSTRUCTIONS

## "PUK 3s professional" / "PUK 3s professional plus"



Maximise your PUK, subscribe to our free PUK – Newsletter and get all the latest info on working with the PUK 3. Sign up for your copy at our homepage [www.lampert.info](http://www.lampert.info)

Dear Customer

This manual is intended to assist you in operating and maintaining your „PUK 3s“. It is in your best interest to read this manual thoroughly, and to follow the instructions conscientiously. You will avoid malfunctioning as a result of operating errors. The device will thank you with a continuous readiness for use for years to come.

**Operation of the device should only be done by trained professionals and be operated according to the intended purpose of use. The manufacturer is in no way liable for any damage caused by improper use and operation. Before use please be sure to read the manual sections “General Safety Requirements” and “Personal Protection”.**

Please retain these instructions for reference.

### Note on Symbol

The equipment manufactured by “Lampert Werktechnik GmbH“ fulfils the standard requirements of CE certification and are manufactured according to VDE guidelines.

The PUK 3s is certified as “BG-PRÜFZERT” by the Central Professional Association and carries the “GS Sign”



Use original parts only for maintenance and updating. Our customer service department with expertly trained staff, suitable resources and equipment would be pleased to help you further.

**The device should only be opened or modified by authorized customer service technicians, otherwise all warranties and liability claims will be void.**

LAMPERT WERKTECHNIK GmbH

February 2010

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## A SYMBOL USAGE



### **Warning!**

“Warning!” indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury. This signal word is not used for property damage hazards unless personal injury risk appropriate to this level is also involved.



### **Caution!**

“Caution!” indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices that may cause property damage.



### **Note!**

“Note!” indicates a situation which implies a risk of impaired welding result and damage to the equipment.



### **Important!**

“Important!” indicates practical hints and other useful special-information. It is no signal word for a harmful or dangerous situation.

## 1 GENERAL APPLICATION



The placement of spot welding on precious metal and precious metal alloys, on steel and steel alloys as well as titanium and various NE-metals.

### **Not authorized for welding teeth fittings! (dental techniques)**

Any usage other than given is prohibited.

Operation in outdoor areas is prohibited. Use in dry room areas only.



**No liability of any kind will be assumed for the durability of welding spots. We recommend that you always check the spots and to solder them in case of doubt.**

## 2 INTRODUCTION

The PUK® - precision welding devices are compact and versatile TIG impulse welders with which fine and minute welds can be carried out under a welding microscope. The operating principles and spectrum of possible applications are very close to those of laser welding. This similarity means that the exact positioning of small, stable weldings or welds in hard-to-get-to or deep lying positions poses no problem.

### 3 **GENERAL SAFETY INSTRUCTIONS - READ BEFORE USING**



#### 3-1 SAFETY INSTRUCTIONS

Opening the device is permitted only by trained experts. Remove the plug before opening the device and make sure that the device is without electrical power. Discharge all device components that may store electricity.

Please consult an expert should any questions arise. Our customer service team with expertly trained staff, necessary resources and equipment would be pleased to assist you further at any time.

Always use original cables that are long enough and make sure that the clamp holding the work piece is fastened properly.

Hazard conditions may be caused by electricity as well as by welding current.

The device must be disconnected from the mains as soon as repair or service works is needed. When leaving the place of work even for a short time, make sure that the electrical outlet is blocked clearly.

Open circuit voltage is the highest and most dangerous voltage for welding current. The highest permitted open circuit voltages are contained in your national and international regulations according to the type of welding current, type of electrical source and the high or low hazard levels at the workplace.

If you believe that operating the device is not possible without creating hazardous conditions, then shut off the device and secure it against unauthorised use.

It is clear that a hazardous conditions are present when:

the device shows visible damage, or

or when functional errors occur

if it no longer functions properly.

Please follow relevant safety measures when handling gas bottles

#### **PUK 3s can be operated in series using a mains voltage of 230V~**

Yellow/green electric conductor = grounded terminal (PE) Other conductors L1 and N are connected to phase and neutral of plug.

Since the introduction of the Euro Norm IEC 38 (effective since May 1987) the mains voltage in all Europe is defined by 230V.

#### **The welding device is set for 230 V ex works!**

This means that it also may be operated using 220 volts due to its tolerance of +/- 15%. Devices set to a different voltage than 230 V will be marked with a special sticker.

**AUTHORIZED SERVICE PERSONNEL ONLY MAY OPEN THE DEVICE!  
otherwise the manufacturer`s warrantee is invalid.**

**IF THE DEVICE HAS BEEN MADE FOR A SPECIAL VOLTAGE, THEN SEE THE TECHNICAL DATA INDICATED ON THE DEVICE! THE POWER SWITCH MUST CORRESPOND WITH THE MAIN VOLTAGE AND THE POWER RECEPTACLE OF THE WELDING DEVICE. (See the technical data!)**

**PLEASE ENSURE THAT THE MAIN POWER BOX CAN SUPPORT THE USE OF THIS DEVICE WITHOUT BLOWING A FUSE**

**USE ONLY THE PROVIDED POWER CONNECTORS!**



### 3-2 PERSONAL PROTECTION AND DANGER

Wear protective gloves on both hands during welding, since sparks and splashes are unavoidable. The protection gloves may not contain a high portion of easy melting plastic fibers. Gloves will protect from harmful UV rays during welding.

Wear appropriate clothes, with no synthetics.

Workpiece and electrode point can heat up when welding strongly. Burn danger.

The electrode point fixed in the handpiece means an injury risk (pass and scratching injuries by hand, face and eyes...).

**Do not look into arc without protecting your eyes. Use only a welders' face protection shield with protecting glass that conforms to regulation (minimum protection level 11).**

The arc releases not only light and heat causing blindness or burning but also emits UV rays. If insufficient protection is used, the UV beams can cause very painful conjunctivital inflammation only noticeable after several hours.

Bystanders close to the arcs also should be made aware of possible dangerous conditions and should wear protective equipment. If necessary protective walls should be set up.

If welding in small rooms, ensure that there is sufficient ventilation since smoke and dangerous gases can be generated.

It is prohibited by law to weld containers that have been used for the storage of gas, fuel, mineral oil etc., even if containers have been standing empty for a long period of time. Explosions may occur during the welding process due to residue.

Note any special regulations for rooms with high fire or explosion hazards.



### DANGER FROM SHIELDING-GAS CYLINDERS

While handling gas bottles the relevant safety regulations are to be considered.

In particular gas bottles are to be secured against falling over and falling down as against heating up (max. 50°C), to protect particularly during longer solar radiation and against severe frost.

## 4 INSTALLATION

### 4-1 SET UP RULES

Place the device so that cool air can reach the entire outside surface without difficulty

Do not cover the device!

Always place the device on a hard non-combustible, insulated material base.

Do not allow metal dust (e.g. during abrasion work) to directly enter the device.

#### 4-2 DESCRIPTION OF THE OPERATING COMPONENTS (FRONT)

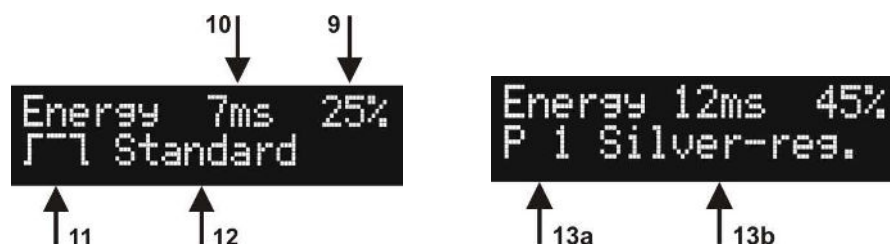


(Figure. 1)

- (1) STAND BY - SWITCH
- (2) LCD - DISPLAY
- (3) PROGRAM KEY
- (only "PUK 3s professional plus")**
- (4) MODE - CHANGE-OVER
- (5) IMPULSE LENGTH / WELDINGTIME
- (6) WELD POWER DIAL
- ADJUSTABLE WELDING DIAL
- (7) CONNECTOR SOCKET FOR HAND PIECE (-)
- (8) SOCKETS (+)

for connection of contact elements such as welding table, welding clamp, holding pliers.

#### (2) LCD - DISPLAY



- (9) Power in percent (%)
- (10) Impulse length (welding time) in Milliseconds (ms)
- (11) Impulse form
- (12) Current mode setting: Standard mode / HF - Pulse welding mode / Gap mode / Micro mode
- (13a) Program indicator P1 - P10 (P1 - P5 are pre-programmed at the factory)
- (13b) Name of Program

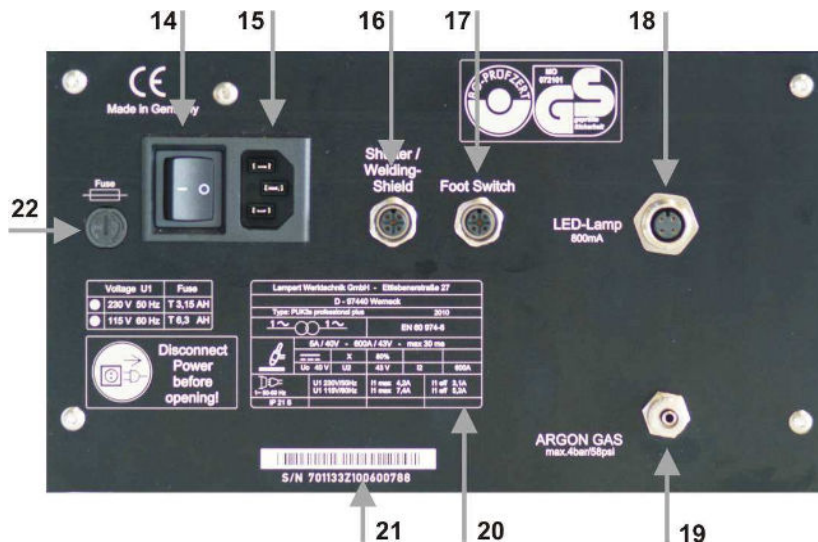
**(only "PUK 3s professional plus")**



The foot switch function can be recognised by this symbol ↓. The foot switch itself is an optional accessory.

#### 4-3 DESCRIPTION OF OPERATING COMPONENTS (REVERSE SIDE)

(Figure 2)



- (14) MAINS POWER SWITCH
- (15) RECEPTACLE  
For connecting the power cable
- (16) CONNECTION SOCKET FOR WELDING SHIELD („Shutter / Welding Shield“)
- (17) CONNECTION SOCKET FOR FOOT SWITCH (optional extra) („Foot Switch“)
- (18) CONNECTION SOCKET FOR MICROSCOPE LIGHTING („LED-Lamp 800 mA“)
- (19) INERT GAS CONNECTOR  
For a  $\varnothing$  6,0 mm pressure hose
- (20) IDENTIFICATION PLATE
- (21) SERIAL NUMBER
- (22) FUSE BOX  
Fuse box with space for spare fuses

#### 4-4 STARTING THE WELDING PROCESS:

##### Setting up:

The device must be set up on a flat and stable surface, a work table is best suitable.

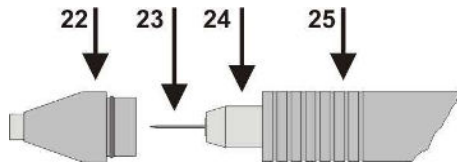
Insert the hand piece connector as straight as possible into the socket (7) and by turning to the right carefully bolt on (hand-tight)

Insert the connector of the clamp or pliers into one of the sockets (8)

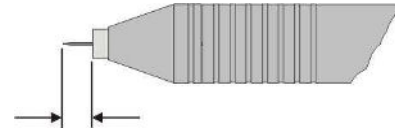
### Insert electrode:



Before changing the electrode, please check and make sure that the machine is switched off. The uncontrolled triggering of a welding impulse can hereby be avoided.



(Figure 3)



(Figure 4)

Remove the argon nozzle (22) from the hand-piece (25) by twisting it in opposite (alternate) directions, and gently pulling.

Loosen the electrode thread (24), insert the newly sharpened tungsten electrode (23) and screw on tightly (**per hand - do not use a wrench**) with the electrode projecting ca.4 – 6 mm out of the nozzle (Fig. 4)

(Only use original electrodes - Thorium dioxide - free)

mount the nozzle



### **PLEASE NOTE!**

**Nozzle (22), electrode screw connection (24), electrodes (23) and pliers devices are wearing parts and are not subject of warranty.**

### Connect eye protection:

Plug the round plug for the welding shield i.e. eye protection system (Mezzo / Optic unit) into the connection socket (16) marked "Shutter – Welding Shield" located on the back of the device and secure it with the nut.



### **Warning!**

**Only the Lampert - eye protection systems "MEZZO welding microscope" or "PUK optics unit" may be attached.**

**Other eye protection systems are not permissible and may lead to health damage**



### **Note!**

**Always test that the eye protection system (shutter) is in correct functioning order before you start welding.**

**Through a press on the welding output regulator (6) you switch the eye protection filter from bright to dark.**

**If the eye protection filter (Shutter) does not switch from bright to dark, it must immediately be replaced.**

### Connect inert gas supply:

Attach the pressure controller to the protective gas container after carefully reading the instructions (if possible, use argon gas with a minimum of 99.8%, e.g. "Argon 4.6"

Connect pressure tube, by using the quick connectors, to the pressure controller and to the gas connection (19) located on the back of the unit.



**It is important to use the provided original - pressure hose only.**

**Examine the hose conclusions to make sure that they are all gas-tight.**

Open gas bottle valve and set the gas flow to about 2 litres per minute

For the micro-adjustment of the correct flow rate you consider section 5



**maximum operating pressure should be 4 bars!**





### Note!

Gas error!!!  
Check Pressure

The PUK 3s will only work when hooked up to a supply of inert gas and only when the machine is receiving enough pressure (ca. 2 litres / min).

If inert gas is not hooked up, not flowing or if the pressure is too low, the display will show the following reading: "Gas error!! Check pressure".

### Connect power supply:

Connect mains lead to the back of the unit (15) and plug into the mains outlet.

Switch the mains power switch (11) to "ON". The display will show the following important safety warning "**Warning ! Protect your eyes Read and follow the manual**".

Confirm the compliance with these safety instructions, by pressing any button. Following this, the machine will run a self-test.



### Note!

Please read the instructions on the connected eye protection devices such as the PUK - optic unit (welding shield) or MEZZO microscope with (welding shield)!



### Caution!

As soon as the mains power switch is switched to "ON", the terminal clamp (i.e. crocodile clip) and cables receive electrical current. Please see to it that these items cannot come into contact with any electrically conducting or earthed materials. For the user / operator there is no danger, but unwanted operating errors can occur.

### Standby Switch (1)

By pressing the "Standby Switch" button, the machine is returned to its „standby“ setting.

When the PUK is in the „standby“ setting, the display, and the LED-lighting of the microscope will go out. Only the red control lamp above the "Standby Switch" will remain on.

The machine can be returned to its „ready to weld“ setting by pressing any button on the front panel or by adjusting either of the rotary knobs (Time / Power).

In addition, PUK will also return to its „ready to weld“ setting again, as soon as the electrode in the hand piece touches any work piece which is connected to the machine (e.g. contacted with the crocodile clip).



**If the display is showing an error message, or a safety warning, it cannot be switched to its "standby" setting.**

**In the case of the error message, the cause of the error must first be fixed before the machine can be returned to "standby".**

**If a safety warning is shown, the operator must first confirm the compliance with these safety instructions, by pressing any button, then the machine can be returned to "standby".**

**As an alternative, the machine can be switched off entirely by pressing the Mains Power Switch (14) on the back of the device.**

#### 4-5 CHANGING LANGUAGE DISPLAYED:

Languages available: ENGLISH – ITALIAN – SPANISH –FRENCH - GERMAN

The machine can be changed from English, to run in any of the 4 other languages mentioned above.

Switch the machine on and confirm the safety notice displayed, so that the device starts and is ready for work.



**Now, press both the „Mode“ button (4) and the rotary-knob „Power“ (6), holding them pressed for 2 seconds.**

The language setting has now been changed to the next language in sequence. By repeating this process, the various languages available can be selected one after the other.

## 5 SET UP OF THE PARAMETERS AND OPERATION

After being switched on and running the self-test, the machine will start from its initial settings:

Standard impulse, welding time 7ms and low output

The initial settings for mode, welding time and power, correspond to the blue LEDs in the display. The display also has blue LEDs to mark the entire parameter range.



### **Important!**

At the outset, until a basic proficiency is reached, we recommend to only change the parameter welding power, leaving the welding time constant. After a short time, when you have become more confident with the technique and have gained more experience, then you can naturally also change the welding time to suit your needs.



**The machine automatically saves the last three sets of welding parameters that have been used.**

By pressing in the rotary knob “Impulse length / welding time” (3), these previous settings can be recalled one after another.

Even when the machine is switched on, or after accidentally changing the parameters, the settings that were last used are there to be recalled again.

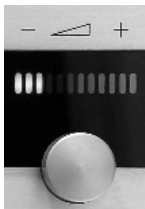


### **Note!**

**Make sure that only with correctly adjusted gas flow rate good welding results are obtained.**

to adjust the quantity of gas keep the output regulator (6) pressed (the gas valve in the machine opens) and adjust the correct flow rate (2 litres/min) using the pressure control valve.

### 5-1 SETTING THE WELDING PARAMETER



Output:

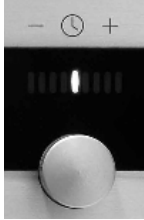
Using the output regulator (6) the welding achievement and/or the strength of the welding energy is set.

The size and intensity of the spot welds are controlled in such a way

Welding time:

The automatic controller for the pulse time/welding time (5) regulates how many milliseconds the welding energy affects.

Dependent on the angle of the electrode to the workpiece the penetration depth and direction of the melted Metals change.



If the electrode is led vertically to the workpiece, the penetration depth is largest.

A description of the welding modes:

*Standard mode*

Welding time 4-30ms, Power 20-100%  
Our all-round program for many different applications.



*HF - Pulse*

The mode "HF-Pulse" has been developed principally for the welding of the most common silver alloys. When used in conjunction with longer welding times, it is also well suited for avoiding heat cracks.



*Gap (Joint-Mode)*

This pulse shape is recommended for applications, in which it is essential to weld in deep joints or angles.



*Micro ( Micro-Mode)*

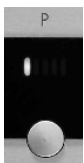
This setting makes precise welds possible at very thin materials.



This particularly fine output gradation, as well as a special pulse shape in the micro mode, is suitable particularly for material thicknesses smaller than 0,4mm and for fine build-up welds (e.g. at claw settings).

5-2 Programming

**(Only "PUK 3s professional plus")**



RECALLING STORED SETTINGS (Program slot 1 – 10)

Apart from the 5 pre-programmed memory slots, this feature brings the possibility to personalise and store the users own welding parameter settings, into 5 additionally available memory slots. These settings can then be recalled at a moments notice.

**Please note:** The preset parameters represent a recommended guideline for work. When working on especially thin or intricate constructions, we advise using the following method to avoid damage to the work piece: Start welding with a lower power and then readjust the power if necessary, gradually increasing it until the correct setting is achieved.

By pressing (short) the button – program memory (3) and then releasing it, the individual memory slots can be accessed.

STORING OF INDIVIDUAL SETTINGS (memory slots 6 - 10)

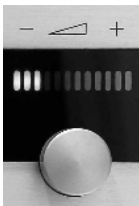
Press the button – program memory (3) (**long – ca. 1 sec.**) and then releasing it, the process for storing the current user settings is initiated.

Press the button – program memory (3) (**short**) and then releasing it, the memory slot can be selected in which the settings are to be saved. (Program slot 6 – 10)

Press the button – program memory (3) (**long – ca. 3 sec.**) and then releasing it, the settings are saved into the selected slot. The display will show the notice “Settings stored. Please enter the name of the program”.

Now the memory slot can be given a name (up to 10 characters). By turning the rotary knob – welding power (6), the icon (number, letter), in the selected character, can be changed. To select the next character in the row, press and release the rotary knob – welding power (6)

Finally, to store the settings and name into the selected memory slot, press and release the rotary knob – Impulse length / welding time (5). The display will show the notice “Your text was stored” the programming process is now completed.



**Please note:** If the user tries to save a set of parameters that is identical to one that is already stored (or identical to one of the pre-programmed settings), the display will show the following error notice. “Settings identical to program – X Settings not stored!”. This is to avoid the “blocking” of a memory slot with a duplication of already stored information.

In this case the memory slot, where the original setting is stored, will blink. The process can then be cancelled by pressing the rotary knob – welding power (6).

## 6 INSTRUCTIONS

### 6-1 WELDING INSTRUCTIONS (Standard-/ HF-Pulse-/ Gap-/ Micro-mode)

(For instructions regarding the foot switch, please refer to chapter 6 - 2 where this subject is handled separately).

Connect the clamp to a blank metal location on the work piece

Touch the electrode tip to the spot to be welded until the welding is done



**without, or with minimum pressure to the electrode tip!**

The welding procedure is automatically done:

- o Safety gas encases the welding spot
- o A signal announces the arc
- o The light arc appears

- o Safety gas supply ceases

The welding procedure may be stopped anytime by removing the electrode from the work piece

## 6-2 WELDING WITH THE FOOT SWITCH (optional accessory)

Make sure that the PUK is switched off. Attach the foot switch cable to the socket "Foot Switch" on the back of the machine.

Next switch the machine back on, the display will show the following important safety warning "Warning ! Protect your eyes Read the manual Follow the advice". Confirm the compliance with these safety instructions, by pressing any button. Following this, the machine will run a self-test.



The foot switch can be activated, by pressing and holding it for ca. 1 second. The display will show the symbol ↓.

Attach one of the terminal clamps (i.e. crocodile clip) to a part of the work piece where the bare metal is exposed.

If the work piece is brought into contact with the electrode, the glare protection system (shutter) inside the microscope "mezzo" will flicker in a clearly visible manner.

Whilst in this operating status, if the foot switch is pressed, the welding process will run automatically, just as described in chapter 6-1.

By again holding the footswitch pressed for ca. 1 second, (without contacting the work piece) the footswitch function can be deactivated. The symbol ↓ will disappear from the display.

## 6-3 IN GENERAL AND POINTERS



### **Important!**

**Always work with sharpened electrodes!**

**This is the best way to achieve maximum results.**

**Make sure the work piece has enough contact to the clamp. If contact problems occur, make sure the clamp is in contact with a metallic blank location.**

**Never weld „hands free“, this means; support both hands i.e. on the workbench during welding. Shaking hands falsify the parameters of the device. .**

**Apply only minimum pressure onto the electrode tip.**

**Weld only with minimum gas pressure!**

**Under 2 l/min are often sufficient**

## TIPS

Take enough time to get to know your device.

Try out various power levels of the device.

Bear in mind that every material reacts differently when welded, according to its heat-conductivity.

Consider the thickness of the material when you choose the power level.

Try to touch the work piece to be welded as precisely as possible.

With just a little experience you will discover how the angle in which you touch the electrode to the work piece will effect the flow direction of the welding point.

Touching the work piece in an angle of 90° will give you the deepest welding point.

A saw or file burr can serve well as a „welding addition“.

When working on “deep laying” or recessed welds, the electrode can allowed to protrude slightly further out of the nozzle. In this case, the gas-flow rate should be slightly increased.

It may be helpful to use a graver to broach grains to later weld them on.

It may be helpful to use wire as a welding addition to close holes or as reinforcement.

### 6-4 SHARPENING THE ELECTRODES



Please switch off the machine before changing the electrode. Uncontrolled releasing of a weld is avoided in such a way.



The electrodes should be sharpened with a diamond grinder with fine or medium grain.  
The angle should be ca. 15° (Fig.)

### 6-5 CARE AND MAINTENENCE

The PUK 3s needs, under ordinary working conditions, only minimum care and maintenance. Remembering a couple of points is crucial, though, to ensure proper functioning and a long life for your welding device.

Regularly check the power plug and power cables, as well as welding cables for damage.

Ensure that the hand piece parts are easy to operate.

If necessary, clean the electrode thread of the hand piece to ensure an optimal contact with the electrode



#### **Warning!**

**IF FUSES NEED TO BE REPLACED, REPLACE ONLY WITH THE SAME VALUES. IF DAMAGES OCCUR AFTER INSTALLING INAPPROPRIATE FUSES (I.E. TOO STRONG) THE WARRANTY BECOMES INVALID.**

**AUTHORIZED PERSONNEL MAY ONLY OPEN THE DEVICE!**








## 7 TECHNICAL DATA

### 7-1 TECHNICAL DATA

■ Device is suitable for spot and precision welding in dry environments	
■ Main Voltage	~230 V / 50-60 Hz +/-15%
■ Mains fuse	T 3,15 A
■ Power input "PUK 3s professional plus"	400 VA
■ Power input "PUK 3s professional"	350 VA
■ Operating voltage	30 – 43 V
■ No I- load voltage	43 V
■ Duty cycle	80%
■ max. charging time	0,8 sek
■ Inert gas	min. ARGON 99,9% (ARGON 4.6)
■ Maximum gas pressure	4 bar
■ Inert class	I
■ Insulation class	B
■ Protection Method	IP 21S
■ Weight "PUK 3s professional plus"	8,8 kg
■ Weight "PUK 3s professional"	8,4 kg

### 7-2 Identification Plate

Symbol explanations:

<b>A</b>	Amperage	<b>V</b>	Voltage	<b>IP</b>	Protection Method
<b>Hz</b>	Hertz		Alternating Current (AC)		Tungsten-Inert Gas-Welding
	Direct Current	 1 ~ 50-60Hz	Power plug single phase / Alternating Current / 50-60Hz		Read the manual
<b>U<sub>0</sub></b>	Idling Voltage	<b>U<sub>1</sub></b>	Mains Voltage		Ground
<b>U<sub>2</sub></b>	Nominal Voltage	<b>I<sub>2</sub></b>	Nominal welding current		Single phase transformer
<b>I<sub>1max</sub></b>	Amperage input	<b>I<sub>1eff</sub></b>	Rated Amperage input	<b>X</b>	Duty cycle

<b>8 TROUBLE SHOOTING</b>			
	<b>ERROR</b>	<b>CAUSE</b>	<b>SOLUTION</b>
<b>1</b>	<b>No welding power</b>		
	Power main switch on. Display stays off	Power connection interrupted	Check power connection and main voltage
		or machine's internal fuse defective	or replace fuse with a suitable fuse of the same type and value.
<b>2</b>	<b>No welding power</b>		
	Power main switch on.	Welding cable connection interrupted	Check connectors
		Bad or no grounding	Connect to work piece. Attach contact clamps directly to the work piece
<b>3</b>	<b>No welding power</b>		
	Power main switch on.	Interruption due to power error	turn device on and off
			If still error, take device to be serviced
			Equipment to technical service
<b>4</b>	<b>Power fuse and/or automatic safety blows</b>	Not enough power protection	Install proper power protection
		Wrong automat	
		Mains fuse releases in the no-load operation	Send device to be serviced
<b>5</b>	<b>Welding unsatisfactory</b>	Wrong safety gas	Use inert gas (Argon 4.6)
<b>6</b>	<b>Oxidation and soot development</b>	Gas pressure too high	Reduce flow to ca. 2 l/min
<b>7</b>	<b>Heavy oxidation development on the welding spot</b>	Wrong safety gas	Use inert gas (Argon 4.6)
<b>8</b>	<b>Tungsten in basic material</b>	Too much electrode pressure on the work piece	Lightly touch work piece so that it barely ignites enough
<b>9</b>	<b>Tungsten electrode adheres to work piece</b>	Too much electrode pressure on the work piece	Lightly touch work piece so that it barely ignites enough
<b>10</b>	<b>Tungsten electrode melts off</b>	Tip sharpened too much	Sharpen to the recommended angle (ca. 15°)
<b>11</b>	<b>Static discharge over the device surface</b>	Special location	Use special floor mat for the work area
<b>12</b>	<b>Work piece adheres to the welding table</b>	Bad connection to welding table	Use clamps or pliers
<b>13</b>	<b>Eye protection system (Shutter) does not work</b>	Plug wrongly installed	Install plug into the socket marked with "Shutter"
<b>14</b>	<b>Equipment welds immediately when affecting the workpiece (no gas before flowing time)</b>	Operational disturbance	Immediately take machine out of operation. Take the equipment to service



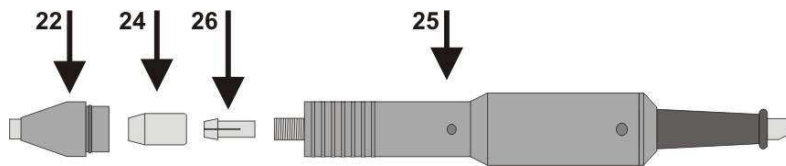


### Warning!

#### Authorized personnel may only open the device!

Text and images correspond to the technical version during print of this manual. We reserve the right to change components.

## 9 REPLACEMENT PARTS LIST



### ■ Hand piece:

25	Complete Hand piece	100 100
22	nozzle	100 150
26	Spread pliers	100 151
24	Nut	100 152

### ■ Electrodes:

Electrodes 10 pcs. In display can (Thorium dioxide - free) incl. Diamond wheel 100 400

### ■ Grindingwheel:

Diamond wheel 100 701

### ■ Gas hose:

3m gas hose 6x4mm (max. 10bar) 100 153

## 10 DISPOSAL REFERENCE

Make retired devices useless by removing the mains cable.

Only for European Union countries:

In accordance with European guideline 2002/96/ EEC over electrical and electronics old devices, used up electrical appliances must be collected separately and supplied to a environmental fair recycling.

## 11 **EC-DECLARATION OF CONFORMITY**

**The Manufacturer,**

**Lampert Werktechnik GmbH**

**Ettlebener Str. 27, 97440 Werneck, Germany,**

**declares that the product**

Precision Welding Device

„PUK 3s professional“ & „PUK 3s professional plus“

conforms to the conditions set forth in the above-named guidelines, including any changes made up to the time of declaration.

**Relevant EEC guidelines:**

According to low voltage guidelines 2006/95/EG

According to EMV (electro-magnetic compatibility) guidelines 2004/108/EG

**The following harmonised standards were used:**

EN 60974-6

EN ISO 12100-1

EN ISO 12100-2

Person duly authorised to carry out technical documentation: N. Hammer

Werneck, February 1th, 2010

Lampert Werktechnik GmbH

Andrea Bauer – Lampert (President and CEO)

