

KORROSIONS GRUPPEN



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GENERAL

Read the instructions carefully before using the pinbrazing unit.

Check that all parts are received.

ECONECT PB 94360 Delivered with:

ECONECT unit	PB 94450
Gun CP15, automatic	PB 91016
Ground device	PB 8069
Grinder 36 V DC	PB 8007
Carrying harness	PB 9523
Tool case	PB 9524

Guarantee: Units 12 months, batteries 6 months. Valid only when using original parts, batteries and chargers supplied or approved by SAFETRACK®. The guarantee will expire if the equipment was used or has been used with non-original spare parts, consumables or not used in accordance with the instructions.

TECHNICAL SPECIFICATION



Technical specification

Voltage	39V DC
No. of brazings/charge	40-60
Unit weight incl.batteries	9,8 Kg
Dimensions LxWxH (mm)	250x265x255
Temperature range	-20 °C - +55 °C

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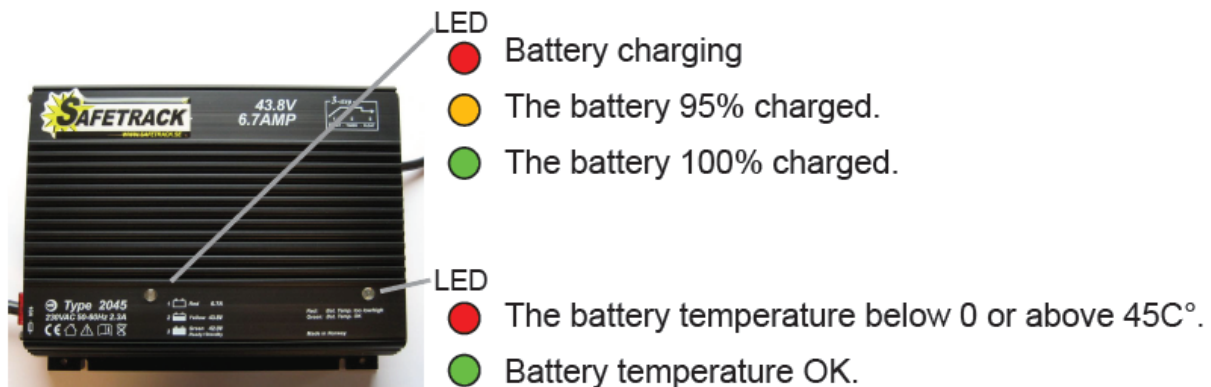
CHARGING THE BATTERY

NOTICE!

CHARGING THE BATTERY CAN ONLY BE CARRIED OUT BETWEEN 0°C to +45°C

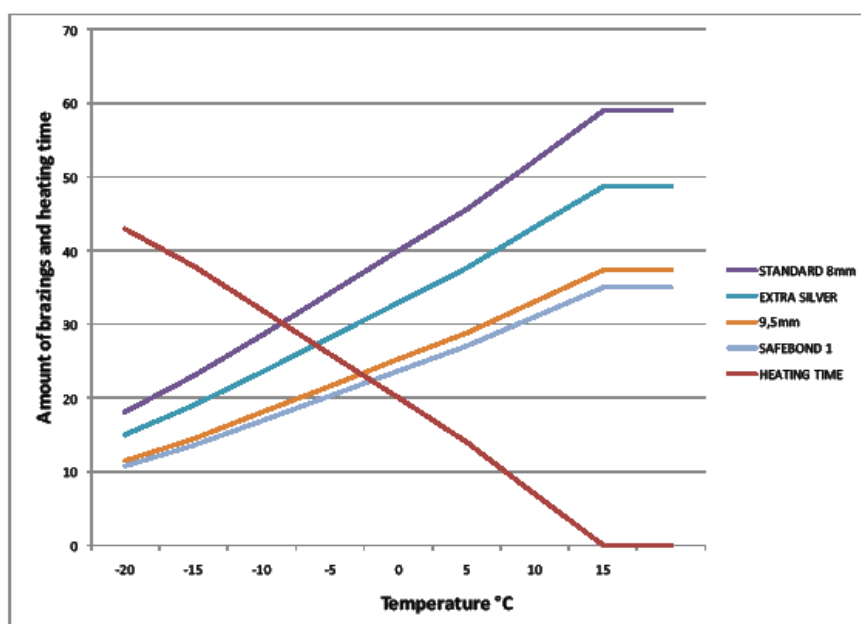
Connect the charger to the grinder / charging outlet on the unit then to the mains. The battery is fully charged after about 4 hours (if completely discharged).

If the batteries are left uncharged, they may be damaged.



Heating time and number of brazings

The build-in heating element automatically heat up the batteries. (Heating time) Possible amount of brazings (See actual brazing pin).



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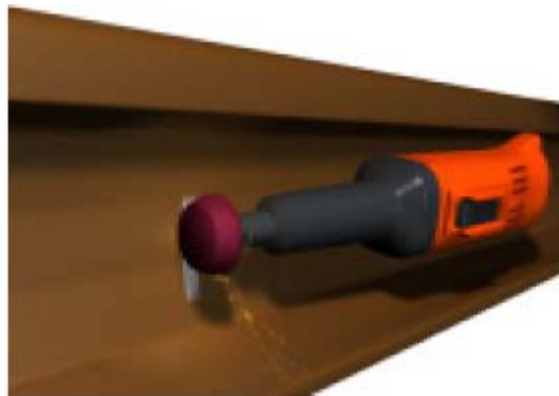
**GRINDING****Warning!**

Always use eye protectors when grinding and brazing!

NOTICE!

Note, use only SAFETRACK's grinding wheel specially made for brazing, other type of wheels will leave a surface not suitable for brazings. Keep the grinding wheel clean and free from oil etc.

- Connect the grinder to the unit.
- Grind the brazing and ground area until you have an even and clean surface.



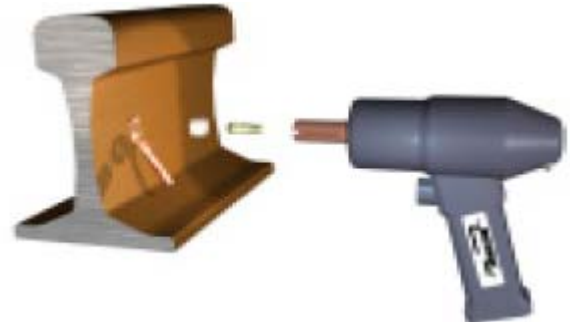
- Attach the ground magnet on the same rail/work piece where the pinbrazing should be done.
- Try to attach the magnet within 0,5m from brazing area.



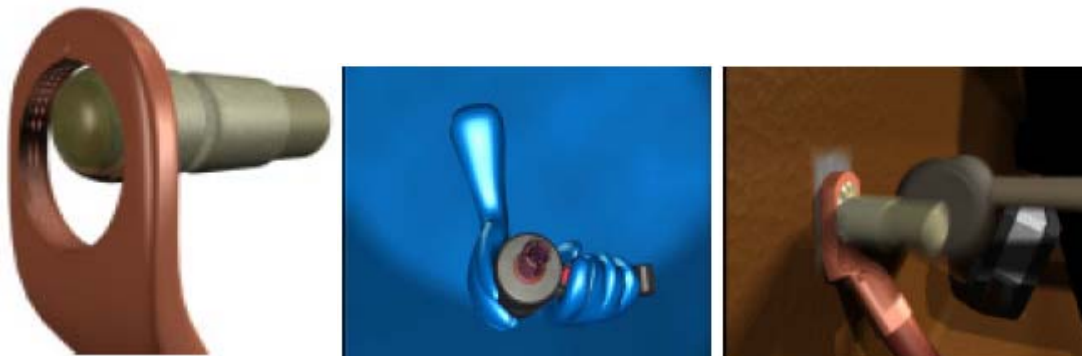
PINBRAZING

Operation

- Connect the brazing gun, power and trigger cable to the unit.
- Connect the ground device to the unit.
- Press on/off button and select the right pin type by pressing the "setting" button. The unit will remember what setting was used last.
- Load the gun with brazing pin and ferrule.



- Make sure to braze in the top of the hole when brazing to a vertical surface.



- Hold the gun firmly with both hands as shown and pull the trigger just once. The electronic will by itself finish the brazing process.
- Hold the gun in place for 3-4 sec after the brazing while the braze freezes.
- Remove the gun **straight** backwards without pulling the trigger!
- Knock off the shank of the brazing pin.

The brazing is completed.

If the brazing is aborted to early **"ERROR"** will turn on. The brazing should be redone for a good result. The lamp will be shut down after 8 seconds.

NOTICE!

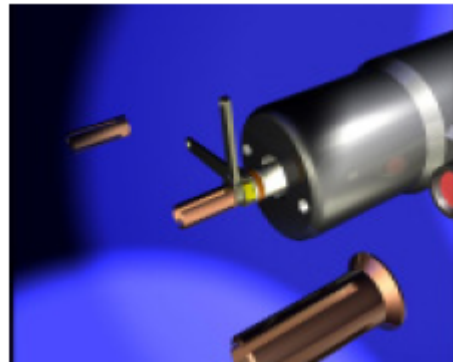
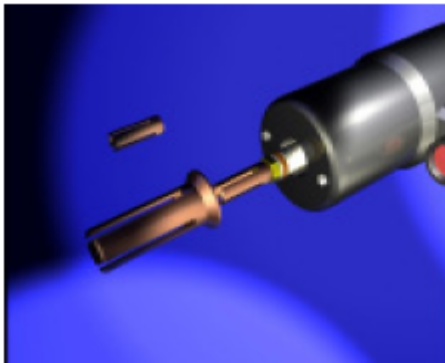
The battery indicator "LOW BATT" flashes when the batteries are almost discharged, when the "LOW BATT" is constantly lit the batteries are discharged and you can't do any more pin brazing. Charge the battery.

**MAINTENANCE****PIN HOLDERS**

Squeeze the fingers on the pin holder together each time you feel that the brazing pin goes in too easy when mounting them into the pin holder. This is important since all the current goes thru the pin holder to the brazing pin. If the fingers are too loose the pin holder will be damaged and must be replaced.

CHANGE PIN HOLDER.

- Separate the ring holder from the gun with your hands.
- Hold the nut closest to the pin holder with a 10mm key.
- Screw the pin holder off.
- When replacing the new pinholder, hold the nut, closest to the pinholder even now.



Warning! Never rotate the shaft, it can damage the gun.

EQUIPMENT-

Make sure the batteries always are fully charged.

- Check the cables from time to time, so damages have not arise.
- Even the contact surface on the ground magnet with a file from time to time.
- Make sure that the brazing pin with the ferule passes easily in the gun, centered.

BRAZING PINS AND FERRULES

- Keep them dry.

RAILBONDS AND CABLE LUGS

- Keep them free from oxidation.-Keep them free from contamination like: Grease, oil.
- Make sure that there are no damages on them.

SETTING RIGHT LIFT HEIGHT

The CP15 brazing gun self adjust to the same lift height every time. See separate instruction for the gun.



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MAINTENANCE

Error indications on the unit:

“ERROR” led is lit.

-The temperature of the battery is over +55 °C.

Action: Wait until the light goes out, then the temperature dropped and it is possible to braze again.

“ERROR” led flashes.

-The temperature of the battery is below +10 °C.

Action: Leave the unit on, the built-in heating element will heat up the battery. Wait until light goes out and the temperature has risen, and it is possible to braze.

“ERROR” and “LOW BATTERY” led flashes.

-The temperature of the battery is below +10 °C and the battery is almost discharged.

Action: Charge the batteries.

“ERROR” Led is lit after a braze.

-The pin brazing was not complete.

Action: The braze should be remade to achieve good results. The Led turns off after 8 seconds.

“ERROR” Led glows

- Failure of a sensor in the unit.

Action: The unit should be sent for repair.

“LOW BATTERY” Led flashes.

-Battery is almost discharged

“LOW BATTERY” led is lit.

-Batteries are discharged. Charge the batteries.

Nothing happen when you press the buttons.

-The electronics may have gotten stuck.

Action: Remove control 5A fuse for a short time, put it back again.

The brazing never stops.

-The electronics may have gotten stuck.

Action: Remove the gun and the ground magnet from the rails and disconnect them from the unit as soon as possible. Remove the control 5A fuse, check that nothing has been damaged before the fuse is put back.

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MAINTENANCE

Replace the fuses:

Push and unscrew anti-clockwise to remove fuse holder. Replace fuse and mount fuse holder.

NOTE!

Control: 5A fuse.

Grinder: 15A fuse



Special functions:



1. Battery indicator:

Press and hold the "SETTING" button, while you push the "ON / OFF" button. "LOW BATTERY" LED will light. Release the buttons. The LEDs on the front panel show the charge status of battery.

2. Lifting height control: First the step above.

Press "SETTING" and the lights start flashing, at this point, you can check the lifting height of the gun.

3. Pressing "SETTING" one more time and you goes back to battery indicator.

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MAINTENANCE

Periodically maintenance of CP15 automatic gun

B.1. Check that all cables and lugs are without damages and properly tighten in gun and unit. The cable set has a locking screw on the plug that goes to the gun.

B.2. Check that the right pinholder is fitted in the gun.



PB No	For brazing pin	Mark
9211	8-9,5mm	A
9213	M8 threaded	B
9215	M10 threaded	C
9217	M12 threaded	D

Make sure that pinholder is tight to the gun, use spanners as the figure shows. Otherwise a spark can destroy the axle.

Spanner 8 mm and 10 mm for 8-9,5 mm and M8 pinholders.

Two pcs of spanner 10 mm for M10 and M12 pinholders.

Make sure, never twist the axle when mounting the pinholder.

The brazing pin shouldn't go too loose in the pinholder, when it does push together with your fingers.

Otherwise you can have a contact fault or a spark can arise.

B.3. Check that the ringholder is the right type. You can dismount it by hand otherwise

adjust with the small screw on the side of the gun

B.4. Load the gun with a 8mm pin and ferrule.

Check that the axle move easily with the pin and ferrule fitted when moving back and forward. If not, change either pinholder or ring-holder.

If it still doesn't move easily the axle is damaged and must be sent for repair.



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MAINTENANCE
Lift level tool
PB 91245

IMPORTANT! The normal liftheight is 2mm.
This is very important for the arc and energy amount.
Too high liftheight increase the risk of a "coldbrazing",
too low liftheight reduce the time and increase misfires.

B.5.1. Insert this end in to the gun.



B.5.2. Press and hold "SETTING" and press ="ON/OFF".

When "LOW BATTERY" is lit, release buttons.

Press "SETTING" and the leds will start to blink. In this mode it is able to check the lift height.

Important! Press the tool completely against the gun then pull the trigger.
Otherwise the gun may be damaged!

Important! Hold the gun so the tool is horizontal.

B.5.3. The lift level is calibrated when the inner rod, made of brass, on the tool is in same level as the outer plastic sleeve.

Tolerance $\pm 0,2$ mm.

If the gun is not calibrated see separate instruction for adjusting of the gun.



MAINTENANCE

Advanced maintenance work Adjusting the liftlevel.

B.6. Reset correct liftheight at a CP15 gun. *Only when to reset a maladjusted gun.*

B.6.1. Fit the instrument PB 91245 on the gun as in B.5.

B.6.2. Connect the cables to the pinbrazing unit and switch on the power.



B.6.3. Take off the plastic plug with the needle in the upper small hole in the front of the gun.

IMPORTANT, never adjust in the hole where the big plug is!

B.6.4. When liftheight is too **low**: Use the 3mm hexagon spanner and adjust the screw in the small hole **anti-clockwise** about 1/4 of a turn then check with the instrument as in B.5.

B.6.5. When liftheight is too **high**: Use the 3mm hexagon spanner and adjust the screw in the small hole **clockwise** about 1/4 of a turn then check with the instrument as in B.5. If all is ok, fit the plug in the hole again. If not ok, send for repair.