

Periodically maintenance of S4 automatic gun

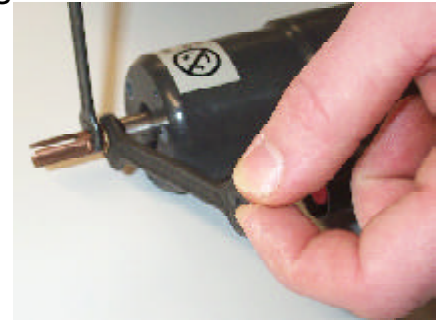
IN-026-02



B.1. Check that all cables and lugs are tight always twist the plug in to the outlets on the units. 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.

<u>SAFE No.</u>	<u>For brazing pin</u>	<u>Mark</u>
9211	8-9,5 mm	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.

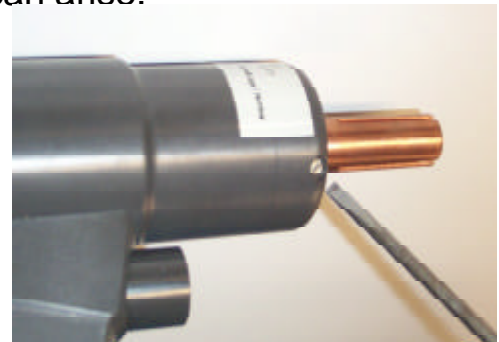
Spanner 8mm and 10mm for 8-9,5 mm and M8 pinholders.

Two pcs of spanner 10mm 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 ringholder.

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

**KORROSIONS
GRUPPEN**

Lift level tool

PB 91245

2002-09-05

IMPORTANT! The normal lift height is 2mm (setting 0) this is very important for the arc and energy amount. Too high lift height increase the risk of a "coldbrazing", too low lift height reduce the time and increase misfires.

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



B.5.2. Turn on the unit and set the gun in position "0" in the back (normal setting and gives a lift level of 2 mm).

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.

*Advanced maintenance work
Adjusting the liftlevel.*

B.6. **Reset correct liftheight at a S4 gun.**
Only when to reset a maladjusted gun.

B.6.1. Set gun in position "0".

B.6.2. Fit the instrument PB 91245 on the gun as in B.5.

B.6.3. Connect the cables to the pinbrazing unit and switch on the power.

B.6.4. 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.6.5. 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.6.6. 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.

