PROCEDURE TO SET PARAMETRES FOR BALL TACK WELDING AND TACK WELDING

WITH GDC AND HANDTOOLS (Only)

1- Return of current

it is important to have clamps, a bench vice with copper or a copper plate. That is why it is important to ask the customer the shape of its parts in order to give him the correct tool for the return of the current.

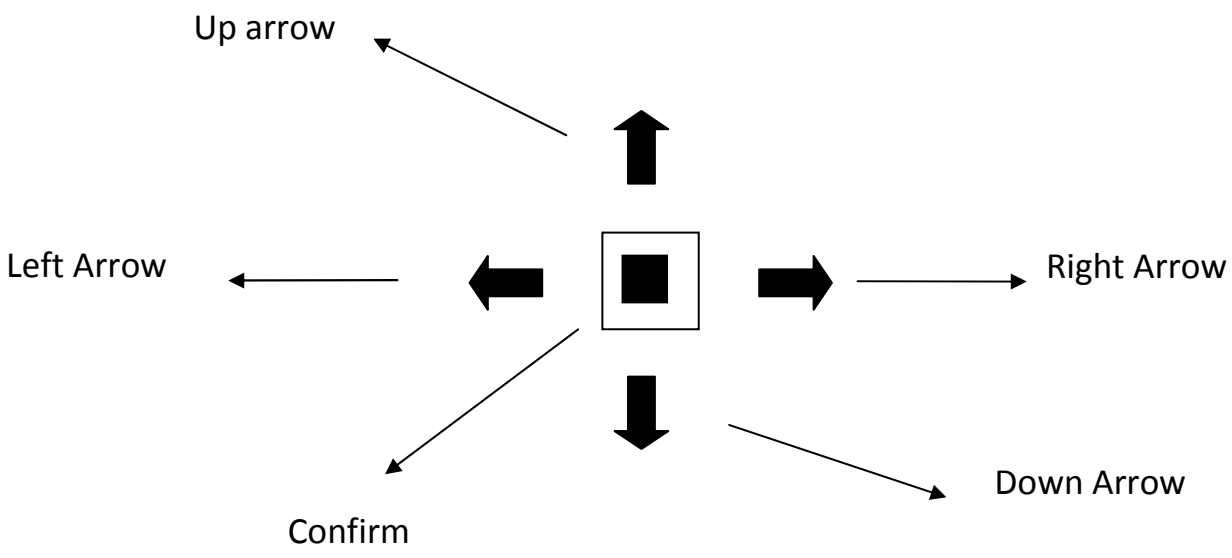
The tool for the return of the current has to be as close as possible near the welding point, in order to ensure a good weld.

2- Parametres

Main screen

P	R	:		1		S	I	N	G	L	E			S	T	O	P	:	N
C	P	A	R	T	S	:	0	0	0	0				C	T	R		:	C
C	B	A	D			:	0				K	E	Y	B	A	O	R	D	
C	E	L	E	C		:	0	0	0	0			I	:	2	8			

To enter in the program 1 press the button in the middle (Confirm)



Then with the Right Arrow go to the screen

	P	r	o	g	r	a	m				N	o	:			1			
	F	o	r	c	e						1		:			0	%		
*	P	o	w	e	r						1		:		2	0	W	s	

Power 1: Power of the 1st weld impulse from 1 to 300 W/s
Example: 20 W/s.
To increase or decrease the value in POWER 1 use the up and down Arrows

Then with the Right Arrow go to the screen : Discharge Time

	P	r	o	g	r	a	m					N	o	:			1		
*	D	i	s	c	h	a	r	g	e	T	i	m	e					:	
								S	H	O	R	T							

Discharge time: Selection of the primary of the discharge transformer.
Time: SHORT or MEDIUM or LONG.
For tack welding and ball tack welding we use SHORT- MEDIUM can be used if there are too many sparks.

Then press the middle button to confirm and select Weld and press again the middle button to confirm wait few seconds and the green light comes up. The green light means the capacitors are charged.

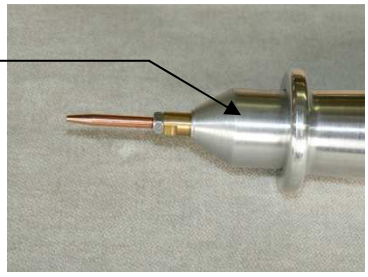
	*	W	E	L	D														
		P	R	O	G	R	A	M	M	I	N	G							
		C	O	N	F	I	G	U	R	A	T	I	O	N					
		M	O	D	E														

Always starts the trials with a POWER 1 at 15Ws/20Ws then increase step by step until you have reached the desired weld result.

Ball tack welding with CS 5 ASP and tack welding with CS 5

The force of the welding pen can be adjusted as per the picture below:

Turn the pressure set-up cap. It will compressed or released the spring inside the pen



For the ball tack welding it is important to have an angle of 45°.
It is also important to keep in mind the force during welding is given by the spring inside the welding pen and not the human force.