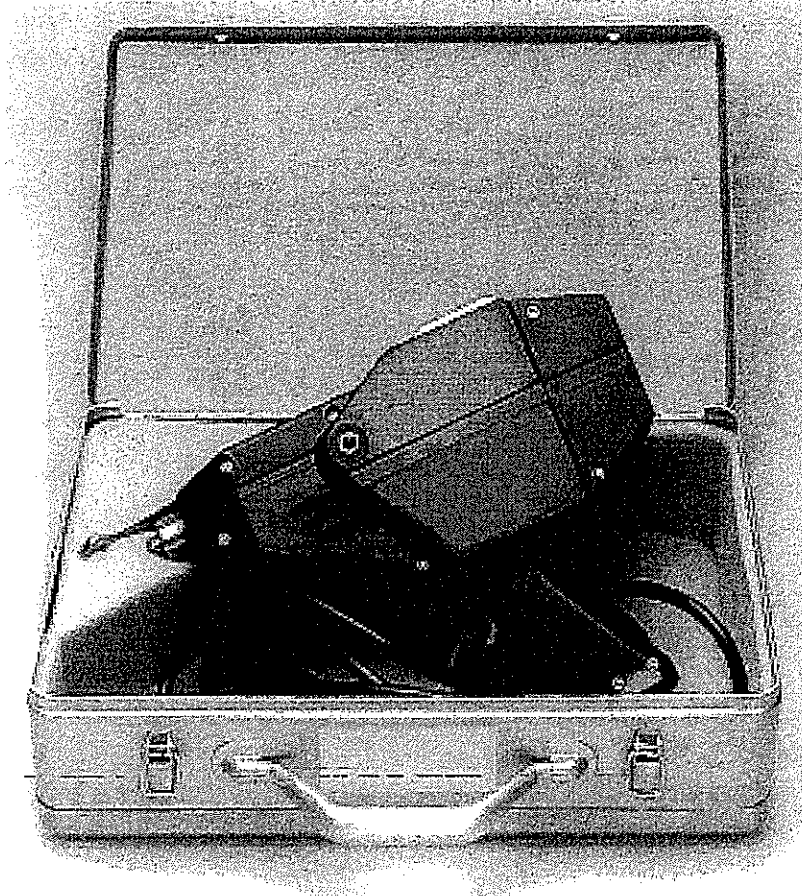


PINWELDER

PW-33-110



OPERATING MANUAL

DYN AIR INC.
2100 REMEMBRANCE ROAD
LACHINE(QUEBEC) H8S 1X3
CANADA

TEL (514) 639-1616
FAX (514) 639-5252

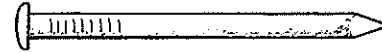
PINWELDER PW-33 :

The DYN AIR portable Pin welder PW-33 is a first class, pin spot welding gun which has proved its reliability in workshops and on job sites all over the world. The PW-33 is supplied in a strong steel carrying case.

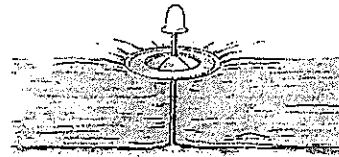
The DYN AIR PW-33 is equipped with a built-in timer which allows time adjustment for best welding on thin or thick steel sheet, galvanised or not.

WELDING PINS:

The DYN AIR PW-33 is designed to weld the DYN AIR DST welding pins AND OTHER BRAND NAMES



Type:	DST
ø pins:	2,2 mm
Standard lengths:	19 to 140 mm
Made of:	galvanised steel



PRECAUTIONARY MEASURES:

Congratulation for your purchase of this sophisticated tool which will give you full satisfaction provided you take care of the following:

Warranty applies to defects in workmanship or material but does not apply to expendable parts (like welding tips) or misuse of the unit.

- Your PW-33 Pin welder has been designed to weld the DYN AIR special pins type DST.
- In order to avoid overheating, the welding rate should not exceed 6 to 8 pins per minute.
- You will obtain true welding on galvanized steel up to 1.2 mm thick. The PW-33 will weld on thicker steel but welding rate should be reduced and welding strength will not be assured.
- Avoid fierce shocks! The gun case is heat resistant and made of strong fiberglass reinforced polyester. However, be careful, do not drop the unit as this may cause breakage inside.
- Protect the airvents against dust and metal-scrap that could enter the gun and cause a short circuit.
- The magnetic tip is interchangeable but should only be unscrewed after complete cooling down of the unit. Unscrewing hot tips will damage unit and avoid warranty.

In case of overheating, please let the unit cool down as soon as possible and check:

- Are you using DYN AIR pins?
- Is the timer properly set?
- Are you welding at higher rate than 6 to 8 pins per minute?

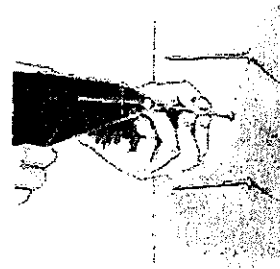
Our dealer who serves you with the pins and clips is at your entire disposal for any help, advise or maintenance service.

DIRECTIONS FOR USE:

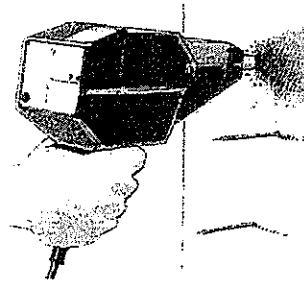
1. Plug the PW-33 as close as possible to the main fuse box (min. 16 A) and if necessary use heavy wire extension cord (min. $3 \times 2,5 \text{ mm}^2$). Be care, too thin wire extension cord will drastically reduce the weld strength.

2. Adjust the timer according to the thickness of the steel. The timer should be adjusted in order to obtain the required welding strength in the shortest possible time. Before starting work, it would be wise to make some tests on a piece of the same sheet metal in order to adjust the timer.

3. Insert a welding pin in the magnetized tip.



4. Press the gun perpendicularly on the metal plate. Hold electrodes at this 90° angle. It will ensure you a good electrical contact.

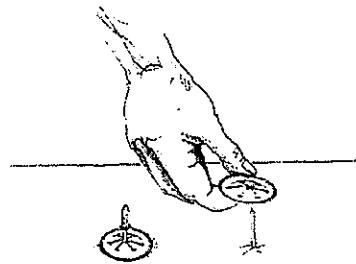


5. Press the trigger and hold it until pilot light turns off.

6. Lift off the gun and repeat. It is recommended to weld about 10 to 12 pins per square metre or to follow the SMACNA standards for the spacing of the pins.

7. Impale the insulation material on the pins welded. Ideally, the pins should be 6 mm longer than the insulation material.

8. Lock insulation by placing the self locking washers onto the pins.



TECHNICAL SPECIFICATIONS:

- | | |
|------------------------|-------------------------|
| • Power supply: | 220 V / 1 Ph / 50-60 Hz |
| • Fuse: | 16 A |
| • Length of the cable: | 3,7 m |

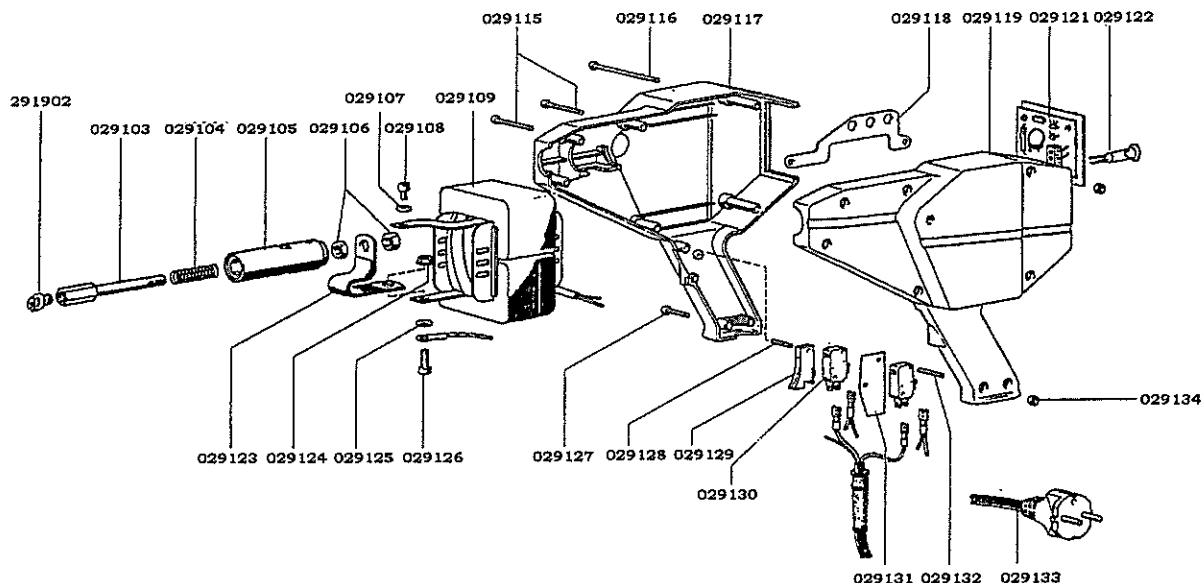
- Weight of the machine:
- Min. section of the wire extension cord: 3 x 2,5 mm²

4 Kg

MAINTENANCE:

To ensure a good contact, it is recommended to clean regularly the magnetic tip of the gun with a little file (provided in the carrying case) or a steel brush.

PW-33



291902	Interchangeable electrode	029123	Connection braid
029103	Electrode holder	029124	Nut
029104	Spring	029125	Washer
029105	Cylinder-secondary electrode	029126	Screw
029106	Brass nut	029127	Casing screws, short (x2)
029107	Washer	029128	Pin, short
029108	Screw	029129	Trigger
029109	Transformer 220 Volts	029130	Micro-switches (x2)
029115	Casing screws, medium (x4)	029131	Isolator
029116	Casing screws, long (x2)	029132	Pin, long
029117	Right casing	029133	Connection cable
029118	Spare electrode holder	029134	Nuts (x8)
029119	Left casing	029135	Complete set of nuts and screws for casing
029120	Complete casing with nuts and screws	029136	Printed circuit and potentiometer of 029121
029121	Timer complete (136+137)	029137	Triac only of 029121
029122	Pilot light	029140	Carrying case