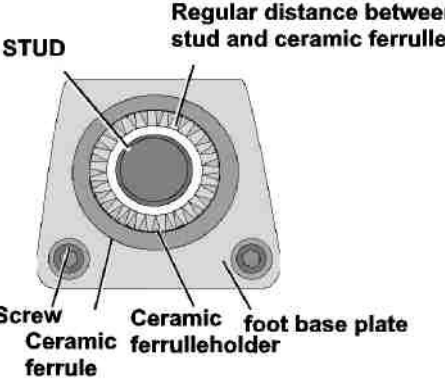

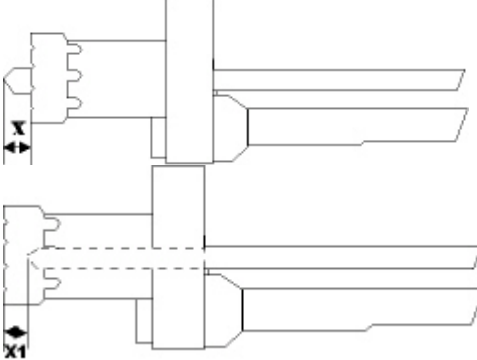




Adjustment of welding gun PHM 5 & 12

 <p>STUD</p> <p>Regular distance between stud and ceramic ferrulle</p> <p>Screw Ceramic ferrulleholder foot base plate</p>	<p>Adjustment of foot base plate so the regular distance between ceramic ferrule and stud (insulation pin) is in centre. Otherwise the stud is hindered when dipping into the melting steel.</p> <ul style="list-style-type: none"> - Slightly loosen screws connecting foot base plate and pillars - Shift foot base plate until there is a regular distance between ceramic ferrule and stud (pin). - Tighten screws and stud (pin) - Also check the stud protrusion. If necessary adjust again.
	<p>Adjust your leg assembly so your stud protrusion (or insulations pin) will stand about 5 mm out your ceramic ferrule X= 4-5 mm.</p> 
	<p>Try to lift by hand to max, and check that the stud (or insulation pin) will be lower than the edge of the ceramic ferrules X1 = 1 - 2 mm</p>
	<p>Now try in welding position to lift again by hand, here you should lift the insulations pin 1 to 2 mm. See pic. Below.</p> 