



PBFS-14 PINSPOTTER



OWNER'S MANUAL

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SET UP

1. Plug Gun Cable Cam-lok Connector into the Gun Cable Socket (A).
2. Plug the Switch Cable into the Switch Cable Socket (B).
3. Plug the Ground Cable Cam-lok Connector into the Ground Cable Socket (C).

ELECTRICAL REQUIREMENTS

Connect PBFS-14 to power supply. (208-240 volts - 60 cycle - 60 amp fusing).

The PBFS-14 unit uses 220 volt single phase.

To hook up to 220 volt single phase, the green lead is ground and the white and black leads are power.

It is suggested that the unit not be wired into the power box permanently, but rather plugged in so that the unit may be quickly unplugged and easily taken elsewhere in the shop or on the job.

PBFS-14 AS A BENCH TOOL

To use your work bench as a welding table, set PBFS-14 alongside work bench. Cover the bench top with a copper sheet (.025) which will act as a permanent ground when duct work is placed on table top. Attach ground clamp to duct work or copper bench top. Clip Pins quickly welded every time with no burn marks or wasted pins due to misfires.

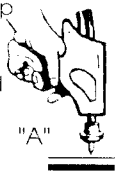
WHEEL PBFS-14 TO THE WORK

Where duct is too large to put on a bench, snap ground clamp onto duct and secure insulation quickly by welding Clip Pins inside or outside of ducts as required. Eliminate the heat mark on the duct using simple "heat sink" on opposite side of weld.

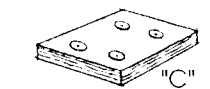
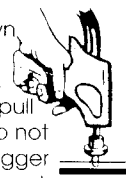
INSTALLING CLIP PINS

Clip Pins are welded as easily as "A", "B", "C".

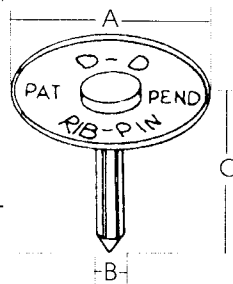
Position Clip pin on Magnetic tip of hand gun.



Press down through insulation, twist gun, pull trigger. Do not release trigger until timer cycle has ended.



Clip Pins are permanently welded in position flush with insulation.



RIB PIN SPECIFICATIONS

CODE NO.	CP-12	CP-34	CP-100	CP-150	CP-200
Insulation Thickness	1/2"	1"	1"	1 1/2"	2"
Dimension "A"	1"	1"	1"	1"	1"
Dimension "B"	.150	.150	.150	.150	.150
Dimension "C"	.4"	.6"	.9"	1.4"	1.9"

TIMER ADJUSTMENT

Your timer dial facing you on the front panel of the unit, determines the duration of the weld cycle. For maximum efficiency of the unit, the weld cycle should be set for the shortest length of time necessary to provide a good weld. An excessive amount of time does not improve the weld. On the contrary, the resulting weld is not as good. It is recommended that at the start of a production run, using a given length of pin with a given gauge of metal, the operator take a few moments to determine the minimum timer setting to perform the job and leave timer at that point.

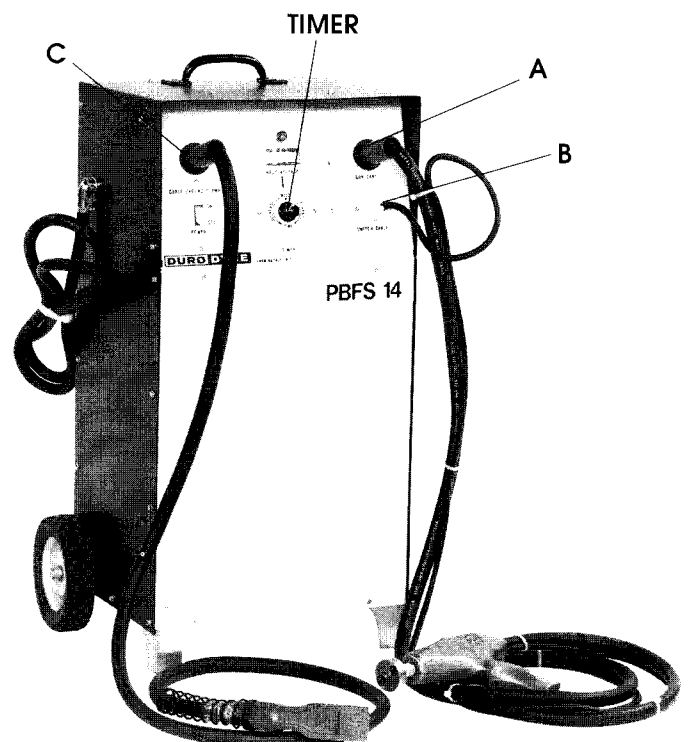
NOTE: There is a common misconception that the longer the weld time, the stronger the weld. This is not true. It is important that you follow the above instructions for maintaining the minimum weld time.

"HEAT SINK"

Included with your PBFS-14 is a simple "heat sink" tool looking somewhat like a cookie cutter. This tool, when placed behind a point of weld on bare metal, will eliminate any mark on the metal by dissipating the heat generated from the point of weld. The use of copper sheet on the work bench will also eliminate this mark.

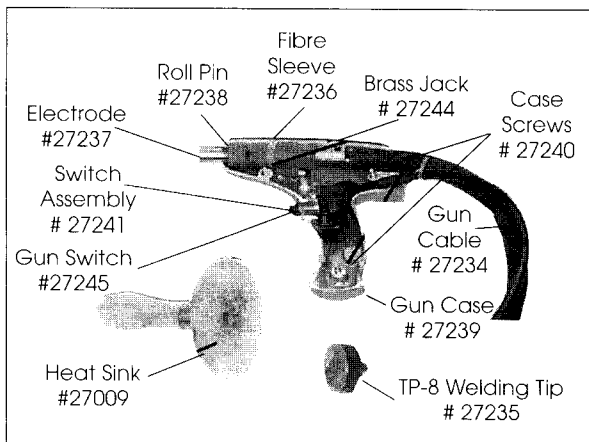
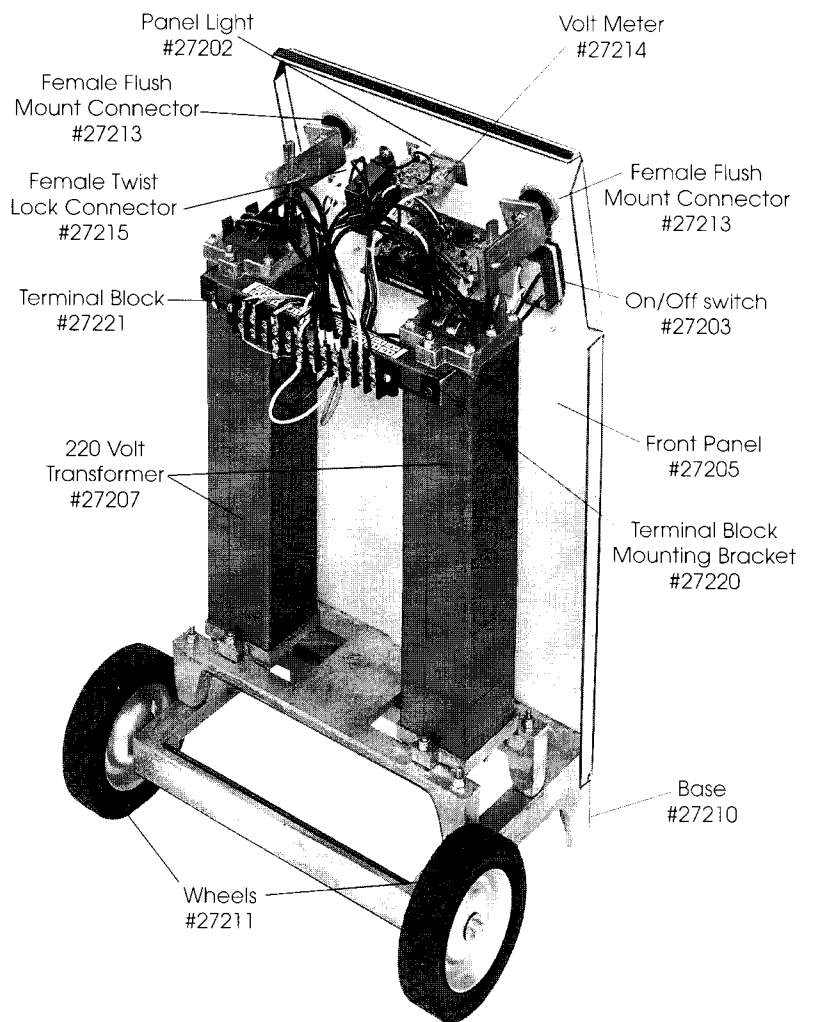
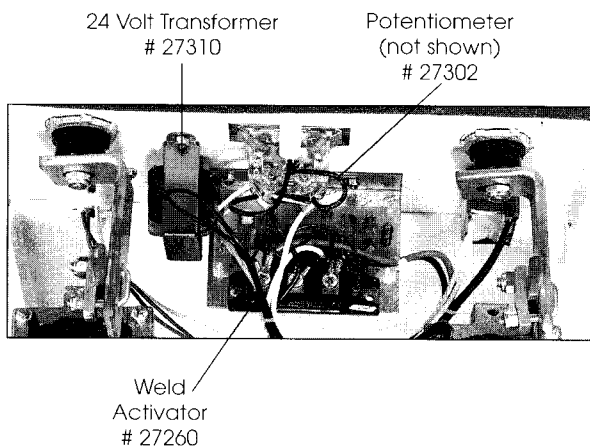
SERVICE AND MAINTENANCE

The PBFS-14 has been designed and built to withstand rugged shop and field usage. Constant, trouble-free operation is assured with a minimum of maintenance. The GUN TIP, the GROUND CLAMP and all CABLE CONNECTIONS should be kept clean to maintain good electrical contact. Wire brush the parts to remove any oxidation or adhesive that may have accumulated during the fastening operation.

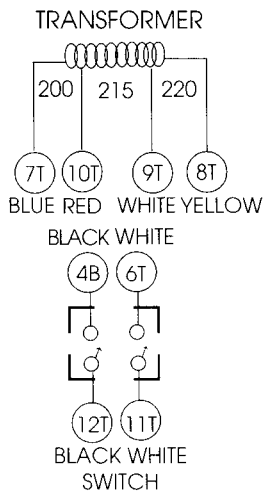


PBFS-14 PARTS & SPECIFICATIONS

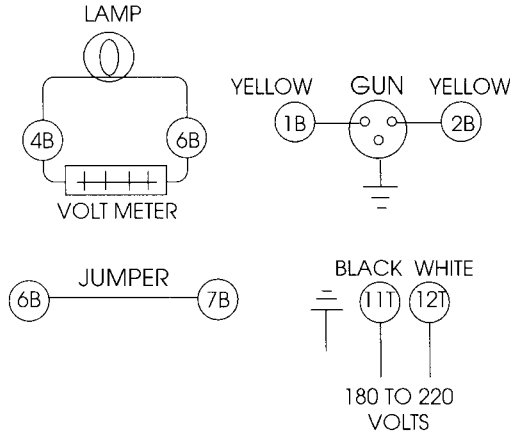
ITEM	DESCRIPTION	ITEM	DESCRIPTION
27009	Heat Sink	27224	Back Panel Washer (not shown)
27129	Transformer Primary (not shown)	27225	Back Panel Bolt (not shown)
27202	Panel Light	27234	Gun Cable
27203	On/Off Switch	27235	TP-8 Welding Tip
27205	Front Panel	27236	Fibre Sleeve
27206	Case (not Shown)	27237	Electrode
27207	220 Volt Transformer	27238	Roll Pin
27210	Base	27239	Gun Case
27211	Wheel ea.	27240	Case screws
27212	Face Plate	27241	Switch Assembly
27213	Female Flush Mount Conn.	27243	Gun Cable
27214	Volt Meter	27244	Brass Jack
27215	Female Twist Loc Conn.	27245	Gun Switch
27216	Handle (not shown)	27259	Weld Activator Conversion Kit
27217	Line Cord (not shown)	27260	Weld Activator
27220	Term. Block Mounting Bracket	27302	Potentiometer
27221	Terminal Block	27310	24 Volt Transformer
27223	Back Panel (not shown)		



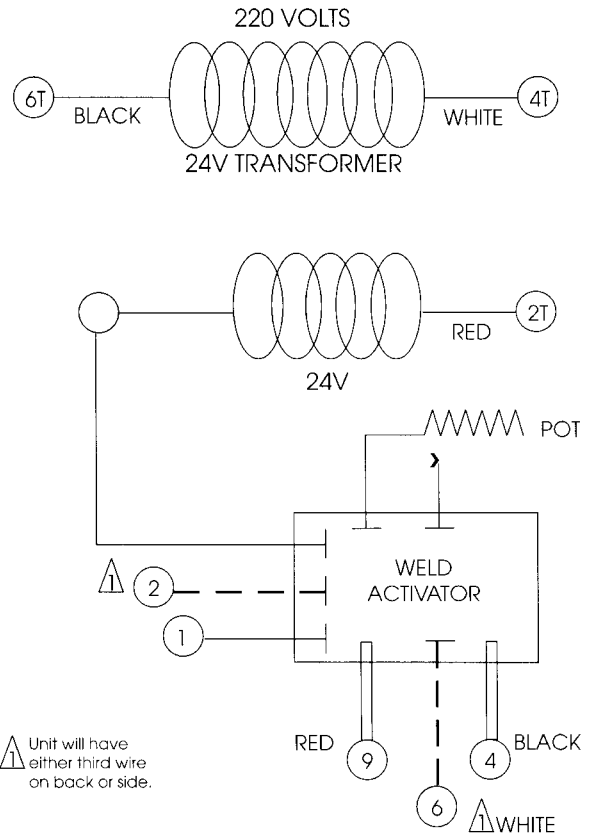
PBFS-14 INTERCONNECTIONS



WELDING COMPONENTS



TIMER COMPONENTS



Note:

Your PBFS-14 Pinspotter is factory wired to operate satisfactorily with the line voltage at the unit reading from 215 VAC to 230 VAC (measure across terminals 11B to 12B).

Wiring may be modified to accommodate lower voltages in cases where welding power is insufficient.

If voltage input is from 200 VAC to 215 VAC:
Remove red wire from 9B and connect to 10B.

If voltage input is from 230 to 250 VAC:
Remove red wire from terminal 9B and connect to 8B.

PBFS-14 ELECTRICAL WIRING SCHEMATIC

