5 USE

5.1 Preparing the machine

5.1.1 Assembling the pneumatic gun

Connect the cables and hoses on the gun to the generator.

5.1.2 Fitting the electrodes

Electrodes and caps with two different tip shapes can be used on the gun:

- Rounded - With this shape the electrode does not have to be adapted to the thickness to be welded and maintenance is easier and faster.
- Flat tip - This shape can reach positions difficult to reach with the rounded electrodes (e.g. close to edges), but the two electrodes must be perfectly aligned in order to weld correctly.

Choose the type of electrode according to the task and in accordance with the instructions provided by the manufacturer of the car on which the work will be done.
Before welding, clean the electrodes with a fine-grained abrasive sponge.
The electrode holders must be adjusted so that the tips of the electrodes align perfectly in the working position.

5.1.3 Preparing the surfaces to be welded

The following instructions must be followed in order to obtain a good weld:

- The electrodes must always be clean and maintained in their original shape;
- The surfaces of the sheets in contact with the electrodes must be clean;
- The surfaces of the sheets in contact with the electrodes must be free from rust and paint;
- The sheets to be welded must be properly aligned (the electrodes must not be used to force the sheets together).

5.2 Switching on the machine

Switch on the device by turning the main switch to the 'I' - ON position.

5.3 Selecting programs and setting welding parameters

Three different operating modes can be used:

- In SMART + mode, the user does not have to choose the welding parameters, as these are automatically determined by the control system.
- In QUICK mode, the user can set a reduced selection of welding program parameters.
- In FULL mode, the user can configure all the welding program parameters.

WARNING
For more information on programming, see the "Operator Panel" chapter.

5.3.1 SMART+ mode

In SMART + mode, the machine automatically identifies the materials between the electrodes and select the most suitable parameters for the work to be done.
During the welding process, the system automatically compensates for any conditions that require modification of the welding parameters, such as poorly coupled metal sheets or the presence of paint or adhesives between them.
Therefore, the user does not have to make any adjustments, except for setting the type of arm and electrodes used.
All standard arms can be used in this mode, but only with electrodes art. 5234 or 5233 (the rounded electrodes art. 5234 are recommended for best results).
For the use of other types of electrodes in SMART+ mode, consult TECNA spa.

5.3.2 QUICK mode

In QUICK mode, the operator can set a reduced selection of welding program parameters, namely time, current and welding force.
When using QUICK mode, the inner surfaces of the sheets to be welded must be cleaned.
Do not use QUICK mode for welding on surfaces that require adhesives.

5.3.3 FULL mode

In FULL mode, the operator can set the welding program parameters according to the indications of the manufacturer of the car on which the work is to be done.
When using FULL mode, the inner surfaces of the sheets to be welded must be cleaned.
Do not use FULL mode for welding on surfaces that require adhesives.