

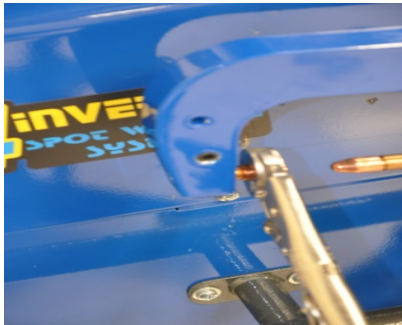
## Best Practices for a Pro Spot I-4 Spot Welder



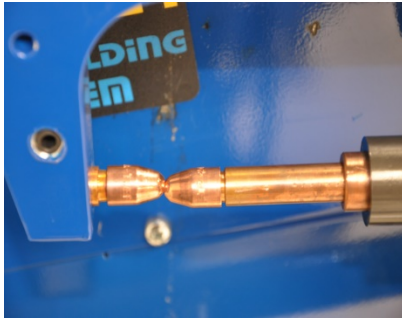
- **Check OEM procedures for spot welding (Edge distance, Pitch, Weld Thru Primer, specific electro tips and inner flange preparations).**
- **Hook up machine to an air supply and turn on**



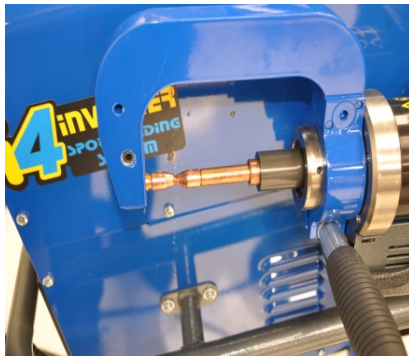
- **Set Air pressure for 90psi for standard gun (blue cover) and 50psi for high pressure gun (black cover).**



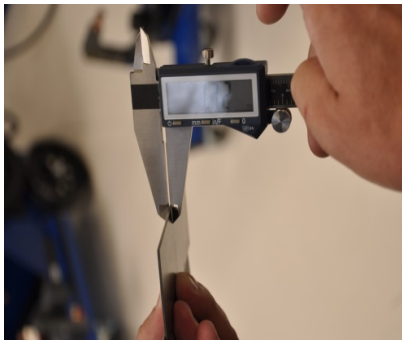
- **Check the electrode tips for wear. Remove tips using proper supplied tooling. DO NOT use a grinder to clean and shape tips.**
- **Install new tips** and set the tips by pulling the trigger and closing the electrodes.



- **Check alignment on the tips. Note the tips in this scenario are not in alignment.**



- **Align the tips using 3 set screws on the gun and recheck.**



- **Measure thickness of both pieces of metal to be spot welded and divide by 2 to obtain the proper setting on the machine**



- **Set the machine to welding operation (machine is set for HHS Galv).**
- **Check the vehicle in the area that is to be welded that there are no sensitive electronics (12-15 inches from weld). If there is a computer for example, **it needs to be removed.****
- **Place the welder in a position so that the gun cable is perpendicular to the vehicle.**



- **Perform a destructive weld test using same metal from the vehicle (See **Best Practice for Testing Spot welds for procedures**).**



- **Use a shunt pliers for the first weld when weld bonding or leaving the E-coat intact between the mating surfaces.**



- **Clean the both outer flanges at weld site where the electrodes will make contact.**



- **Perform the weld. Remember to do the following: Place insulated clamps near the area that is being welded. Do not use the pressure from the gun to draw the flanges together. Finally, pull the gun so that the stationary electrode is making contact with the flange and the moveable electrode is driven into the flange.**

**Note—All items in red are non-included items**

**Note—Once a year, have factory trained technician check the coolant and replace if necessary**