

TWE - 17000

HEAVY-DUTY STUD GUN

OPERATIONS MANUAL



THE TWE 17000 HAS BEEN DESIGNED TO FIT COMFORTABLY FOR ALL HANDS, INCLUDING WHEN WEARING A WORK GLOVE. THE NECK OF THE HANDLE HAS BEEN TAPERED SO THAT WHEN GRASPED, THE TRIGGER CAN BE ACCESSED EASILY, WITHOUT ANY UNNECESSARY STRAIN. THE HANDLE LENGTH ALLOWS FOR BETTER BALANCE OF THE STUD GUN AND IT KEEPS THE WELDING CABLE AND CONNECTOR AWAY FROM YOUR HAND, MINIMIZING OPERATOR FATIGUE.

TRU-WELD

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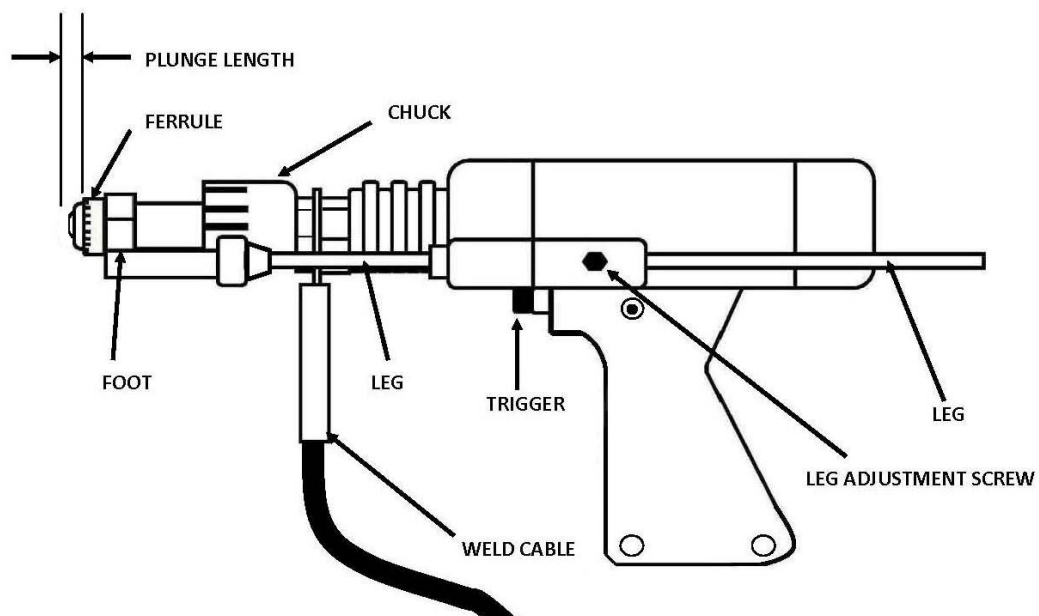


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STUD GUN SET-UP

Each stud welding application requires that the stud gun be set up properly for the correct stud and ferrule arrangement.

- ◆ Select the correct style and size of chuck for the stud to be welded and attach it to the stud gun.
- ◆ Select the proper length leg assemblies for the length of the stud.
- ◆ Select the proper foot piece best suited for your application.
- ◆ Select the grip to fit the ferrule which is provided with the stud to be welded.



TRU-WELD ARC STUD GUN

** Specifications are subject to change without prior notification.

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LIFT ADJUSTMENT

Setting the lift when all of the accessories and stud have been properly set on the stud gun, prior to welding, plug the control connector of the stud gun directly into the stud welder (do not attach the weld cable). Turn on the stud welder and actuate the trigger of the stud gun with the stud and ferrule in place. Note the retraction of the shaft of the stud gun. This is designated as the Lift.

The lift setting should be about $3/32$ " for general welding applications and studs ranging in diameter through $3/4$ " this adjustment should be suitable. For larger diameter studs and select applications the lift should be adjusted to approximately $1/8$ ".

Adjusting the lift:

- Remove the back cap of the stud gun.

- Loosen the two socket set screws around the periphery of the lift adjustment screw.

- To increase lift rotate the lift adjustment screw counter clockwise and to decrease lift rotate clockwise.

- With each turn check the lift by actuating the stud gun until the desired lift is achieved.

- Tighten the socket set screws to hold the lift adjustment screw in place to secure the selected setting.

- Replace the back cap of the stud gun.

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PLUNGE RATE ADJUSTMENT

This adjustment is used to control the rate of speed the stud plunges into the molten pool after the arc has been drawn.

Free travel adjustment: This adjustment can be used to control the force with which the stud is plunged into the molten weld pool by moving the engagement point of when the shaft of the stud gun engages the dampener.

Both of these adjustments are located at the front of the stud gun under the bellow of the stud gun shaft.

The outer adjustment knob can be turned to adjust the plunge rate; clockwise to decrease the rate of plunge and counter clockwise to increase it.

The dampener sleeve behind can be turned to adjust free travel by rotating it counter clockwise. Two turns should be the maximum amount of adjustment. Before electing to set the free travel, adjust the plunge rate to see if the desired effect is achieved.

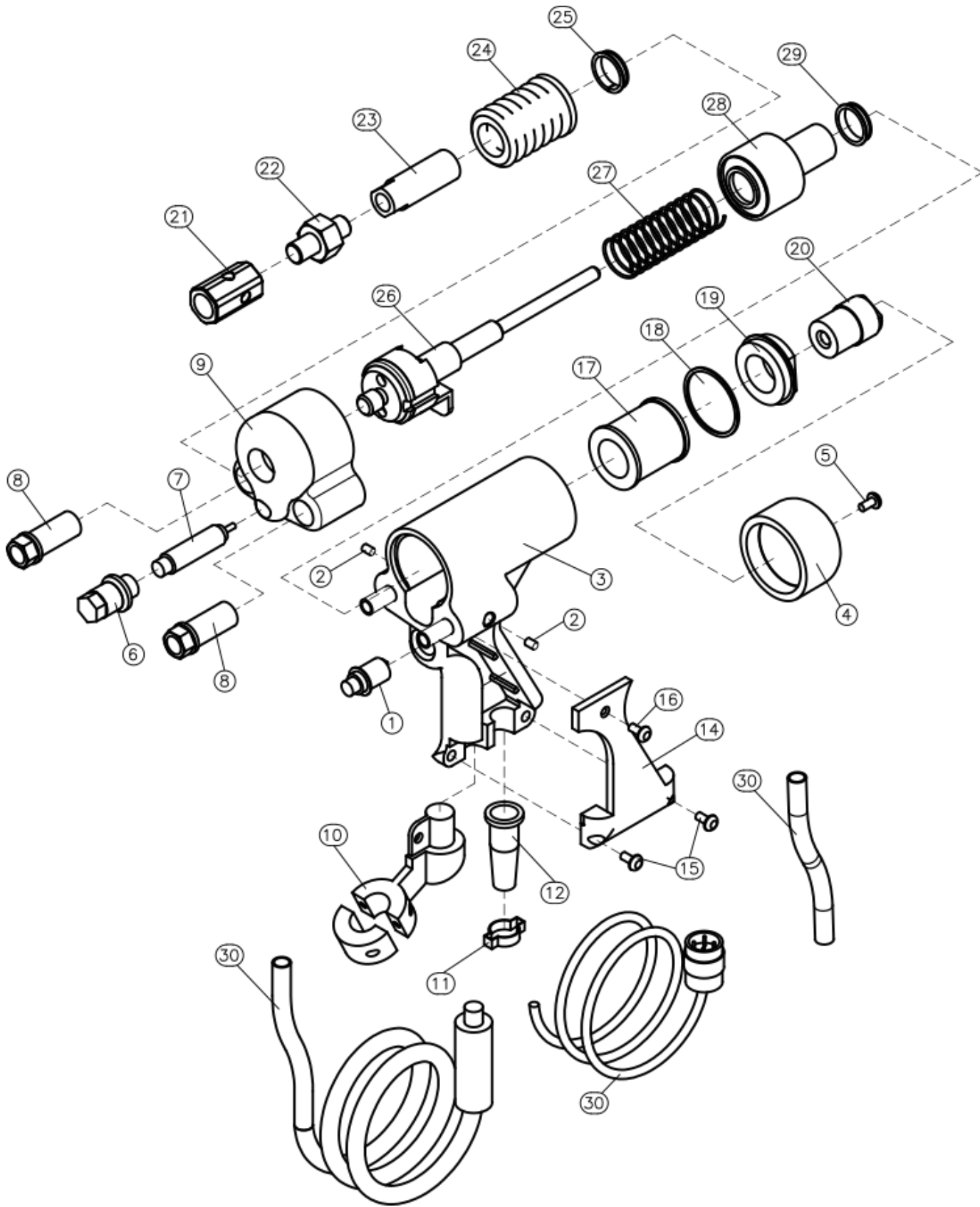


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Attaching the stud gun to begin welding:

- ◆ Always select the desired of weld and control cable extension that is recommended for the stud welder selected.
- ◆ Attach the stud gun weld and control cable to the end of the cable extension.
- ◆ Actuate the stud gun without placing it on the surface to be welded to assure that the connection through the control cable is correct to complete the circuit and actuate the stud gun.
- ◆ Make certain the stud welder is set up properly for beginning the welding procedure selected.
- ◆ Place the selected stud into the chuck and attach the ferrule to the ferrule grip.
- ◆ Place the stud onto the surface to be welded and press the stud gun down until the ferrule is flush with the welding surface.
- ◆ Trigger the stud gun and hold it in place until the cycle of the stud welding is complete.
- ◆ Pull straight up off the stud without flexing the stud gun back and forth.
- ◆ DO NOT depress the trigger of the stud gun again when removing the stud gun from the welded stud.
- ◆ Remove the ferrule by breaking it off and examine the weld.
- ◆ Make proper adjustments if required.

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ITEM	QTY	PART NUMBER	PART DESCRIPTION
1	1	TWE17010	SWITCH
2	2	TWE17017	SET SCREW
3	1	TWE17004	GUN BODY
4	1	TWE17007	REAR CAP
5	1	TWE05429	SCREW - REAR CAP
6	1	TWE09662P	DAMPENER COVER
7	1	TWE12096	DAMPENER
8	2	TWE09661	END CAP NUT
9	1	TWE17008	LONG FRONT CAP
10	1	TWE17012ASSY	CABLE CLAMP
11	1	TWE13039	CLIP
12	1	TWE01095	RUBBER STRAIN RELIEF
13	4	TWE01106	WIRE NUT
14	1	TWE17005	HANDLE COVER
15	2	TWE17019	HANDLE COVER SHORT SCREW
16	1	TWE17020	HANDLE COVER SHORT SCREW
17	1	TWE17013	GUN COIL
18	1	TWE17009	WAVE WASHER
19	1	TWE09660	LIFT ADJUSTMENT INSERT
20	1	TWE09659	LIFT ADJUSTMENT SCREW
21	1	033-506	ADAPTER END
22	1	033-506	CONNECTOR STUD
23	1	TWE09650	SHAFT EXTENSION
24	1	TWE09673	BELLOWS
25	1	TWE17014	SHAFT BEARING
26	1	TWE17022	LIFT ROD ASSEMBLY
27	1	TWE09669	MAIN COMPRESSION SPRING
28	1	TWE09647	LIFT ASSEM. MODULE
29	1	TWE09664	COIL GUIDE BEARING
30	1	TWE11013	CABLE SLEEVE
31	1	TWE07313	4/0 POWER CABLE
32	1	TWE07312	16-4 CONTROL CABLE

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