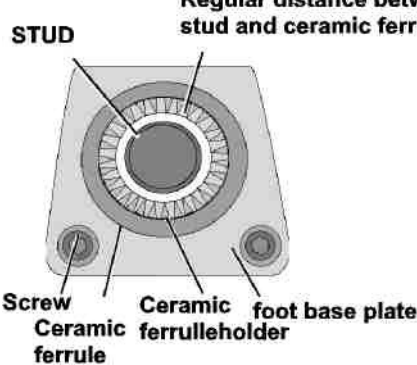

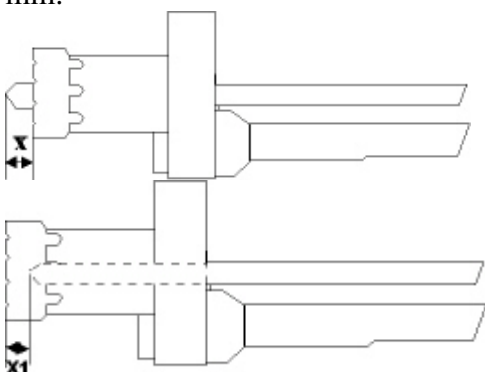




Adjustment of welding gun PHM 5 & 12

	<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>	