



CORROSION CONTROL

## WELDING INVERTER FOR PIN BRAZING

USING INVERTEC 400SX with the BAC Easybond Generator Gun.



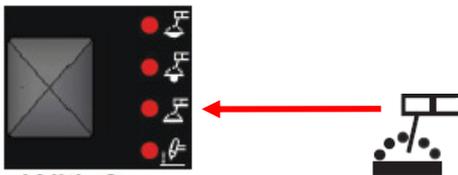
**Ensure that you read the Operator's Manual and fully familiarize yourself with all the safety and operational requirements prior to using this equipment**

- 1./ Switch power on at the rear of the unit



- A. Power Switch: Turns input power On/Off to the machine
- B. Input Cable: Connect it to the mains.

- 2./ Set the welding mode to stick user defined parameters



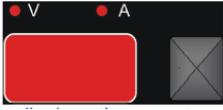
- 3./ Set Current to 240 Ampere (245 max) using the output current control knob





CORROSION CONTROL

- 3./ Voltage will auto set to 45V max, this can be checked by switching the display from Amperes to Volts.



- 4./ Set by rotating "Hot Start" knob between 30%-50% of the full scale.



- 5./ Set Arc Force knob to maximum.



- 6./ Ensure that the Brazing Gun is plugged into the positive terminal and the Earth is plugged into the negative Terminal.
- 7./ Fire off several test Brazing Pins in accordance with the Pin Brazing Gun Operation manual. If required make necessary adjustments using the Output Current and/or the Hot Start knob. Do not set output Current higher than 245 amperes.
- 8./ Once the Brazing Pins are firing to the required standard make a note of the settings for future reference.

**BAC Corrosion Control Ltd**

Stafford Park 11, Telford, Shropshire, TF3 3AY

Tel: +44 (0) 1952 290321

Fax: +44 (0) 1952 290325

Email: [sales@bacgroup.com](mailto:sales@bacgroup.com)