

TAYLOR STUDWELDING SYSTEMS LIMITED

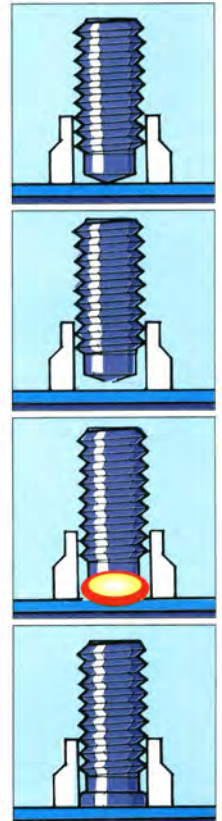


OPERATING GUIDE

FOR

TYPE DA8-A

DRAWN ARC STUDWELDING PISTOLS



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GENERAL INFORMATION

MANUFACTURERS DETAILS

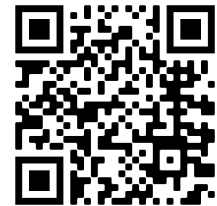
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PURPOSE AND CONTENT OF THIS GUIDE

This guide has been written for :

- ☞ The operator of the welding machine.
- ☞ Installation and maintenance personnel.
- ☞ Purchasing personnel.

This guide contains information on :

- ☞ Installation and connection
- ☞ Operation.
- ☞ Technical data.
- ☞ Spare parts and Accessories.

FURTHER INFORMATION

Should you require additional technical information, please contact us directly (details above) or our local agent/distributor (details of agents etc. can be obtained from us).

This guide contains important information which is a pre-requisite for safe operation of the equipment. The operating personnel must be able to consult this guide. In the interests of safety, make this guide available to your personnel in good time.

If the equipment is sold / passed on, please hand over this guide to the new owner. Please immediately inform us of the name and address of the new owner, in case we need to contact them regarding the safety of the device.



Please read this guide carefully before installation of the machine.



Please especially observe the safety instructions.

SAFETY

PROTECT YOURSELF AND OTHERS !

These welding pistols whilst unconnected are inert but once connected as part of a complete welding installation may present potential risks and dangers. Please read and understand these safety notices.

1. ELECTRICAL

No portion of the outer cover of the welding controller should be removed by anyone other than suitably qualified personnel and never whilst mains power is connected.

ALWAYS ! disconnect the mains plug from the socket.

DO NOT ! use any fluids to clean electrical components as these may penetrate into the electrical system.

Installation must be according to the setting up procedure detailed in the appropriate operating/installation guides for the equipment being used and must be in line with national, regional and local safety codes.

2. FIRE

During welding particles of very hot metal are expelled. Ensure that no combustible materials can be ignited by these.

3. PERSONNEL SAFETY

Arc rays can burn your eyes and skin and noise can damage your hearing. Operators and personnel working in close proximity must wear suitable eye, ear and body protection.

Fumes and gases can seriously harm your health. Use the equipment only in a suitably ventilated area. If ventilation is inadequate, then appropriate fume extraction equipment must be used.

Hot metal spatter can cause fire and burns. Appropriate clothing must be worn. Clothing made from, or soiled with, combustible materials must NOT be worn. Have a fire extinguisher nearby and know how to use it.

Magnetic fields from high currents can affect heart pacemakers or other electronically controlled medical devices. It is imperative that all personnel likely to come into the vicinity of any welding plant are warned of the possible DANGER before entering the area.

To minimise the risks of exposure to electromagnetic radiation, operators should not drape the welding cables over their shoulders or wrap them around themselves in any way whilst using the equipment. It is also recommended that operators route the welding earth return cables away from themselves and do not stand between the two earth return cables during welding

4. MAINTENANCE

All cables must be inspected regularly to ensure that no danger exists from worn or damaged insulation or from unsound electrical connections. Special note should be made of the cables close to the pistol, where maximum wear occurs.

As well as producing inconsistent welds, worn cables can overheat or spark, giving rise to the risk of fire.

5. TRAINING

Use of the equipment must be limited to authorised personnel only who must be suitably trained and must have read and understood this and any other applicable documentation. This guide must be made available to all operators at all times and further hard copies of this guide may be purchased from the manufacturer or downloaded from our website. Measures must be taken to prevent the use of this equipment by unauthorised personnel. Please note that Taylor Studwelding Systems Ltd also offer, at an additional cost, personnel training packages, should a certificate of competency be required for operating/maintenance personnel.

6. INSTALLATION

Ensure that the site chosen for the equipment is able to support the weight of the equipment and that it will not fall or cause a danger in the course of its normal operation. Do not hang connecting cables over sharp edges and do not install connecting cables near heat sources or via traffic routes where people may trip over them or they may be damaged by the passage of vehicles (forklifts etc.).

7. INTERFERENCE

During welding operations, intense magnetic and electrical fields are unavoidably produced which may interfere with other sensitive Electronic equipment.

All Taylor Studwelding equipment is designed, manufactured and tested to conform to the current appropriate European standards and directives regarding electromagnetic emissions and immunity and as such is safe to use in any normal environment

8. DISPOSAL

The equipment either wholly or any of its component parts may be disposed of as part of general industrial waste or passed to a scrap merchant. Non of the components used in the manufacture are toxic, carcinogenic or harmful to health. Please note that, in line with the WEEE directive, Taylor Studwelding Systems Ltd offers a return for disposal policy.

INTRODUCTION TO STUDWELDING

When matched with an appropriate controller and earth cables, the Taylor Studwelding DA8-A studwelding pistol is intended for precision stud welding up to 10 mm diameter studs. The pistol is lightweight, ergonomic and has been designed to operate with a minimum amount of maintenance. The energy required to carry out the welding operation is derived from an appropriate studwelding controller.

Taylor Studwelding Systems Ltd controllers are modern, robustly designed and offer maximum reliability combined with an easy to understand operator interface.

THE PROCESS

The process of drawn arc studwelding is long established and well proven. The basic steps are as follows :

- A measured amount of weld stud protrusion is set at the welding pistol.
- Once in position, the pistol lifts the stud away from the work-piece, simultaneously striking an arc between the two.
- Both the tip of the weld stud and the surface of the work-piece melt as the arc is sustained for a pre-determined interval.
- At the completion of the pre-determined interval, the pistol returns the weld stud to the molten pool on the work-piece, thus forming a weld.

The most common and traditional drawn arc welds have a weld duration greater than 100ms and employ the use of a single use ceramic arc shield, commonly referred to as a ferrule. This ferrule helps to protect the arc during the weld and assists in formation of the final fillet. Post welding the ferrule is removed and disposed of.

It is possible to stud weld without a ferrule. This method is more commonly employed with welds having a duration of less than 100ms and this type of weld is referred to as short cycle stud welding. Although no ferrule is employed, it is recommended practice in short cycle welding to employ a suitable shielding gas to reduce the amount of porosity in the completed weld and improve weld quality.

The DA8-A range of pistols are what are commonly referred to as “fixed lift” pistols. This is because the pistol does not include a clutch assembly in the lift mechanism. In practical terms this means that although the lift can be user adjusted within its operational limits, should certain parameters change from weld to weld, for example the studs to be welded vary in length or the surface being welded to being very uneven, this will have an effect on the amount of lift during the weld and may impact adversely on the quality of the finished weld. Because of this, we recommend that only properly manufactured weld studs be used and that customers should always strive to weld to flat, even surfaces.

It is important to decide, based on your specific application, which model variant of the DA8-A will be best for you. For example. If you are welding standard drawn arc studs with ferrules, the standard DA8-A would be your choice whereas if your application calls for short cycle or CD type studs welding using a template with 35mm positioning guides , the A2 would be the best choice. You could also select the A4 for this application providing that the studs to be welded are under 40mm in length as this is limit for stud length in the A3 and A4 variants. See page 6 for an outline of the different model variants.

MODEL VARIANTS



DA8-A

COMPLETE PISTOL PART NUMBER :

99-101-063

The basic standard model of the DA8-A pistol is shown here on the left. This model is supplied rigged as standard to use European screw-on chucks and for welding standard drawn arc studs with ceramic ferrules .

Four other model variants are available, each rigged differently to handle different more specific applications. These are shown below.

DA8-A1



99-101-064

Uses standard European Screw-on chucks and long/gas chucks.
Rigged for gas purging and fitted with a 30mm nose piece

DA8-A2



99-101-065

Uses standard European Screw-on chucks and long/gas chucks.
Rigged for gas purging and fitted with a 35mm nose piece

DA8-A3



99-101-066

Uses CD type chucks
Fitted with one-piece 30mm front cap.
Can be rigged for gas purging optionally.

DA8-A4



99-101-067

Uses CD type chucks
Fitted with one-piece 35mm front cap.
Can be rigged for gas purging optionally.

SET UP AND WELDING - CHUCKS

Select the required weld stud on the basis of process, diameter, length and material. See our separate catalogues entitled "Drawn Arc Stock List" & "Capacitor Discharge Stock List"



which can be found by scanning the adjacent QR codes or alternatively are available from your local Taylor stockist.



DRAWN ARC

CD

Select the required chuck, appropriate to the pistol variant and weld stud diameter. European screw-on chucks have a female M10 mounting thread and mount directly onto the male M10 thread on the shaft of the standard A, A1 & A2



variants whilst CD type chucks fit directly into the chuck nut on the front of the shaft of the A3 & A4 variants (a list of available chucks of both types may be found in the accessories section of this guide on pages 20 - 25).



CD type chucks have an adjustable backstop which needs to be adjusted to suit whatever length of stud has been selected (up



to a maximum length of 40mm). This is because the pistol variants using the CD type chucks have a fixed length setup. The stud must be inserted fully into the chuck until the flange of the stud hits the face of the chuck and then adjusted out by turning the adjuster screw until there is an approximate gap of 3 - 4mm between the face of the chuck and the back of the stud flange.



Euro chucks do not have any adjustment. This is because the pistol variants using these chucks adjust for the length of the stud on the pistol and not in the chuck.



Instead they have a blind depth hole into which the weld stud is loaded. If welding with ferrules, select the appropriate size of ferrule grip to suit the ferrules being used.

SET UP AND WELDING - STANDARD DA8-A

Having selected and where necessary prepared the chuck, it can now be fitted to the pistol. To begin, remove the foot assembly by loosening the thumbscrews on the front end cap (chuck fitting may be accomplished without removing the foot assembly. However, removal of the assembly provides easier access).



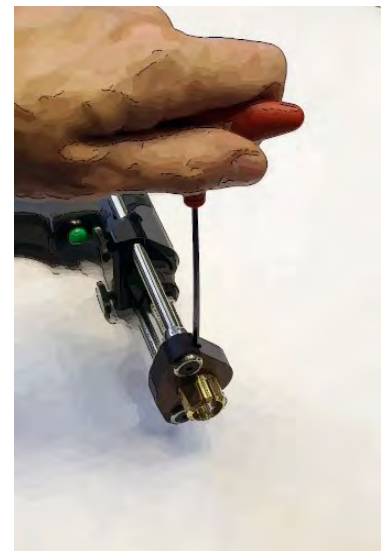
Slide the chuck into bellows support and screw the chuck into position on the M10 mounting thread on the front of the pistol shaft.



Tighten the chuck into position using an appropriate wrench (usually 14mm A/F for Euro chucks - see page 25).

IMPORTANT! Do not over-tighten chucks. This requires only hand tightening. Over-tightening may result in un-warranted damage to your pistol.

Re-fit the foot assembly by sliding into the front end cap and tightening the thumbscrews then fit the brass ferrule grip into the foot adaptor. Ensure the ferrule grip is an appropriate match to the chuck fitted earlier. The ferrule grip is held in position by two set screws positioned 180° apart in the foot adaptor. Gently secure the ferrule grip using a 2.5mm hex key. Again, be aware that over-tightening may damage the grip.



SET UP AND WELDING - STANDARD DA8-A

With the correct stud and ferrule to be welded fitted into the chuck/ferrule grip, loosen the thumbscrews and slide the foot assembly until the stud is protruding past the ferrule to the desired distance. Once this is set, re-tighten the thumbscrews.



Remove the ferrule and check the centrality of the stud in the ferrule grip by looking straight down the centre of the pistol shaft. If the stud appears to be off-centre. Use a 3mm hex key to loosen the foot screws on the foot adaptor and re-position the adaptor on the legs (the holes in the adaptor are designed to allow adjustment). Re-tighten the screws once the adjustment has been made.

The next step is to set the required lift for welding. This must be done in three stages to ensure that the lift is set properly. Stage one is to back the lift off so that the pistol can be properly positioned to set the lift. To back the lift off, twist the rear end cap adjuster anti-clockwise until the pistol indicator is in the MAX position.



Stage two is to “zero” the lift. NOTE Ensure that the pistol is not connected to the controller whilst performing this stage. To do this the pistol (with a stud and ferrule loaded) needs to be pressed into the position as if a weld is about to take place with the shaft moving back until the ferrule is hard against the surface. With the pistol held firmly in this position, turn the rear end cap adjuster clockwise and continue to turn it until it reaches the zero position. This is the point where further turning of the adjuster will start to force the stud forward, lifting the ferrule away from the surface. This is the zero position.



SET UP AND WELDING - STANDARD DA8-A

Stage three is to set the required lift. The rear end cap adjuster has a click detent which allows the adjuster to stop every half-turn. This means that each half-turn \approx 0.5mm lift. Therefore, if 2mm of lift is required, turn the rear end cap adjuster anti-clockwise 4 clicks from the zero position to set the lift.

IMPORTANT! If any changes are made to the setting of the pistol, the chuck, ferrule grip, stud length etc. The lift may be affected and this procedure may need to be re-executed to ensure that the required lift is applied.



SET UP AND WELDING - A1 & A2 MODELS

Having selected and where necessary prepared the chuck, it can now be fitted to the pistol. To begin, remove the foot assembly by loosening the thumbscrews on the front end cap (chuck fitting may be accomplished without removing the foot assembly. However, removal of the assembly provides easier access).



Slide the chuck into bellows support and screw the chuck into position on the M10 mounting thread on the front of the pistol shaft.

Tighten the chuck into position using an appropriate wrench (usually 14mm A/F for Euro chucks - see page 25).

IMPORTANT! Do not over-tighten chucks. This requires only hand tightening. Over-tightening may result in un-warranted damage to your pistol.



SET UP AND WELDING - A1 & A2 MODELS

With the correct stud to be welded fitted into the chuck, loosen the thumbscrews and slide the foot assembly until the stud is protruding past the nose cone to the desired distance. Once this is set, re-tighten the thumbscrews.



Check the centrality of the stud in the nose cone by looking straight down the centre of the pistol shaft. If the stud appears to be off-centre. Use a 3mm hex key to loosen the foot screws on the foot adaptor and re-position the adaptor on the legs (the holes in the adaptor are designed to allow adjustment). Re-tighten the screws once the adjustment has been made.

The next step is to set the required lift for welding. This must be done in three stages to ensure that the lift is set properly. Stage one is to back the lift off so that the pistol can be properly positioned to set the lift. To back the lift off, twist the rear end cap adjuster anti-clockwise until the pistol indicator is in the MAX position.



Stage two is to “zero” the lift. NOTE Ensure that the pistol is not connected to the controller whilst performing this stage. To do this the pistol (with a stud loaded) needs to be pressed into the position as if a weld is about to take place with the shaft moving back until the nose cone is hard against the surface. With the pistol held firmly in this position, turn the rear end cap adjuster clockwise and continue to turn it until it reaches the zero position. This is the point where further turning of the adjuster will start to force the stud forward, lifting the nose cone away from the surface. This is the zero position.

SET UP AND WELDING - A1 & A2 MODELS

Stage three is to set the required lift. The rear end cap adjuster has a click detent which allows the adjuster to stop every half-turn. This means that each half-turn \approx 0.5mm lift. Therefore, if 2mm of lift is required, turn the rear end cap adjuster anti-clockwise 4 clicks from the zero position to set the lift.

IMPORTANT! If any changes are made to the setting of the pistol, the chuck, stud length etc. The lift may be affected and this procedure may need to be re-executed to ensure that the required lift is applied.



SET UP AND WELDING - A3 & A4 MODELS

Having selected and where necessary prepared the chuck, it can now be fitted to the pistol. Insert the chuck into the opening in the chuck nut and firmly push the chuck until it comes to rest at the bottom of the opening. Once this is done, tighten the chuck using the 17mm A/F box spanner provided (see page 25).



IMPORTANT! Do not over-tighten chucks. This requires only hand tightening. Over-tightening may result in un-warranted damage to your pistol.

The next step is to set the required lift for welding. This must be done

in three stages to ensure that the lift is set properly. Stage one is to back the lift off so that the pistol can be properly positioned to set the lift. To back the lift off, twist the rear end cap adjuster anti-clockwise until the pistol indicator is in the MAX position.



SET UP AND WELDING - A3 & A4 MODELS



Stage two is to “zero” the lift. NOTE Ensure that the pistol is not connected to the controller whilst performing this stage. To do this the pistol (with a stud loaded) needs to be pressed into the position as if a weld is about to take place with the shaft moving back until the nose cone is hard against the surface. With the pistol held firmly in this position, turn the rear end cap adjuster clockwise and continue to turn it until it reaches the zero position. This is the point where further turning of the adjuster will start to force the stud forward, lifting the nose cone away from the surface. This is the zero position.

Stage three is to set the required lift. The rear end cap adjuster has a click detent which allows the adjuster to stop every half-turn. This means that each half-turn \approx 0.5mm lift. Therefore, if 2mm of lift is required, turn the rear end cap adjuster anti-clockwise 4 clicks from the zero position to set the lift.

IMPORTANT! If any changes are made to the setting of the pistol, the chuck, stud length etc. The lift may be affected and this procedure may need to be re-executed to ensure that the required lift is applied.



WELDING - ALL MODELS

Once the pistol has been set up, welding can take place. The pistol will need to be connected to an appropriate drawn arc stud welding controller which has been connected in line with its operating instructions. The Taylor Studwelding Systems pistols outlined in this operating guide are designed to operate across a range of drawn arc controllers including, but not exclusive to, those manufactured by Taylor Studwelding Systems Ltd.



WELDING - ALL MODELS

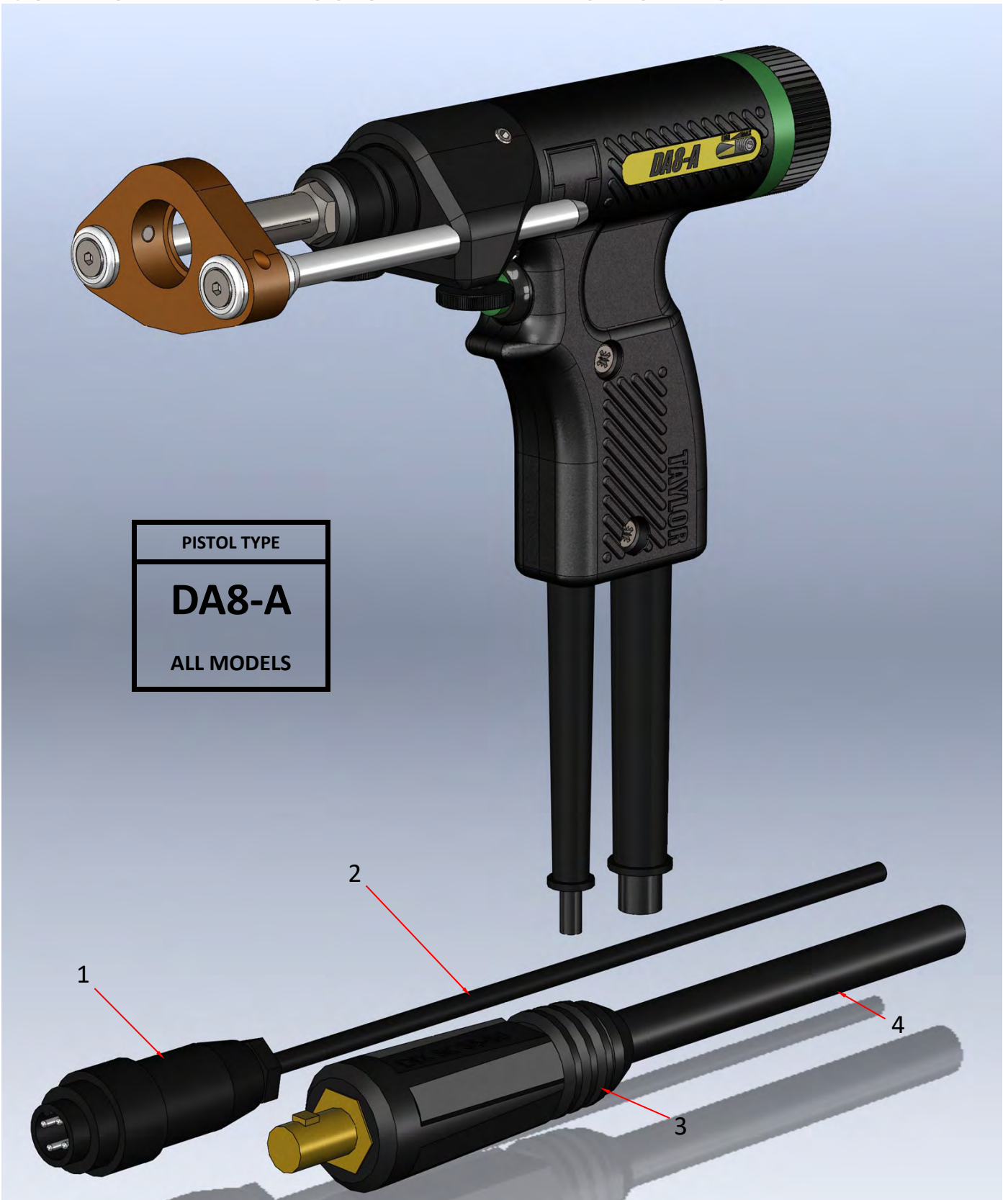
Ensuring that a stud has been loaded, position the stud at the location on the work piece where it is to be welded. Press down firmly on the pistol until the ferrule (or the face of the nose cone if using instead) is firmly in contact with the work piece. Do not drape or wrap the pistol cables over or around yourself whilst operating the equipment. Allow the cables to trail naturally to the floor.

Press the trigger.



Once welding has taken place. Draw the pistol off the welded stud. Always lift the welding pistol vertically from the welded stud. Failure to do this may cause damage to the chuck, which will result in the chuck and stud arcing together during subsequent welds and thereby reducing the working life of the chuck.

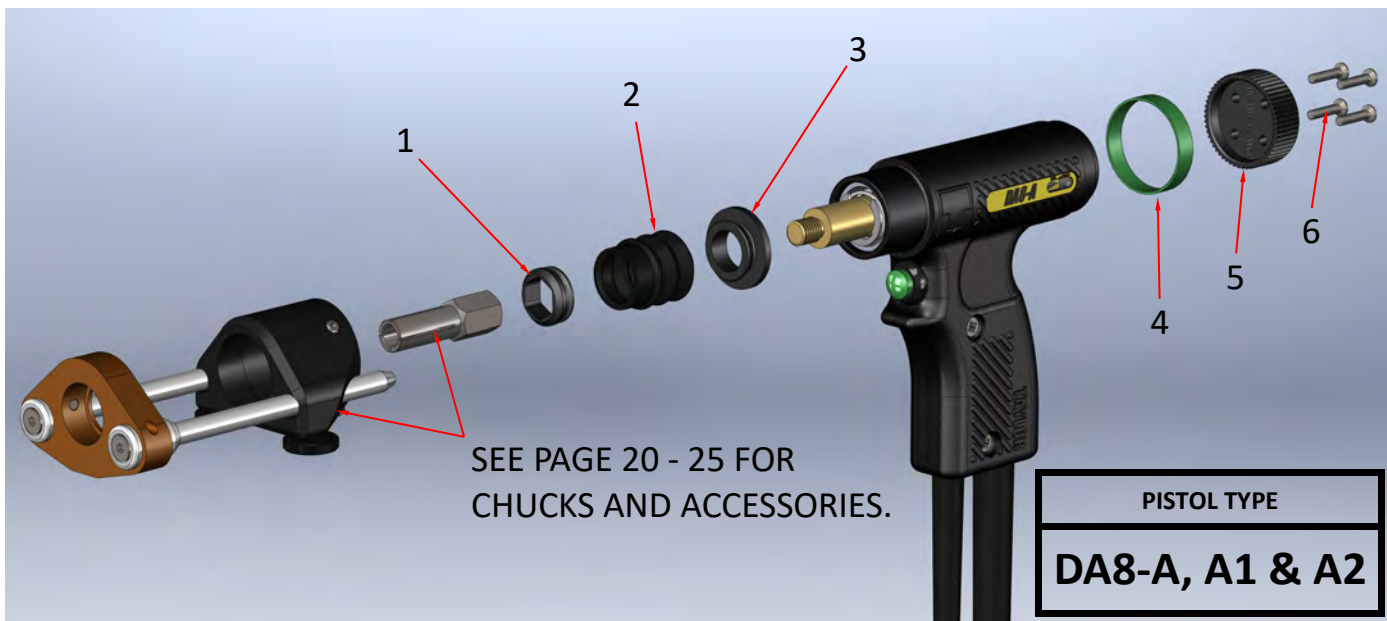
COMPONENT EXPLOSION AND PARTS LISTING



PISTOL TYPE
DA8-A
ALL MODELS

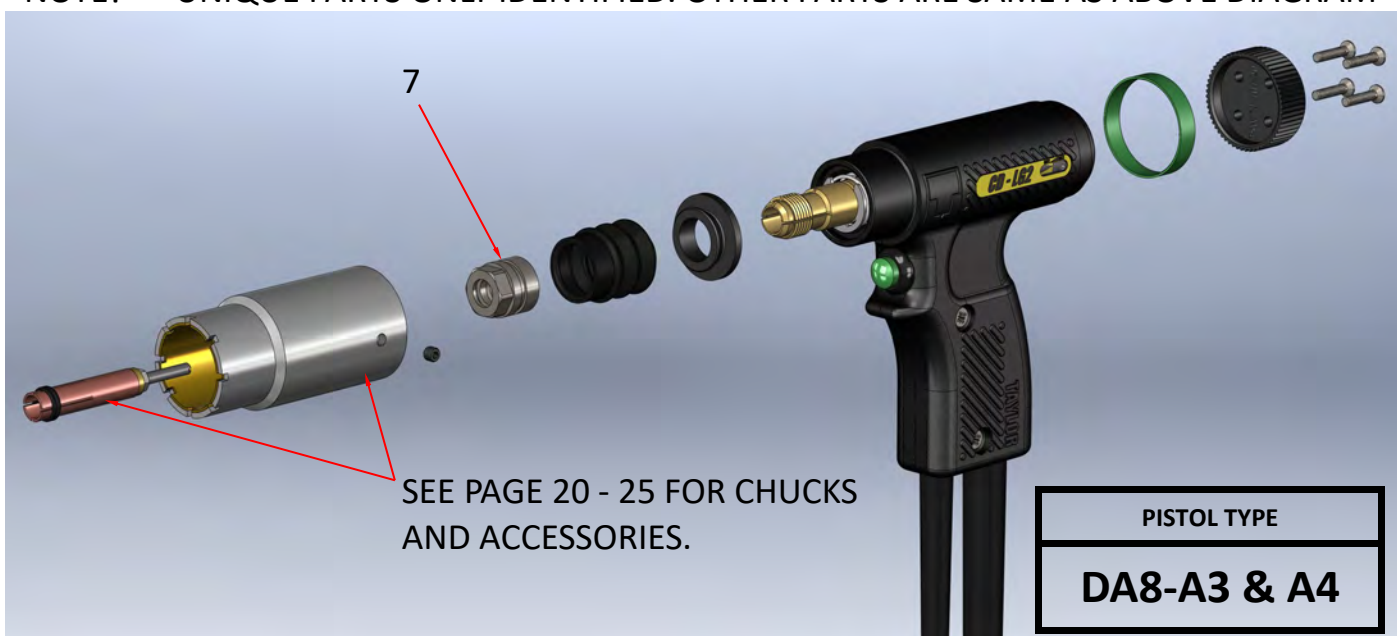
ITEM	QTY	PART No.	DESCRIPTION
1	1	71-101-030	CONTROL PLUG
2	5.5	71-300-009	CONTROL CABLE (per metre)
3	1	81-101-051	WELD PLUG
4	5	71-300-002	WELD CABLE (per metre)
5	8	71-101-032	CABLE CLIP (NOT SHOWN)

COMPONENT EXPLOSION AND PARTS LISTING

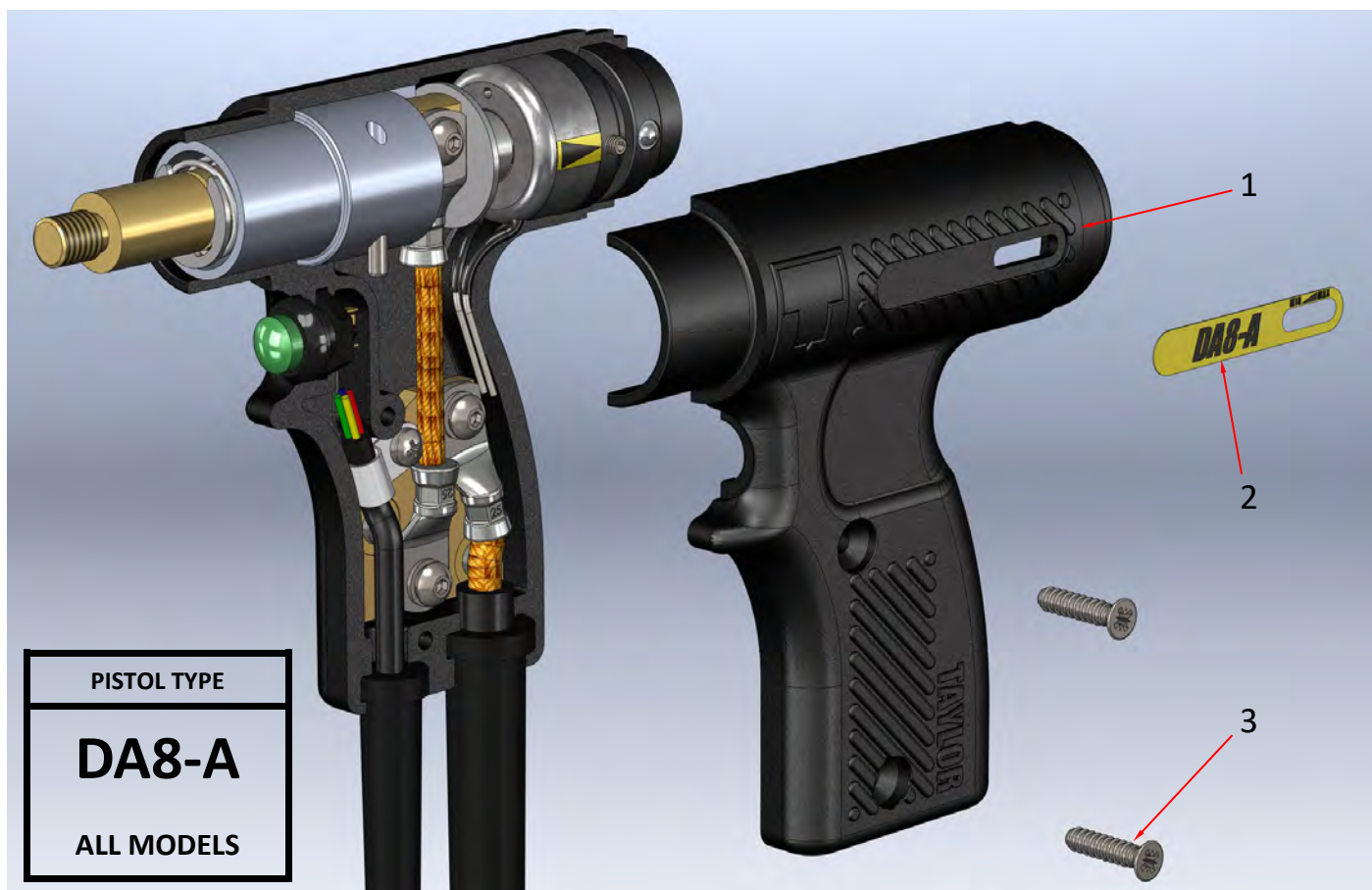


ITEM	QTY	PART No.	DESCRIPTION
1	1	71-101-222	BELLOWS SUPPORT
2	1	71-101-003	BELLOWS
3	1	71-101-004	BELLOWS RETAINING RING
4	1	71-101-233	BODY RING
5	1	71-101-203	REAR END CAP
6	4	Z120-04-020	SCREW
7	1	71-101-002	CHUCK NUT

NOTE! UNIQUE PARTS ONLY IDENTIFIED. OTHER PARTS ARE SAME AS ABOVE DIAGRAM

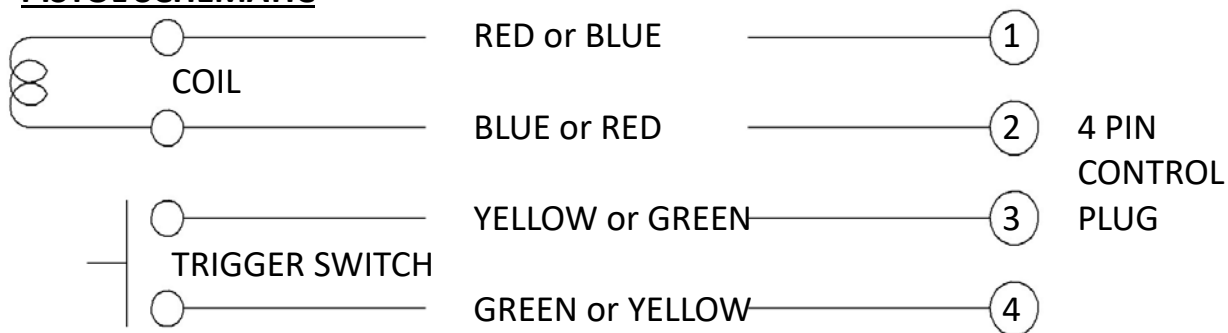


COMPONENT EXPLOSION AND PARTS LISTING

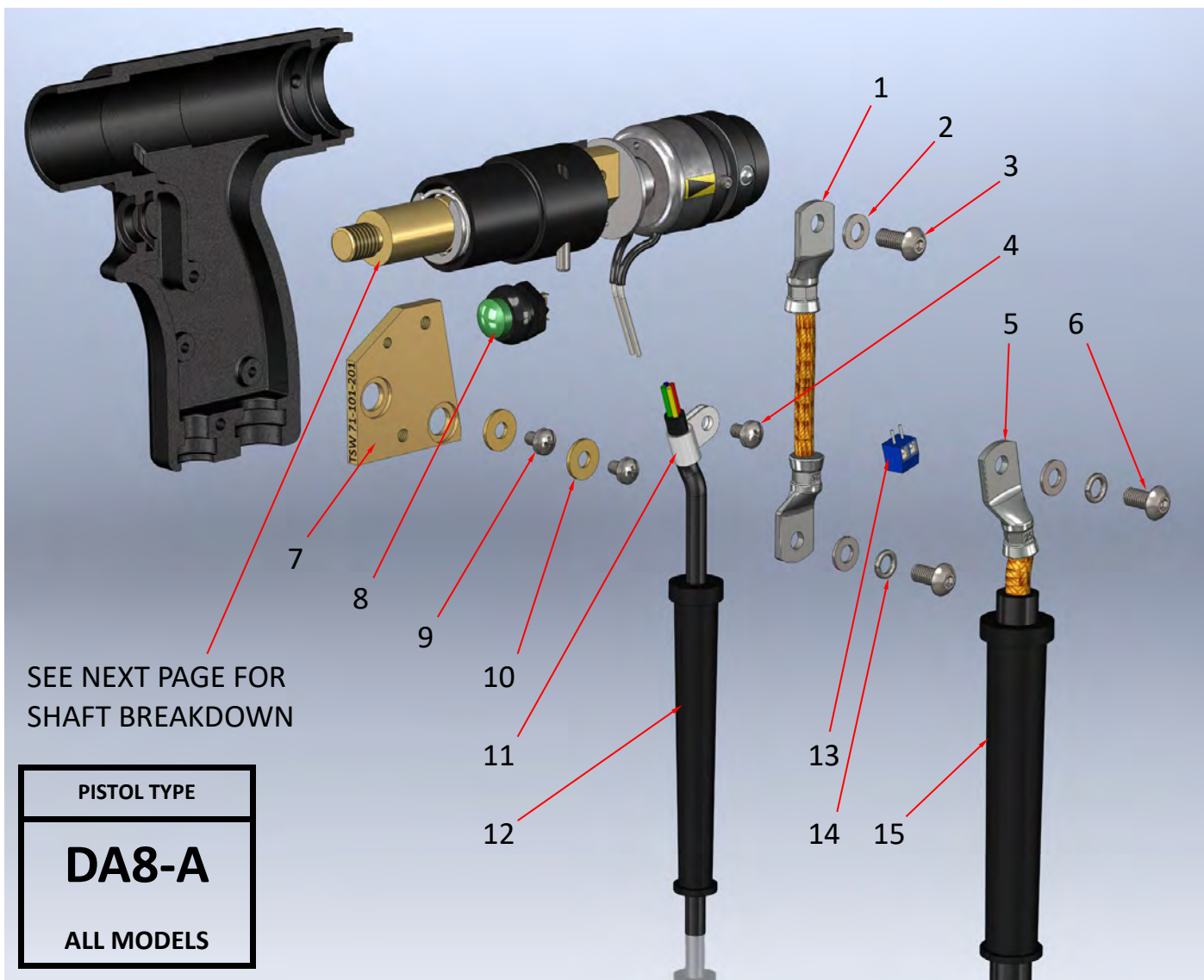


ITEM	QTY	PART No.	DESCRIPTION
1	1	71-101-200	PISTOL BODY MOULDING PAIR
2	1	71-101-223	DECAL STICKER
3	2	Z250-10-019	SCREW

PISTOL SCHEMATIC

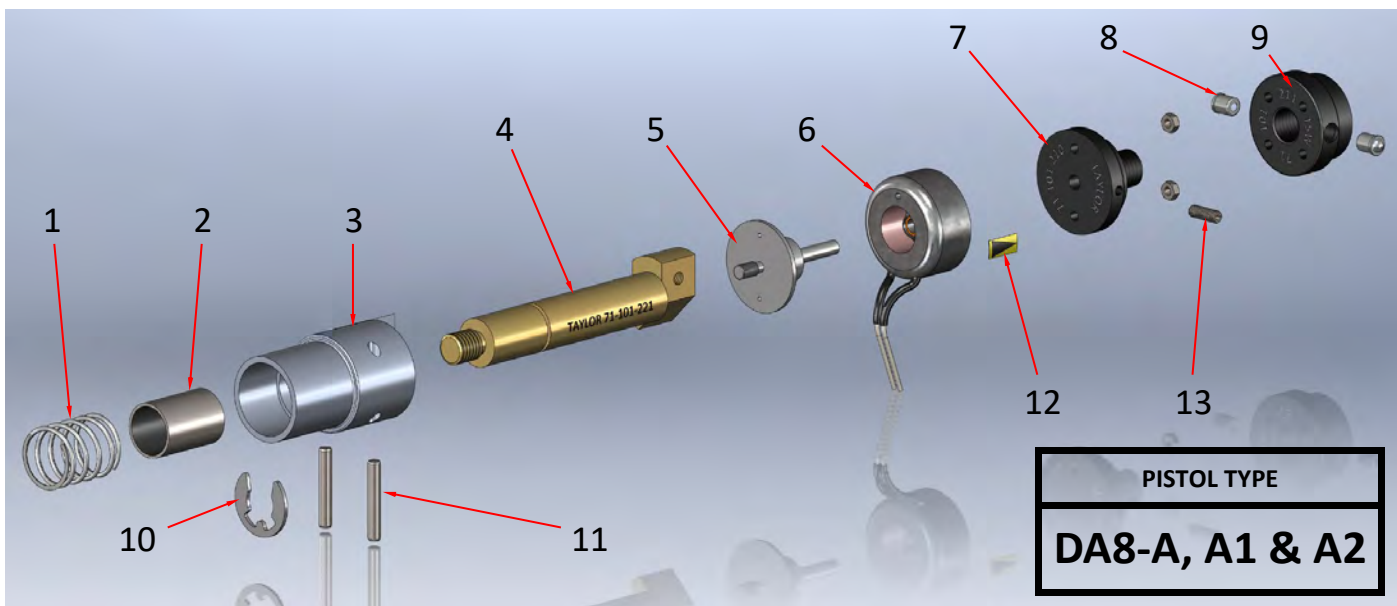


COMPONENT EXPLOSION AND PARTS LISTING



ITEM	QTY	PART No.	DESCRIPTION
1	1	71-101-220	FLEXI-BRAID ASSEMBLY
2	3	Z600-05-000	WASHER
3	1	Z115-05-012	SCREW
4	1	Z200-04-006	SCREW
5	1	Z700-05-022	TERMINAL
6	2	Z115-05-008	SCREW
7	1	71-101-201	TERMINAL PLATE
8	1	81-101-279	PUSHBUTTON SWITCH
9	2	Z225-08-914	SCREW
10	2	Z605-05-999	WASHER
11	1	71-101-214	CABLE CLIP
12	1	71-101-033	CABLE SLEEVE
13	1	71-101-252	HEADER
14	3	Z615-05-000	WASHER
15	1	71-101-034	CABLE SLEEVE

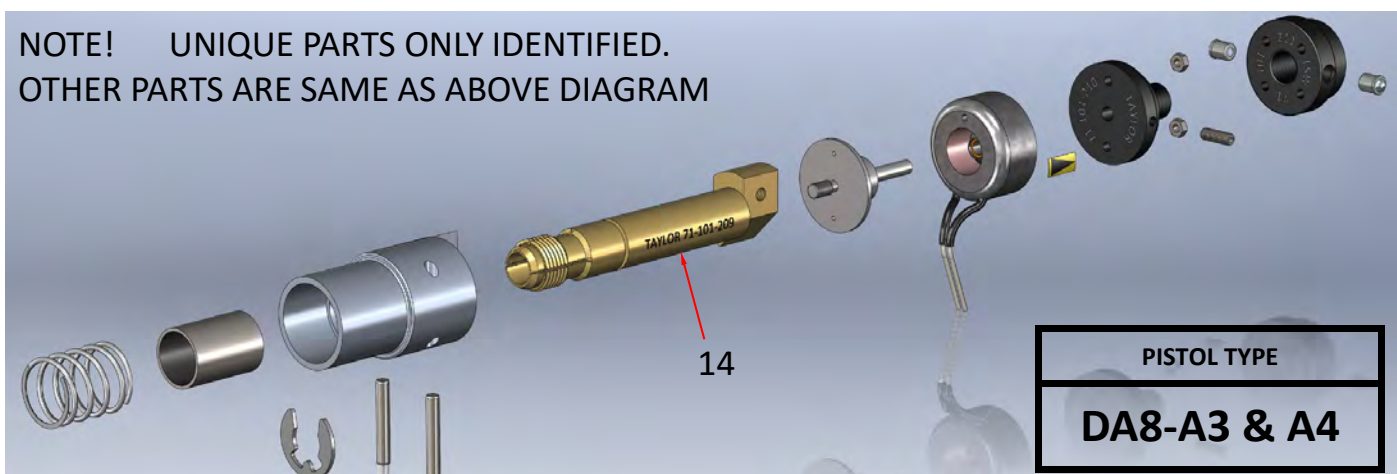
COMPONENT EXPLOSION AND PARTS LISTING



ITEM	QTY	PART No.	DESCRIPTION
1	1	71-101-231	SPRING
2	1	71-102-071	BEARING
3	1	71-101-208	BEARING HOUSING
4	1	71-101-221	SHAFT
5	1	72-103-035	POLE PIECE
6	1	72-103-042	COIL
7	1	71-101-210	COIL MOUNT
8	2	71-101-213	DETENT
9	1	71-101-211	COIL MOVER
10	1	71-101-011	CIRCLIP
11	2	Z800-04-026	PIN
12	1	71-101-219	INDICATOR LABEL
13	1	Z400-04-012	SCREW
14	1	71-101-209	SHAFT

NOTE! THESE COMPONENTS ARE NOT AVAILABLE SEPERATELY.

NOTE! UNIQUE PARTS ONLY IDENTIFIED.
OTHER PARTS ARE SAME AS ABOVE DIAGRAM

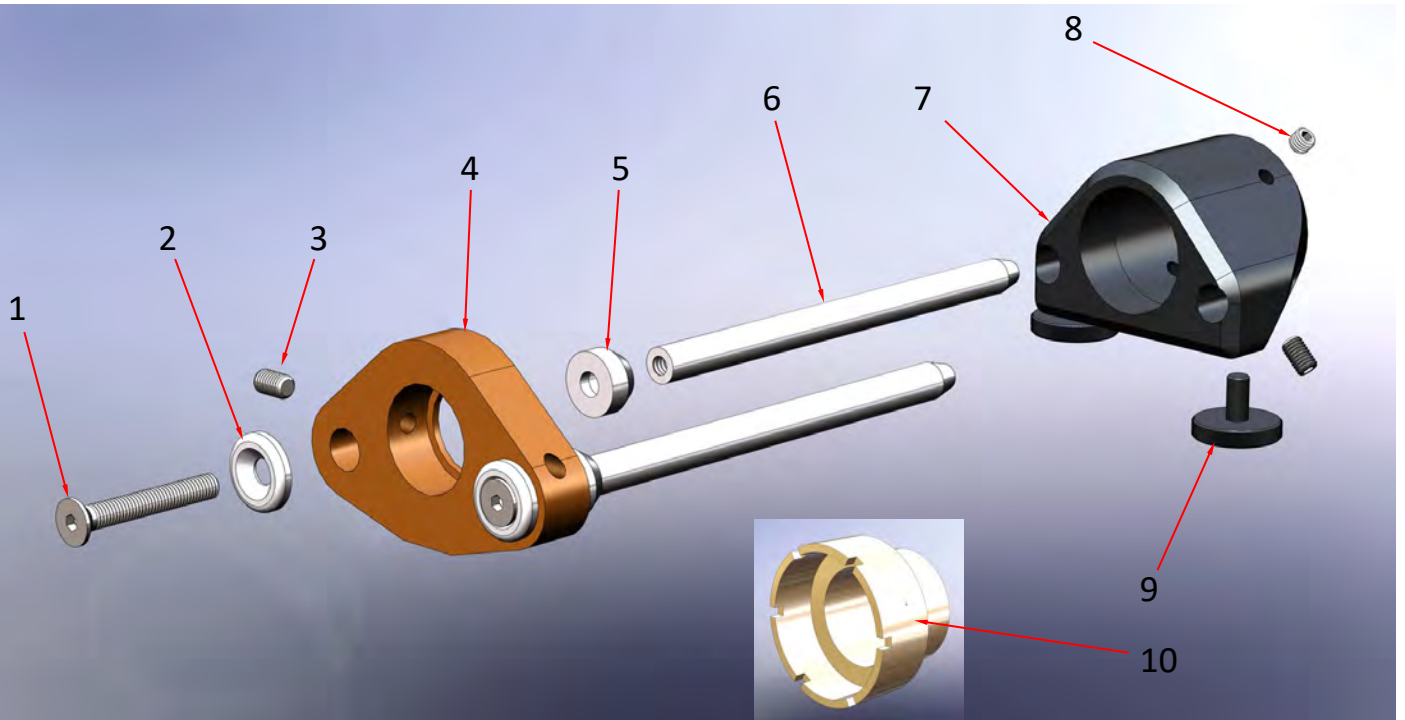
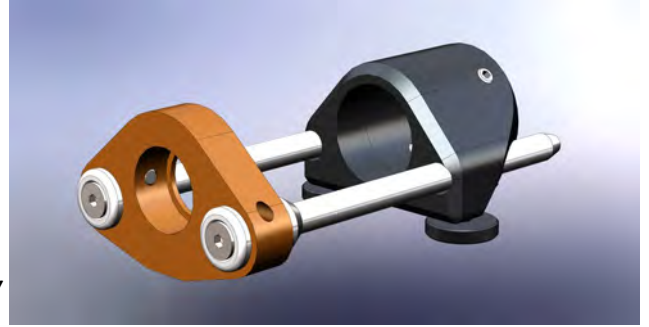


ACCESSORIES

STANDARD FRONT END ASSEMBLY - DA8-A

COMPLETE ASSEMBLY AVAILABLE UNDER
PART NUMBER : 89-101-322
DOES NOT INCLUDE ITEM 10.

NOTE! ITEM 10 IS FOR LOW VOLUME WORK ONLY

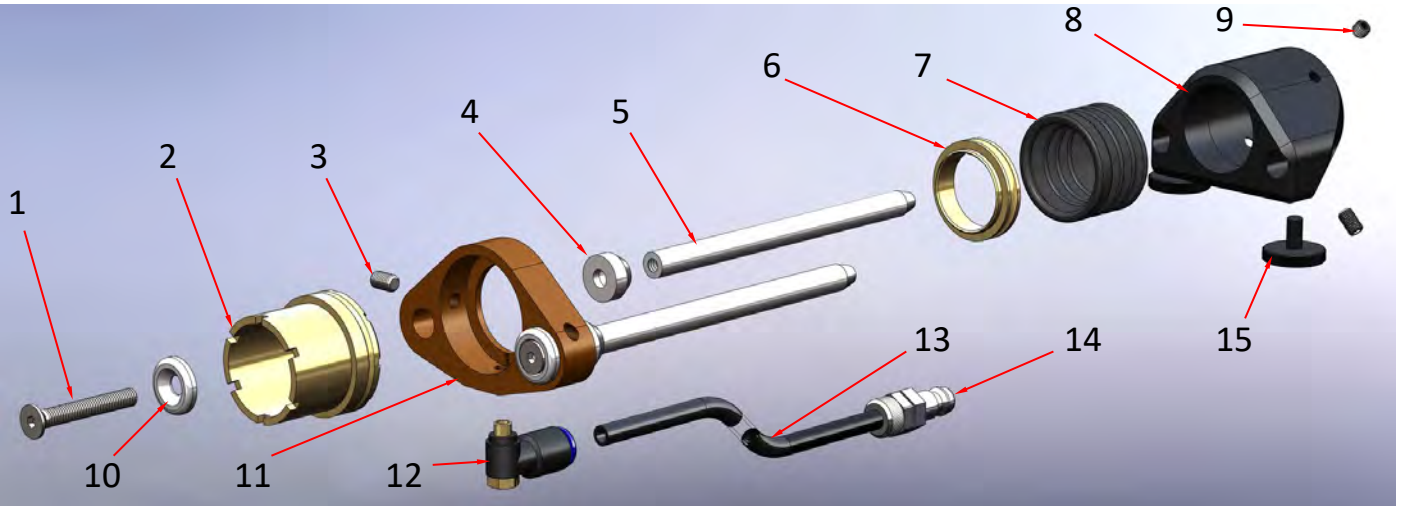
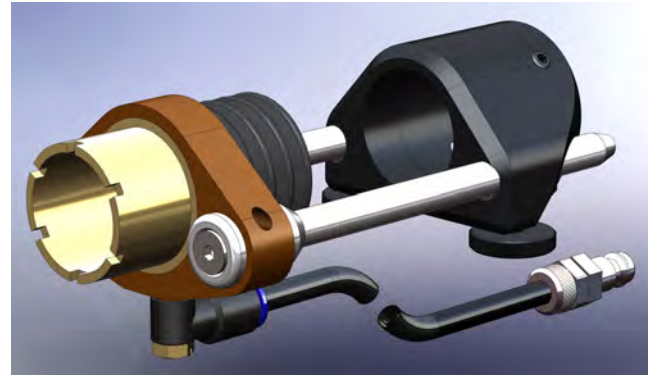


ITEM	QTY	PART No.	DESCRIPTION
1	2	Z125-05-035	SCREW
2	2	81-101-003	FOOT WASHER (FRONT)
3	4	Z400-05-008	SET SCREW
4	1	81-101-336	FOOT ADAPTOR
5	2	81-101-001	FOOT WASHER (REAR)
6	2	72-103-092	LEG (110 LONG. STANDARD WITH DA8-A)
or	2	81-101-004	LEG (230 LONG. OPTIONAL EXTRA)
or	2	89-101-081	LEG (330 LONG. OPTIONAL EXTRA)
7	1	81-101-328	FRONT END CAP
8	2	Z400-05-004	SET SCREW
9	2	81-101-339	THUMBSCREW
10	1	89-101-399	NON FERRULE WELD ADAPTOR (OPTIONAL EXTRA)

ACCESSORIES

STANDARD FRONT END ASSEMBLY - DA8-A1

COMPLETE ASSEMBLY AVAILABLE UNDER
PART NUMBER : 89-101-324

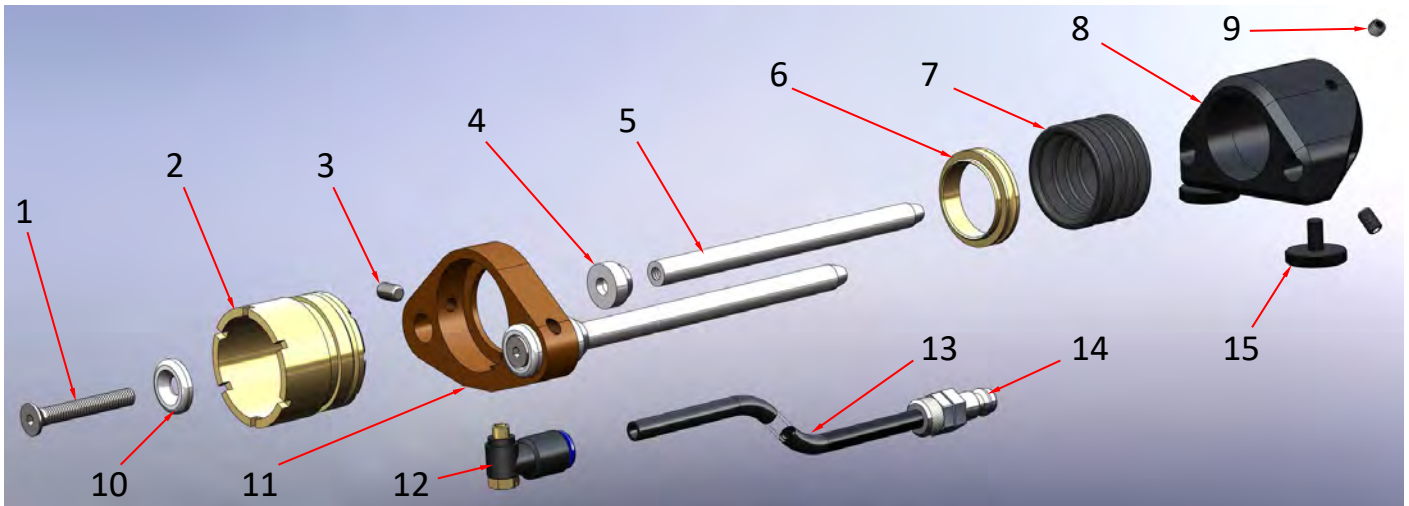
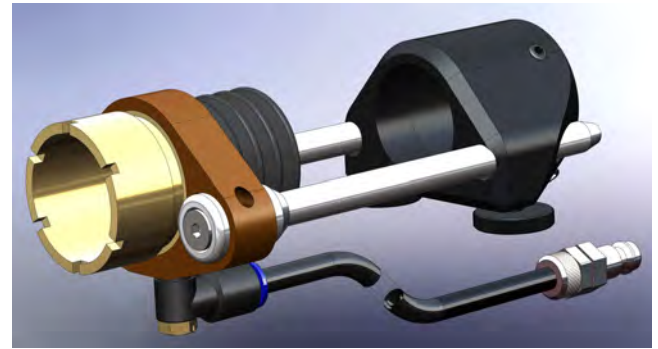


ITEM	QTY	PART No.	DESCRIPTION
1	2	Z125-05-035	SCREW
2	1	81-101-340	Ø30 GAS NOSE CONE
3	4	Z400-05-008	SET SCREW
4	2	81-101-001	FOOT WASHER (REAR)
5	2	81-101-004	LEG (220 LONG. STANDARD WITH DA8-A1)
or	2	89-101-081	LEG (330 LONG. OPTIONAL EXTRA)
6	1	81-101-326	BELLOWS SUPPORT
7	1	89-101-244	BELLOWS
8	1	81-101-328	FRONT END CAP
9	2	Z400-05-004	SET SCREW
10	2	81-101-003	FOOT WASHER (FRONT)
11	1	81-101-325	FOOT ADAPTOR
12	1	PFE-P06-M5M	GAS FITTING
13	5.5	71-200-043	GAS PIPE (per metre)
14	1	71-200-067	GAS PLUG
15	2	81-101-339	THUMBSCREW

ACCESSORIES

STANDARD FRONT END ASSEMBLY - DA8-A2

COMPLETE ASSEMBLY AVAILABLE UNDER
PART NUMBER : 89-101-323

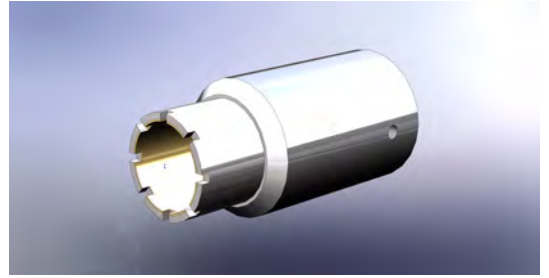


ITEM	QTY	PART No.	DESCRIPTION
1	2	Z125-05-035	SCREW
2	1	81-101-327	Ø35 GAS NOSE CONE
3	4	Z400-05-008	SET SCREW
4	2	81-101-001	FOOT WASHER (REAR)
5	2	81-101-004	LEG (220 LONG. STANDARD WITH DA8-A1)
or	2	89-101-081	LEG (330 LONG. OPTIONAL EXTRA)
6	1	81-101-326	BELLOWS SUPPORT
7	1	89-101-244	BELLOWS
8	1	81-101-328	FRONT END CAP
9	2	Z400-05-004	SET SCREW
10	2	81-101-003	FOOT WASHER (FRONT)
11	1	81-101-325	FOOT ADAPTOR
12	1	PFE-P06-M5M	GAS FITTING
13	5.5	71-200-043	GAS PIPE (per metre)
14	1	71-200-067	GAS PLUG
15	2	81-101-339	THUMBSCREW

ACCESSORIES

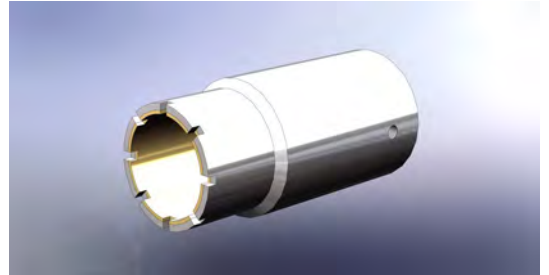
STANDARD FRONT END ASSEMBLY - DA8-A3

COMPLETE ASSEMBLY AVAILABLE UNDER
PART NUMBER : 89-101-530



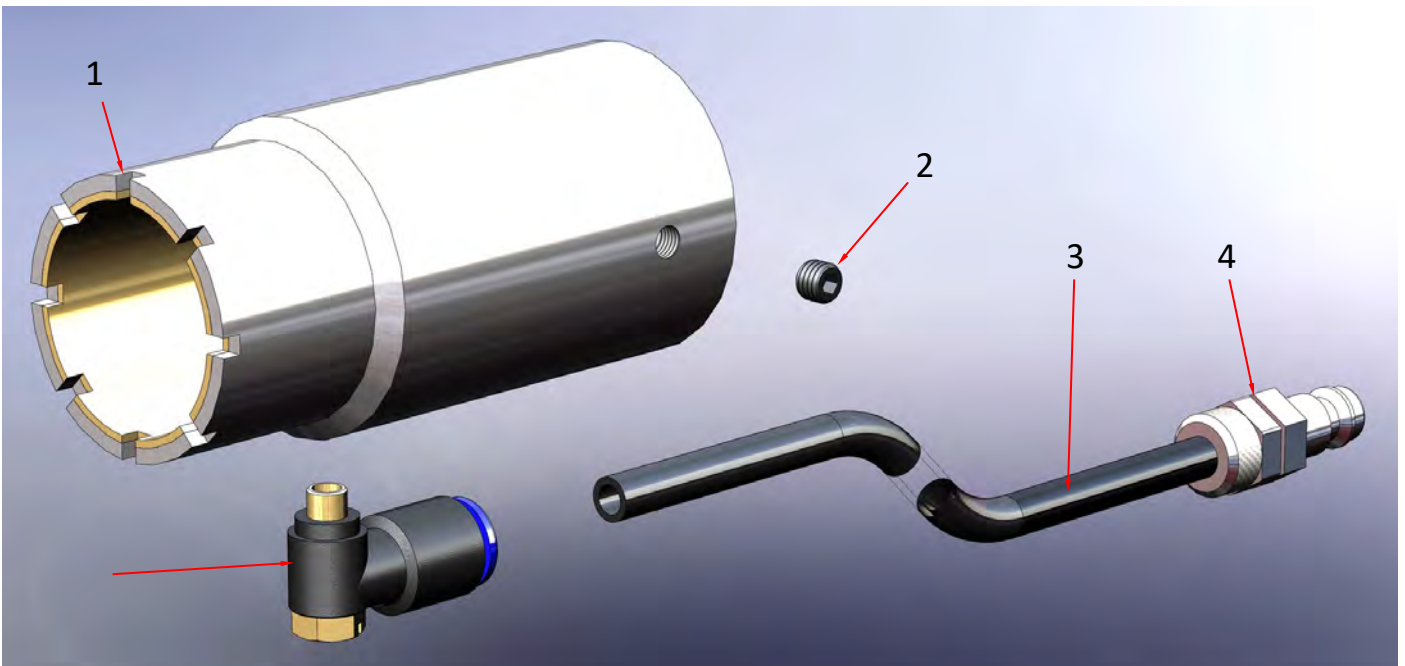
STANDARD FRONT END ASSEMBLY - DA8-A4

COMPLETE ASSEMBLY AVAILABLE UNDER
PART NUMBER : 89-101-535



OPTIONAL GAS PARTS/SPARES

AS STANDARD THE A3 & A4 MODEL VARIANTS ARE NOT FITTED FOR GAS BUT CAN BE RIGGED FOR GAS EASILY BY THE ADDITION OF THE OPTIONAL EXTRA PARTS BELOW.

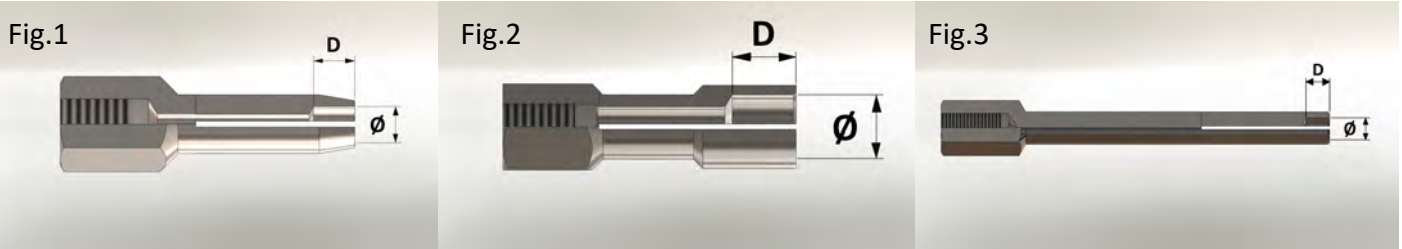


ITEM	QTY	PART No.	DESCRIPTION
1	1	89-101-530/535	Ø30/Ø35 NOSE CONE
2	2	Z400-05-004	SET SCREW
3	5.5	71-200-043	GAS PIPE (per metre) (OPTIONAL EXTRA)
4	1	71-200-067	GAS PLUG (OPTIONAL EXTRA)
5	1	PFE-P06-M5M	GAS FITTING (OPTIONAL EXTRA)

ACCESSORIES

EUROPEAN SCREW-ON CHUCKS (STANDARD & LONG/GAS CHUCKS) & FERRULE GRIPS

USE STANDARD CHUCKS & FERRULE GRIPS WITH THE STANDARD DA8-A PISTOL AND LONG/GAS CHUCKS WITH THE DA8-A1 & DA8-A2 MODEL VARIANTS.



OUR STOCK RANGE OF STANDARD EUROPEAN SCREW-ON CHUCKS (Fig.1 & 2) ARE SHOWN IN TABLE 1 BELOW. WE CAN ALSO SUPPLY CHUCKS FROM OUR NON-STOCK LIST (SEE TABLE 2) BUT THESE MAY REQUIRE ADDITIONAL DELIVERY LEAD TIMES AND MAY, IN SOME CASES, BE SUBJECT TO MINIMUM ORDER QUANTITIES.

OUR STANDARD STOCK LIST OF LONG/GAS EUROPEAN SCREW-ON CHUCKS (Fig.3) IS SHOWN IN TABLE 3.

TABLE 1

Ø	D	PART NUMBER
3	5	89-101-003
4	5	89-101-004
5	6	89-101-005
5	11	89-101-007
6	7	89-101-006
8	9	89-101-008
10	11	89-101-010
12	13	89-101-012

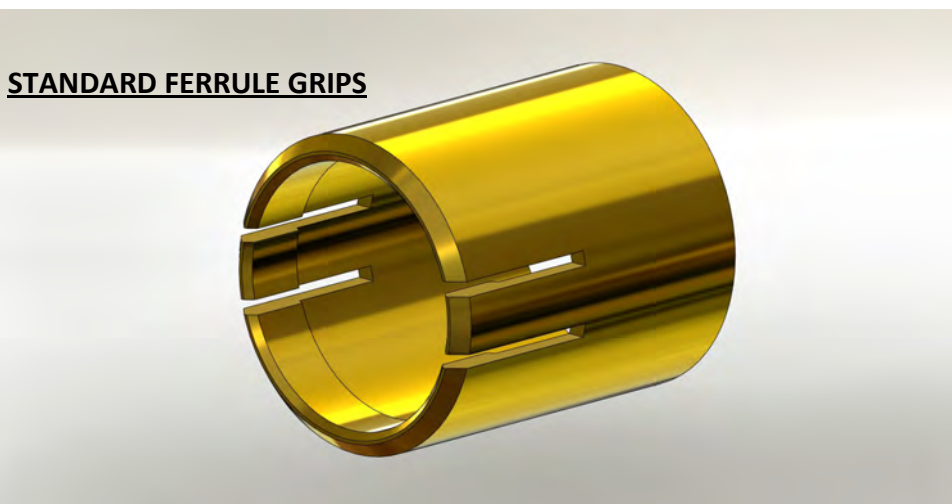
TABLE 2

Ø	D	PART NUMBER
4	25	89-101-021
6	15	89-101-022
6	25	89-101-023
8	6	89-101-024
8	25	89-101-025
10	4	89-101-026
10	6	89-101-027
12	6	89-101-028

TABLE 3

Ø	D	PART NUMBER
5	4	89-101-035
6	4	89-101-036
6	7	89-101-037
8	4	89-101-038
8	9	89-101-039
10	11	89-101-040
12	13	89-101-042

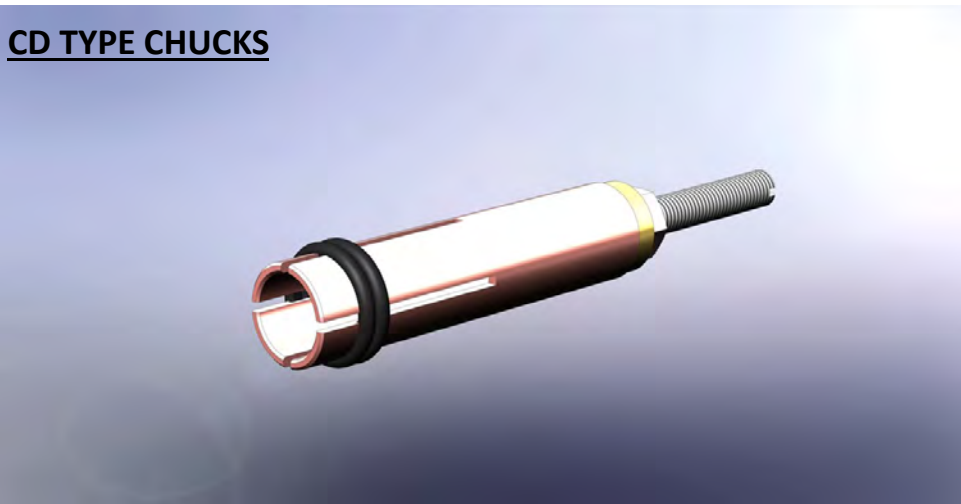
STANDARD FERRULE GRIPS



Ø	PART NUMBER
M3	89-101-051
M4	89-101-051
M5	89-101-052
M6	89-101-052
M8	89-101-053
M10	89-101-054
M12	89-101-055

ACCESSORIES

CD TYPE CHUCKS



Ø	PART NUMBER
M3	79-101-003
M4	79-101-004
M5	79-101-005
M6	79-101-006
M7.1	79-101-007
M8	79-101-008
M10	79-101-010

USE WITH DA8-A3 & DA8-A4 PISTOL MODEL VARIANTS.

TOOLS



CHUCK KEY (DA8-A3 & A4)

79-101-111

HEX KEY SET (2, 2.5, 3, 4, 5, 6 & 8)

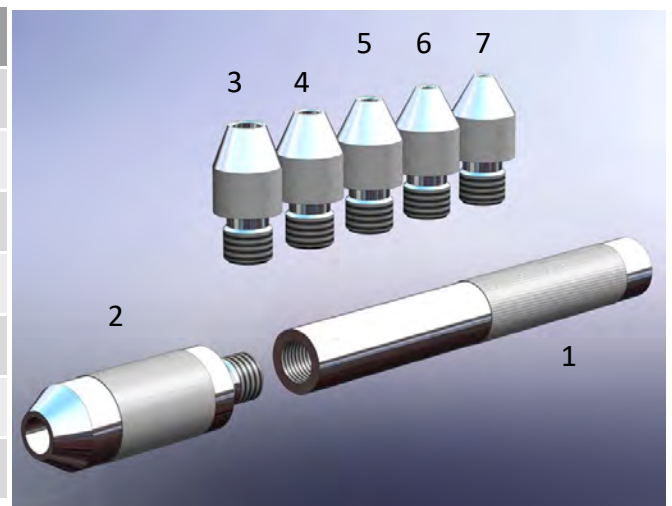
98-100-003

CHUCK WRENCH (DA8-A, DA8-A1 & A2)

98-100-004

STUD TESTING TOOL

ITEM	QTY	DESCRIPTION	PART No.
1	1	BENDING BAR	79-101-121
2	1	M10 NOZZLE	79-101-128
3	1	M8 NOZZLE	79-101-127
4	1	M6 NOZZLE	79-101-126
5	1	M5 NOZZLE	79-101-125
6	1	M4 NOZZLE	79-101-124
7	1	M3 NOZZLE	79-101-123



COMPLETE SET AVAILABLE UNDER PART NUMBER : 79-101-120

EU DECLARATION OF CONFORMITY

Responsible Party Name : Taylor Studwelding Systems Ltd
Address : Commercial Road
Dewsbury
West Yorkshire
WF13 2BD
UK

Designation of Product : Studwelding gun series DA8-A

The above mentioned equipment complies with the requirements of the following directives :

93/68/EEC	The CE Marking Directive
2014/35/EU	The Low Voltage Directive
2014/30/EU	The Electromagnetic Compatibility Directive

The above mentioned products conform to the following European standards :

EN 60974-1:2012	ARC WELDING EQUIPMENT - PART 1 : WELDING POWER SOURCES
EN 60974-10:2014	ARC WELDING EQUIPMENT - PART 10 : ELECTROMAGNETIC COMPATIBILITY (EMC) REQUIREMENTS

I hereby declare that the above mentioned equipment has been designed to comply with the relevant sections of the above referenced standards. The equipment complies with all applicable essential requirements of the above mentioned directives.

Signed.



David Taylor
Managing Director

Authorised European Representative : **J D PEARMAN**
GLENN MILLERWEG 36
1311 RT ALMERE
NETHERLANDS

