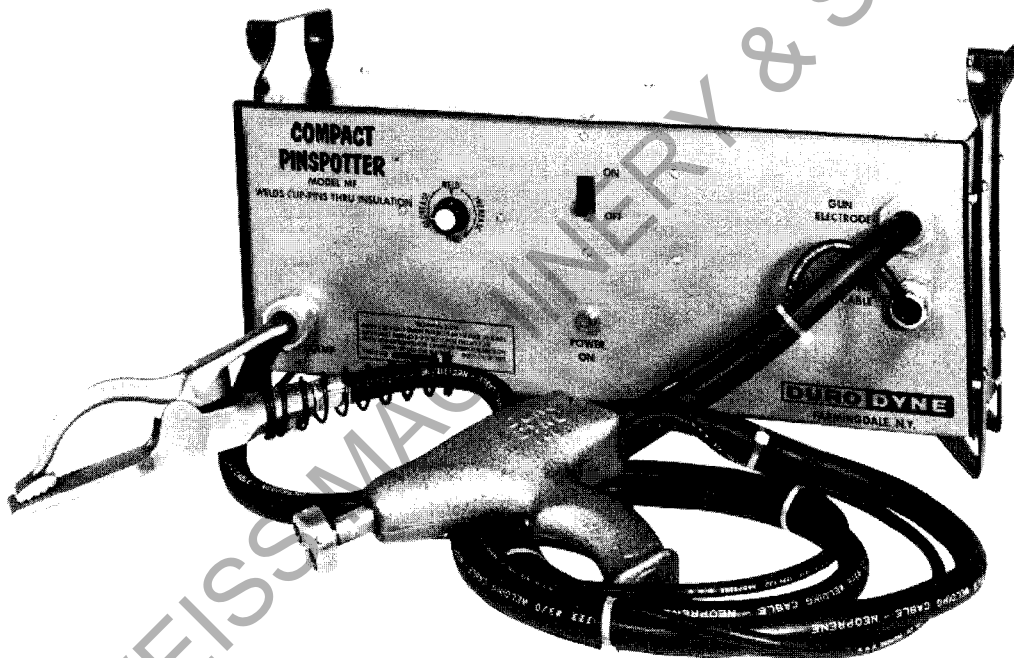




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# MFPT PINSPOTTER

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## OWNER'S MANUAL

## ELECTRICAL REQUIREMENTS

Connect MFPT to power supply. (208-240 volts - 60 cycle - 30 amp fusing).

The MFPT unit uses 220 volt single phase.

To hook up to 220 volt single phase, the green lead is ground and the white and black leads are power.

To hook up 220 volt to three phase, the green lead is ground and the white and black leads attach to any two of the other three legs.

It is suggested that the unit not be wired into the power box permanently but rather plugged in so that the unit may be quickly unplugged and easily taken elsewhere in the shop or on the job.

## MFPT AS A BENCH TOOL

To use your work bench as a welding table, set MFPT alongside or on top of work bench. Cover the bench top with a copper sheet (.025) which will act as a permanent ground when duct work is placed on table top. Attach ground clamp to duct work or copper bench top. Clip Pins quickly weld every time with no burn marks or wasted pins due to misfires.

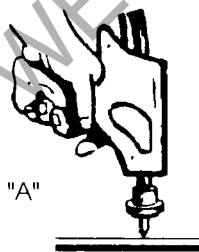
## BRING MFPT TO THE WORK

Where duct is too large to put on a bench, snap ground clamp onto duct and secure insulation quickly by welding Clip Pins inside or outside of ducts as required. Eliminate the heat mark on the duct using simple "heat sink" on opposite side of weld.

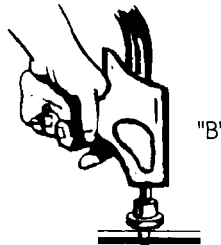
## INSTALLING CLIP PINS

Clip Pins are welded as easily as "A", "B", "C".

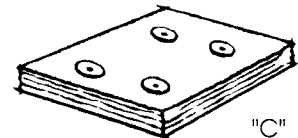
Position Clip pin on Magnetic tip of hand gun.



Press down through insulation, twist gun, pull trigger. Do not release trigger until timer cycle has ended.

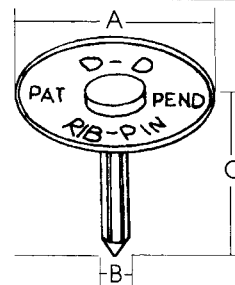


Clip Pins are permanently welded in position flush with insulation.



## RIB PIN SPECIFICATIONS

CODE NO.	CP-12	CP-34	CP-100	CP-150	CP-200
Insulation Thickness	1/2"	1"	1"	1 1/2"	2"
Dimension "A"	1"	1"	1"	1"	1"
Dimension "B"	.150	.150	.150	.150	.150
Dimension "C"	.4"	.6"	.9"	1.4"	1.9"



## TIMER ADJUSTMENT

Your timer dial facing you on the front panel of the unit, determines the duration of the weld cycle. For maximum efficiency of the unit, the weld cycle should be set for the shortest length of time necessary to provide a good weld. An excessive amount of time does not improve the weld. On the contrary, the resulting weld is not as good. It is recommended that at the start of a production run, using a given length of pin with a given gauge of metal, the operator take a few moments to determine the minimum timer setting to perform the job and leave timer at that point.

NOTE: There is a common misconception that the longer the weld time, the stronger the weld. This is not true. It is important that you follow the above instructions for maintaining the minimum weld time.

## "HEAT SINK"

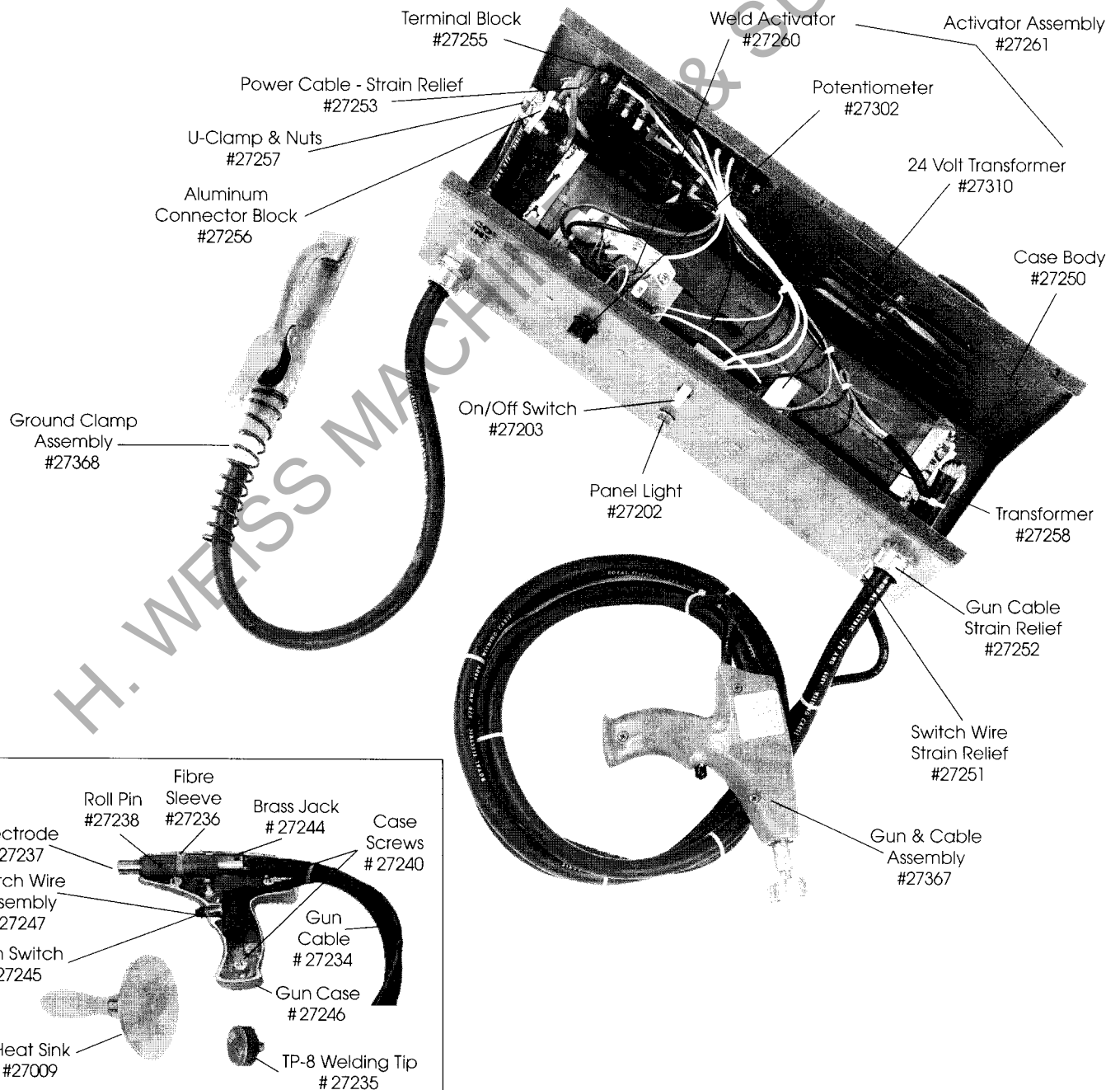
Included with your MFPT is a simple "heat sink" tool looking somewhat like a cookie cutter. This tool, when placed behind a point of weld on bare metal, will eliminate any mark on the metal by dissipating the heat generated from the point of weld. The use of copper sheet on the work bench will also eliminate this mark.

## SERVICE AND MAINTENANCE

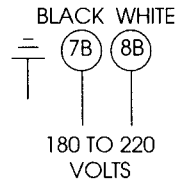
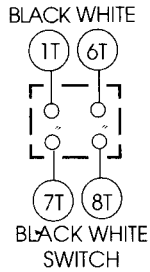
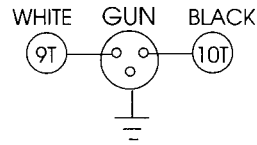
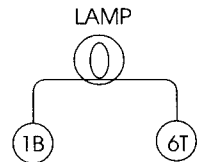
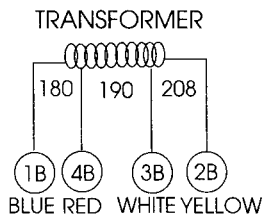
The MFPT has been designed and built to withstand rugged shop and field usage. Constant, trouble-free operation is assured with a minimum of maintenance. The GUN TIP, the GROUND CLAMP and all CABLE CONNECTIONS should be kept clean to maintain good electrical contact. Wire brush the parts to remove any oxidation or adhesive that may have accumulated during the fastening operation.

## MFPT PARTS &amp; SPECIFICATIONS

ITEM	DESCRIPTION	ITEM	DESCRIPTION
27005	TP-2 Tip	27248	Gun Cable/Electrode
27009	Heat Sink	27249	Case Cover (not shown)
27117	Transformer Primary (not shown)	27250	Case Body
27202	Panel Light	27251	Switch Wire - Strain Relief
27203	On/Off Switch	27252	Gun Cable - Strain Relief
27234	Gun Cable	27253	Power Cable - Strain relief
27235	TP-8 Tip	27255	Terminal Block
27236	Fibre Sleeve	27256	Aluminum Connector Block
27237	Electrode	27257	U-Clamp & Nuts
27238	Roll Pin	27258	MF Transformer
27240	Case Screws	27259	Weld Activator Conversion Kit
27244	Brass Jack	27260	Weld Activator
27245	Gun Switch	27310	24V Transformer
27246	Gun Case	27367	Gun & Cable Assembly
27247	Switch Wire Assembly	27368	Ground Clamp Assembly

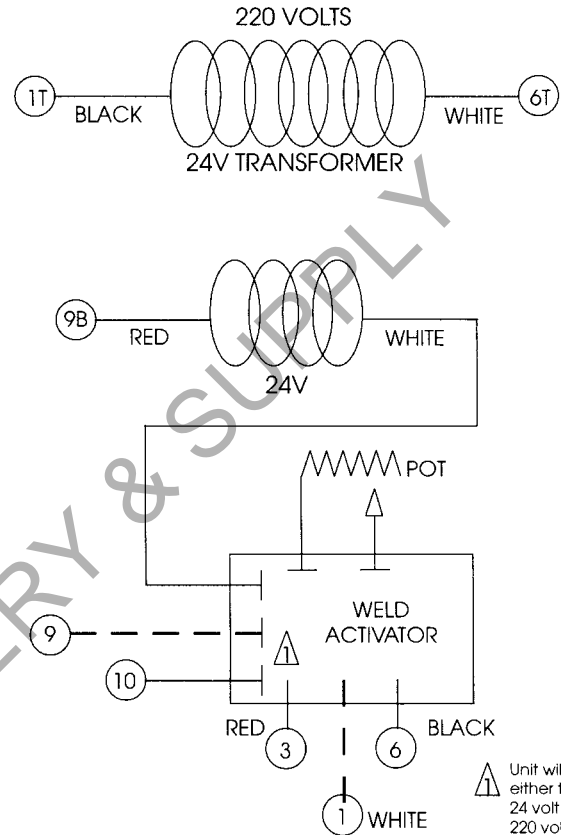


## MFPT INTERCONNECTIONS



TERMINAL BLOCK

1T	2T	3T	4T	5T	6T	7T	8T	9T	10T
1B	2B	3B	4B	5B	6B	7B	8B	9B	10B



## MFPT ELECTRICAL WIRING SCHEMATIC

