

SAFETRACK®

S30 XC

Electronic Pinbrazing unit

IN-012-02



**Read the instructions carefully
before using the pinbrazing unit.**



1. Check that all parts are received.

SAFE 9307 Delivered with:

Gun S4, automatic, SAFE 9102
Electronic unit, SAFE 9327
Earthing device, SAFE 8067
Batteries, sealed, High power 16 Ah, 3pcs, SAFE 8093
Grinder 36 V DC, SAFE 8005
Carrying harness, SAFE 9523
Tool case, SAFE 9524

SAFE 9306 delivered instead
with a S3 gun, SAFE 9303

Technical specification

Voltage	36V DC
No. of brazings/charge	40-60
Unit weight incl.batteries 13Ah/16Ah	22/25 Kg
Dimensions LxWxH (mm)	280x230x390

Accessories:

High Power batteries, sealed 16 Ah SAFE 8093
High Power batteries, sealed 13 Ah SAFE 8092
Extra box for 16Ah batteries with lid (excl. batteries), SAFE 9320
Extra box for 13Ah batteries with lid (excl. batteries), SAFE 9321
Grinding machine 36 V DC, SAFE 8005
Grinding Pin/Stone SAFE 8025
Carbide burr Type C SAFE 8014
Battery charger, stationary use, SAFE 8049
Battery charger, car use, SAFE 8055
S4-Automatic gun,self adjusted, SAFE 9102
Carrying harness, SAFE 9523
Extension cables 5m. (To extend existing gun 9235/ground 9237/grinder 9338 cables)
Extended cables 4,5m (Replace std cables)
Tool case, SAFE 9524
Rail transport wagon HANDY, SAFE 9361
Wheely kit with large rubber wheels, SAFE 9362. (To be attached on Handy, SAFE 9361)
Angle device for S4 gun. SAFE 9232

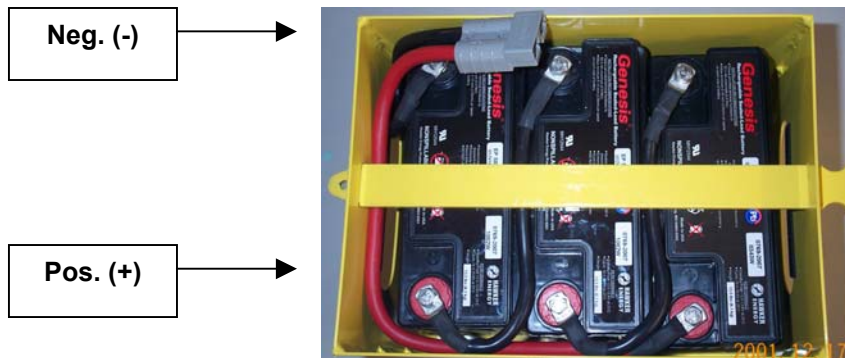
Guarantee: Units 12 months, batteries 6 months. Valid only when using original parts, batteries and chargers supplied or approved by **SAFETRACK®**. The guarantee will expire if the equipment was used or has been used with non-original spare parts, consumables or not used in accordance with the instructions.

Http://www.safetrack.se E-Mail: Sales@safetrack.se



2. Charging the batteries.

- Connect the batteries in series in the battery box.



- Be sure it is a good ventilated room you are using as a charging room.
- Connect the battery **charger** to the **grinder outlet** on the pin brazing unit then to the mains. When removing from charging remove the main first then from the unit.
- Charging is ready after about 3-5 hours. See the specific instructions for that charger you are using. Normally is the charger blinking or in any other way indicating charging completed.

Warning! The charger may not be placed over the batteries while charging in case of gas formation!

Note: Use only battery charger specially made for pin brazing unit S30 (36 V DC) delivered or approved by SAFETRACK.

3. Brazing instruction.

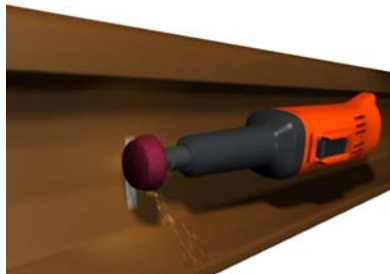


Warning! Use always eye protectors when grinding and brazing!

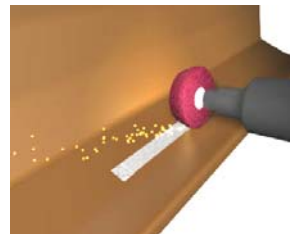
- Connect the brazing gun, power and trigger cable to the unit.
- Connect the earthing device to the unit.
- Connect the grinder to the unit.

Note, use only SAFETRACK's grinding wheel specially made for brazing, other type of wheels will leave a surface not suitable for brazings. Keep the grinding wheel clean and free from oil etc.

- Grind the brazing and earthing area until you have an even and clean surface.



Move the grinder up and downwards.



Even also the surface for the earth magnet.

- Attach the earth magnet on the same rail/work piece where the pinbrazing should be done. Try to attach the magnet within 0,5m from brazing area.
- Adjust the right pin type, the power will automatically be switched on.



Brazing pin	Adjustment
-------------	------------

8 mm std.	1
8 mm extra / threaded	2
9,5 mm	3

- Load the gun with brazing pin and ferrule.



- Make sure to braze in the top of the hole when brazing to a vertical surface.

Setting the right lift height.

- Press carefully the gun with the cable shoe, the ferrule and the brazing pin too the work piece.
- Note that you always must use a railbond together with the brazing pin and the ferrule to do a pin brazing, except when brazing a special threaded brazing pin then only a ferrule and M8, M10 or M12 brazing pin is to be used.

Using S3-Manual gun.

- Adjust the right lift height with the adjustment on the back of the gun.

The inner pipe should be in the same level as the outer pipe.



Using S4-Automatic gun.

- Set the wheel in position "0" at the back of the gun. The gun will automatically adjust the right lift level every time you braze. (Position + and – are for specific cases when appropriate.)



Brazing.

- Hold the gun firmly with both hands as shown and pull the trigger just once. The electronic will by it self finish the brazing process.

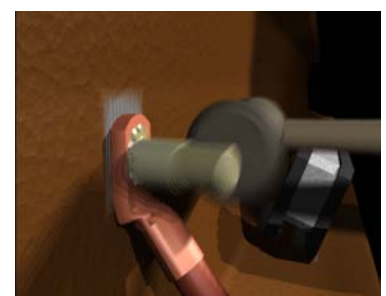


- Hold the gun in place for 3-4 sec after the brazing while the braze freezes.

- Remove the gun **straight** backwards without pulling the trigger!

Knock off the shank of the brazing pin.

The brazing is completed.



MAINTENANCE

BATTERIES

Check that:

- The cables are tight and intact.
- The terminals are free of oxide.
- The batteries are fully charged.

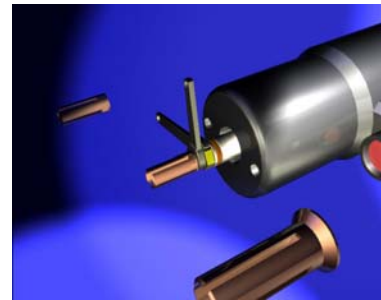
If you are using extra battery cassette, try to use it as much as the other and do always keep it fully charged.

PIN HOLDERS

Squeeze the fingers on the pin holder together each time you feel that the brazing pin goes in too easy when mounting them into the pin holder. This is important since all the current goes thru the pin holder to the brazing pin. If they fingers are too loose the pin holder will be damaged and must be replaced.

CHANGE PIN HOLDER

- Separate the ring holder from the gun with your hands.
- Hold the nut closest to the pin holder with a 10mm key.



- Screw the pin holder off.
- When replacing the new pinholder, hold the nut, closest to the pinholder even now.

EQUIPMENT

- Check the cables from time to time, so damages have not arise.
- Even the contact surface on the ground magnet with a file from time to time.

BRAZING PINS AND FERRULES

- Keep them dry.

RAILBONDS AND CABLE LUGS

- Keep them free from oxidation.
- Keep them free from contamination like: Grease, oil, dirt, paint, glue etc.
- Make sure that there are no damages on them.

Trouble shooting

1999-09-03

In order to perform this trouble shooting you will need: voltmeter, 8 mm and 10 mm spanners, hexagon spanner 3 mm, 4mm and 5 mm, control instrument to check lift height for S4 pistol. Optional :- battery load meter.

Working material	Are the bonds in good condition - no breaks, clean ? Are the pins of the correct type ?
Grinding wheel	Is the grinding wheel the approved type ? The Tyrolit is a silicon free wheel. You can use a steel carbide wheel. No other wheels are allowed.
Batteries	Sealed cells - check voltage 36V DC battery needs to be charged 39V DC battery is fully charged
Brazing gun	S3 Check cables, plugs. Does axle move easily with pin and ring fitted ? Are the pin and ring holders bent ? S4 Check cables, plugs. Does axle move easily with pin and ring fitted ? Are the pin and ring holders bent ? Unscrew the front of the gun and open carefully. Smell if there is burning, otherwise clean and replace Check the lifting height with the control instrument.
Ground magnet	Is the magnet broken (between the plates) ? Is the plug well screwed in ? Even the contact surfaces.
Electronic units	Check cables and connections for play. Are the contact on the cables damaged ? Are the knobs loose ? Are the fuses whole ? (inside on S 101) Open the panel, check for a burnt smell, (the breaker can have burnt out) Check that cables are attached correctly. Make a full optical control.
Battery Charger	Measure with a voltmeter under load that the unit is working



SAFETRACK BAAVHAMMAR AB

L.Mölleberga, 245 93 Staffanstorp, Sweden

Tel. +46 (0)40 44 55 51

Fax. +46 (0)40 44 55 53

E-mail. Sales@safetrack.se



Contactor inside the electronic, SAFE 91136

DECLARATION OF CONFORMITY

According to ISO/IEC Guide 22 and EN 45014

Manufacturers name: **Safetrack Baavhammar AB**

Manufacturers adress: **Safetrack Baavhammar AB
L.Mölleberga
245 93 STAFFANSTORP
SWEDEN**

declares that following products:

Product: **Pinbrazing unit**
Model number: **S10, S30, S50, S100, S101**

conforms to:

Safety: **IEC 950 (1991) / EN 60950 (1988) / EN 60204-1**

EMC: **EN 55022 (1988) class B/CISPR 22 (1985) class B
IEC 801-2 (1991) / EN 55101-2 (1990):8kV CD,15kVAD**

The products also conforms with Low Voltage Directive 73/23/EEC, EMC Directive 89/336/EEC and 89/392/EEG, 91/368/EEG. The products has been tested in a typical configuration.

Staffanstorp, Sweden 98-12-13



Torsten Båvhammar
President



In case of a modification of the products which has not been agreed on with us or The guarantee will expire if the equipment was used or has been used with non-original spare parts, consumables or not used in accordance with the instructions. Then this declaration becomes null and void and the warranty expires.

SAFETRACK BAAVHAMMAR AB
L.Mölleberga
245 93 Staffanstorp
SWEDEN

Tel. +46 (0)40 44 55 51
Fax. +46 (0)40 44 55 53
VAT No. SE556342145101
Sales@safetrack.se
www.safetrack.se



Thank You for choosing a guaranteed SAFETRACK product!
TERMS OF WARRANTY

Safetrack offer an additional year warranty (beside the ordinary 12 month) when you return this form. We will within the warranty period exchange or repair the product free of charge* since...

- ✓ ... the product is returned complete to Safetrack Baavhammar AB or official service agent.
- ✓ ... the product has not been misused or carelessly handled.
- ✓ ... previous repairs have only been attempted by Safetrack Baavhammar AB or approved service agents.
- ✓ ... proof of purchase date is produced when the goods are handed in or sent for repair.
- ✓ ... we have only used original Safetrack spare parts and consumables.

Tack för att Du valt en garanterad SAFETRACK produkt!
GARANTIVILLKOR

Safetrack reparerar eller byter ut produkten utan kostnad* om fel uppstår inom 24 månader från köptillfället om ni registrerar produkten (annars 12 månader från köptillfället) eftersom...

- ✓ ... vi levererat utrustningen komplett till Safetrack Baavhammar AB eller auktoriserad servicepartner.
- ✓ ... produkten ej har varit utsatt för vanvård eller felaktigt användande.
- ✓ ... tidigare gjorda reparationer är utförda av Safetrack Baavhammar AB eller auktoriserad servicepartner.
- ✓ ... köpehandlingen för produkten medföljer leveransen.
- ✓ ... vi endast har använt Safetrack originaldelar och arbetsmaterial.

* (Except consumption parts and batteries)

* (Gäller ej förslitning/ förbrukningsmaterial eller batterier)

Serial no: _____
Product no: _____
Part no: _____

Keep this part / Behåll denna del.



Please, complete form after purchase.

Vänligen fyll i formulär och skicka in efter köp.

Warranty registration / Garantiregistrering

Note! Extended warranty only valid after signing up within 6 months after purchase.

Observera! Den förlängda garantin gäller bara vid registrering inom 6 mån från köp.

Send in by mail, fax or use www.safetrack.se for registration.



Date of Purchase

Inköpsdatum

Serial number

Serienummer

Equipment

Utrustning

☐	S30 XC Pin brazing unit S30 XC Pinlödningsaggregat	☐	S4 Pinbrazing gun S4 Pinlödningspistol
☐	S101 Pin brazing unit S101 Pinlödningsaggregat	☐	S300 Pin brazing unit S300 Pinlödningsaggregat
☐	X250 Pin brazing unit X250 Pinlödningsaggregat	☐	Heaty 300/600 Heaty 300/600
☐	Safebond unit Safebondaggregat		

Company

Företag

First name

Förnamn

Surname

Efternamn

Address

Adress

Country

Land

Phone

Telefon

E-mail

E-mail

Distributor:

Köpt av distributör:

Visit us at www.safetrack.se

SAFETRACK BAAVHAMMAR AB, L.Molleberga 245 93 Staffanstorp, Sweden

Phone: +46(0)40-44 53 00, Fax +46(0)40-44 55 53 sales@safetrack.se

