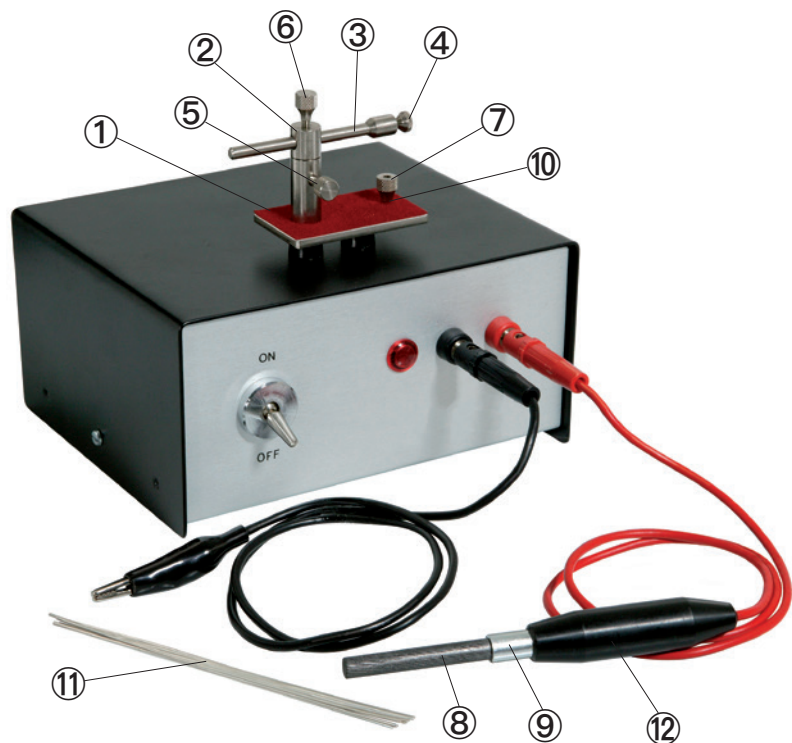


## Operating Instructions Dial Soldering Unit

- ① Base Plate (grounding)
- ② Articulated pillar
- ③ Wire sustenance arm
- ④ Fixation screw
- ⑤ Fixation screw
- ⑥ Fixation screw
- ⑦ Fixation screw
- ⑧ Soldering coal
- ⑨ Coal holder
- ⑩ Fixed dial for soldering
- ⑪ Metal dial feet rod
- ⑫ Insulated handle



Use crocodile clip on black cable to make an earth or negative connection by clipping on to base ①. The other end has to be inserted into the black plug on apparatus. Use the red cable to make a positive connection by inserting the end into the red plug on the apparatus. The other end has the carbon stick ⑨ for soldering.

Scrape and clean the spot where the new dial foot is to be soldered. Fix the dial ⑩ to base ① by means of screw ⑦ making sure that there is a good contact. Choose the diameter of the dial foot wire and file the end of the dial foot to make sure that there is a flat contact. Pass the foot wire through the hole in arm ③, held in rotating post ②. Center the wire exactly over the spot where it is to be soldered by screws ④, ⑤ and ⑥. Shake the cleaning solution and place a drop where the wire touches the dial. Place a chip, cut from the soldering wire, against the wire. This chip should be kept in place with tweezers in the left hand. With the right hand, press lightly the carbon ⑧ against the wire ⑪. An up and down movement against the wire should provoke sparks. The heat so produced will melt the chip of solder which will form a collar around the foot wire. Do not continue too long the up and down movement so that the dial is not overheated and so damaged (max. length of time 2 secs.). Now cut the wire to the required length of the dial foot and clean off the surplus solder.

### Important notice:

1. *Be sure to set the voltage switch at the back of the apparatus to the correct voltage of your workshop (110 or 220 V).*
2. *Always clean very carefully the foot wire after each soldering, making sure that there are no traces of oxidation or blackness due to the up and down movement of the carbon against the foot wire. It is also advisable that during the up and down movement the carbon stick is rotated to produce a better spark.*