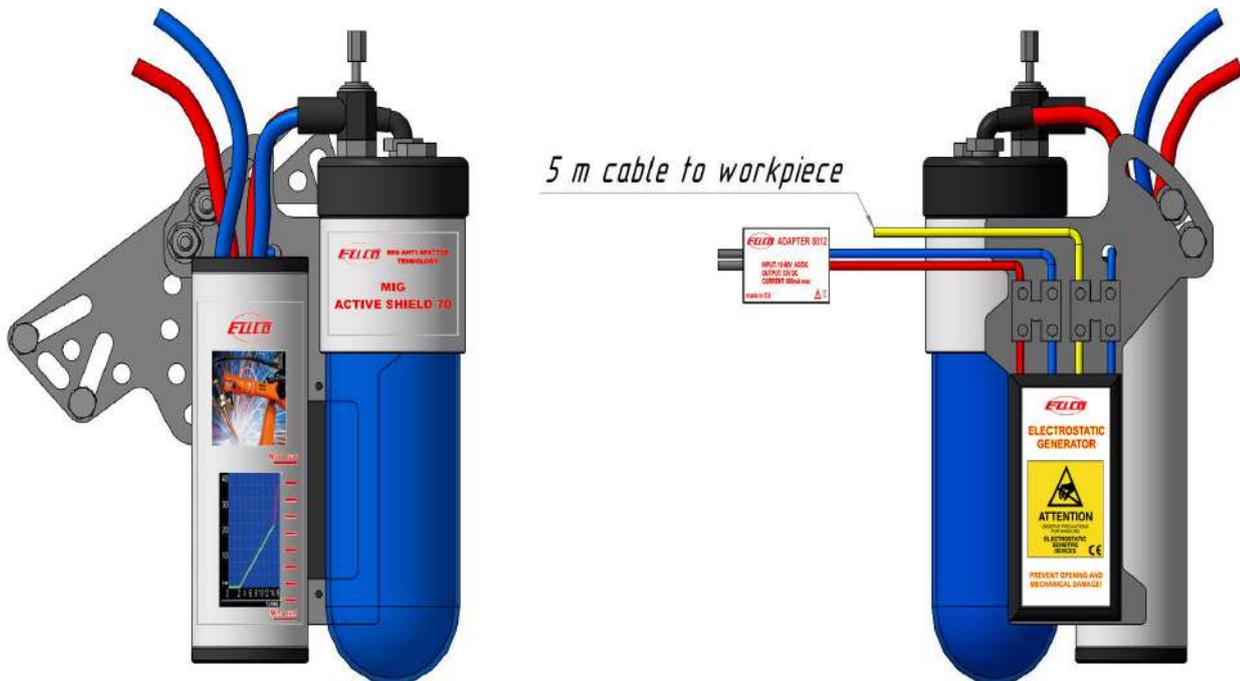




MIG ANTI SPATTER TECHNOLOGY CREATED IN THE WELDING CELL



TESTING GUIDE



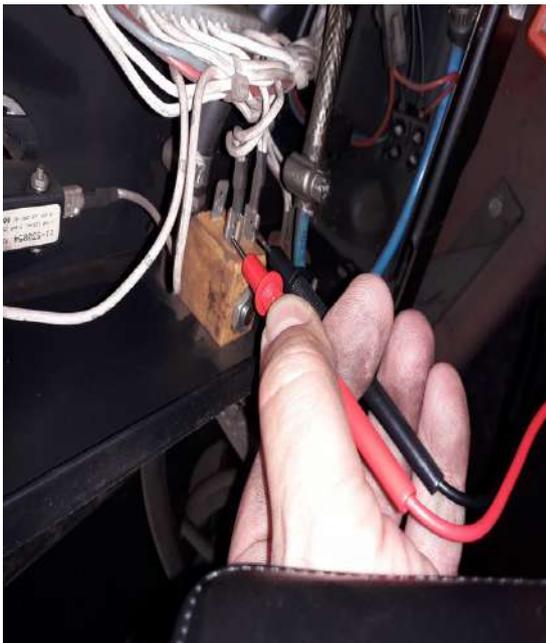
MIG ACTIVE SHIELD 70

1. Make picktures of your welds before installing the device.



2. Read the MIG Active Shield 70 – USER MANUAL

3. Before installing measure the output voltage of the gas solenoid when it is activated at least for 5 sec. It must be in the range 12 – 80 V AC/ DC. If the output voltage is out of this range do not install the unit.



4. If the output voltage is in the above range install the device on the robot following the instructions in the USER MANUAL.

5. Make the connections following the instructions.

6. When the device is installed, connected , filled with working fluid, activate the gas line to remove the air from the chamber.
7. Make the adjustments as it is described in the User Manual.
8. Start welding.
9. You can change the adjustments during welding to find the optimum effect.
10. Point your attention to the device. Ones installed it is completely autonomous. It activates when welding starts and deactivates when welding stops. No additional activities are needed. This saves extra production time. Put this to the result.
11. Continue to weld by pointing your attention to the welding gun. Determine periods and times for cleaning the welding gun. These are non production times.
12. Compare the results before and after. Calculate the time earned per shift. This is additional production time. Add this to the result.



13. In many cases a self-cleaning process can be achieved. Add this to the result.
14. Using air blowing after the welding cycle in many applications can bring the same result.
Take in mind – never blow through the device, always after it.
15. Point your attention to the welding gun consumables. The life of consumables is extended several times. Add this to the result.

16. Point your attention to the fluid consumption. Just one refill 70 ml of the fluid is enough for burning about 250 kg of your welding wire. Compare with other methods. Add to the result.

- Shake the fluid before use.



17. Make pictures on your welds again. Compare pictures before and after. Then by counting spatters on welded details before and after determine the approximate percentage of reduction.

18. Try to remove the rest of spatters using a small metal scraper with minimal effort. Add to the result.



19. Limitations. When welding shot blasted or galvanized surfaces, also heated surfaces due to changes in surface conditions, the effect of using this method is limited. Other anti spatter methods may be added in these cases.



MIG ANTI-SPATTER TECHNOLOGY CREATED IN THE WELDING CELL