

# Cutlass Fasteners, Inc.

83 Vermont Ave., Unit 6, Warwick, RI 02888  
Tel: (401) 732-6333 Fax: (401) 732-6336  
cutlass-studwelding.com

## Stud Welding...

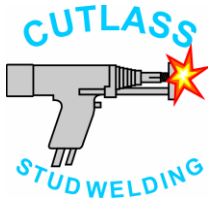
- Fasteners
- Equipment
- Service

## BANTAM CD WELD GUN MANUAL

<b>MODEL</b>	<b>:</b>	<b>BANTAM C8</b>	<b>BANTAM C10</b>
<b>PART NO.</b>	<b>:</b>	<b>602-325A</b>	<b>602-343A</b>
<b>SERIAL NO.</b>	<b>:</b>		



PLEASE READ THIS OPERATION AND MAINTENANCE MANUAL  
CAREFULLY BEFORE USING YOUR NEW CUTLASS STUD WELDER.



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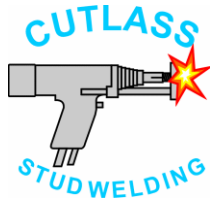
## BANTAM CD WELD GUN MANUAL

### WARRANTY

The electrical and mechanical components of the Cutlass Stud Welders are thoroughly performance inspected prior to assembly in the Welder. The assembled Welder is completely performance checked. The Welder is delivered to you in perfect electro-mechanical condition. All parts used in the assembly of the Welder are fully warranted for a period of three (3) months from the date of delivery.

Under this warranty, the manufacturer reserves the right to repair or replace, at its option, defective parts which fail during the warranty period. Notice of any claim for warranty repair or replacement must be furnished to the manufacturer, by the purchaser, within five (5) days after the defect is first discovered. The manufacturer does not assume any liability for paying shipping costs, or for any labor or material furnished where such costs are not expressly authorized in writing.

We do not warrant the Cutlass Stud Welders, parts or accessories against failures resulting from misuse, abuse, improper installation, normal wear and tear, maladjustment or use not in accordance with the operating instructions furnished by the manufacturer. Cutlass shall never be liable for any consequential damages.



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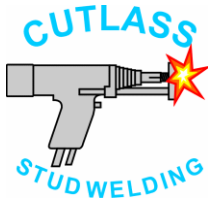
## BANTAM CD WELD GUN MANUAL

### SUGGESTED SAFETY PRECAUTIONS

In any welding operation, it is the responsibility of the welder to observe certain safety rules to insure his personal safety and to protect those working near him.

Reference is directed without endorsement or recommendation, to ANSI Z49.1, Safety in Welding and Cutting, and to AWG Publication A6, 1-66 Recommended Safe Practices for Gas-Shielded Arc Welding.

1. Always treat electricity with respect. Under open circuit conditions, the welding machine output may be dangerous.
2. Do not work on live circuits and conductors. Disconnect the main power line before checking the machine or performing any maintenance operations.
3. Ensure the welding machine cabinet is properly grounded to a good electrical ground.
4. Do not stand in water or on damp floors while welding or weld in the rain. Avoid wearing wet or sweaty clothes when welding.
5. Do not operate with worn or poorly connected cables, and do not operate weld gun with loose cable connections. Inspect all cables frequently for insulation failures, exposed wires, loose connections and repair as needed.
6. Do not overload weld cables or continue to operate with hot cables.
7. Do not weld near flammable materials or liquids, in or near atmospheres, or on ducts carrying explosive gases.
8. Do not weld on containers which have held combustible or flammable materials, or on materials which give off flammable or toxic vapors when heated, without proper cleaning, purging, or inerting.
9. Ensure adequate ventilation is provided when welding in confined spaces.
10. Never look at the electrical arc without wearing eye shields.
11. Always use proper protective clothing, gloves etc. Never weld close to a bystander who is unaware of the possible dangers of ultraviolet light and weld splatter on their eyes.
12. Installation, servicing and trouble shooting should only be done by qualified personnel, familiar with this type of equipment.



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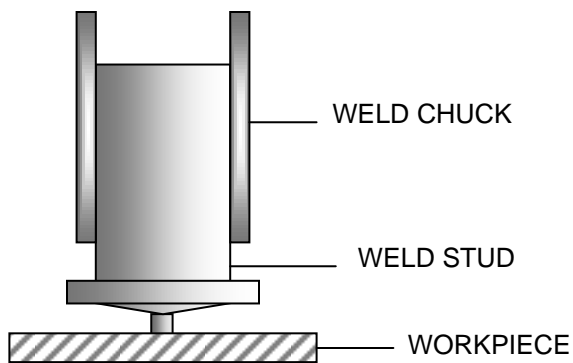
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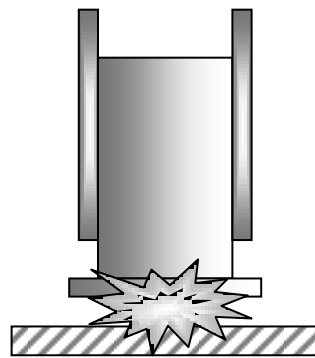
## BANTAM CD WELD GUN MANUAL

### THE CAPACITOR DISCHARGE STUD WELDING PROCESS

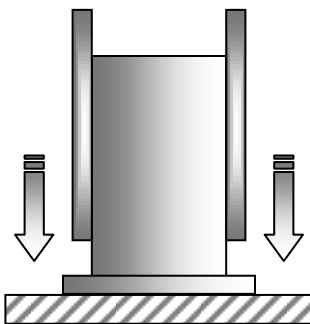
#### HOW THE STUD WELD IS MADE:



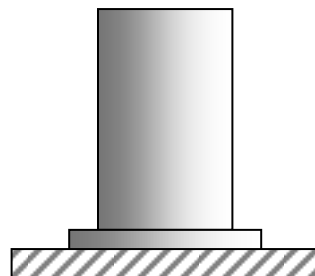
1. The stud is located on the spot to which it is to be welded.



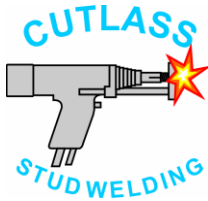
2. Stored energy is discharged through the precisely engineered weld tip at the base of the fastener.



3. The stud is plunged into the molten weld pool, and fusion is achieved across the complete section of the weld.



4. The weld gun is withdrawn leaving the fastener permanently welded to the workpiece.



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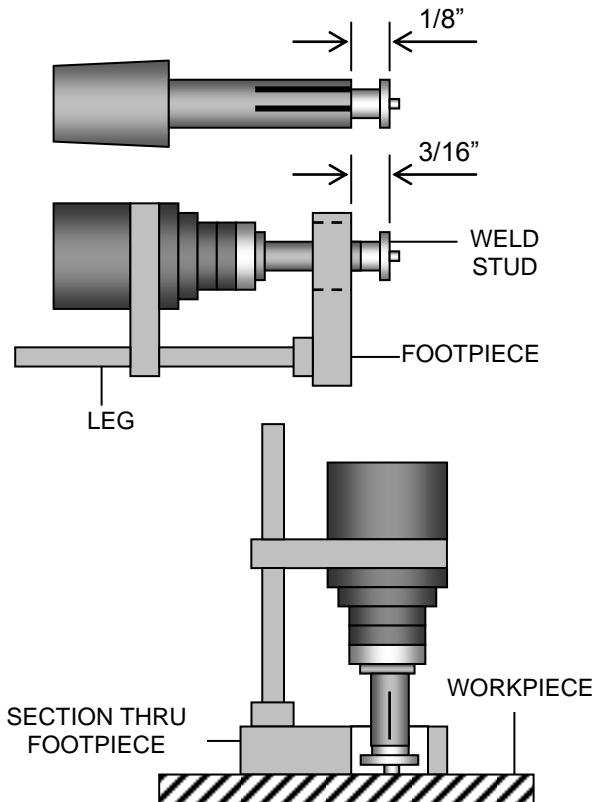
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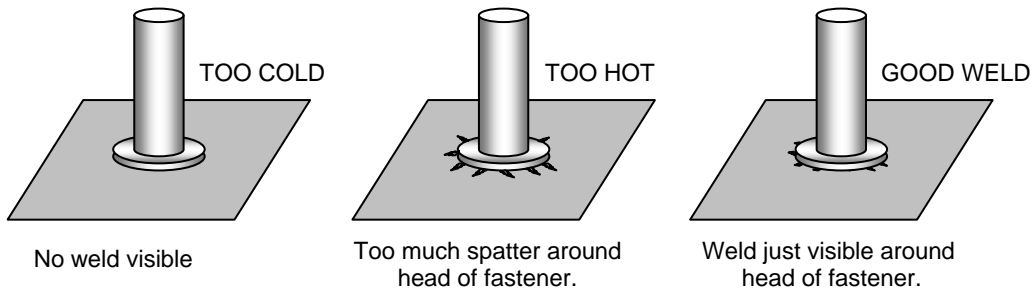
## WELD GUN SETUP



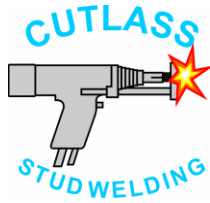
1. The weld chuck should be adjusted as shown. For longer studs, as much of the stud should be held as possible. This may require complete removal of the adjusting screw.
2. Seat weld chuck firmly in the front of weld gun and attach leg and footpiece assembly. Set leg depth so approximately 3/16" of stud/chuck protrudes beyond the footpiece.
3. Place the weld gun perpendicular to the workpiece as shown. Apply pressure to the gun so the footpiece lies firmly on the workpiece.
4. Hold gun steady and pull trigger when stud is in required position. After weld cycle withdraw gun from stud. Pull gun straight back so weld chuck is not damaged.
5. Inspect weld and adjust setting as required.

## TEST WELDING

Before making your first weld, check the ground clamp. It is essential that no power be lost through a poor connection. The surface under the ground should be free from oil, scale, grease and rust. The test should be on a piece of scrap material similar to the material to be used during actual production.



**NOTE:** IF WELD APPEARS COLD, DO NOT PLACE GUN ON WELDED STUD AND TRIGGER AGAIN. DAMAGE TO WELD CHUCK OR CONTROLLER WILL OCCUR.



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## BANTAM CD WELD GUN MANUAL

### CAUSES OF POOR OR ERRATIC WELDS

1. Loose weld chuck – does not grip stud tightly.
2. Faulty or loose ground connections.
3. Dirty base material (oil, grease, rust etc).
4. Voltage too high or too low.
5. Broken or loose cables.
6. Gun binding – dirt in weld gun preventing free movement.
7. Leg and/or footpiece incorrectly set.
8. Use of center punch.
9. Weld cables coiled.

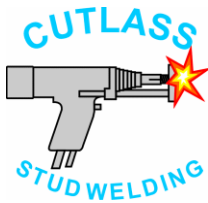
NOTE: The weld cables and ground cables should be laid out in a straight line or large loops. Poor weld quality may result if welding cables are closely coiled.

### WELDER MAINTENANCE

Your Cutlass welder is designed for long service with minimum care. Ordinary common sense maintenance will keep it operating efficiently. Following are some tips on preventative maintenance:

1. Treat the welding and control cables with respect. Avoid sharp bends and kinks which may break the cables. Do not use the cables as a "tow-line" to move controller. Avoid damaging or straining the cables where they enter the gun or connectors.
2. Ensure unit vents are not obstructed, and that the unit is not covered while in use. Avoid overheating.
3. Keep the welding gun free of dust and dirt. Periodically clean weld splatter from front of gun.
4. The welder should not be placed in close proximity to any MIG or TIG welders, nor should the Clipper share a common power supply with MIG or TIG equipment. Similarly the main ground connection from the Clipper to the workpiece should not be linked in any way to MIG or TIG grounds.

**FAILURE TO COMPLY COULD INVALIDATE YOUR WARRANTY**



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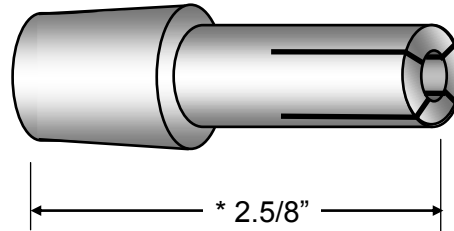
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## BANTAM CD WELD GUN MANUAL

### STANDARD ACCESSORIES

#### INCH

STUD SIZE	PART NUMBER
2-56UNC	015-509
12GA, 4-40UNC	602-467A
1/8	015-511
10GA, 6-32UNC	602-451A
8-32UNC	602-452A
#10, 3/16	605-101A
0.217	605-112
1/4	605-104A
5/16	605-105A
3/8	605-106A



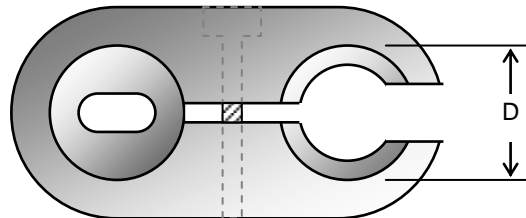
**STANDARD  
ADJUSTABLE  
WELD CHUCKS**

#### METRIC

STUD SIZE	PART NUMBER
3MM	605-111
4MM	602-423A
5MM	605-102
6MM	605-103
8MM	605-105A
10MM	605-106

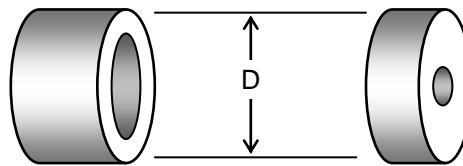
- LONGER LENGTHS AVAILABLE ON REQUEST

**CD FOOTPIECE**



SIZE	'D' DIA.	PART NO.
SMALL	7/8"	023-252
MEDIUM	1.160"	023-252M

DESCRIPTION	PART NO.
JIG LOCATING BUSH D = 7/8"	650-691
NAIL GUIDE D = 7/8"	601-350
CHUCK DRIFT	000-374
SPARK SHIELD, SML. D = 1.16", A = 3/16"	999-013
SPARK SHIELD, LGE. D = 1.16", A = 1/2"	999-018

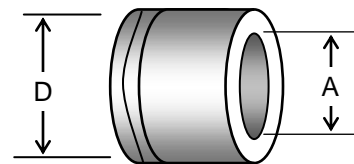


**JIG LOCATING BUSH**

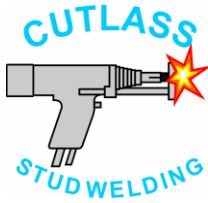
**NAIL GUIDE**



**CHUCK DRIFT**



**SPARK SHIELD**



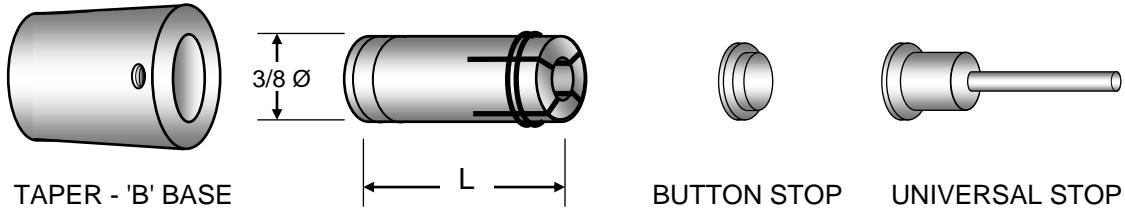
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### B COLLETS - INCH SIZES

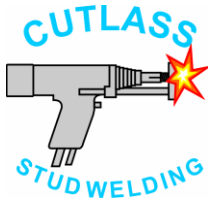
STUD SIZE	"L" LENGTH	PART NUMBER
2-56UNC	1.3/8"	669-232
12GA., 4-40UNC	1.3/8"	669-219
1/8	1.3/8"	669-230
10GA., 6-32 UNC	1.3/8"	669-220
8-32 UNC	1.3/8"	669-222
3/16, 10-24UNC, 10-32UNF	1.3/8"	669-216
0.217	1.3/8"	669-217
1/4	1.3/8"	669-218
5/16	1.3/8"	669-228
3/8	1.3/8"	669-229

### B COLLETS - METRIC SIZES

STUD SIZE	"L" LENGTH	PART NUMBER
3MM	1.3/8"	669-243
4MM	1.3/8"	669-231
5MM	1.3/8"	669-244
6MM	1.3/8"	669-235
8MM	1.3/8"	669-228
10MM	1.3/8"	669-247

### B COLLET ACCESSORIES

ITEM	PART NUMBER
B COLLET TAPER BASE	669-223
BUTTON STOP	669-225A
UNIVERSAL STOP	669-225



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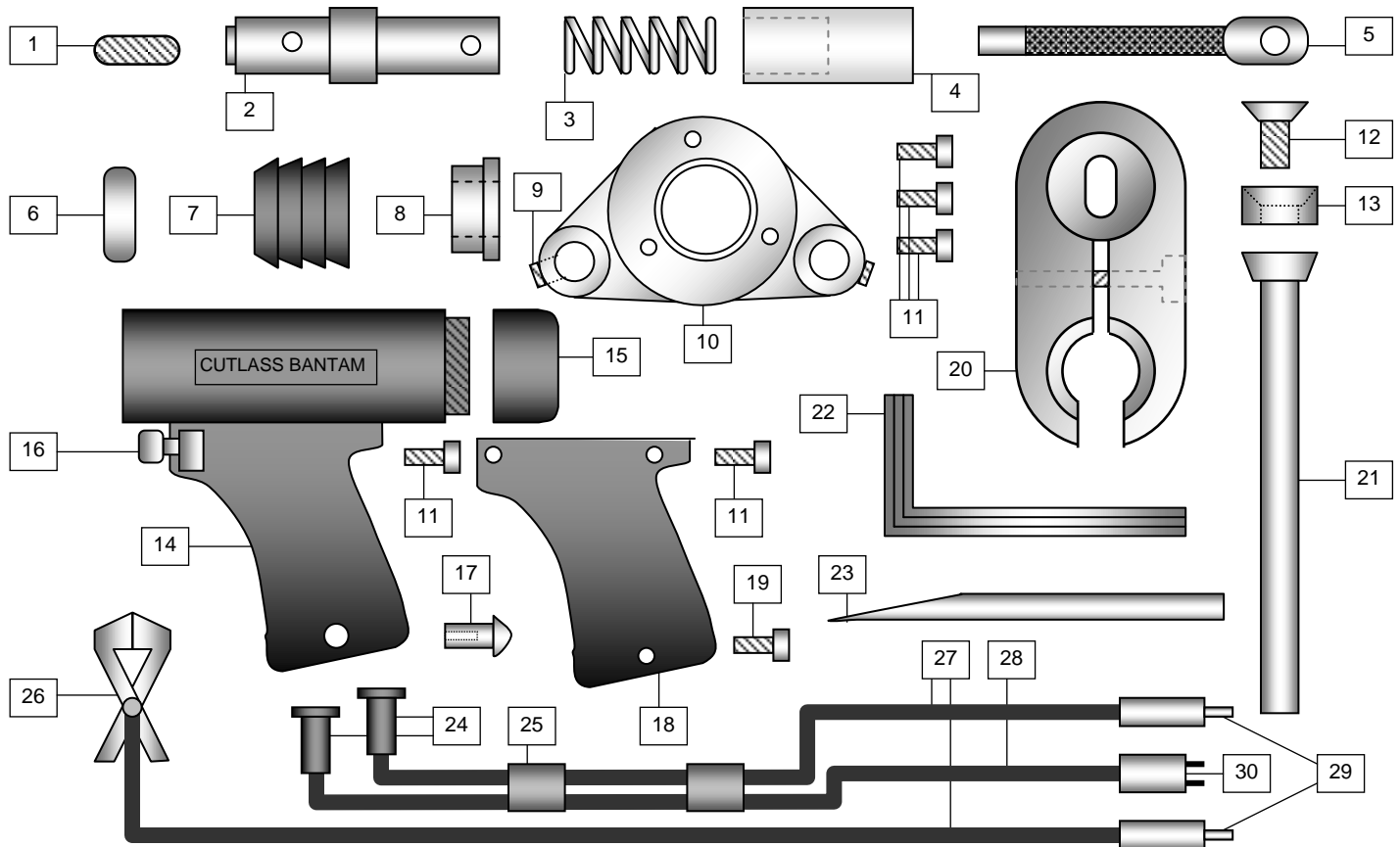
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## BANTAM C8 GUN PARTS



ITEM	DESCRIPTION	PART NO.
1	SPINDLE SCREW	016-405
2	SPINDLE - CD	602-074A
3	HEAVY SPRING (SILVER)	001-800
4	REAR BEARING	022-357
5	INTERNAL WELD CABLE	602-056
6	BELLOWS RETAINER	001-816
7	BELLOWS	003-499
8	FACEPLATE BUSH CD T/L	602-103
9	FACEPLATE SCREW	010-410
10	FACEPLATE T/L	011-513
11	10-24 X 1/2 SCREW	009-914
12	LEG SCREW	017-775
13	LEG WASHER	017-332
14	GUN BODY	016-383
15	BACK CAP	015-803
16	TRIGGER SWITCH	650-640

ITEM	DESCRIPTION	PART NO.
17	LOWER HANDLE NUT	002-906
18	GUN HANDLE	016-384
19	10-24 X 3/4 SCREW	000-916
20	FOOTPIECE S/L	023-252
21	7" LEG ASSEMBLY	000-355
22	5/32 HEX KEY	000-373
23	CHUCK DRIFT	000-374
24	CABLE SLEEVE	001-181
25	1" RUBBER SLEEVE	600-627
26	GROUND CLAMP	650-625S
27	#4 WELD CABLE	600-768
28	CONTROL CABLE	600-717
29	WELD PLUG C/M	000-568
30	CONTROL PLUG C/M	000-594
3A	EX. HEAVY SPRING	001-801