



OPERATING INSTRUCTIONS FOR
GROB SAW BLADE WELDERS
Model RWA
FOR CARBON STEEL and BI-METAL BLADES

Read Complete Instructions Before Operating Welder

PLACING WELDER INTO SERVICE:

When connecting welder, check current specification stamped on nameplate. For satisfactory operation, full voltage must be available.

Welders are single phase (A-C) alternating current. Do not connect to (D-C) direct current.

PREPARING SAW BLADE ENDS:

1. Use Grob T-10 cut-off tool to assure a square cut. (See Fig. 1.)
2. To insure good contact between welding jaws and saw blade ends, saw blade ends must be square. Remove coating on blade with emery cloth.

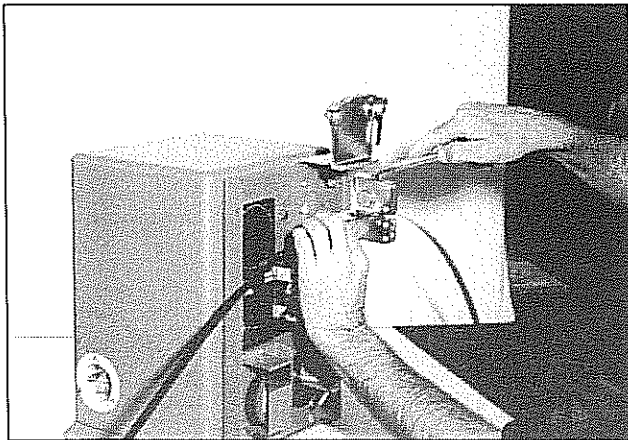


Fig. 1
T-10 CUT-OFF TOOL

CLAMPING:

Turn T-Crank handle to the right on clamp "Position." (See Fig. 3.) Place blade ends between jaws, with teeth against Alignment gauges, and blade ends **CENTERED** between jaws. Blade ends must butt together in perfect alignment, then clamp blades. With blade ends clamped, turn T-Crank to the right size of blade indicated on nameplate.

SELECTING WELDING HEAT:

Some practice is helpful to select the proper welding heat for each particular saw blade. (See Fig. 3.)

Too much welding heat might overheat the metal; and weaken the weld.

WELDING:

Press weld button (See Fig. 3.) and **HOLD IN UNTIL WELD IS COMPLETED**. The current passing through the saw blade will heat the ends until hot enough to flow together under welding tension. This reduces the gap between jaws, to where the current is automatically shut off.

As the metal is hot, and the welding jaws are cold, the weld becomes chilled and glass hard.