



Welding Hand Pieces Instruction Pamphlet

Dual Probe Hand Piece **DPHP**
Single Probe Hand Piece **SPHP**
Tweezer Hand Piece **THP**

Sunstone Welding Hand Pieces

- Greater flexibility than a weld head
- Works with any Sunstone welder
- Inexpensive
- Easy to maintain
- Simple to use



THP
Tweezer Hand Piece



SPHP
Single Probe Hand Piece



DPHP
Dual Probe Hand Piece

The Dual Probe Hand Piece DPHP

The dual probe hand piece (DPHP) allows single sided, series welds to be made in thin sheet metal. The DPHP offers the flexibility to weld from any angle, at any orientation. Make two welds from the same side of a work piece with each weld actuation.

As seen in Figure 1 the most popular application for the DPHP is to weld battery pack assemblies. The proper procedure for using the DPHP to weld battery packs is outlined below. If using a Sunstone dual pulse welder follow the process outlined in the dual pulse welder instruction pamphlet to set pulses one and two.

1. Place both welding probes on the battery tab material.
2. Apply light to moderate pressure.
3. Actuate the foot switch



Figure 1: A cordless drill battery pack being welded using the dual probe hand piece (DPHP) welding attachment.

Electrode sticking may be an indication that more pressure is needed. It may also indicate that less weld energy is required. If electrode fouling occurs use a Scotch Brite abrasive pad to remove oxide and foreign metals. Electrode tips can be maintained using a small

needle file (provided with each welder). If the DPHP requires re-coning a belt sander can be used.

The Single Probe Hand Piece (SPHP)

The single probe hand piece (SPHP) is used to make single point welds in thin sheet metal. The SPHP can be used for hard to reach locations or in fixtures by attaching to a ground plane. Figure 2 shows the SPHP being used to weld two thin pieces of sheet metal.

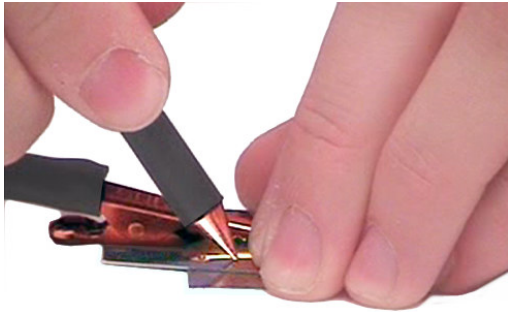


Figure 2: The single probe hand piece (SPHP) being used to weld thin sheet metal.

The proper procedure to use the SPHP is outlined as follows:

1. Attach the ground clip as close as possible to the weld location.
2. Place the probe at the location to be welded.
3. Apply pressure
4. Actuate the weld using the panel or foot switch.

Again, if electrode fouling occurs use a Scotch Brite abrasive pad to remove oxide and foreign metals. Electrode tips can be maintained using a small needle file (provided with each welder). If the SPHP requires re-coning a belt sander can be used.

The Tweezer Hand Piece (THP)

The tweezer hand piece (THP) can be used when opposing surfaces are available. Figure 3 shows the THP being used to weld two sheets of thin sheet metal.



Figure 3: The tweezer hand piece (THP) being used to weld thin sheet metal.

The proper procedure to use the THP is outlined as follows:

1. Pinch the metal between the tweezer electrodes.
2. Apply adequate pressure to insure good contact between the metal surfaces.
3. Actuate the weld using the panel or foot switch.

Again, if electrode fouling occurs use a Scotch Brite abrasive pad to remove oxide and foreign metals. Electrode tips can be maintained using a small needle file (provided with each welder).

For additional instruction please see our instructional video at www.SunstoneEngineering.com.

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853 Canyon Cove Dr.
Payson, Ut 84651
Phone: 801-658-0015
Fax: 866-709-1209