



CORROSION CONTROL

## Technical Datasheet

### PIN BRAZING

The Easybond unit is suitable for all types of installation and maintenance work. It is primarily for the user who needs a simple, rugged and low cost machine. The unit is portable and easy to transport.



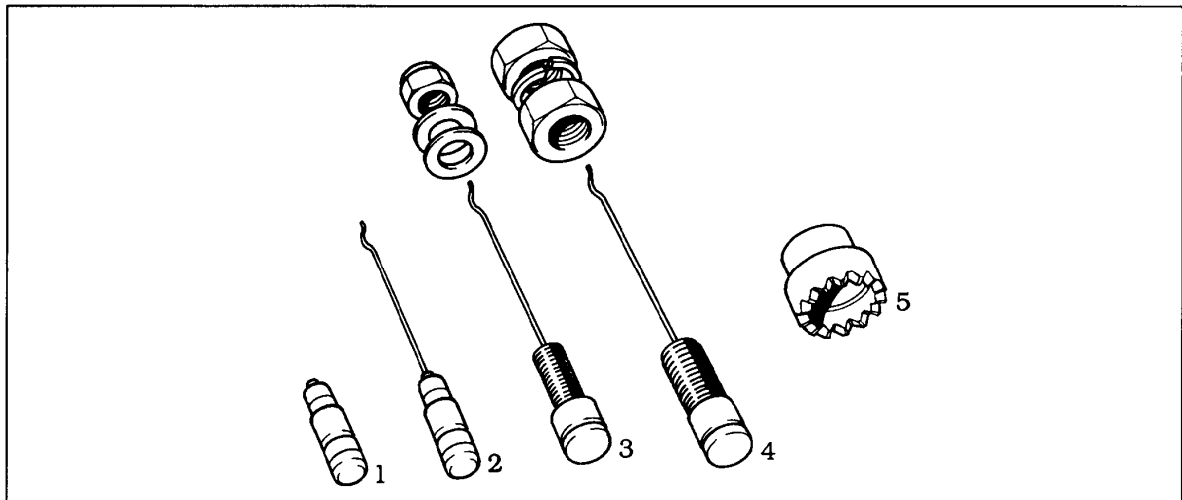
The brazing process is controlled by means of the fuse wire on the brazing pin. The capacity is approximately 15 brazes with the standard type of brazing pin per battery charge but it can easily be increased by a battery charger mounted in a vehicle, the batteries being charged up during transportation between workplaces. When alternating between charging and brazing it is possible to increase the capacity up to 5 times during a working day.

An Easybond unit consists of:

- Easybond Gun
- Earth Cable
- Grinder (optional)
- Battery Pack (the batteries are sealed to prevent acid spill) and Battery Charger
- Attache Case for the Gun, Earth Cable and Grinder

The Easybond unit complete weight is approximately 30 kg.

### PINS AND FERRULES





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The working temperature of the brazing solder in the brazing pins is 610 °C, in line with the classification of the operation as hard soldering.

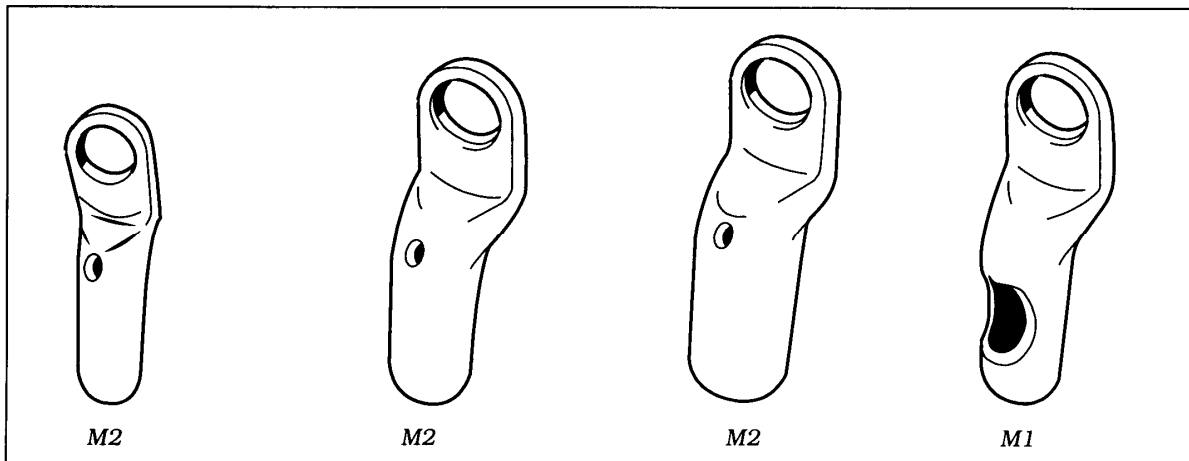
A new ferrule must always be employed in pin brazing (the ferrule must be changed after each brazing operation). The purpose of the ferrule is to prevent spattering of the molten solder, to prevent oxidation of the molten solder, and to protect the operator against radiation from the arc. The ferrule must be stored dry.

The following pins are available:

Fig.	Description	Dimensions	Pack Size
1	Direct Brazing pin, standard (without fuse wire)	Ø 8 or 9.5 mm	100
2	Direct Brazing pin, standard (with fuse wire)	Ø 8 or 9.5 mm	100
3	Threaded brazing pin (with fuse wire)	M8	50
3	Threaded brazing pin (with fuse wire)	M10	40
4	Threaded brazing pin (with fuse wire)	M12	40
5	Ferrule	for 8 mm direct pins	200
5	Ferrule	for 9.5 mm direct pins	150
5	Ferrule	for all threaded pins	100

Direct pins are available in either standard or with extra solder. Direct pins with extra solder are recommended for cables with a cross sectional area of 25 mm<sup>2</sup> and greater.

### CABLE LUGS FOR DIRECT PINS



BAC cable lugs are specially manufactured in the intended material for pin brazing. The lugs are made in two different types. M1 is pin brazed to the cable. M2 is crimped to the cable. The following sizes are available:

Suitable for	Pack size
10 mm <sup>2</sup> Cable	100
16 mm <sup>2</sup> Cable	100
25 mm <sup>2</sup> Cable	50
35 mm <sup>2</sup> Cable	50
50 mm <sup>2</sup> Cable	40