

e•drill™ QUICK START & MAINTENANCE GUIDE

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INTRODUCTION:

The purpose of this quick-start guide is to assist the operator in setting up and operating the e•drill system in as little time as possible. Refer to User Guide for detailed programming and operation information. **IMPORTANT!!** Be sure ALL Installation procedures have been completed before operating the system.



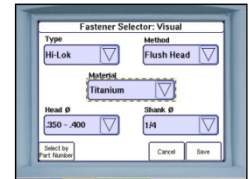
Prior to system use, is highly recommended the user be trained by PPedm in system use, service, and has read the operators manual completely.

POWERING UP THE SYSTEM:

1. With the e•drill and Hand Held Terminal installed, and power connected to the Mobile Service Unit (MSU), locate the power switch on the back service panel of the MSU and turn it to the "ON" (up) position.
2. The system will power up and after a few seconds the Hand Held Terminal touch screen will illuminate and display the last fastener entry.

SELECTION OF PARAMETERS TO PERFORM A CUT:

1. Determine the type of fastener you are about to cut. If the screen of the Hand Held Terminal is not illuminated, touch the screen to awaken it. Go to bottom right tabs on screen and select visual or select by part number and from that selection in the next screen Input in the fastener part number or visual parameters.
2. Install the proper electrode into the e•drill. i.e. Brass or Copper and proper electrode O.D. (5/32", 3/16" or 6.-8 etc.) and the correct adaptor for the fastener type to be removed.



REPLACING AND SETTING THE ELECTRODE:

Electrode replacement is necessary when either:

- A) The current electrode is consumed and should be replaced when indicated by a flashing green light on the hand-tool and a message on the Hand Held Terminal, or
- B) When changing to a different fastener with different stem diameter or oversize type.



EACH FASTENER SIZE AND DIAMETER, AND OVERSIZE FASTENER HAS A MATCHING ELECTRODE SIZE. WHEN CHANGING TO A DIFFERENT STEM DIAMETER OR OVERSIZE TYPE FASTENER, THE PROPER CORRESPONDING ELECTRODE MUST BE INSTALLED FOR SUCCESSFUL SYSTEM OPERATION.

1. Unlock the installed Adapter Tip by gripping and twisting it counter-clockwise (when viewed from the front of the e drill). Then pull the Adapter tip straight out.
2. Unthread the existing Electrode using the Torque-Ring Wrench by inserting it over the Electrode until it engages the Electrode detents. Remove the Electrode by turning it counter-clockwise. It may be necessary to advance the electrode: in which case, with system power on, advance the installed electrode completely forward by depressing gun trigger until the Electrode advances fully. When you have reached the forward limit the LED at the top of the e•drill will illuminate Red and the e•drill mechanism will stop automatically. If the electrode wont advance, and the system is indicating that the electrode should be replaced, press the green retract button briefly before attempting to advance the electrode.
3. Hand-thread the replacement Electrode onto the e•drill. Install the Torque-Ring Wrench by slipping it over the Electrode until it engages the Electrode detents. Tighten the replacement Electrode with the Torque -Ring until it "breaks" (or skips) when the required torque is reached. Remove the Torque-Ring and replace the required Adapter Tip over the Electrode.
4. Retract the Electrode by pressing and holding down the green retract button in the base of the e drill grip until the LED in the back of the e•drill handle illuminates Green indicating the Electrode is fully retracted.

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MAINTENANCE REQUIREMENTS:

Periodic maintenance is required to keep this system operating properly, most critical of which is gun maintenance, described below. System maintenance is controlled by internal firmware cut cycle counters that shut down the system for maintenance once a maintenance cycle is reached. Once the predetermined cut cycles are reached operator intervention is required to perform maintenance and reset the counters.

Gun Maintenance:



BG/CG GUNS ONLY: Properly setting and maintaining the Ground Pin is critical to proper e•drill operation. Failure to properly set and maintain the Ground Pin will cause poor e•drill performance and cutting results, and will potentially damage the system.

BG/CG GUNS ONLY: DAILY the condition of the end of the Ground Pin and its protrusion should be checked with the Ground Pin Setting Tool (P/N EDT0102) provided with the system. The ground pin is extremely fragile and an electrode should be attached at all times to protect the ground pin. The ground pin should not be bent and should be central inside the electrode, and it should still have its protective plastic sleeve intact. Adjust as necessary and dress with the abrasive pad located on the setting tool if the tip is fouled. Consult the User's Guide for further details.



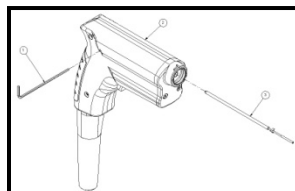
ALL GUNS: Check Cable, Strain Relief and Case for damage. Check for water leaks out of Case. Check Electrode is tight. When cutting **steel** fasteners: At the end of a work session the tip of the gun should be dried, and if it has been used on a highly corrosive fastener material such as alloy steel, then the inside of the tip area should be lightly sprayed with a lubricant such as WD40.



Ground Pin Replacement:

BG/CG GUNS ONLY: If the ground pin is maintained as above, and fastener heads are cleaned before attempting to cut, ground pin replacement is only necessary after several thousand cut operations.

Refer to the User Guide - Ground Pin Replacement section for detailed instruction on replacing the Ground Pin.



System Maintenance Screen:

System maintenance functions are accessed through the System Maintenance Screen. Touching an LED button will turn the button green (on) and activating the function. Retouching the button will turn the function off and the button back to red (off). The **Tank Full** and **Tank Empty** LED's display system water level status in the Sediment Tank and turn on and off automatically as the system is serviced.



DI water system maintenance:

The DI water system requires periodic filling or "Top Off" to replace small amounts of DI water used in the cutting cycle. The system will indicate when that is necessary. To "Top Off", Immerse the tip of the e•drill™ (do not submerge the entire drill, only the Adapter Tip should be submerged). Touch the **Top Off** function. At the completion of the Top Off cycle the Tank Full LED button will illuminate green when the system is full and the pump will turn off automatically.

The system will also indicate when the sediment tank should be emptied or the filter replaced. Consult the Users Guide for the relevant procedures.



For additional support assistance call the Customer Service Line at: (714) 891-6533.