



# Model: 631

Watts: 2500

Heat Stages: 18



## Output Voltages

Switch Position	<u>AB/Low</u>	<u>BC/Med</u>	<u>AC/High</u>
1	1.9	2.8	4.7
2	2.1	3.1	5.2
3	2.2	3.4	5.7
4	2.5	3.7	6.2
5	2.7	4.0	6.7
6	2.9	4.3	7.2

1. Choose one of three secondary circuits: AB/Low, BC/Medium, AC/High
  - It is recommended first using AB/Low—switch position '1'.
2. Fasten the electrode holder to either terminal of the selected circuit and the ground cord to the other terminal.
  - Double electrode holders do not require a ground cord.
3. Clamp the work piece with the ground clamp to complete the circuit.
  - Not necessary with double electrode holders.
  - It also possible to clamp or bolt the ground cord to a vise to ground the work piece while holding it.
4. Turn selector switch (and/or change secondary circuit) to gradually increase heat until desired result is achieved for the application.
  - For best performance keep the inside of electrode tubes clean with steel brush (part #'s: 775 & 785).

**To see our complete line of equipment:**

- *Etching*
- *Soldering*

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### Parts checklist:

- ((3) 3/8" Attachment Knob
- (1) Switch Knob

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