



# Model: 551-P

Watts: 900

Heat Stages: 15



## Output Voltages

Switch Position	<u>AB/Low</u>	<u>BC/Med</u>	<u>AC/High</u>
1	1.2	2.0	3.3
2	1.3	2.2	3.5
3	1.4	2.4	3.8
4	1.6	2.6	4.2
5	1.7	2.9	4.6

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).

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#### Parts checklist:

- (3) 3/8" Attachment Knob
- (1) Switch Knob
- (1) 1/8" Double Holder
- (1) #726 Plunger Rod
- (1) Spool of Solder
- (12) #326-1/8"x4" Electrodes

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