## DO'S AND DON'TS

| DO | DON'TS |
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| Use the proper electrode material for the job you are doing. | Never use unidentified electrodes or electrode materials. |
| Use standard electrodes wherever possible. | Avoid special, offset or irregular tips when the job can be done with a standard straight tip. |
| Use the most suitable tip diameter for the thickness of stock being welded. | Don't use small tips on heavy gauge welding jobs or large tips on small work. |
| Use open sight drains to observe more readily the water flow through the holders. | Don't forget to turn on the cooling water full force before starting to weld. |
| Connect the water inlet hose to the proper holder inlet so that the water flows through the center cooling tube first. | Never use water hose that will not fit the holder water connection nipples snugly. |
| Internally cool the spot welding tips with cool water flowing at a rate of at least ½ gallons per minute through each tip. | Do not allow water connections to become leaky, clogged or broken. |
| Be sure the internal water cooling tube of the holder projects into the tip water hole to within ¼'' of the tip hole bottom. | Avoid using holders with leaking or deformed tapers. |
| Adjust the internal water cooling tube of the holder to the proper height when changing to a different length tip. | Never use electrode holders that do not have an adjustable internal water cooling tube. |
| Be sure top of adjustable water cooling tube in holders is cut at an angle so as to avoid jamming tip down and shutting water off. | Do not permit adjustable water tube to be "frozen" by accumulation of deposits. A few drops of oil periodically will keep the tube free. |
| Place a thin film of our copper paste (PC968) on the tip taper prior to inserting in the holder, to make it easier to remove. | Do not allow electrodes to remain idle in tapered holder seats for extended periods. |
| Use ejector type holders for easy removal of tips and to avoid damage to tips tapers. | Don't use pipe wrenches or similar tools in removing electrodes. |
| Keep the tip taper and holder taper clean, smooth and free of foreign deposits. | Avoid using white lead or similar compounds to seal a leaking taper. |
| Dress spot welding electrodes frequently enough to maintain the quality of the welds. | Never permit a spot welding top to mushroom enough to make dressing difficult. |
| Dress electrodes in a lathe to their original contour whenever possible. | Never dress electrodes with a coarse file. |
| Use a rawhide or rubber mallet for striking holder or tips in aligning operations. | Don't pound on the holder or tip with a steel hammer in aligning the welder arms. |
| Provide flood cooling on both sides of the seam welding wheel. | Avoid the use of seam welder wheels too thin to stand the heat or pressure of your job. |
| Use properly designed knurling wheels to maintain proper seam welding wheel shape. | Do not permit seam welding wheel to run off the corners of the work being welded. |