












# CR200

# OPERATION CONTROLS

## ALUMINUM

		Current (A) 	Time (ms) 
	Keys	130 - 140	20 - 30
	Pins	150 - 160	50 - 70
	4mm Stud	150 - 160	50 - 80
	5mm Stud	160 - 170	75 - 110
	6mm Stud	170 - 180	100 - 140

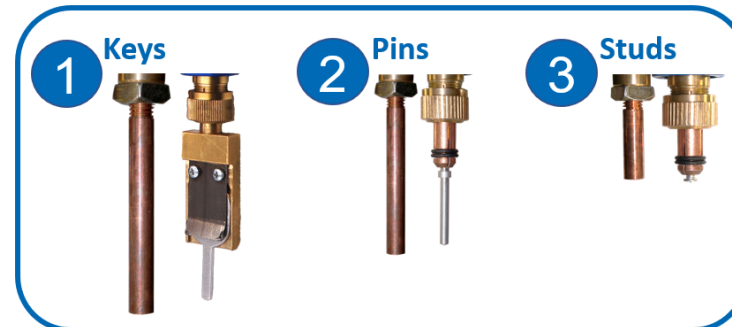
## STEEL

		Current (A) 	Time (ms) 
	Keys	120 - 130	20 - 30
	4mm Stud	140 - 150	40 - 50



## Grounding Rods

Grounding Rod Size	For Use With...
4.25" / 108 mm	1 Keys
3" / 77 mm	2 Pins
1.9" / 48 mm	3 Studs



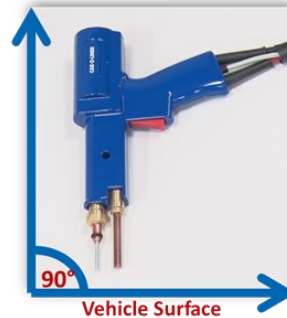
# CR200

# REFERENCE GUIDE

A 90° Angle and a 2mm Gap is required for a proper weld  
(when lifting the key electrode or pin/stud mandrel)



Do you know how much 2 mm is?  
1 dime = 1 mm thick  
2 dimes = 2 mm thick



It is critical to hold the Gun vertically straight at a 90° Angle to the surface of the vehicle to ensure that the 2 mm gap is maintained when the grounding rod is adjusted.

