SafeTac GPSS setup & use

- 1. Ensure power is turned off.
- 2. Connect leads marked input Positive & input Negative to welding machine terminals positive to positive, negative to negative.
- 3. Connect work lead to lead marked output Negative& electrode holder (Stinger) to lead marked output Positive.
- 4. Start machine Safe indicators on VRD should be Green.
- 5. When welding or striking an arc the Danger indicators will turn on and flash to indicate a high voltage is present at the output of theVRD.
- 6. When welding is finished or the resistance across the electrode holder & work clamp increase to above 200 Ohms the VRD will turn on (Green Safe).

Note: Because the output voltage of the VRD is approximately 12 Volts rather than full OCV (Around 60 to 80 Volts) it may be slightly harder to establish an arc, this can be improved by ensuring leads are well maintained and work piece is clean prior to commencing welding.

Also if the flux of the electrode prevents the metal rod from contacting the work piece it will be hard to establish an arc, this can be overcome by twisting the electrode to remove a small amount of the flux to allow better contact between the electrode and the work piece

LED indication is as follows

- 1. Green (Safe) output of VRD is less than 35 VDC typically around 12 VDC.
- 2. Red or flashing RED (Danger) output of VRD is above 35 VDC typically around 60 to 80 VDC.
- 3. Later model SafeTac VRD units are microprocessor controlled; the indicators work as above but have extra functions
- 4. 1. If the output of the VRD fails to reduce to below 35 VDC when the output resistance increases to above 200 Ohms the RED indicators will turn on solid, after 2 seconds the indicators will flash from green to red alternately and the internal alarm will sound.
- 5. 2. The VRD turn on time can be software programmed to a longer period if required for difficult situations.

