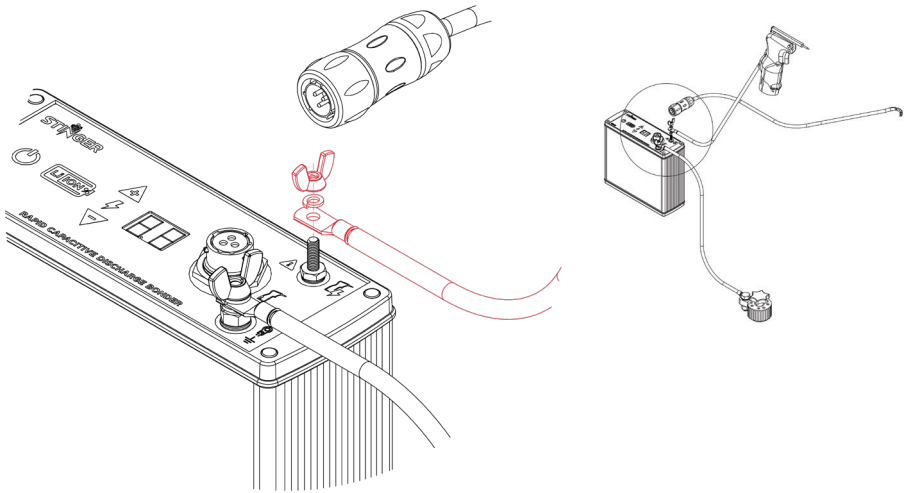


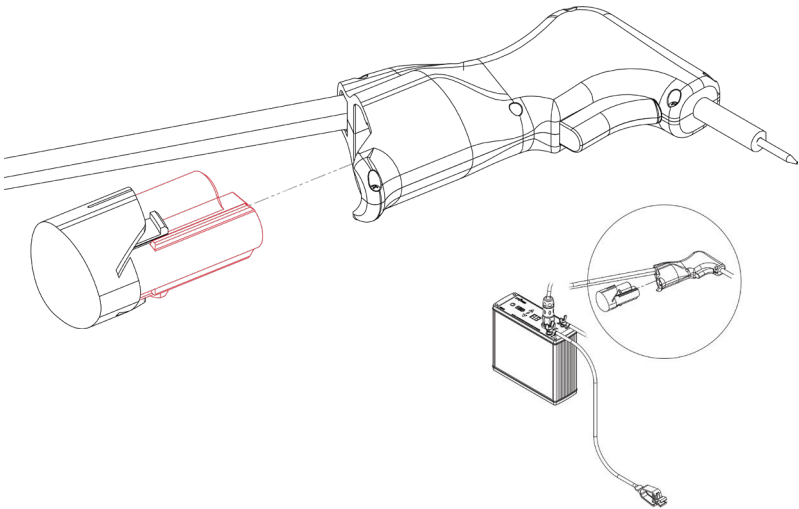
SCAN TO VISIT
THE S100 PAGE

For the complete S100 manual go to:
<https://bditest.com/S100-Manual>

1. Connect the lug on the red cable from the bonder handle to the smaller terminal. Then install and hand-tighten the wing nut again. Do not over tighten.
2. Line up the 3-pin connector from the handle with the receptacle on the panel. Twist the barrel of the connector to secure it.
3. Use either cable with the magnetic clamp or the mechanical clamp. Connect clamp to bare, clean steel. To activate the magnetic clamp, place it on a bare, clean steel surface then turn the switch to ON.



4. Insert the battery pack into the handle in the orientation shown in the drawing below until the pack snaps into place. Charge the battery pack before use.



STANDARD S100 KIT

S100 Stinger™ Spot Bonder

Bonding Handle and 5 ft Cables

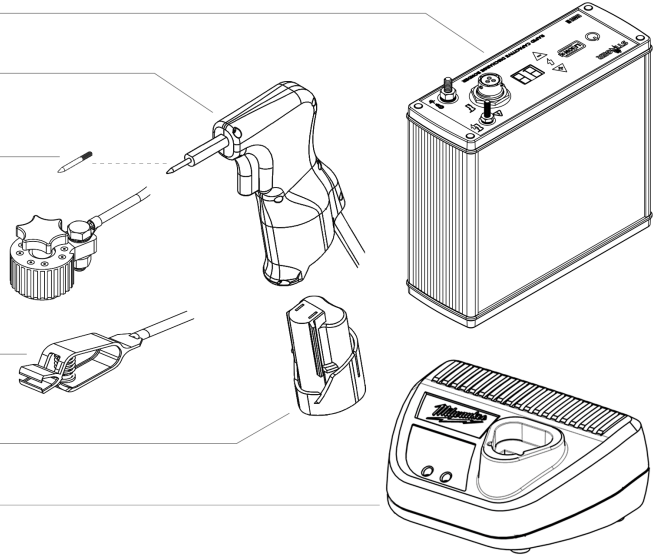
1x Straight Bonding Tip

Magnetic Grounding Clamp
With 5 ft Cable

Mechanical Grounding Clamp
With 5 ft Cable

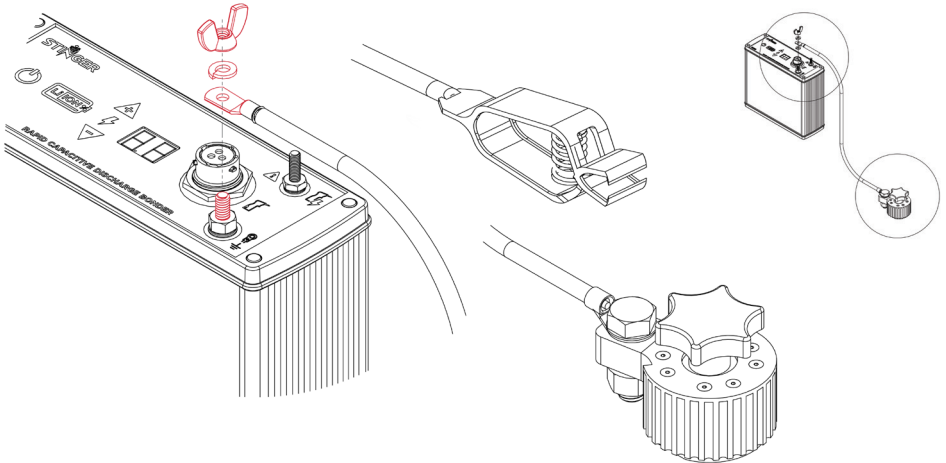
1x Milwaukee® M12™
REDLITHIUM™ 3.0 Battery

Milwaukee® M12™ Lithium-Ion
Battery Charger



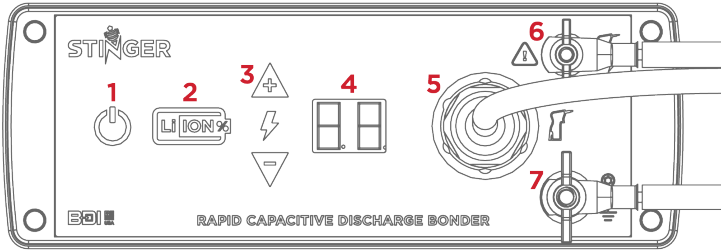
INITIAL SETUP

1. Connect the black ground cable lug to larger stud on Stinger™ top panel. Thread on the 1/4-20 wing nut for a firm hand-tight.



* M12 and REDLITHIUM are registered trademarks to the Milwaukee Electric Tool Corporation.

OVERVIEW (SWITCH PANEL)



CONTROLS		CONNECTORS	
1	POWER BUTTON	5	3-PIN CONTROL CABLE
2	LI-ION BATTERY BUTTON	6	POSITIVE ELECTRODE LEAD
3	BOND INTENSITY CONTROLS	7	GROUND TERMINAL
4	DISPLAY		

START BONDING!

1. Power on by pressing the Power button momentarily (no. 1 in the table above).
2. Check battery charge level by pressing the Li-Ion Battery button (no. 2 in the table above).
3. Set bonding energy to 35 joules. **See Operations Manual** for details on adjusting the settings and verifying bond quality.
4. Make sure ground clamp is on a bare, clean spot of steel, near work area.
5. Firmly press bonding tip to the sensor's bonding shim. Double check the sensor is in correct position.
6. Squeeze trigger to create a spot-bond. **See Operations Manual** for additional details on verifying the strength of a spot-bond.
7. Move tip to next location in bonding pattern and repeat step 5 through 6.
8. When finished, press the Power button to turn off.

COMMON ERROR MESSAGES

ERROR	CAUSE	SOLUTION
bA Lo	Very low battery	<ul style="list-style-type: none"> - Check battery charge level - Change to battery with full charge - If ambient temperature is cold, make sure the battery itself is warm
rE	Resistance error	<ul style="list-style-type: none"> - Bonding resistance greater than 1 ohm - Ensure all connections are properly made and tight - Check all wingnuts and cables - Ensure proper surface prep at gage location - Ensure proper contact between the bonder-to-gage and gage-to-specimen - Place the discharge tip firmly in contact with the material to be bonded before pressing the trigger

REFER TO THE S100 STINGER™ OPERATIONS MANUAL ON OUR WEBSITE AT:

[HTTPS://BDITEST.COM/S100-STINGER-MANUAL](https://bditest.com/s100-stinger-manual)

TO LEARN MORE ABOUT THE S100 AND FOR WARRANTY INFORMATION, WARNINGS AND PRECAUTIONS, AND DETAILED INSTRUCTIONS ON HOW TO OPERATE IT.

THE S100 STINGER™ IS MANUFACTURED BY BDI | MADE IN THE USA

FOR SUPPORT:

Email: support@bditest.com

Or call: +1.303.494.3230