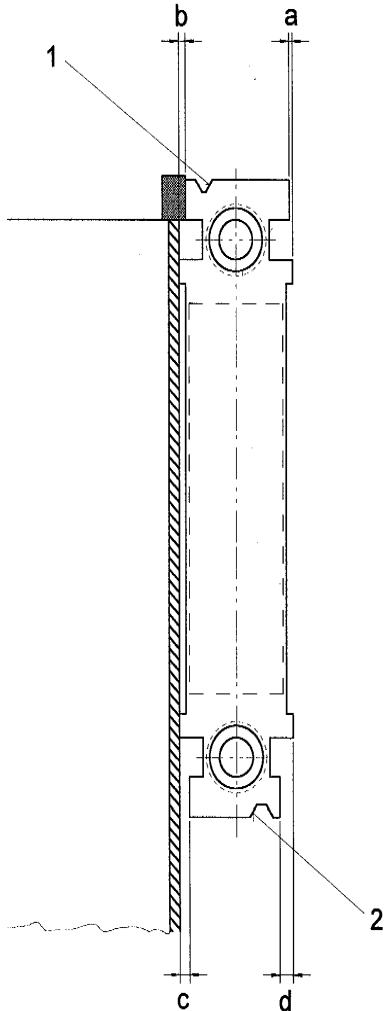


Instruction Manual

How to use SFM Magnet-Holder-Device



Please **avoid** contact with metal-particals and **hard shocks**. If necessary refine device with compressed air.

Place holder in right-angled position against the brazing-joint. Small disalignments will be automaticly corrected.

4 standoff-dimensions

Typ A, D, DF: (a=0,5; b=0,75; c=1,0; d=1,25mm)

Typ DK, DKF: (a=0,25; b=0,5; c=0,75; d=1,0 mm)

are marked by different sizes of notches (see fig. 1, 2).

For cooling purpose remove the holder device only by tool after the brazing prozess and place it onto a clean surface sheetmetal. Important: Please wait 3 Minutes before cooling fixtures in water.

How to exchange the springs (Type DF, DKF) :

Before exchanging the springs a total refining by compressed air is required. Note, that smallest metal particles between magnet and metal side plates will destroy the magnet.

Turn a wide screwdriver between the parallel side plates for seperating the parts. Exchange the springs and beware to the orientation of side plates (see size of notches).

Notice:

Strong magnetic fields can effect or destroy electronic- , mechanic- or data storage-devices. This can also effect electronic heartbeat support. A safety distance is required, please handle as prescribed of specivic instruction manuals.

Prevent the magnet-holder-device for direct access to the autogenous flame! Place the holder behind the core bit and cutting segment to the opposite side of flame.

SFM Magnet Holder Devices are only recommended for fixing cutting segments during brazing process. All other usage is not as declared.

We cannot accept liability for the caused damage if the above instructions will be ignored.