

PinBrazing Tips

For repeatable perfect connections



Safetrack Baavhammar AB

The world leader in cable bonding technology for
Railways, Grounding & Cathodic Protection Industry

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IMPORTANT

Reading and applying the tips in this brochure will
result in optimal & reliable cable connections!



The Brazing Principle

1. Pull the trigger and the brazing pin lifts 2 mm



2. Flux powder cleans the brazing area



3. Silver alloy melts and flows forward by the capillary force



The optimal brazing position

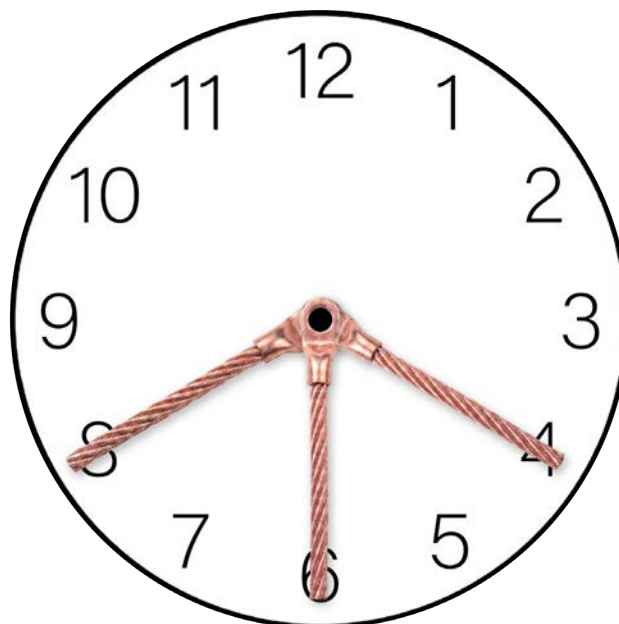


Braze in top
of the hole.



Hold the gun steady
with both hands.

Recommended brazing position: cable at 6 o'clock.
Acceptable brazing positions: between 4 and 8 o'clock.



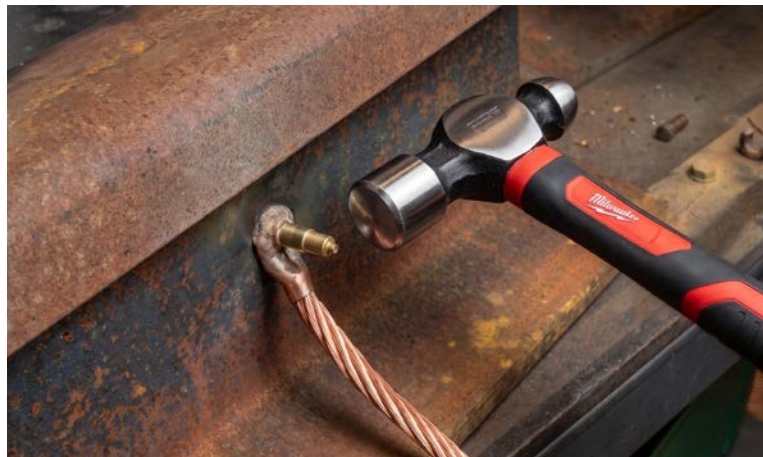
After finished PinBrazing



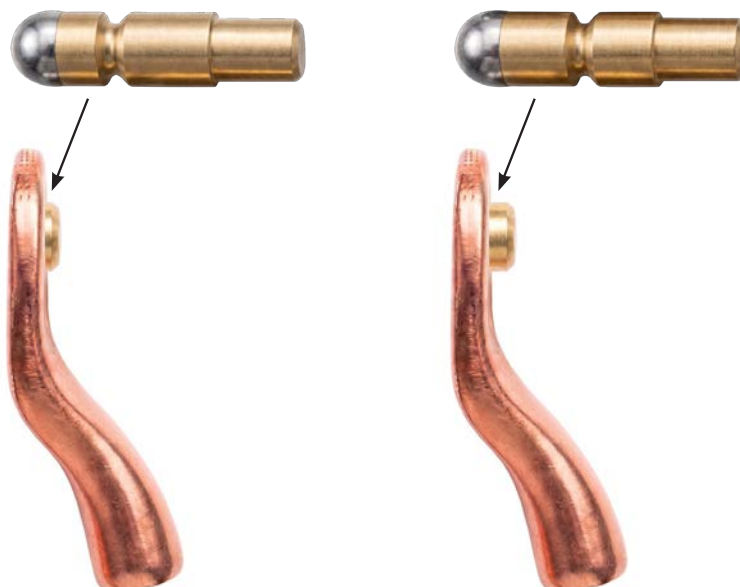
When brazing is finished, wait 3 seconds and then pull the gun straight backwards without pulling the trigger.



When knocking off the shaft of the brazing pin...



...remember that the X-silver brazing pin will always leave a higher pin stub.



Usage of materials

Keep grinding stones free from oil, grease, glue, paint etc.



Ensure the connection area is free from galvanization, paint, rust, oil and other contaminants before brazing.

Materials storage

Keep connectors, cable lugs, brazing pins and ceramic ferrules free from moist, oil, grease, glue, paint, dirt etc.



Correct equipment & materials

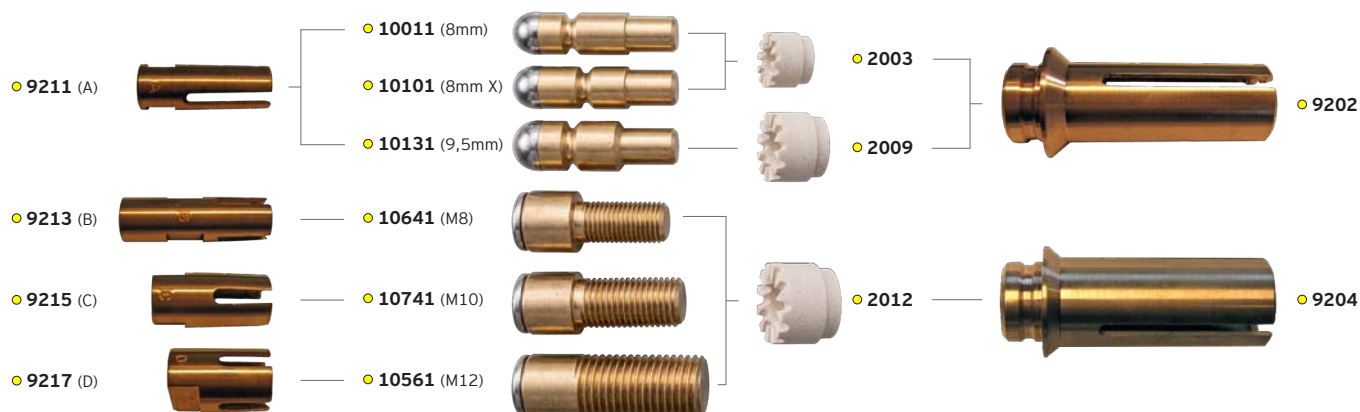


For safety and long-term reliability:

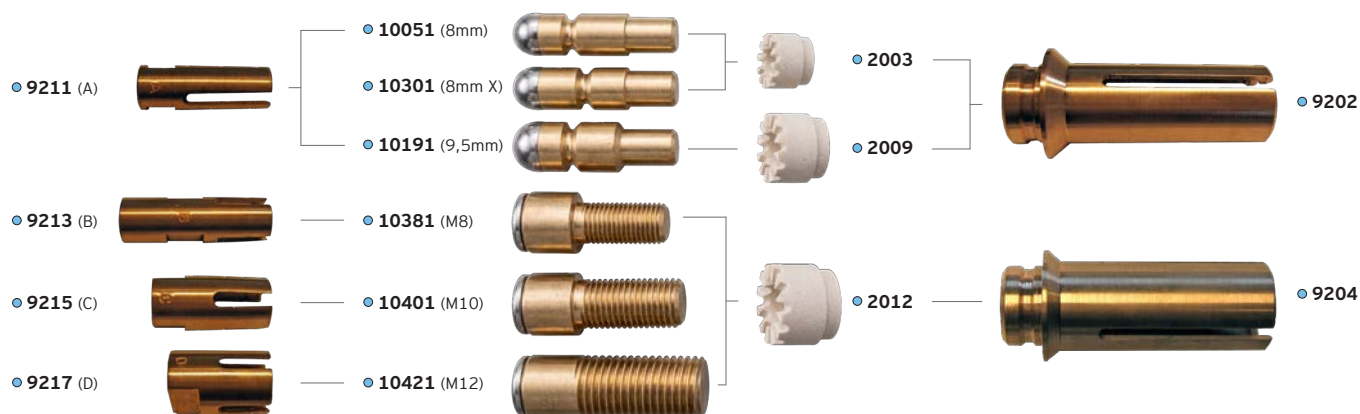
Make sure to always use original Safetrack® equipment and materials



Railway material matrix



Cathodic Protection material matrix



Step by step instructions



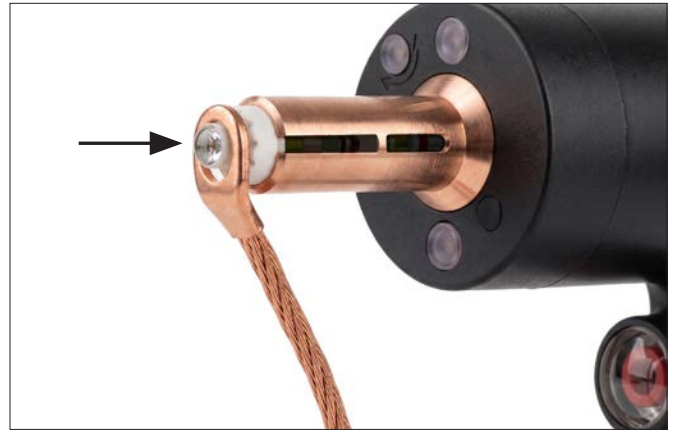
1. Grind the grounding area.



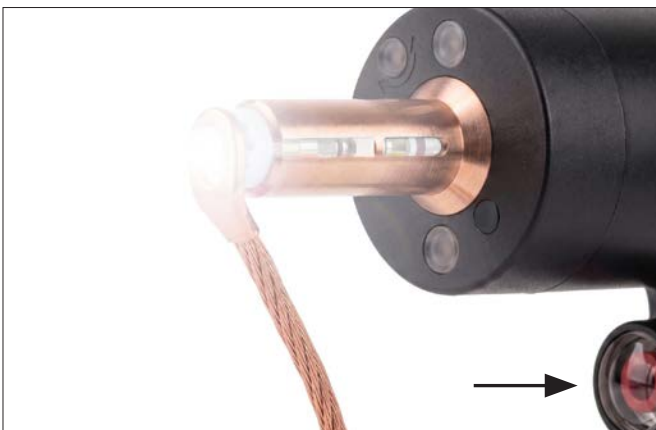
2. Grind the brazing area.



3. Prepare the materials and load the gun with the pin & ferrule.



4. Make sure to position the pin in the top of the hole of the cable lug.



5. Pull the trigger and the brazing will finish automatically.



6. After finished brazing, wait 3 seconds and pull the gun straight back without pulling the trigger.

Instructions continued + videos



7. After the brazing has cooled, knock the shank off with a hammer.



8. PinBrazing complete!
Reliable cable connection achieved!

Youtube PinBrazing videos



[Railway Cable Connection instructions](#)

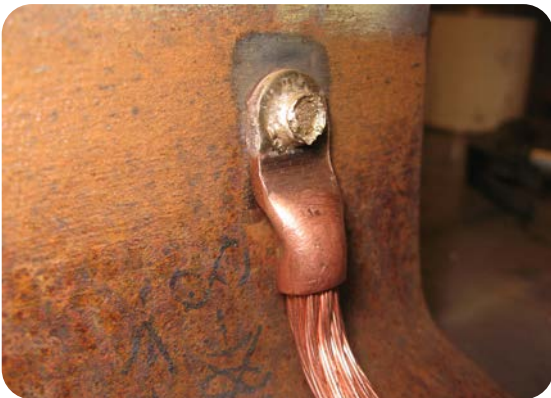


[Pipeline Cable Connection instructions](#)



[PinBrazing videos playlist](#)

Installation examples



PinBrazing tips videos



S30 X/C Troubleshooting guide



How to replace a pin holder



PinBrazing examples worldwide



Safetrack Youtube channel