

# **BOLT BUSTER®**

## HEAT INDUCTION TOOL

### **READ ME FIRST !!!**

1. Insert work coil on top of the aluminum heat sink and tighten down with thumbscrews. **IMPORTANT** Tighten Thumbscrews and make sure no loose electrical connection exists between the work coils and main inverter. An intermittent connection will affect performance and can cause excessive connector heat which will damage the unit.
2. Use the proper diameter work coil to match the work piece (nut/bolt). A loose slip-fit over the nut/bolt is best. Try to fit the nut and bolt into the work coil (1/8" gap). The nut and bolt can touch the fiber glass insulation as well, but do not force the coil over nut or bolt, use a larger coil
3. Use the 23 " BBC-FLEX23 wire provided, to make a custom work coil, if you need a special size. Clamp a socket/bolt with a vise - use as a mandrel and bend the wire around it with a minimum of the 3 turns to the desired diameter. A loose slip fit is best. Never force a nut/bolt into a too small coil. This will damage the coil insulation
4. The work coil is protected with fiberglass insulation. If frayed the work coil will ground and cause sparks. **CAUTION** Sparks may ignite flammable liquids, i.e GAS. When sparks are seen , use a new coil to prevent damage to the bolt buster unit
5. Press switch to activate unit and hold over work piece typically 10 – 15 seconds for a 5/8" head bolt. For Larger bolts allow more time. Typical heat time for a 1" diameter bolt should heat dull red in under a minute
6. You do not need to heat the bolt/nut orange red hot (> 1200 F). Apply enough heat for the application which is typically 1,000 – 1200F. **STOP** Heating when dull red is first seen, then apply wrench quickly. **IF IT TAKES OVER 15-25 SECONDS TO HEAT A SMALL 1/2" - 5/8" DULL RED, STOP! MAKE SURE THUMB SCREWS ARE TIGHT AND COIL IS NOT TOO BIG FOR THE BOLT HEAD**
7. There is a Duty Cycle of 2 Minutes (ON) and 2 Minutes (OFF). This gives the internal circuitry time to cool down and will prevent damage to the unit. **IF THE UNIT STOPS WORKING, WAIT 4-6 MINS FOR INTERNAL THERMO PROTECTOR TO COOL**
8. The unit when plugged in will get warm; this is normal and helps dry any moisture in the unit. Do not operate without work coil attached. When not in use store in cool and dry area
9. Use only heavy duty extension cords with the following rating. (25 foot length - 14 AWG, 50 Foot length - 12 AWG) with three prong grounded plug. Using thin and frayed extension cords will limit the current flow to the unit which in turn will limit the amount of power and performance
10. Periodic maintenance (10+ hours of use), check and tighten set screws located below thumbscrews on the aluminum heat sink. This ensures a secure electrical connection to the transformer wires. Do not use extreme torque when tightening the set screws
11. **READ OWNERS MANUAL** for all safety and warning instructions. Included with Kit