



## Digital Hydraulic Weld Force Gauge

### *Operator's Manual*



**WARNING: Always Turn Off Current When Using Gauge**

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[Tuffaloy.com](http://Tuffaloy.com)

## **On-Off**

To turn the gauge on, press the power button. The backlight will stay on for 10 seconds.

**Note:** The gauge will automatically turn off after 1 minute of inactivity.

To turn the gauge off, press and hold the power button for 2 seconds.

## **Backlight**

While the gauge is on, press the power button to turn the backlight on for 10 seconds.

**Note:** The backlight will automatically turn on whenever pressure changes +/- 10% of scale.

## **Unit Selection**

While the gauge is on, press the menu button to cycle through the different units available.

**Note:** The gauge can display in psi, bar, kgf/cm, MPa, and atm.

**Note:** It is recommended to use the PSI units. **1 PSI is equal to 1 lbf.**

## **Zero Reset**

While the gauge is on, press and hold the menu button for 5 seconds and release.

## **Power Mode**

While the gauge is on, press and hold the menu button until the screen displays "OFF=0".

Press the power button to select "0" or "1".

OFF=0: Auto shutoff mode. The gauge will automatically turn off after 1 minute of inactivity.

OFF=1: Manual shutoff mode. The gauge will remain on until manually turned off.

Press the menu button twice to return to the force display screen.

## **Force Display Mode**

While the gauge is on, press and hold the menu button until the screen displays "OFF=0".

Press the menu button again and the screen will display "HL=0".

Press the power button to select "0" or "1".

HL=0: Actual display mode. The screen will display the actual and continuous force reading.

HL=1: Peak display mode. The screen will only display the peak force reading.

Press the menu button to return to the force display screen.

## **Battery Replacement (Figure 1)**

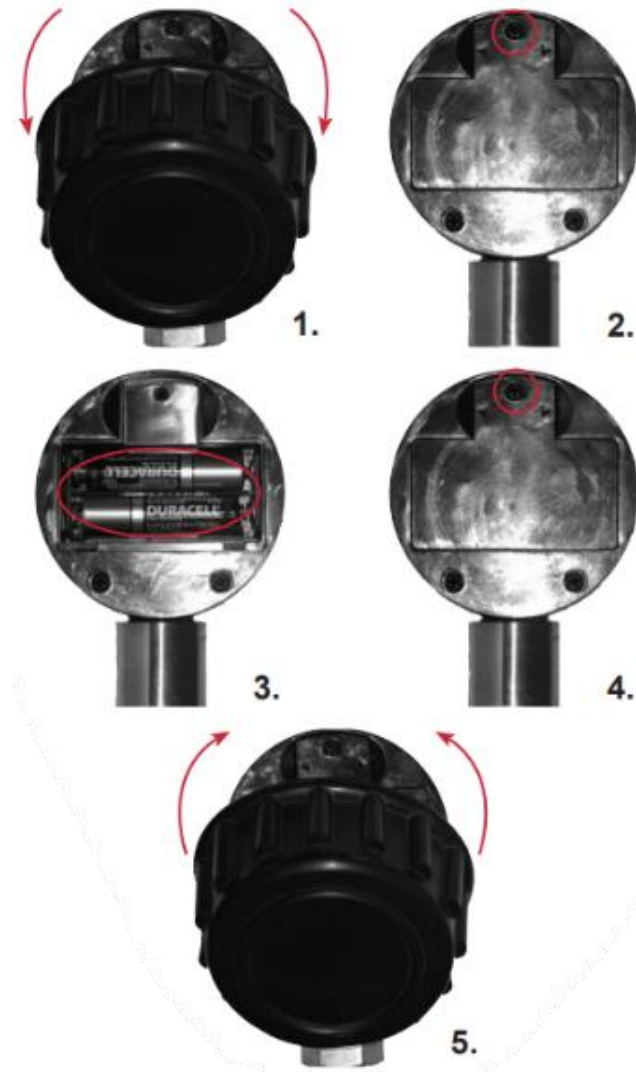
1. Remove the rubber boot to reveal the battery cover.
  - a. **Note:** Do not unscrew the gauge head from the gauge body.
2. Remove the top Phillips screw and open the battery cover.
3. Remove and replace the old batteries with 2 AAA batteries.
4. Close the battery cover and re-install the top Phillips screw.
5. Re-install the rubber boot onto the gauge head.

## **Re-Certification**

All units are factory calibrated and certified prior to shipment and should be returned to the factory for annual re-certification. Please contact the distributor the unit was purchased from for re-certification instructions.

## **Repairs**

If the unit is damaged, please contact the distributor the unit was purchased from and have them send the unit back to Tuffaloy for repair estimate.



*Figure 1: Battery Replacement Procedure*