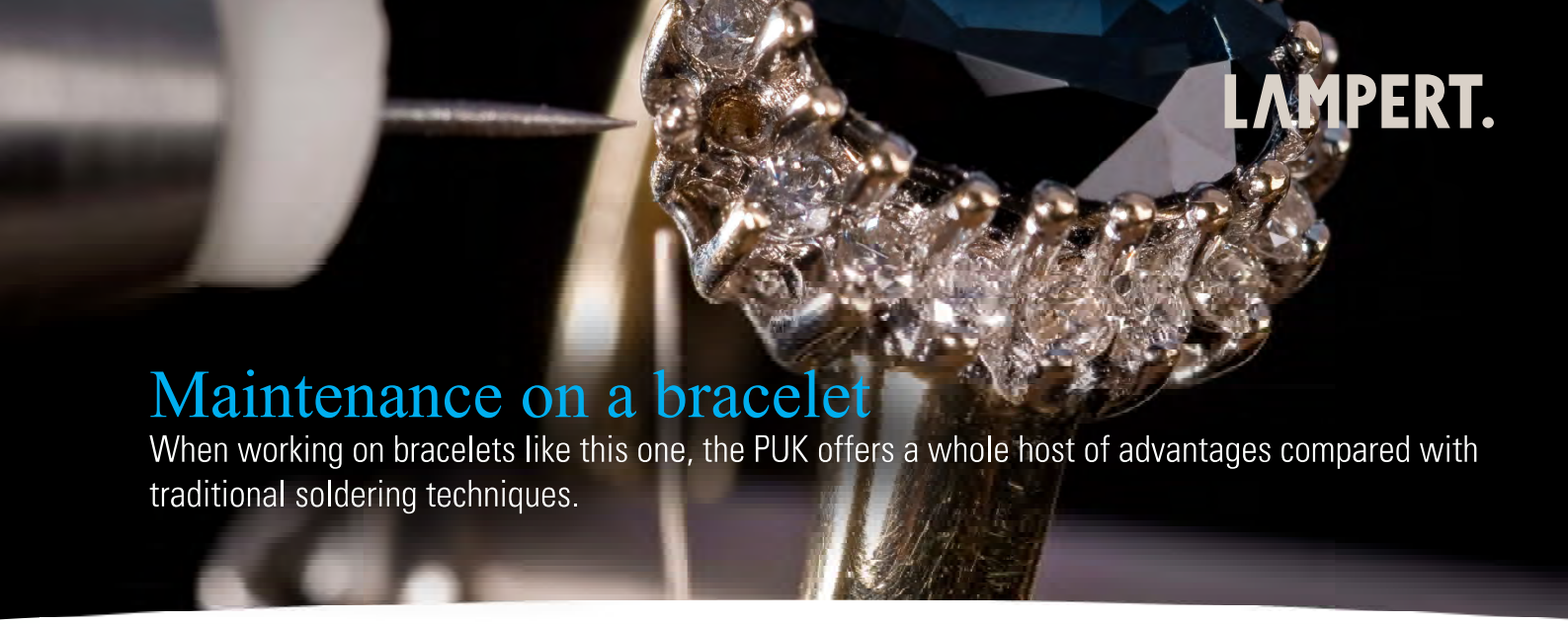


Maintenance on a bracelet

When working on bracelets like this one, the PUK offers a whole host of advantages compared with traditional soldering techniques.

1. Shortening: Preparation

The links are cut open with an as thin a saw blade as possible. This is to make it as easy as possible to weld them closed again later.

2. Shortening: Welding

Before starting to weld, the link has to be bent into position so that it closes well; there should not be any gap between the two ends. To ensure a good result the link can be held in place using a pair of pliers or tweezers. Hereby, the link is positioned in such a way that the two ends press lightly against each other during welding.

3. Shortening: The settings

Providing an appropriate power setting is chosen, it should be sufficient to place just a few welding spots. In this case we are working on 14k, with 0,55mm thickness:

PUK 3 and PUK 3s:	Micro-Mode,	Impulse duration: 6ms,	Power: 18 %
PUK04:		Impulse duration: 6ms,	Power: 18 %

4. Replacing a link: Preparation

In this example, one of the links has been soldered stiff and must be replaced. The remains of the wire are carefully drilled out so that a new eyelet can be fitted in.

5. Replacing a link: New eyelet

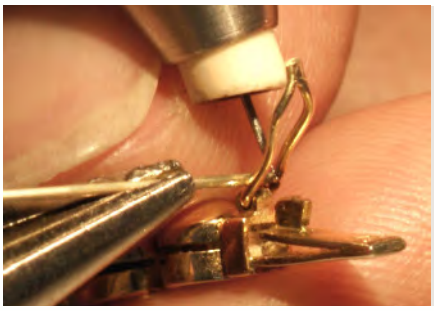
Here an appropriate wire is bent into a long U-shape and fitted into place.

6. Replacing a link: More welds

The long ends of the eyelet can now be easily welded one after the other.
The settings are as before:

PUK 3 and PUK 3s:	Micro-Mode,	Impulse duration: 6ms,	Power: 18 %
PUK04:		Impulse duration: 6ms,	Power: 18 %

7. Locking: Another little job



As an additional service, a small stay is welded into the locking clip of the latch; this will stop it from twisting. Again using the same settings.

8. Locking: A clean job

Again using an appropriate wire, the wire is first attached to one side using a few welding spots. Next, the wire is cut to length and welded on the other side to fix it in place.

9. Finished

The job is completed, and the cleaning up necessary has been kept to a minimum.