



DO THE JOB RIGHT.®

Item #54820

# SHEET METAL PLUG KIT

## INSTRUCTIONS

The **EASTWOOD SHEET METAL PLUG KIT** includes 10 each of needed pre-punched 18 Gauge round steel plugs in  $\emptyset 0.75$ ",  $\emptyset 1.00$ " and  $\emptyset 1.38$ " sizes as well as an industrial quality, Step Drill for creating matched holes. Precision die-punched plugs deliver accuracy and consistency for fill-in welding with every piece.

### CONTENTS

- (10)  $\emptyset 0.75$ " Plugs
- (10)  $\emptyset 1.38$ " Plugs
- (10)  $\emptyset 1.00$ " Plugs
- (1) Titanium Coated, Step Drill



### READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.

Welding emits a powerful high voltage and extreme heat which can cause severe burns, electrical shock and death.

### IMPORTANT NOTE:

Welding can be dangerous to you and other persons in the work area. Injury or death can occur if safe welding practices are not followed. Safety information is set forth below and throughout this manual. Save these instructions for future reference.

To learn more about welding safety, read OSHA Title 29 CFR 1910, available at [www.osha.gov](http://www.osha.gov); ANSI Z49.1, "Safety in Welding, Cutting and Allied Processes," available at [www.aws.org](http://www.aws.org); and the consumable manufacturer's Safety Data Sheets.

### PREP

Plugs are coated with a rust-proofing agent. Clean thoroughly with Eastwood #10041Z, PRE Cleaning Prep or equivalent before welding.

### USE

- Carefully drill out a hole matching the desired Plug using the Included Step Drill.
- Support the Plug with a welding magnet or other suitable means.
- For best results and to avoid weld-draw, resulting in distortion or twisting during construction, the Plugs should first be tack welded in place, allowed to cool, then finish welded.

### REPLACEMENT PLUGS

- #54821 Eastwood .75 Inch Replacement Sheet Metal Plugs (10 Pack)
- #54822 Eastwood 1 Inch Replacement Sheet Metal Plugs (10 Pack)
- #54823 Eastwood 1.38 Inch Replacement Sheet Metal Plugs (10 Pack)

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: [tech@eastwood.com](mailto:tech@eastwood.com)

PDF version of this manual is available at [eastwood.com](http://eastwood.com)

The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA  
800.343.9353 [eastwood.com](http://eastwood.com)

## SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

### DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

### WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

### CAUTION

CAUTION indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

### NOTICE

NOTICE is used to address practices not related to personal injury.



#### READ INSTRUCTIONS

- Thoroughly read and understand this manual before using.
- Save for future reference.



#### DANGER ELECTRIC SHOCK HAZARD!

- Improper use of an electric Welder can cause electric shock, injury, and death! Read all precautions described in the specific Welder Manual to reduce the possibility of electric shock.
- Disconnect welder from power supply before assembly, disassembly, or maintenance of welder or components.
- Always wear dry, protective clothing and leather welding gloves and insulated footwear. Use suitable clothing made from durable flame-resistant material to protect your skin.
- If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks.
- Always operate welders in a clean, dry, well ventilated area. Do not operate a welder in humid, wet, rainy or poorly ventilated areas.
- The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with bare skin or wet clothing.
- Stay separated from the welding circuit by using insulating mats to prevent contact from the work surface.
- Be sure that the work piece is properly supported and grounded prior to beginning an electric welding operation.



#### DANGER FIRE OR EXPLOSION HAZARD!

- Welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials.  
**DO NOT** operate Welder in areas where flammable or explosive vapors are present.  
**DO NOT** use near combustible surfaces. Remove all flammable items from the work area where welding sparks can reach (minimum of 35 feet).
- Always keep a fire extinguisher nearby while welding.
- Use welding blankets to protect any flammable surfaces.



#### WARNING ELECTROMAGNETIC HEALTH HAZARD!

- The electromagnetic field that is generated during arc welding may interfere with various electrical and electronic devices such as cardiac pacemakers. Anyone using such devices should consult with their physician prior to performing any electric welding operations.
- Exposure to electromagnetic fields while welding may have other health effects which are not known.



#### WARNING ARC RAYS CAN INJURE EYES AND BURN!

- Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).
- Use suitable clothing made from durable flame-resistant material for skin protection.
- If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks and arc rays.



#### WARNING HEALTH HAZARD!

- Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation.
- Prolonged inhalation of welding fumes above safety exposure limits can injure the lungs and other organs.
- Use enough ventilation and/or exhaust at the arc to keep fumes and gases from the immediate working area.
- Use an OSHA approved respirator when welding in confined spaces or where there is inadequate ventilation.



#### CAUTION BURN HAZARD!

- Welding heats metal and tools to temperatures that will cause severe burns!
- Use protective, heat resistant gloves and clothing when using Eastwood or any other welding equipment. Never touch welded work surface, gun tip or nozzle until they have completely cooled.



#### CAUTION INJURY HAZARD!

- Grinding and sanding will eject metal chips, dust, debris, and sparks at high velocity. To prevent eye injury wear approved safety glasses.
- Wear an OSHA-approved respirator when grinding or sanding.
- Read all manuals included with specific grinders, sanders or other power tools used before and after the welding process. Be aware of all power tool safety warnings.



#### CAUTION CUT HAZARD!

- Handling sharp metal can cause serious cuts. Wear thick, well-fitting work gloves to prevent cuts from handling sharp metal.



#### CAUTION

- For aesthetic sheet steel repair use only. Not for structural use. Not for pressure vessel use.