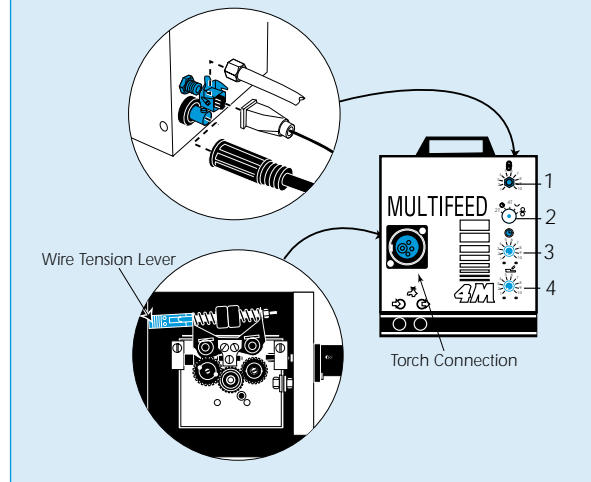


Wire Feed Unit



Controls on the front of the unit are:

1. Wire Speed Switch;
2. Control knob (5 positions) – No. 1 2-T = 2 touch, standard; No. 2 Timer; No. 3 4-T = 4 touch, latch-type welding; No. 4 Gas Purge and No. 5 Wire inch control.
3. Timer (seconds).
4. Burn-back control.

WHATEVER you are using...

Clip the earth clamp to the work, as close to the proposed weld as possible to ensure good electrical contact and **switch the unit ON**.

BASIC TECHNIQUES

If using a WIRE FEED UNIT...

Turn on the gas supply at the cylinder and open the gas regulator to give a flow rate to suit the wire speed (the regulator is graduated in litres per hour).

Expose about 25mm of wire before striking an arc. Once the arc is struck, continue triggering the gun until you have finished.

ARC AIR GOUGING TORCH...

Depress the air control switch on the torch to allow a flow of air from the compressor.

Once the arc is struck you may proceed to gouge. When you have finished, simply close off the air control switch and isolate the torch from the work.

WHATEVER you are using...

Note that recommended settings are merely guides. Changing them slightly may give better results. So, **always make a test weld**.

EQUIPMENT CARE

Never push the equipment beyond its design limits. If it will not do what you want with reasonable ease, assume you have the wrong tool for the job. Ask at your local HSS Hire Shop for advice.

When not in use, store the equipment somewhere clean, dry and safe from thieves.

If using a WIRE FEED UNIT...

Keep the welding gun's tip clean. If necessary, remove the tip and scrape off any slag build-up.

Turn off the gas cylinder if leaving the unit unattended to reduce wasteful leaks.

Replace the drum of wire as soon as it runs out – switch **OFF** the unit and turn **off** the gas supply first.

FINISHING OFF

WHATEVER you are using...

Switch OFF and unplug the unit. Leave everything to cool then take the earth clamp off the work.

Finally, neatly coil all leads and hoses, ready for return to your local HSS Hire shop.



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HSS Hire Shops



Welder-Gen. Accessories

Arc Air Gouging Torch

Parallel Weld Box

Wire Feed Unit



Code 55919-55939-55929

GENERAL SAFETY

For advice on the safety and suitability of this equipment contact your local HSS Hire Shop.

Keep children, animals and all others out of the work area.

Never use this equipment if you are ill, feeling tired, or under the influence of alcohol or drugs.

These accessories should only be used by a competent person who has read and understood these instructions.

Warning

If you are wearing an electronic life support device (a heart Pacemaker) you must consult your doctor before going near or working with this equipment. Magnetic fields associated with high currents may affect these devices.

Never wear contact lenses when operating these machines.

Check the equipment before use, if it shows signs of damage or excessive wear, return it.



Note that this equipment may generate potentially harmful noise levels. To comply with Health and Safety at Work regulations, ear defenders must be worn by everyone in the vicinity.



A suitable welding mask must be worn by any person operating this equipment.



Skin must be covered – protective clothing, footwear and gauntlets must be worn.



A head shield with an 11 EW shade MUST be worn by anyone in the work area – goggles are not suitable.

If the headshield or lens becomes damaged, return it to your local HSS Hire Shop.

Never use welding equipment near any combustible gases or materials.

Ensure work area is tidy, well lit and ventilated.

Let It Cool

Handle welding equipment and work with care – it will be hot. Leave equipment to cool before changing welding rods, moving earth clamps, and so on.

A fume extractor or smoke eliminator should be used in the work area.

Never use welding equipment near computers or any sensitive electronic equipment.

Always transport, store and operate the machine in an upright position.

Keep the power unit's air vents clear of all obstructions.

Always switch equipment OFF before making any adjustments to it. Never leave it switched ON and unattended.

ELECTRICAL SAFETY

The Wire Feed Unit must only be powered from a 110V supply via the welder-generator.

Keep flexes and leads out of harms way. Never run them through water, over sharp edges, or where they could trip someone.

If the equipment fails, or if its leads or plugs become damaged, return it. Do not attempt to repair it yourself.

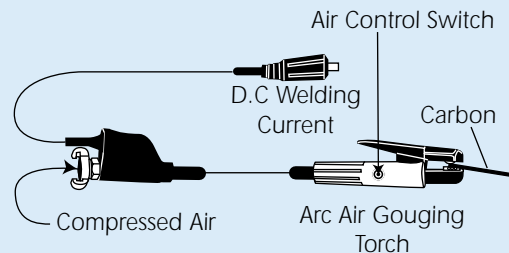
Using electrical equipment in very damp or wet conditions can be dangerous.

GETTING STARTED

Ensure the workpiece is clean, dry and free from rust, paint and grease. Aim to weld only bright, bare metal.

If possible, clamp workpieces securely in their final positions to stop them moving during welding/cutting.

Arc Air Gouging



ARC AIR GOUGING TORCH...

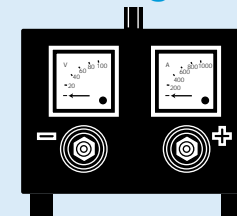
With the torch isolated from its power supply fit the gouging carbon into the holder, making sure the 3 air holes on the holder are facing the work.

Connect the torches dual DC connector/

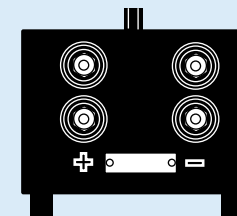
compressor cable into the power source (+) and its compressed air supply (see diagram) then connect the earth clamp lead to the work (-) and turn the power/air on.

The switch on the torch handle turns the air on and off.

Parallel Welding Box



Output Side



Parallel Weld Box
Input Side

PARALLEL WELD BOX... This piece of equipment must be used in conjunction with 2 Genset Welder Generators (300A+).

You must take the positive and negative connectors from both generators and connect these into their respective fittings at the back of the Weld Box.

Make sure that when the Gensets are running they are emitting the same power flow.

This set-up provides power for one man to operate a welding attachment.

Now connect the output on the front of the welding

box to the torch.

WIRE FEED UNIT...

Connect the X (+)positive cable from the welder generator into the back of the wire-feed unit, then connect the 110V extension lead into the back of the wire-feed unit and into the welder generator. The negative cable on the Welder Generator is the 'earth' connection, attach this to the workpiece.

Connect the regulator to the appropriate cylinder and the gas hose to the back of the wire-feed unit, then fit the torch to the front of the unit.

Fit the welding wire into the unit's wire-feed drive by depressing the tension lever (see diagram). The lever controls the tension for holding the welding wire securely.

Now, disengage the wire drive rollers (there is a lever for this), pull some wire off the drum and, having clipped off the end to leave it straight, feed it through the plastic sleeve and drive rollers and about 75mm into the gun's hose.

Finally, re-engage the drive rollers, switch the power back on and trigger the gun until about 25mm of wire emerges from the end. You can then replace the welding gun's tip and resume welding.