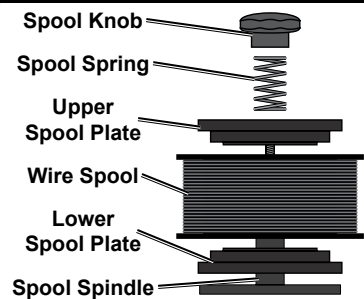
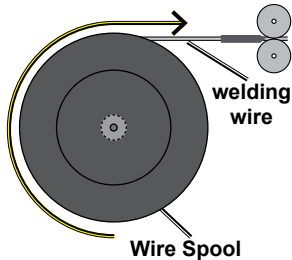


⚠ WARNING To prevent serious injury, read manual warnings and instructions before use.

1 Assemble face shield handle and lens.



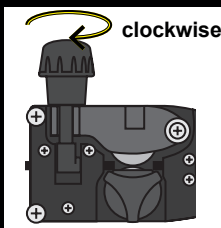
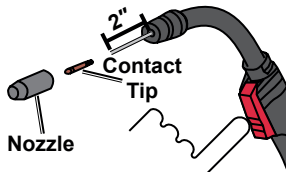
2 Install wire spool. Insert wire through both wire liners and clamp it into feed mechanism. *See manual if changing wire size or using solid wire.*



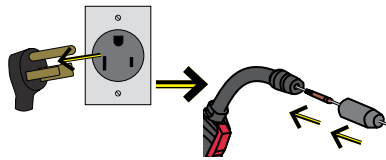
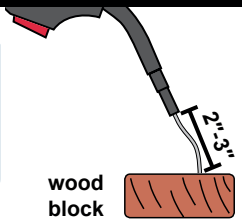
⚠ WARNING

To prevent fire and serious injury:
Keep torch and wire clear of grounded objects while welder plugged in.

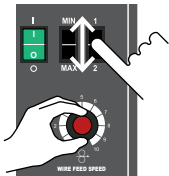
3 Take off nozzle and tip, plug in welder, turn it on, and squeeze trigger until wire comes out.



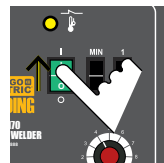
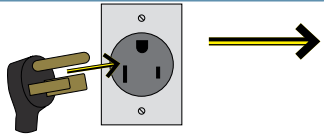
4 Incrementally tighten wire feed tension knob clockwise until wire will bend from feed tension at 2"-3".



5 Unplug welder and replace nozzle and tip. Adjust wire feed speed and current settings according to chart.



6 Hold gun clear of workpiece, then plug in welder and turn it on.



CLEAN FLUX-CORE WELDS FIRST!

Flux-core welds will have a coat of slag over them until cleaned.



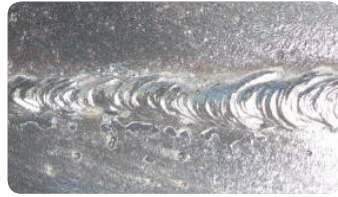
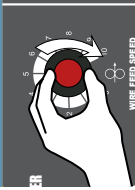
**Good
Weld**



**Current
Too Low
or Wire Feed
Too Slow**

TO CORRECT:
Increase
Current
Min1 -> Min2
Max1 -> Max2

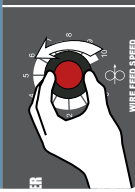
or



**Current
Too High or
Wire Feed
Too Fast**

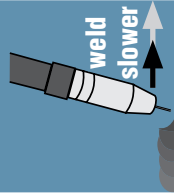
TO CORRECT:
Decrease
Current
Max2 -> Max1
Min1 -> Min2

or



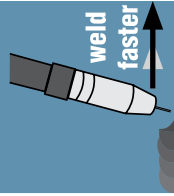
**Weld Speed
Too Fast**

TO CORRECT:



**Weld Speed
Too Slow**

TO CORRECT:



**Stickout
Too Long or
Wrong
Polarity**

TO CORRECT:
Check Polarity
and
maintain
less
than 1/2"
stickout

