DANGER

- Electric welding or plasma cutting cause ultraviolet rays and weld spatter. Bystanders will be exposed to ultraviolet rays and weld spatter.
- Wear welding helmet with appropriate shade lens while using electric welders or plasma cutters.
- Do not allow bystanders while welding or cutting.
- Wear safety shield and protective clothing (user and bystanders).
- Read and follow instructions.

Ultraviolet rays will burn eyes; weld spatter can cause injury.

WARNING

- Acetylene gas does not burn safely with YA1500 or YA1550 torches.
- Do not use YA1500 or YA1550 torches with acetylene gas.
- Read and follow instructions.
- Uncontrolled burning can cause injury.

- Materials can cause sparks or flying metal when heated which can cause fire.
- Wear safety shield and protective clothing (user and bystanders).
- Sparks, fire and flying metal can cause injury.

WARNING

- Electrical shock can result from absence of grounding prong.
- Do not remove or bypass the grounding prong in any electrical plug.
- Electrical shock can cause injury.

- Smoke, fumes and gases are created by the welding process.
- Use only in well ventilated area.
- Avoid breathing smoke, fumes and gases.
- Smoke, fumes and gases can cause injury.
INSTRUCTION MANUAL FOR WIRE WELDING MACHINES

WARNING!
READ, UNDERSTAND AND FOLLOW THIS MANUAL CAREFULLY BEFORE INSTALLING, USING, OR SERVICING THE WELDING MACHINE. PAYING SPECIAL ATTENTION TO SAFETY RULES. CONTACT YOUR DEALER IF YOU DO NOT FULLY UNDERSTAND THESE INSTRUCTIONS.

1. INSTALLATION
This machine must be used for welding only. It must not be used to defrost pipes. It is also essential to pay special attention to the chapter on SAFETY PRECAUTIONS. The symbols next to certain paragraphs indicate points requiring extra attention, practical advice or simple information. This manual must be stored carefully in a place familiar to everyone involved in using the machine. It must be consulted whenever doubts arise and be kept for the entire life-span of the machine; it will also be used for ordering replacement parts.

1.1 PLACEMENT
Unpack the machine and place it in an adequately ventilated area, dust-free if possible, taking care not to block the air intake and outlet from the cooling slots.

CAUTION!
REDUCED AIR CIRCULATION causes overheating and could damage internal parts. Keep at least 20 inches of free space around the machine. Never place any filtering device over the air intake points of this welding machine. The warranty shall become void if any type of filtering device is used. Mount the parts supplied with the machine as shown in the figure.

2. DESCRIPTION OF THE MACHINE

[Diagram of the machine with labels A to F]

A) Switch
Turns the machine on and off, and also regulates the welding voltage range.

B) Setting knob
This knob serves to adjust the welding wire speed.

3. GENERAL DESCRIPTIONS

3.1 SPECIFICATIONS
This welder is used for welding soft steel, stainless steel and aluminium.

3.2 EXPLANATION OF TECHNICAL SPECIFICATIONS

CSA The welding machine is built according to these international standards.
N Serial number, which must always be indicated in any inquiry regarding the welding machine.
Ii Secondary no-load voltage (peak value)
X The duty cycle expresses the percentage of 10 minutes during which the welding machine can run at a certain current without overheating. Example: X = 60% at I2 = 100 A
This means that the machine can weld with a current I2 = 100 A for 6 out of 10 minutes, thus 60%.
Iw Welding current
Uv Secondary voltage with welding current I2
U Rated power voltage, 1=60Hz Single-phase 50-Hz power supply.
<table>
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<td>U₀ MAX. O.C.V.</td>
<td>I₁</td>
</tr>
<tr>
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<td>U₁</td>
</tr>
<tr>
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<td>PROTECTION TYPE</td>
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<tr>
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<td>2</td>
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<tr>
<td>PROTECTION TYPE</td>
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</table>

**IP 21**

- Current absorbed at the corresponding welding current.
- Degree of housing protection.

**3.3 DESCRIPTION OF PROTECTION**

This device is protected by a normally closed thermostat on the power transformer. When the thermostat is tripped the machine stops welding, while the motor-driven fan continues to run and the yellow LED lights. After it has been tripped, wait a few minutes to allow the transformer to cool down.

**4. INSTALLATION**

**WARNING!**

The Mig 115 must be installed by qualified personnel. All connections must be made in full compliance with all applicable rules and regulations.

- Make sure that the wire diameter corresponds to the one indicated on the roller, and mount the wire reel. Make sure that the welding wire passes through the groove in the small roller 7.
- Before connecting the power cable 23, make sure that the power voltage corresponds to that of the welder, then:
  - a) for permanent connection to the power mains without a plug, you must insert a main switch having a suitable capacity in compliance with the rated specifications.
  - b) for a plug-socket connection, use a plug having a suitable capacity in compliance with the rated specifications. In this case the plug must be used to completely disconnect the machine from the mains, after setting the switch 47 to "O" (off).
- The yellow-green wire must be connected to the ground terminal. Connect the ground clamp 37 to the part to be welded. The welding circuit must not be deliberately placed in direct or indirect contact with the protective wire except in the workplace.
- If the workplace is deliberately grounded using the protection wire, the connection must be as direct as possible, using a wire at least as large as the welding current return wire, and connected to the workplace at the same point as the return wire, using the return wire clamp or a second grounding clamp placed next to it. All precautions must be taken to avoid stray welding currents.
- Turn the machine on using the switch 47.
- Remove the tapered gas tip 44 by turning it clockwise. Unscrew the contact tip 43.

Do not press the torch trigger until you have read the instructions carefully.

It is important to make sure the machine is turned off whenever changing the wire reel and wire roller, to prevent the wire feed motor from starting accidentally.

Press the torch trigger 39 and release it only when the welding wire comes out.

**Welding wire can cause puncture wounds.**

Never aim the torch at parts of the body, other people or metals when loading the welding wire.

Screw the contact tip 43 back on, making sure that the hole diameter corresponds to the wire used.

Slide the tapered gas welding tip 44 on, always turning clockwise.

**4.1 CONNECTING THE GAS HOSE**

- The gas cylinder must be equipped with a pressure regulator and gauge.
- If the cylinder is placed on the cylinder holder of the machine, it must be held in place by the chain provided and be of an appropriate size to avoid jeopardizing the stability of the machine.
- Connect the gas hose leaving the back of the machine to the pressure regulator only after the cylinder is in place.
- Open the gas cylinder and set the gauge to approximately 8-10 lb/min.

**CAUTION:** Make sure the gas used is compatible with the material to be welded.

**4.2 GENERAL NOTES**

Before using this welder, carefully read the regulations CEI 96/9 or CEN/ELEC HD 432 and CEI 28/17 or CEN/ELEC HD 433. Also make sure that the insulation on cables, torch and ground cable is intact.

**5. WELDING**

**5.1 WELDING MILD STEEL**

**5.1.1 With shielding gas.**

Either 75% ARGON + 25% CO₂ or 100% CO₂ may be used for welding mild steel.

Connect the cables as shown in the figure 3. Select the welding current by means of the rotary switch 47. Move the torch near the welding point and press the trigger 39. Adjust the potentiometer knob 2 until the welding is done.

**Fig. 3**
with a constant, continuous noise. If the speed is too fast, the wire tends to stick to the piece and cause the torch to skip; if the speed is too low, the wire melts in spaced drops or the arc does not remain lit. When you have finished welding, turn off the machine and close the gas cylinder.

For the correct welding angle see figure 5.

5.1.2 Without shielding gas.
Connect the cables as shown in the figure 4.

![Fig 4](image)

Use only diam. 0.9 flux cored wire that complies with the standard AWS AS.20 E71 T1 or E71 TGS, suitable for use without shielding gas.
Connect the ground cable clamp to the workplace.
After connecting the cables, follow the instructions given in paragraph 5.1.1.
NOTE: For compact, wall-protected welds always work from left to right and from top to bottom. Remove all waste after each welding operation.
For the correct welding angle see figure 5.

5.2 WELDING ALUMINIUM
The welder must be prepared as for welding mild steel with gas protection, but with the following differences:
- 100% ARGON as the shielding gas for welding.
- A wire having a composition suited to the base material to be welded.

For welding ALLUMAN: 3±5% silicon wire
For welding ANTICORROD: 3±5% silicon wire
For welding PERALUMAN: 5% magnesium wire
For welding ERGAL: 5% magnesium wire
Use grinding wheels and brushes specifically designed for aluminium, and never use them on other materials.
REMEMBER that cleanliness is quality!
The wire rears must be stored in nylon bags with dehumidifying packets.
For the correct welding angle see figure 5.

5.3 WELDING STAINLESS STEEL
The welder must be prepared as for welding mild steel with gas protection, but with the following differences:

- Reel of stainless steel wire compatible with the composition of the material to be welded.
- Cylinder containing 98% ARGON + 2% O2 (recommended composition)

The recommended torch angle and welding direction are shown in figure 5.

![Fig 5](image)

6 MAINTENANCE AND CHECKS
6.1 GENERAL NOTES

⚠️ WARNING!
- Turn off the welder and unplug the power cord from the socket before each checking and maintenance operation.
- Moving parts can cause serious injuries.
- Keep away from moving parts.

🔥 GLOWING HOT SURFACES can cause serious burns.
- Let the unit cool before servicing.
- Periodically remove any dust or foreign matter that may have deposited on the transformer or diodes; to do so, use a jet of clean, dry air.
- When replacing the wire roller, make sure the groove is aligned with the wire and corresponds to the diameter of the wire used.
- Always keep the interior of the gas nozzle clean to avoid metal bridges created by welding drox between the gas nozzle and the contact tip. Make sure the outlet hole of the contact tip has not expanded excessively; if so, replace.
- Strictly avoid striking the torch or allowing it to suffer violent impact.
6.2 TROUBLESHOOTING GUIDE

<table>
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<th>REMEDY</th>
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<td>Line fuse blown</td>
<td>Replace line fuse</td>
</tr>
<tr>
<td>Burnt out diodes</td>
<td>Replace</td>
</tr>
<tr>
<td>Burnt out electronic board</td>
<td>Replace</td>
</tr>
<tr>
<td>Loose torch or ground connections or any other electrical power connections</td>
<td>Tighten all connections</td>
</tr>
</tbody>
</table>

Working with a lot of metal splatter:
- Voltage adjustment switch has a wide contact: Replace the switch
- Improper adjustment of welding parameters: Set the correct parameters through the welding voltage switch and the wire-speed adjustment potentiometer
- Poor ground connection: Check grounding connections

The wire jams or arcing between the drive rolls and the torch infed wire guide:
- Contact tip with wrong diameter: Replace
- Misalignment of the drive roll groove: Realign
- Obstructed or plugged: Remove and clean filler

No wire feed or irregular wire feed:
- Drive roll too large for wire groove: Replace the drive roll groove
- Obstructed or plugged: Remove and clean filler
- Wire welding not tight: Tighten all the way completely tightened
- Clogged contact tip: Replace

Periocular fishes seen:
- Excess oxidation of the weld area: Clean the edges with a metal file
- Gas nozzle partially or completely clogged by replace being caused not to clog the gas outlets

7. SAFETY PRECAUTIONS

7.1 FIRE

**WARNING!**
- Avoid causing fire because of sparks, slag, hot metal or pieces.
- Make sure that suitable fire-fighting equipment is available close to welding area.
- Remove all flammable and combustible material from the welding area and its surrounding (32 ft minimum).
- Do not weld containers of combustible or flammable material, even when empty.
- Allow the welded material to cool down before touching it or putting it in contact with combustible or flammable material.
- Do not weld parts with hollow spaces, containing flammables.
- Do not work under conditions with high concentrations of combustible vapors, gases, or flammable dust.
- Always check the work area half an hour after welding so as to make sure that no fire has started.
- Do not keep any combustible material such as lighters or matches in your pockets.

7.2 BURNS

**WARNING!**
- Wear protective clothing in order to protect against burns caused by ultraviolet radiation given off by the arc, and from weld metal sparks and slag.
- Wear protective gloves designed for use in weld cleaning, hat and high-safety toe shoes, button shirt, collar and pocket flaps, and wear cuff-less trousers to avoid entry of sparks and slag.
- Wear helmet with safety goggles and glasses with side shields underneath, appropriate filter lenses or plates (protected by clear cover glasses). This is a MUST for welding to protect the eyes from radiant energy and flying metal. Replace cover glasses when broken, pitted, or spattered.
- Avoid oil or greasy clothing. A spark may ignite them. Hot metal such as electrode stubs and workpieces should never be handled without gloves.
- Ear plugs should be worn when working on overhead or in a confined space. A hard hat should be worn when others work overhead.
- Flammable hair preparations should not be used by persons intending to weld or cut.

7.3 FUMES

**WARNING!**
- Welding operations give off harmful fumes and metal dusts which may be hazardous to your health.
- Work in a well-ventilated area.
- Keep your head out of fumes.
- In closed areas, use suitable exhaust fans.
- If ventilation is not enough, use breathing apparatus approved for this procedure.
- Clean the material to be welded of any solvents or halogen degreasers. Some chlorine solvents may decompose with the radiation emitted by the arc, and create phosgene gas.
- Do not weld plated metals or those containing lead, graphite, cadmium, zinc, chrome, mercury or beryllium, unless you have the proper breathing apparatus.
- The electric arc creates ozone. A long exposure to high concentrations may cause headaches, nasal, throat and eye irritation as well as serious congestion and chest pains.

IMPORTANT: DO NOT USE OXYGEN FOR VENTILATION.
- Gas leaks in a confined space should be avoided.
- Leaked gas in large quantities can change oxygen concentration dangerously. Do not bring gas cylinders into a confined space.
- DO NOT WELD where solvent vapors can be drawn into the welding atmosphere or where the radiant energy can penetrate to atmospheres containing even minute amounts of trichloroethylene or perchloroethylene.
7.4 EXPLOSIONS

**WARNING!**

- Do not weld above or near containers under pressure.
- Do not weld in environments containing explosive dusts, gases or vapors.

This welding machine uses inert gases such as CO2, ARGON, or a mixture of ARGON + CO2 for the protection of the arc, thus you should take special precautions:

A) CYLINDERS
- Do not directly connect cylinder to the machine gas hose without a pressure regulator.
- Handle or use pressure cylinders in conformity with the existing rules.
- Do not use leaking or damaged cylinders.
- Do not use cylinders which are not well secured.
- Do not carry cylinders without the protection of the installed valve.
- Do not use cylinders whose content has not been clearly identified.
- Never lubricate cylinder valves with oil or grease.
- Do not put the cylinder in electrical contact with the arc.
- Do not expose cylinders to excessive heat, sparks, molten slags or flame.
- Do not tamper with the cylinder valves.
- Do not try to loosen tight valves by means of hammers, keys, or any other object.
- NEVER DEFACE or alter name, number, or other markings on a cylinder.
- Do not lift cylinders off the ground by their valves or caps, or by chain, slings or magnets.
- Never try to mix any gases in a cylinder.
- Never refill any cylinder.
- Cylinder fittings should never be modified or exchanged.

B) PRESSURE REGULATORS
- Keep pressure regulators in good condition. Damaged regulators may cause damages or accidents, they should only be repaired by skilled personnel.
- Do not use regulators for gases other than those for which they are manufactured.
- Never use a leaking or damaged regulator.
- Never lubricate regulators with oil or grease.

C) HOSES
- Replace hoses which appear damaged.
- Keep the excess hose wound and out of the working area in order to avoid any damage.

7.5 RADIATIONS

**WARNING!**

- Ultra-violet radiation created by the arc may damage your eyes and burn your skin. Therefore:
- Wear proper clothing and helmet.
- Do not use contact lenses.
- Use masks with grade DIN 10 or DIN 11 safety lenses at the least.
- Protect people in the surrounding welding area.
- Remember: the arc may dazzle or damage the eyes. It is considered dangerous up to a distance of 15 meters (50 feet). Never look at the arc with the naked eye.
- Prepare the welding area so as to reduce reflection and transmission of ultra-violet radiation. Install sheetings or curtains to reduce ultra-violet transmissions.
- Replace mask lenses whenever damaged or broken.

7.6 ELECTRIC SHOCK

**WARNING!**

- Electric shock can kill.
- All electric shocks are potentially fatal.
- Do not touch live parts.
- Insulate yourself from the piece to be welded and from the ground by wearing insulated gloves and clothing.
- Keep garments (gloves, shoes, hat, clothing) and body dry.
- Do not work in humid or wet areas.
- Avoid touching the piece to be welded.
- Should you work close to or in a dangerous area, use all possible precautions.
- If you should feel even the slightest electric shock sensation, stop welding immediately. Do not use the machine until the problem is identified and solved.
- Have an emergency disconnect switch as close to the machine as possible and make sure all personnel are aware of the switch's location.
- Frequently inspect the power supply cable.
- Disconnect power supply cable from mains before replacing cables or before removing unit covers.
- Do not use the unit without installed covers.
- Always replace any damaged parts of the unit, with original material.
- Never disconnect unit safety devices.
- Make sure that the power supply line is equipped with a properly grounded plug.
- Make sure that the work bench is connected to a good earth ground.
- Any maintenance should only be carried out by qualified personnel.

7.7 PACE MAKER

**WARNING!**

- Magnetic fields from high currents can affect pace-maker operation. Persons wearing electronic life support equipment (pacemaker) should consult their doctor before going near any welding operations.
7.8 WELDING WIRE CAN CAUSE PUNCTURE WOUNDS.

⚠️ WARNING!
- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.

7.9. MOVING PARTS CAN CAUSE INJURY.

⚠️ WARNING!
- Moving parts, such as fans, can cut fingers and hands and catch loose clothing.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.
- Keep hands, hair, loose clothing, and tools away from moving parts.
- Reinstall panels or guards and close doors when servicing is finished and before starting the machine.

7.10 NOISE

⚠️ WARNING!
- The welding procedure may produce noise levels in excess of 80 dB, in which case the machine operator must take the necessary safety precautions as prescribed by the national safety regulation.
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<td>GAINÉ À TELON</td>
<td>VAIMA EN TELOON</td>
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<td>MC1158</td>
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<td>DIFUSOR</td>
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<td>43</td>
<td>MG2103</td>
<td>0.025 (1mm) CONTACT TIP</td>
<td>TUBE DE CONTACT</td>
<td>TOBERA PORTA CORR. 0.025</td>
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<td>43</td>
<td>MG2103</td>
<td>0.025 (1mm) CONTACT TIP</td>
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<tr>
<td>43</td>
<td>MG2103</td>
<td>0.025 (1mm) CONTACT TIP</td>
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<td>43</td>
<td>MG1191</td>
<td>TAPERED NOZZLE</td>
<td>BUSE GAZ</td>
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<td>BUSE POINTAGE</td>
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<td>45</td>
<td>MS1155</td>
<td>TÉCHET</td>
<td>TÉCHETTE</td>
<td>ANTOUCH</td>
</tr>
</tbody>
</table>

*These items are not normal stock items but can be made available on an needied requirement.

These articles are not on the detail.

Estos artículos no están incluidos en nuestro stock pero pueden ser suministrados a la demanda.

All consumables and repair parts should be ordered through your snap-on dealer.
MANUFACTURER'S LIMITED WARRANTY

This equipment is warranted against defects in materials and workmanship for a period of two years from the date of purchase.

EXCEPTION: THE MIG TORCH OR PLASMA TORCH IS WARRANTED FOR A PERIOD OF 30 DAYS FROM THE DATE OF PURCHASE.

Should the equipment become defective for such reason, the Manufacturer will repair it without charge, if it is returned to the Manufacturer's factory, freight prepaid. This warranty does not cover: (1) failure due to normal wear and tear; (2) consumable parts, such as, but not limited to, torch contact tips, gas cups, insulating bushings, electrodes, swirl rings, and diffusers; (3) damage by accident, force majeure, improper use, neglect, unauthorized repair or alteration; (4) anyone other than the original purchaser.

THIS LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED. THE MANUFACTURER SHALL NOT BE LIABLE FOR ANY INJURY TO PERSONS, INCLUDING DEATH, OR LOSS OR DAMAGE TO ANY PROPERTY, DIRECT OR CONSEQUENTIAL, INCLUDING, BUT NOT LIMITED TO, LOSS OF USE, ARISING OUT OF THE USE, OR THE INABILITY TO USE, THE PRODUCT. THE USER ASSUMES ALL RISK AND LIABILITY WHATSOEVER IN CONNECTION WITH THE USE OF THE PRODUCT, AND BEFORE DOING SO, SHALL DETERMINE ITS SUITABILITY FOR HIS INTENDED USE, AND SHALL ASCERTAIN THE PROPER METHOD OF USING IT. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, OR THE EXCLUSIONS OR LIMITATIONS OF INCIDENTAL OR CONSEQUENTIAL DAMAGES. SO THE ABOVE LIMITATIONS OR EXCLUSIONS MAY NOT APPLY TO YOU.

THIS WARRANTY GIVES YOU SPECIFIC LEGAL RIGHTS, AND YOU MAY HAVE OTHER RIGHTS OF WHICH MAY VARY FROM STATE TO STATE.

FOR INFORMATION CONCERNING USE, WARRANTY SERVICE, OUT OF WARRANTY SERVICE OR PRODUCT INFORMATION, CONTACT:

WELDER / PLASMA SERVICE
1025 SAUNDERS LANE
WEST CHESTER, PA 19380
(800) 222-9353
HOURS: MON - FRI 8:00 A.M. TO 4:30 P.M. EASTERN TIME

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