

QUICK SET-UP GUIDE

*This guide is intended to provide quick instructions on the set-up of your new welder.
Please take time to review the operator's manual prior to operating this unit.*



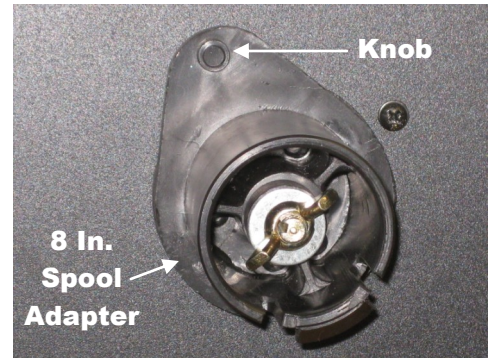
MIG 135

Item #164611

*For more help visit www.ntwelderhelp.com
Or Call 1-877-304-0294*

1**INSTALLING A 4" SPOOL OF WIRE**

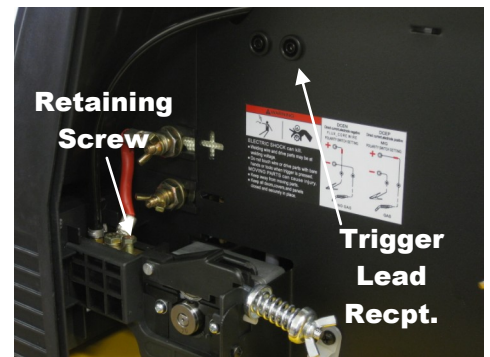
Remove wing nut, washer and black bushing. Slide on spool so wire feeds off the bottom of spool. Reinstall bushing, washer and wing nut. See Step 13 to adjust wire spool tension.

2**INSTALLING A 8" SPOOL OF WIRE**

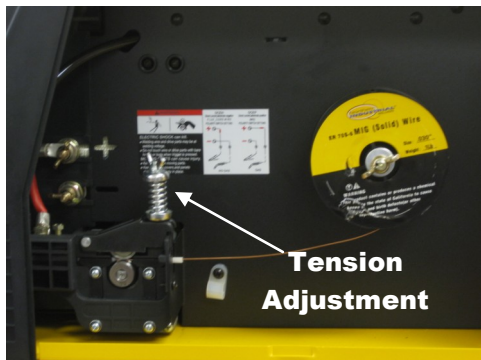
Remove wing nut, washer and black bushing. Slide on spool adapter. Reinstall bushing, washer and wing nut. Slide on 8" spool of wire. Knob on spool adapter slides into hole on side of 8" spool of wire. See Step 13 to adjust wire spool tension.

5**SLIDE MIG GUN INTO WIRE FEEDER**

Remove Retaining Screw (see step 6) Slide the machine end of the MIG gun into the front panel receptacle. Push it all the way into the wire feeder as far as it will go. Feed trigger leads through the opening in the front panel.

6**TIGHTEN RETAINING SCREW FOR MIG GUN**

Tighten the retaining screw on the wire feeder housing to secure the gun. Install trigger leads into the trigger lead receptacle.

9**FEED WIRE - CLOSE TENSION ARM**

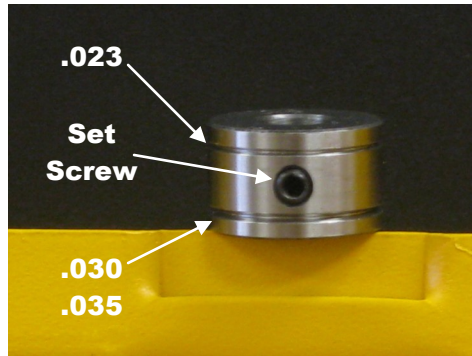
Close the drive roll tension arm. Apply tension to the wire by turning the wing nut clockwise on the Drive Roll Tension Adjustment. Do not overtighten. See Step 14.

10**FEED WIRE - REMOVE GUN TIP & NOZZLE**

To finish feeding the wire through the MIG gun, you will need to remove the gun nozzle and tip.

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DRIVE ROLL GROOVE SELECTION



The smaller groove on the drive roll is to be used with .023 wire. The larger groove can be used for .030 and .035 wire. Use the supplied "L" shaped hex wrench to loosen set screw and to align the proper groove to the wire path. Retighten set screw.

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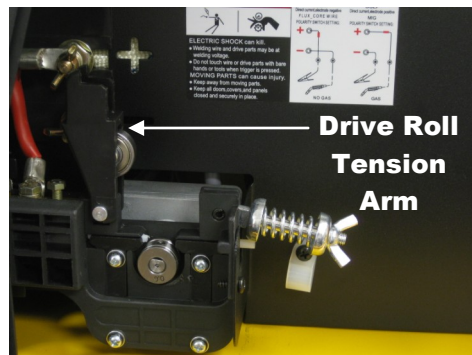
MIG GUN - MACHINE END



This MIG gun is a one piece connection. Notice the retaining groove on the machine end. The hex-headed retaining screw in the step (6) will set down into this groove.

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FEED WIRE - OPEN TENSION ARM



Open the drive roll tension arm on the wire feeder.

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FEED WIRE - THREAD WIRE



Feed the loose end of the wire through the Inlet Guide Tube, past the drive roll and into the back of the MIG Gun. Keep tension on the wire to prevent unspooling on the spool. Make certain wire is centered on groove and adjust drive roll (Step 3) if needed.

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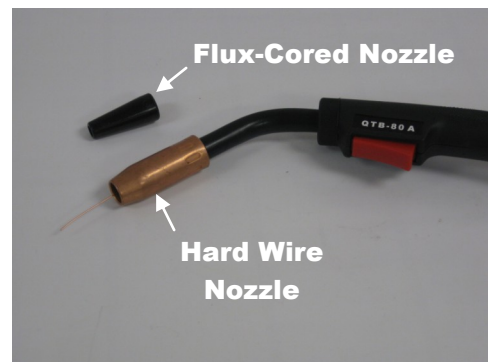
FEED WIRE - PULL TRIGGER TO FEED WIRE



Stretch out the MIG gun. Turn on input power and pull the trigger to feed the wire through the gun. Stop when the wire pushes through the end of the gun.

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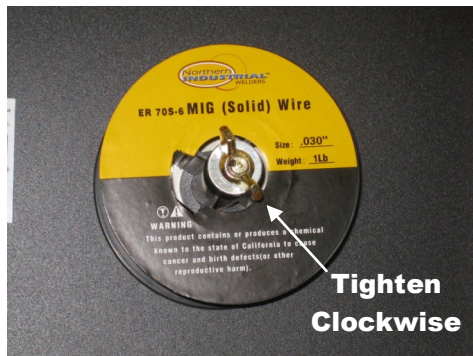
FEED WIRE - REINSTALL TIP AND NOZZLE



Slide the correct size contact tip for the wire size you are using over the end of the wire and tighten clockwise to secure. Choose the correct nozzle, thread on nozzle and clip any excess wire.

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ADJUSTING SPOOL TENSION



Adjust the wing nut in the center of the spool to adjust spool tension. A small amount of slack should be in the weld wire when wire feeding stops. Too much tension will cause poor feeding. Too little tension will cause the wire on the spool to uncoil.

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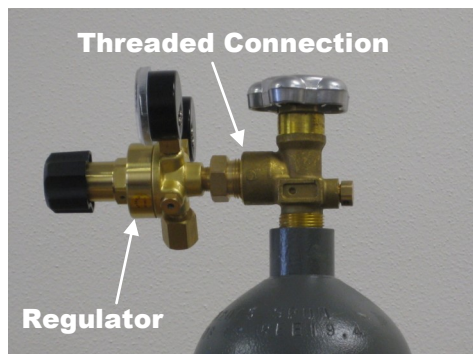
ADJUSTING DRIVE ROLL TENSION



Test drive roll tension by feeding wire into a gloved hand from about 4 inches away. Loosen tension to apply little pressure. Slowly increase tension until the wire coils up in your hand without slipping in the drive rolls.

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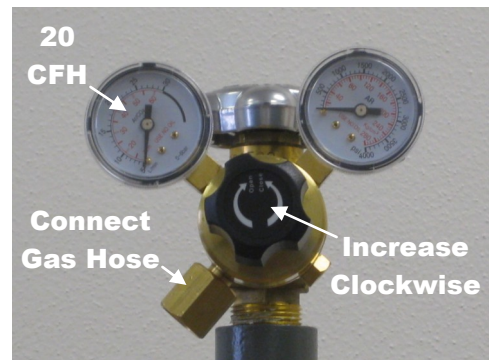
INSTALL SHIELDING GAS



Thread the regulator directly to the bottle. A CO2 adapter will be needed if using straight CO2 gas. One end of the supplied gas hose connects to the regulator. The other end connects to the gas valve on the back of the machine.

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SET GAS FLOW



Open the drive roll tension arm on the wire feeder. Open the valve on the shielding gas bottle. Turn on the unit power and pull the trigger. Adjust the regulator to set for 20 cubic feet per minute. Reinstall the drive roll tension arm on the wire feeder.

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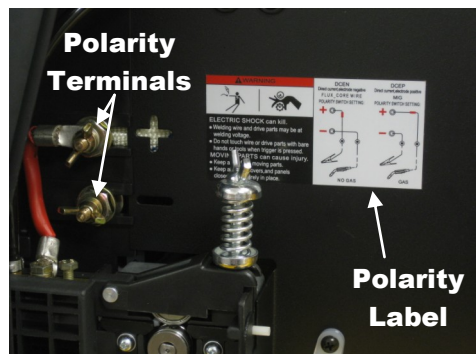
SETTING FRONT PANEL CONTROLS



On the wire compartment access panel is a set-up guide. Find the type of material being welded and the size of wire you are using. Slide over to the thickness of the thinnest material you are welding. Set the voltage and wire feed speed on the front of the unit.

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SETTING POLARITY - CHECK WIRE TYPE



Feed ground cable through the front opening. Install on the open polarity terminal. Solid wire uses Electrode Positive (DCEP) polarity. Flux-cored wire use Electrode Negative (DCEN) polarity. See polarity label in the wire compartment and change as needed.