

Lasapparaat MIG300

Gebruikershandleiding

KIBANI[®]
immer das Beste



Lees deze handleiding voor je eigen veiligheid voordat je de kettingzaag in gebruik neemt.
Bewaar deze handleiding voor toekomstig gebruik.

SAFETY INFORMATION:

Thank you for purchasing our product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.

Before using welding, pls ensure that

- 1.ARC WELDING CAN BE DANGEROUS.
- 2.THIS WELDING MACHINE MUST BE CONNECTED TO A POWER SOURCE IN ACCORDANCE WITH APPLIANCE ELECTRICAL CODES.
- 3.FOR SAFETY TURN OFF AND UNPLUG MACHINE WHEN INSTALLING NEW WIRE SPOOL, ADJUSTING WIRE TENSION ROLLER OR REPLACING CONTACT TIP.
- 4.THE GAS NOZZLE MUST ALWAYS BE INSTALLED WHEN WELDING-DO NOT WELD WITHOUT THE GAS NOZZLE IN PLACE. THE CONTACT TIP IS ELECTRICALLY "HOT" AND IF IT CONTACTS THE GROUNDED WORK PIECE IT WILL CAUSE DAMAGE.
- 5.ALL INSTALLATION, MAINTENANCE, REPAIR OPERATION OF THIS EQUIPMENT SHOULD BE PREFORMED BY QUALIFIED TECHNICIANS IN ACCORDANCE WITH NATIONAL, STATE AND LOCAL CODES.
- 5.ELECTRIC SHOCK COULD KILL.
- 6.DISCONNECT FROM POWER SOURCE BEFORE ASSEMBLING,
7. DISASSEMBLE OR MAINTENANCE OF THE TORCH OR CONTACT TIP OR CHANGING WIRE SPOOLS.
- 8.DISCONNECT FROM POWER SOURCE BEFORE ASSEMBLING, DISASSEMBLY OR MAINTENANCE OF THE TORCH OR CONTACT TIP OR CHANGING WIRE SPOOLS.
- 9.FUMES AND WELDING GASES CAN BE DANGEROUS.
- 10.WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION.
11. ARC RAYS CAN BURN.
- 12.HOT METAL WILL BURN.
- 13.ELECTROMAGNETIC FIELDS MAY BE DANGEROUS.

WARNING!

PLS BE REMINDED TO WEAR ALL PROTECTION DEVICES BEFORE WELDING IN A SAFE PLACE.

SPECIFICATION:

Model No.	MIG-200	MIG-300	MIG-400	MIG-500	MIG-600
Description	AC, SINGLE-PHASE, PORTABLE, FLUXWIRE WELDING MACHINE FOR FLUX (NO GAS) WELDING. WITH THERMAL PROTECTION. COMPLETE		DC, SINGLE-PHASE, FAN-COOLED WIRE WELDING MACHINE ON WHEELS, FOR FLUX (NO GAS) AND MIG-MAG (GASS) WELDING.WITHTHERMAL PROTECTION. COMPLETE WITH FLUX WELDING ACCESSORIES. THE KIT FOR WELDING DIFFERENT TYPES OF		
Application	HOBBY LINE AND LIGHT FABRICATION,RIG HT IN THE JOB SITE		HOBBY LINE AND LIGHT FABRICATION,RIG	LIGHT INDUSTRIAL FABRIATION, CAR BODY, CONSTRUCTION	
Input Voltage(V)	110,230	110,230	230	230	230
Frequency(HZ)	50,60	50,60	50,60	50,60	50,60
Input Power(Kva)	2.5	3.6	3.7	5.2	6
Output Current Range	50-90	50-120	60-140	60-160	60-180
Rated Duty Cycle	90@10%	105@15%	115@15%	140@15%	140A@20%
No load voltage(V)	33	37	34.2	35.8	37
Welding wire dia (mm)	0.6-0.9	0.6-0.9	0.6-0.9	0.6-0.9	0.6-0.9
Adjustment Positions	4	4	4	4	4
Insulation class	H	H	H	H	H
Protection class	IP21S	IP21S	IP21S	IP21S	IP21S

Model	NO GAS MIG200,300	MIG 400	MIG 500,600
Circuit Breaker	30A	40A	40A

Reminder:

1:MIG200,MIG300 welder is AC of no gas (flux) function. It could weld max 1kgs welding wire . Please be reminded to assemble the correct size of wire in usage. MIG400,MIG-500,MIG-600 DC is no gas(flux) and with gas(solid) both can use welders.

2:When torch nozzle touch the workpiece, there would be arc starting. And when you press torch button, it would start feeding wire and welding.so when you not welding,don't let the nozzel torch the workpiece.

3:The contact tip is a consumable item and must be replaced when the bore becomes enlarged or oval. The contact tip MUST be kept free from spatter.

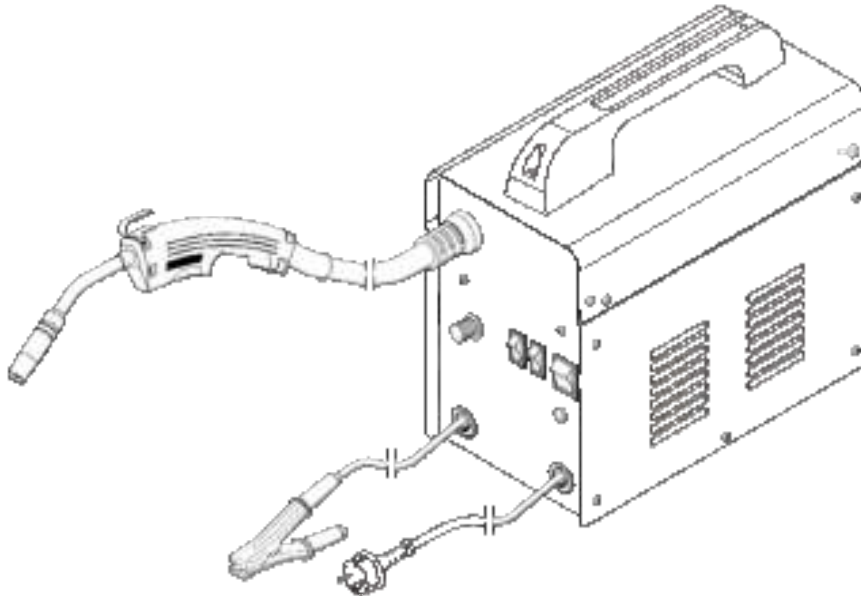
4:The Nozzle must also be kept clean and free from spatter. Build-up of spatter inside the nozzle can cause a short

circuit at the contact tip which will result in expensive machine repairs. To keep the contact tip free from spatter.

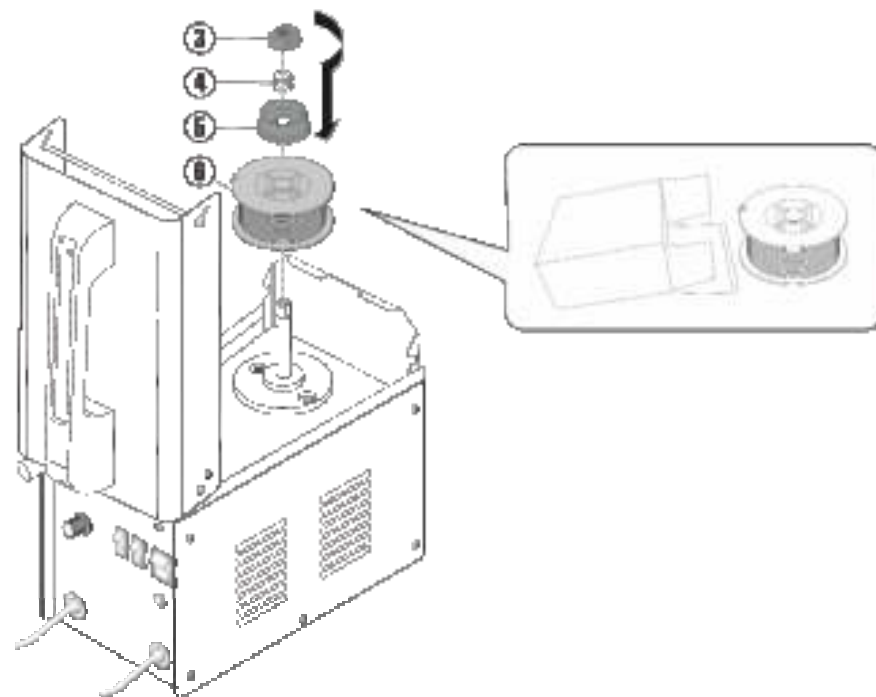
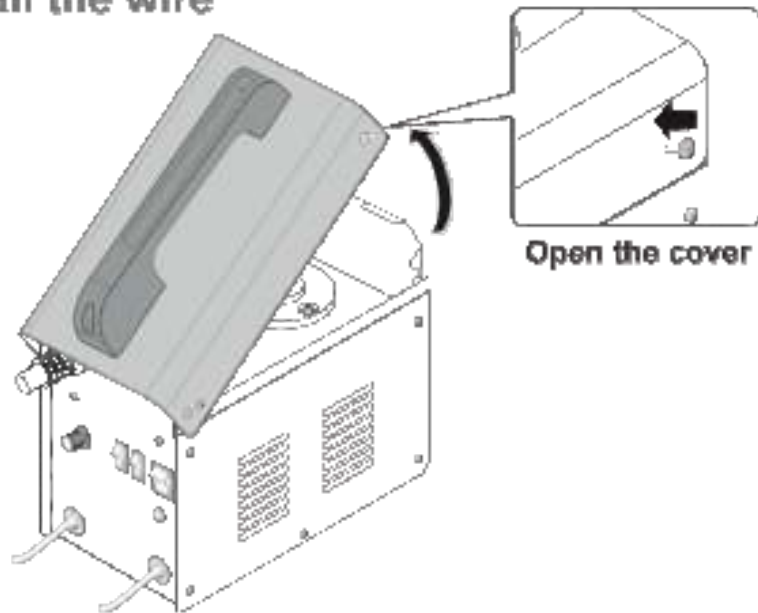
5: Should the welder become overheated due to prolonged use beyond the stated duty cycle the thermal protection will cause the welder to cut out and the orange light on the front panel will illuminate. Wait for fifteen minutes for the welder to cool down at which time it will reconnect automatically.

PREPARATION:

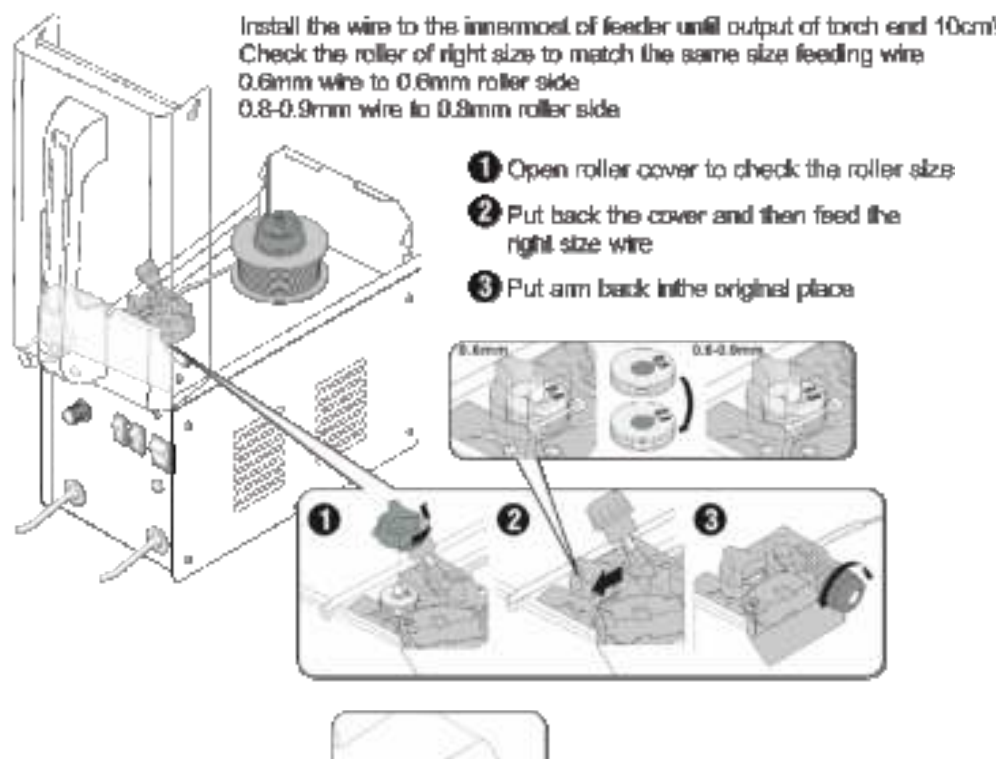
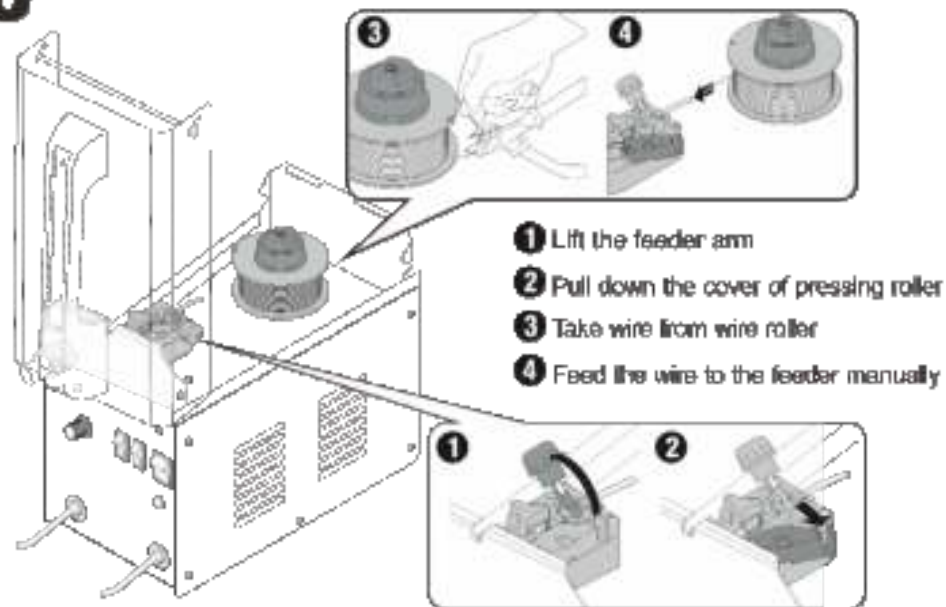
1 Check the components



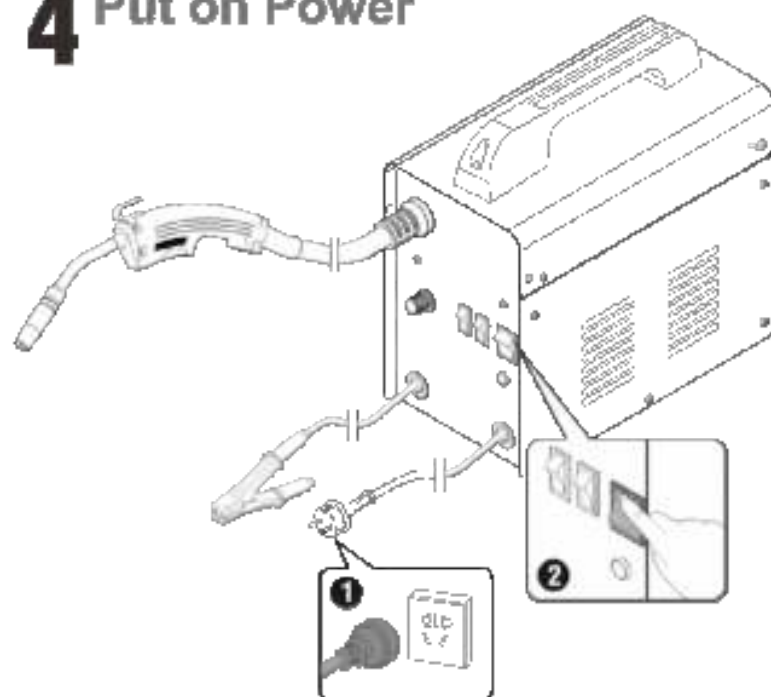
2 Install the wire



3 Fix the wire to the feeder

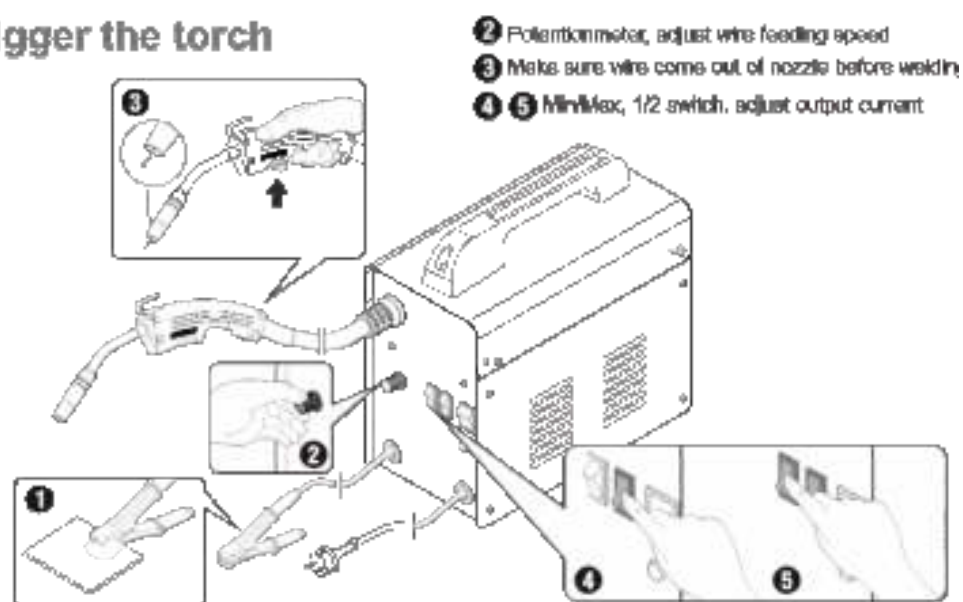


4 Put on Power



2 Power switch, switch On/ Off

5 Trigger the torch



2 Potentiometer, adjust wire feeding speed

3 Make sure wire come out of nozzle before welding

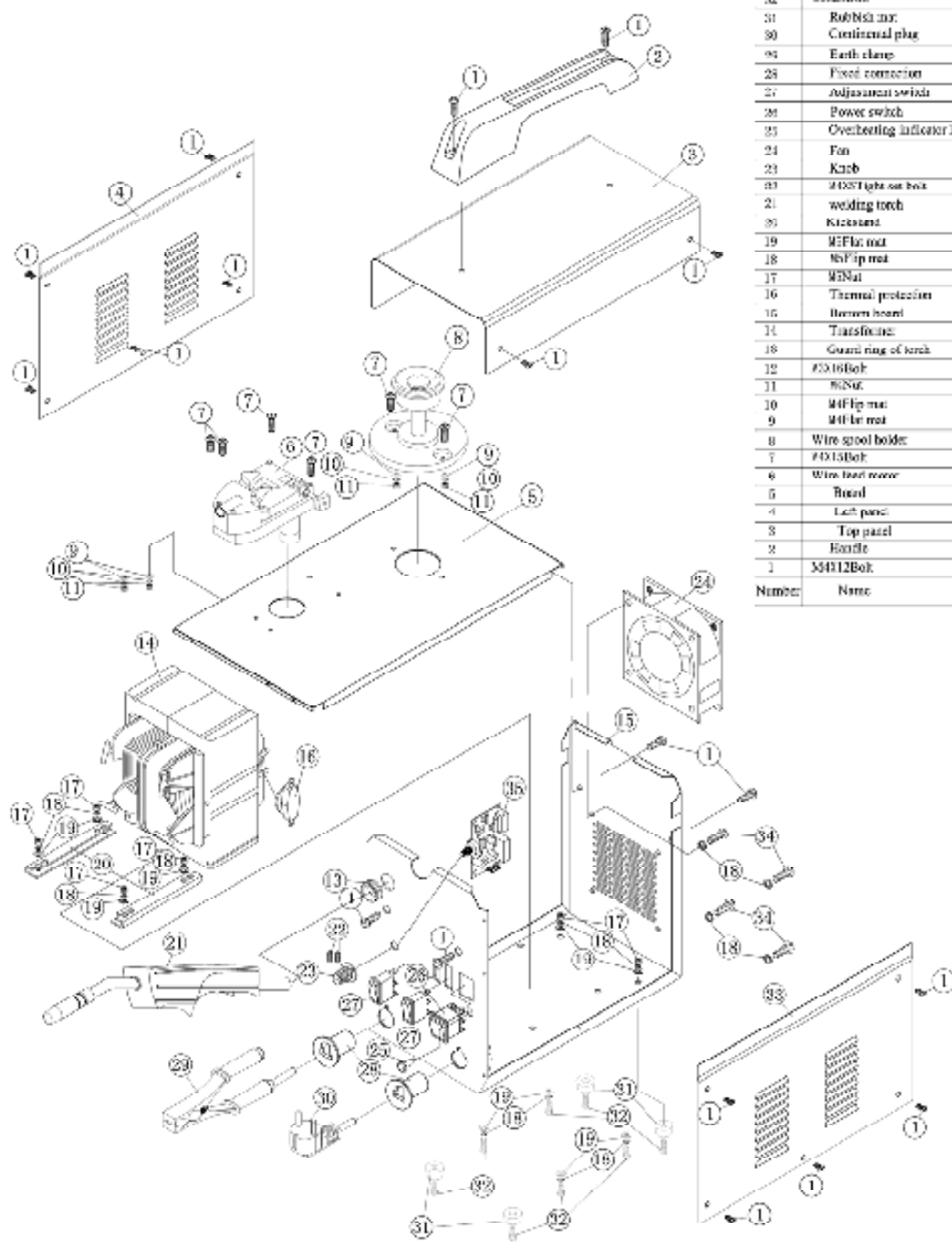
4 5 MiniMax, 1/2 switch, adjust output current

Thermal Protection:

Should the welder become overheated due to prolonged use beyond the stated duty cycle the thermal protection will cause the welder to cut out and the orange light on the front panel will illuminate. Wait for fifteen minutes for the welder to cool down at which time it will reconnect automatically.

IMPORTANT: These instructions are not intended to teach you how to weld. If you have no experience, we recommend that you seek training from an expert source. MIG welding is relatively easy, but does require a steady hand and supervised practice on scrap metal, as it is only with continued practice that you will achieve the desired results.

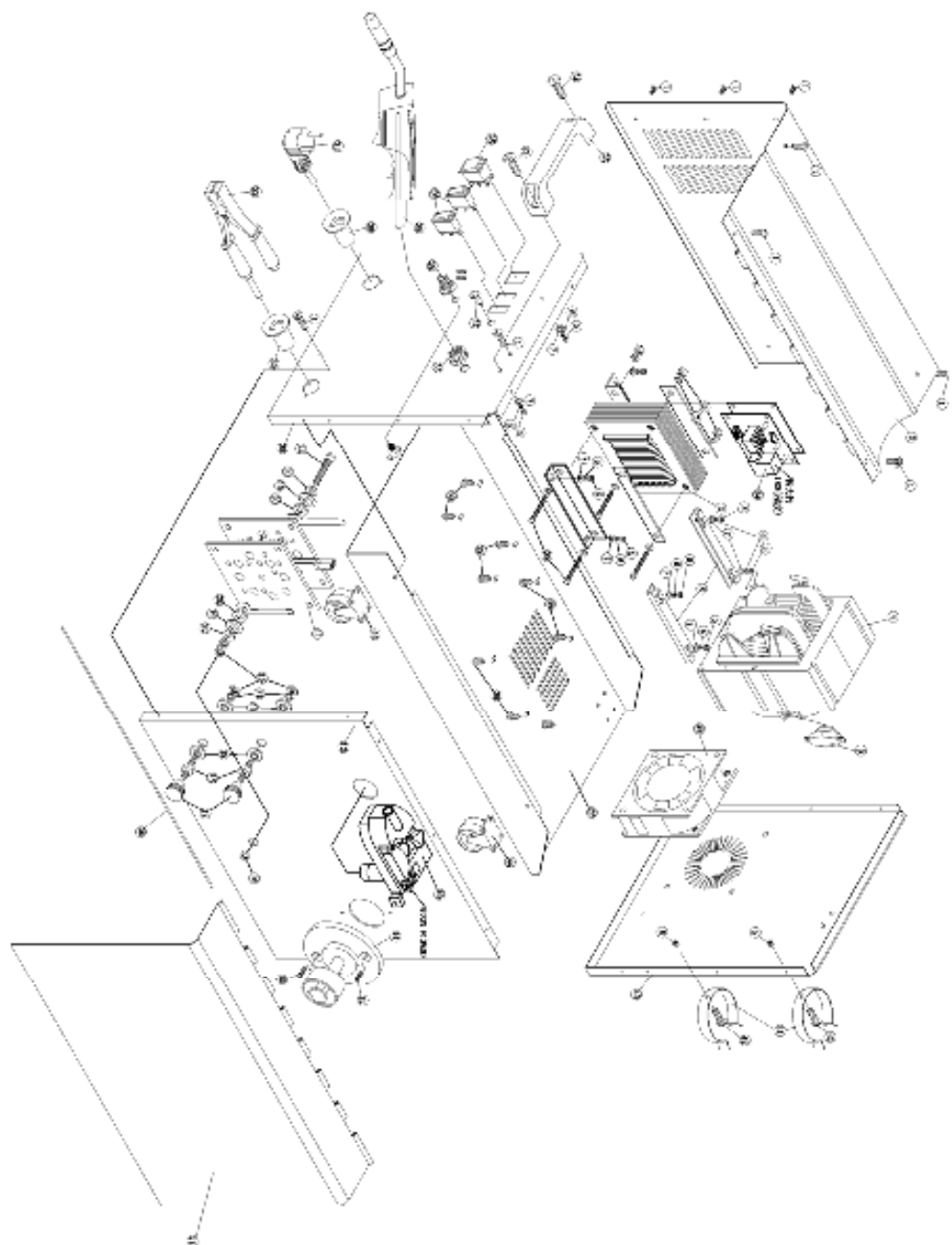
MIG200 and MIG300 Explosive view



Number	Name	Quantity
		1
		1
35	PCB	1
34	Wx15Bol	4
33	Right panel	1
32	Wx25Bol	8
31	Rx15x10x10	4
30	Continental plug	1
29	Earth clamp	1
28	Fixed connector	2
27	Adjustment switch	1
26	Power switch	1
35	Overheating indicator light	1
24	Fan	1
23	Knob	1
33	Light on box	2
21	welding torch	1
30	Knob	2
19	WFlig mat	14
18	WFlig mat	10
17	WFlig mat	10
16	Thermal protection	1
15	Brown board	1
14	Transformer	1
18	Guard ring of torch	1
12	Wx16Bol	2
11	Wx16Bol	2
10	WFlig mat	2
9	WFlig mat	2
8	Wire spool holder	1
7	Wx15Bol	6
6	Wire lead cover	1
5	Board	4
4	Left panel	1
3	Top panel	1
2	Handle	1
1	Wx12Bol	20

MIG400, MIG500 and MIG600 Explosive view

44	M8X20 bolt	1
43	Pin	1
42	M4X12 bolt	2
41	Wottle bracket	2
40	Back panel	1
39	M6X25 bolt	8
38	M6X10 bolt	4
37	Right panel	1
36	φ3 steel wire (47mm)	1
35	Front panel	1
34	Wire-feeding control panel	1
33	Net	1
32	Barth clamp	1
31	Flux	1
30	Influx rod	2
29	Electrode holder	1
28	Potentiometer handle	1
27	Indicator light	1
26	Main switch	2
25	Switch	1
24	M6X30 bolt	2
23	Handle	1
22	Bottom panel	1
21	M6 spring cushion	3
20	M6 plain cushion	4
19	Plastic insulation cabinet	6
18	Connection terminal	2
17	M6 plastic nut	2
16	M6 nut	4
15	M4X15 bolt	2
14	Fire shaft collar	1
13	M4X15 bolt	4
12	Vertical panel	1
11	Socketflar	1
10	Wire-feeding motor	1
9	Heat exchanger	1
8	Open bracket	2
7	M3 plain cushion	18
6	M5 spring cushion	18
5	M5 nut	20
4	Transformer	1
3	Resistor	1
2	Left panel	1
1	M4X12 bolt	20
No.	Item	Qty



TROUBLE SHOOTING

Trouble shooting	Possible Causes
Arc unable, excessive spatter	Welding output too high
	Torch moved too slowly
Lack of weld penetration	Welding output too low
	Torch moved too fast
	Input voltage too low
Burning holes in work piece	Welding output too high
	Torch moved too slowly
Welder does not operate(mains indicator not lit, no arc produced)	Check main supply connection
	Check supply fuse
Welder does not operate with trigger pressed	Check main supply connection
	Check supply fuse
	Check torch trigger and it's connections
	Thermal overload cut out-allow to cool
	check pcb correct or not-replace
Break in welding circuit	Incorrect size of contact tip for wire
	Contact tip damaged- replace
	Contact tip loose- tighten
	Feed rollers worn-replace
	Welding wire corroded-replace
	Pressure roller adjustment incorrect-adjust
	Pressure roller sticking-lubricate-replace
Supply fuse is trip off	Input current is too big,suggest to change to bigger fuse to 30A
Does not feed the wire	Check the instalation,make sure wire is properly installed according to the manual guide.
	Check if any wire loose.as the feed motor wire,the PCB wire ect
	Pls feed the wire by hand more length,may easy feed out
	Press the torch trigger more strength and more times.
	Take off the contact tip and nozzel and not put the wire first,see if the wire roll turn.
	PCB have the problem,change a PCB