

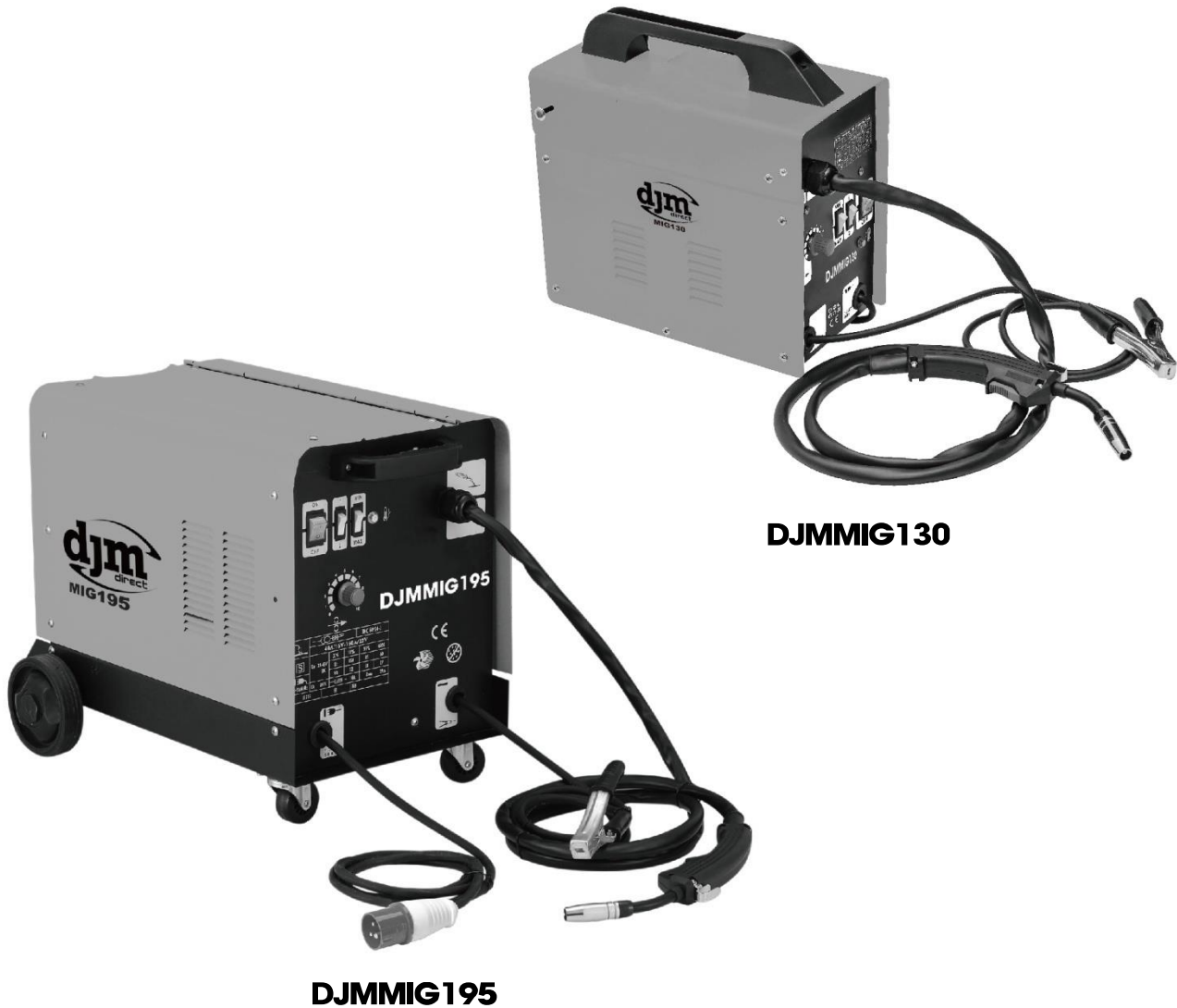
Item No: DJMMIG130 DJMMIG195



MIG WELDER

DJM Direct.com

Unit 43 Churchill Way, Lomeshaye Industrial Estate,
Nelson, Lancashire BB9 6RT



DJMMIG130

DJMMIG195

Mig Welder

Translation of Original Operating Manual

1.Introduction

MANUFACTURER:

DJM Direct.com

Unit 43 Churchill Way,
Lomeshaye Industrial Estate,
Nelson, Lancashire BB9 6RT UK

DEAR CUSTOMER

We hope your new tool brings you much enjoyment and success.

NOTE:

According to the applicable product liability laws, the manufacturer of the device does not assume liability for damages to the product or damages caused by the product that occurs due to:

- Improper handling,
- Non-compliance of the operating instructions,
- Repairs by third parties, not by authorized service technicians,
- Installation and replacement of non-original spare parts, .
- Application other than specified,

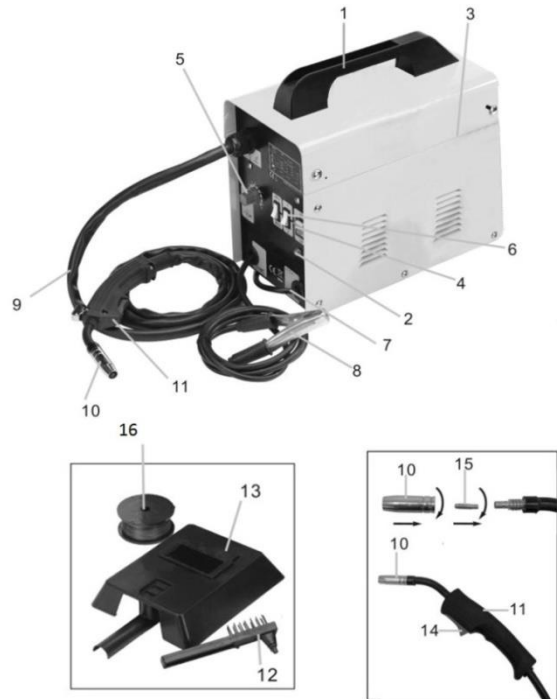
WE RECOMMEND:

Read through the complete text in the operating instructions before installing and commissioning the device. The operating instructions are intended to help the user to become familiar with the machine and take advantage of its application possibilities in accordance with the recommendations. The operating instructions contain important information on how to operate the machine safely, professionally and economically, how to avoid danger, costly repairs, reduce downtimes and how to increase reliability and service life of the machine. In addition to the safety regulations in the operating instructions, you have to meet the applicable regulations that apply for the operation of the machine in your country. Keep the operating instructions package with the machine at all times and store it in a plastic cover to protect it from dirt and moisture. Read the instruction manual each time before operating the machine and carefully follow its information. The machine can only be operated by persons who are instructed concerning the operation of the machine and who are informed about the associated dangers. The minimum age requirement must be complied with. In addition to the safety requirements in these operating instructions and your country's applicable regulations, you should observe the generally recognized technical rules concerning the operation of machines.

2.Device Description

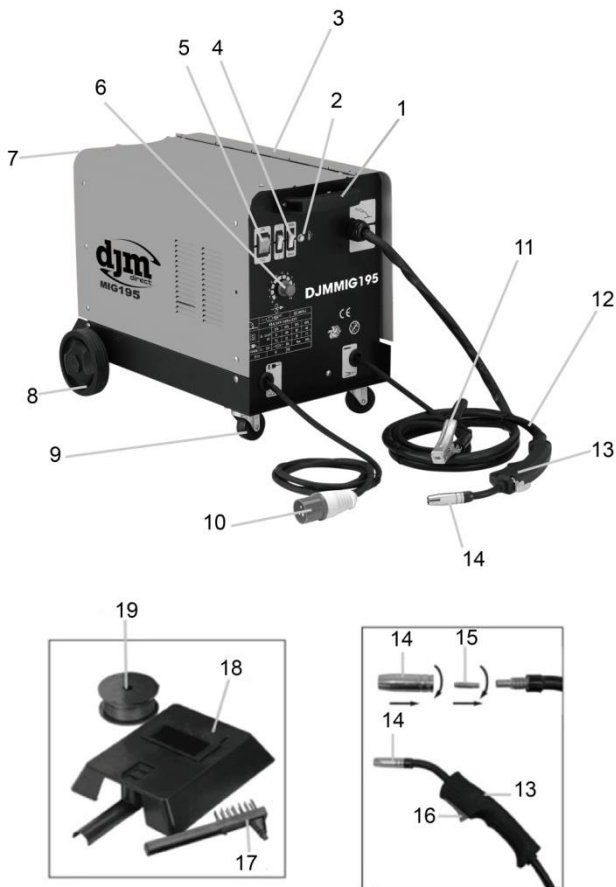
DJMMIG130(NO GAS)

1. Handle
2. Thermostat control lamp
3. Housing cover
4. ON/OFF switch
5. Welding wire speed controller
6. Switch for welding current adjustment
7. Mains plug
8. Earth clamp
9. Hose package
10. Welding nozzle
11. Torch
12. Wire brush
13. Welding screen
14. Torch trigger
15. Welding tip
16. Solid wire($\varnothing 0.9\text{mm}$, 0.45kg)



DJMMIG195(GAS/NO GAS)

1. Handle
2. Thermostat control lamp
3. Housing cover
4. Switch for welding current adjustment
5. ON/OFF switch
6. Welding wire speed controller
7. Gas connection point
8. Wheels
9. Wheels
10. Mains plug
11. Earth clamp
12. Hose package
13. Torch
14. Welding nozzle
15. Welding tip
16. Torch trigger
17. Wire brush
18. Welding screen
19. Solid wire(Ø1.0mm, 1kg)



3. Unpacking

- Open the packaging and remove the device carefully.
- Remove the packaging material as well as the packaging and transport bracing (if available).
- Check if the delivery is complete.
- Check the device and accessory parts for transport damage.
- If possible, store the packaging until the warranty period has expired.

ATTENTION

The device and packaging materials are not toys! Children must not be allowed to play with plastic bags, film and small parts! There is a risk of swallowing and suffocation!

4. Intended Use

The flux cored welding set is designed for self-shielding flux cored welding using suitable wire. The additional application of gas is not required.

The equipment is to be used only for its prescribed purpose. Any other use is deemed to be a case of misuse. The user / operator and not the manufacturer will be liable for any damage or injuries of any kind caused as a result of this.

Please note that our equipment has not been designed for use in commercial, trade or industrial applications. Our warranty will be voided if the equipment is used in commercial, trade or industrial businesses or for equivalent purposes.

5. Safety Precautions For All Types Of Welding

5.1 WARNING:AS with all machinery, there are certain hazards involved with their operation and use. Exercising respect and caution will considerably lessen the risk of personal injury. However, if normal safety precautions are overlooked, or ignored, personal injury to the operator may result.

5.2 General precautions

5.2.1 Burn prevention

Wear protective clothing-gauntlet gloves designed for use in welding, apron, and protective shoes. Button shirt collar and pocket flaps, and wear cuffless trousers to avoid entry of sparks and slag. Wear helmet with safety goggles or glasses with side shields underneath, appropriate filter lenses or plates(protected by clear cover glass). This is a must for welding or cutting, (and chipping) to protect the eyes from avoid oily grasy clothing. A spark may ignite them. Hot metal such as electrode stubs and workpieces should never be

handled without gloves. First aid facilities and a qualified first aid person should be available unless medical facilities are close by for immediate treatment of flash burns of the eyes and skin burns. Ear plugs should be worn when working 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.

5.2.2 Toxic fume prevention

Severe discomfort, illness or death can result from fumes, vapours, heat, or oxygen enrichment or depletion that welding (or cutting) may produce. Prevent them with adequate ventilation. NEVER ventilate with oxygen. Lead-, cadmium-, zinc-, mercury- and beryllium-, bearing materials, when welded (or cut) may produce harmful concentrations of toxic fumes. Adequate local exhaust ventilation must be used, or each person in the area as well as the operator must wear an air-supplied respirator. For beryllium, both must be used. Metals coated with or containing materials that emit toxic fumes should not be heated unless coating is removed from the work surface, the area is well ventilated, or the operator wears an air-supplied respirator. Work in a confined space only while it is being ventilated and, if necessary, while wearing an air-supplied respirator. Vapours from chlorinated solvents can be decomposed by the heat of the arc (or flame) to form PHOSGENE, a highly toxic gas, and other lung and eye irritating products. The ultraviolet (radiant) energy of the arc can also decompose trichloroethylene and perchloroethylene vapours to form phosgene. DO NOT WELD or cut where solvent vapours can be drawn into the welding or cutting atmosphere or where the radiant energy can penetrate to atmospheres containing even minute amounts of trichloroethylene or perchloroethylene.

5.2.3 Fire and explosion prevention

Causes of fire and explosion are:

- Combustibles reached by the arc, flame, flying sparks, hot slag or heated material;
- Misuse of compressed gases and cylinders;
- short circuits.

BE AWARE THAT flying sparks or falling slag can pass through cracks, along pipes, through windows or doors, and through wall or floor openings, out of sight of the goggled operator. Sparks and slag can fly 10M.

To prevent fires and explosion: keep equipment clean and operable, free of oil, grease, and (in electrical parts) of metallic particles that can cause short circuits. If combustibles are in area, do NOT weld or cut. Move the work if practicable, to an area free of combustibles. Avoid paint spray rooms, dip tanks, storage areas, ventilators. If the work cannot be moved, move combustibles at least 10M, away out of reach of sparks and heat; or protect against ignition with suitable and snug fitting, fire- resistant covers or shields.

Walls, ceilings, and floor near work should be protected by heat resistant covers or shields. Fire watcher must be standing by with suitable fire extinguishing equipment during and for some time after welding or cutting if:

- appreciable combustibles (including building construction) are within 10m.
- appreciable combustibles are further than 10m but can be ignited by sparks.
- openings (concealed or visible) in floors or walls within 10m can expose combustibles to sparks.
- d) combustibles adjacent to walls, ceilings, roofs or metal partitions can be ignited by radiant or conducted heat.

After work is done, check that area is free of sparks, glowing embers, and flames. An empty container that held combustibles, or that can produce flammable or toxic vapours when heated, must never be welded on or cut, unless container has first been cleaned. This includes.....a thorough steam or caustic cleaning (or a solvent or water washing, depending on the combustible's solubility) followed by purging and inerting with nitrogen or carbon dioxide, and using protective equipment.

Water filling just below working level may substitute for inerting.

A container with unknown contents should be cleaned (see paragraph above), do NOT depend on sense of smell or sight to determine if it is safe to weld or cut.

Hollow castings or containers must be vented before welding or cutting - they can explode.

In explosive atmospheres, never weld or cut where the air may contain flammable dust, gas, or liquid vapours.

5.3 Electric arc(MIG,TIG) welding

Comply with precautions in 1 above, and this section. Arc welding, properly done, is a safe process, but a careless operator invites trouble. The equipment carries high currents at significant voltages. The arc is very bright and hot. Sparks fly, fumes rise, ultraviolet and infrared energy radiates, weldments are hot. The wise operator avoids unnecessary risks and protects himself and others from accidents.

5.3.1 Burn protection

Comply with precautions in 2. The welding arc is intense and visibly bright. Its radiation can damage eyes, penetrate lightweight clothing, reflect from light coloured surfaces, and burn the skin and eyes. Skin burns resemble acute sunburn, those from gas - shielded arcs are more severe and painful.

DON'T GET BURNED! COMPLY WITH PRECAUTIONS!

a) Protective clothing

Wear long sleeved clothing (particularly for gas shielded arc) in addition to gloves, apron and shoes (2A). As necessary, use additional protective clothing such as leather jacket or sleeves, flameproof

apron, and fire-resistant leggings. Avoid outer garments of untreated cotton. **Bare skin protection:** Wear dark substantial clothing, Button collar to protect chest and neck and button pockets to prevent entry of sparks.

b) Eye and head protection

Protect eyes from exposure to arc. NEVER look at an electric arc without protection. Welding helmet or shield containing a filter plate shade no. 12 or denser must be used when welding. Place over face before striking arc. Protect filter plate with a clear cover plate. Cracked or broken helmet or shield should NOT be worn; radiation can pass through to cause burns. Cracked, broken, or loose filter plates must be replaced IMMEDIATELY. Replace clear cover plate when broken, pitted, or spattered. WE SUGGEST you wear flash goggles with side shields under the helmet, to give some protection to the eyes should the helmet not be lowered over the face before an arc is struck. Looking at an arc momentarily with unprotected eyes (particularly a high intensity gas-shielded arc) can cause a retinal burn that may leave a permanent dark area in the field of vision. Before welding whilst wearing contact lenses, seek advice from your optician.

c) Protection of nearby personnel

For production welding, a separate room or enclosed bay is best. In open areas, surround the operation with low reflective, non-combustible screens or panels. Allow for free air circulation, particularly at floor level. Provide face shields for all persons who will be looking directly at the weld. Others working in the area should wear flash goggles. Before starting to weld, make sure that screen or bay doors are closed.

5.3.2 Toxic fume prevention

Comply with precautions in 2B. Generator engine exhaust must be vented to the outside air. Carbon monoxide can kill.

5.3.3 Fire and explosion prevention

Comply with precautions in 2C. Equipment's rated capacity. Do not overload arc welding equipment. It may overheat cables and cause a fire. Loose cable connections may overheat or flash and cause a fire. Never strike an arc on a cylinder or other pressure vessel. It creates a brittle area that can cause a violent rupture or lead to such a rupture later under rough handling.

5.3.4 Shock prevention

Exposed live conductors or other bare metal in the welding circuit, or in unearthed, electrically-LIVE equipment can fatally shock a person whose body becomes a conductor. DO NOT STAND, SIT, LIE, LEAN ON, OR TOUCH a wet surface when welding, without suitable protection.

5.3.5 Protection for wearers of electronic life support devices (pacemakers)

Magnetic fields from high currents can affect pacemaker operation. Persons wearing electronic life support equipment (pacemaker)

should consult with their doctor before going near arc welding, gouging, or spot welding operations.

5.3.6 To protect against shock:

Keep body and clothing dry. Never work in damp area without adequate insulation against electrical shock. Stay on a dry duckboard, or rubber mat when dampness or sweat can not be avoided. Sweat, sea water, or moisture between body and an electrically LIVE part - or earthed metal - reduces the body surface electrical resistance, enabling dangerous and possibly lethal currents to flow through the body.

a) Earthing the equipment

When arc welding equipment is earthed according to the National Electrical Code, and the workpiece is earthed, a voltage may exist between the electrode and any conducting object. Examples of conducting objects include, but are not limited to, buildings, electrical tools, work benches, welding power source cases, workpieces, etc. Never touch the electrode and any metal object unless the welding power source is off. When installing, connect the frames of each unit such as welding power source, control, work table, and water circulator to the building earth.

Conductors must be adequate to carry earth currents safely. Equipment made electrically LIVE by stray current may shock, possibly fatally. Do NOT EARTH to electrical conduit, or to a pipe carrying ANY gas or a flammable liquid such as oil or fuel.

b) Electrode holders

Fully insulated electrode holders should be used. Do NOT use holders with protruding screws or with any form of damage.

c) Connectors

Fully insulated lock-type connectors should be used to join welding cable.

d) Cables

Frequently inspect cables for wear, cracks and damage. IMMEDIATELY REPLACE those with excessively worn or damaged insulation to avoid possibly lethal shock from bared cable. Cables with damaged areas may be taped to give resistance equivalent to original cable. Keep cable dry, free of oil and grease, and protected from hot metal and sparks.

e) Terminals and other exposed parts

Terminals and other exposed parts of electrical units should have insulating covers secured before operation.

f) Electrode

a) Equipment with output on/off control (contactor) Welding power sources for use with the gas metal arc welding, gas tungsten arc welding and similar processes normally are equipped with devices that permit on/off control of the welding power output. When so equipped the electrode wire becomes electrically LIVE when the power source switch is ON and welding gun switch is closed. Never touch the electrode wire or any conducting object in contact with the

electrode circuit unless the welding power source is off. b) Equipment without output on/off control (no contactor) Welding power sources used with shielded metal arc welding and similar processes may not be equipped with welding power output on/off control devices. With such equipment the electrode is electrically LIVE when the power switch is turned ON. Never touch the electrode unless the welding power source is off.

g) Safety devices

Safety devices such as interlocks and circuit breakers should not be disconnected or shunted out. Before installation, inspection, or service of equipment, shut OFF all power and remove line fuses (or lock or red-tag switches) to prevent accidental turning ON of power. Do not open power circuit or change polarity while welding. If, in an emergency, it must be disconnected, guard against shock burns, or flash from switch arcing. Always shut OFF and disconnect all power to equipment. Power disconnect switch must be available near the welding power source.

6. Preparation Of The Working Area

The working area must be sufficiently spacious, not humid, and well-ventilated as to avoid any fumes which develop from the welding process and from incidental material adhering to the pieces to be welded (oils, paints, tars...) which may cause annoyance to the operator. Avoid welding by contact with humid parts nearby combustible liquids. Least of all, do not weld upon tanks which may contain flammable residuals.

ADDITIONAL SAFETY PRECAUTIONS FOR MIG WELDING

- ✓ **ALWAYS** ensure that there is full free air circulating around the outer casing of the machine, and that the louvres are unobstructed.
- ✓ Welding arc can seriously damage your eyes. Both operator and spectators must **ALWAYS** use a proper welding face shield or helmet, with suitable filter lenses. Proper gloves and working clothes should be worn at all times.
- ✓ **ALWAYS** inspect the hose before use to ensure it is in good condition.
- ✓ **ALWAYS** keep the free length of hose outside the work area.
- ✓ **ALWAYS** remove all flammable materials from the welding area.
- ✓ **ALWAYS** Keep fire extinguisher handy....' **Dry Powder, CO2 or BCF, NOT Water**
- ✗ **NEVER** remove any of the panels unless the machine is disconnected from the supply, AND never use the machine with any of the panels removed.

- ✗ **NEVER** attempt any electrical or mechanical repair unless you are a qualified technician. If you have a problem with the machine contact your local dealer.
- ✗ **NEVER** use or store in a wet/damp environment. DO NOT EXPOSE TO RAIN.
- ✗ **NEVER** continue to weld, if, at any time, you feel even the smallest electric shock. Stop welding IMMEDIATELY, and DO NOT attempt to use the machine until the fault is diagnosed and corrected.
- ✗ **NEVER** point the MIG torch at any person or animal.
- ✗ **NEVER** touch the MIG torch nozzle until the welder is switched OFF and the nozzle has been allowed to cool off.
- ✗ **NEVER** connect, disconnect, or attempt to service the MIG torch, until the machine is switched OFF and disconnected from the mains supply.
- ✗ **NEVER** allow the cables to become wrapped around the operator or any person in the vicinity.

DANGER – ELECTRIC SHOCK CAN BE FATAL.

A Person qualified in first aid should always be present in the working area. If person is unconscious and electric shock is suspected, do not touch the person if he or she is in contact with the welder or cables. Disconnect the welder from the power source and then use first aid. Dry wood, or other insulating material can be used to move cables, if necessary, away from the person.

7. Safety Equipment

A comprehensive range of safety equipment for use when welding is available from your local dealer.

NO-GAS WELDING – PRINCIPLES OF OPERATION

MIG (Metal Inert Gas) welding is a process in which a power wire electrode is fed continuously into the weld pool at a controlled, constant rate.

The wire is connected to the negative side of a rectified voltage supply. The workpiece is connected to the positive side of the supply.

When the wire is fed, it comes into contact with the workpiece and an arc is struck. The arc melts the wire and the material, fusing it together.

The wire, which is fed by the wire feed motor is fed into the weld pool, burning itself off at a rate dependent upon the selected wire feed speed.

To protect the weld pool from oxidation and impurities during the welding process, a shielding gas flows over and around the weld pool. This gas flow is provided by a flux core within the welding wire electrode. The flux melts due to the heat produced, giving off a gas. This gas prevents oxygen, in the surrounding air, from coming into contact with the molten pool at a critical time. Solidification takes place, creating a much stronger, cleaner weld, free of impurities.

BENEFITS OF NO-GAS MIG WELDING

1. No need for cumbersome or short life gas bottles
2. Better outdoor use as wind has less chance of disturbing the gas shroud.
3. 50% faster welding time.
4. Operator training time kept to a minimum.
5. There is no slag removal, thus eliminating almost all post-welding cleaning operations.
6. Minimum waste of welding consumables.
7. Overall, a faster more efficient way of getting the job done.
8. Less heat - less distortion.
9. Ability to weld thin material.

8. Technical Data

Specifications:

DJMMIG130(NO GAS)

Mains Voltage -	230V / 50Hz
Rated Max. Supply Current -	16A
Output Amperage Range @	
Duty Cycle –	50A@60% 120A@ 10%
No Load Voltage -	33V
Suitable Size Flux Cored -	0.6-0.9mm
Wire Spool Capacity -	Up to 1Kg

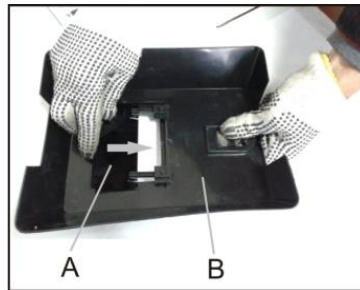
DJMMIG195(GAS/NO GAS)

Mains Voltage -	230V / 50Hz
Rated Max. Supply Current -	20A
Output Amperage Range @	
Duty Cycle –	180A@ 10%
No Load Voltage -	23-43V
Suitable Size Flux Cored -	0.8-1.0mm
Wire Spool Capacity -	Up to 1Kg

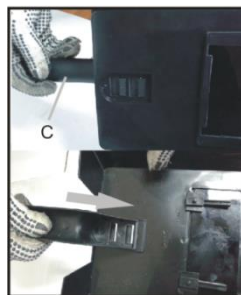
9. Assembly & Installation

9.1 Fitting the welding screen

- Place the welding glass (A) over it in the frame for welding screen(B).



- Insert the handle welding mask hole.



9.2 Fitting the wire spool

Wire types

Various welding wires are required for different applications. The welding set can be used with welding wires with a diameter of 0.9 mm(For DJMMIG130) or 1.0mm(For DJMMIG195). The appropriate feed rollers and contact tubes are supplied with the set. The feed roller, contact tube and wire cross-section must always match each other.

Wire spool capacity

Wire spools with a maximum weight of 0.45 kg can be fitted in the welding set. (For DJMMIG130)

Wire spools with a maximum weight of 1 kg can be fitted in the welding set. (For DJMMIG195)

9.3 Inserting the wire spool

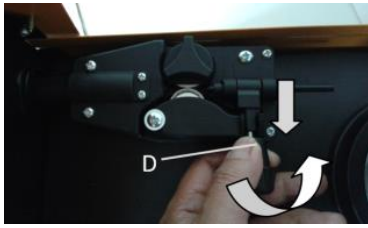
- Unlock the housing cover by turning the fastening screw through 90° and flip open the cover.

- Check that the windings on the spool do not overlap so as to ensure that the wire can be unwound evenly.

- Place the wire spool on the spool holder . Ensure that the end of the welding wire is unwound on the side of the wire guide, see arrow.



- Inserting the welding wire and adjusting the wire guide
- Pull the pressure roller spring and swing it upward.



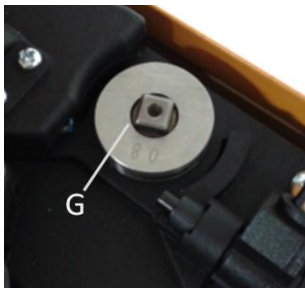
- Pull the pressure roller holder(E) downwards .



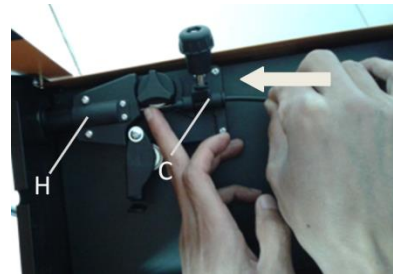
- Swing the screws (F) 90 ° and pull off upwards.



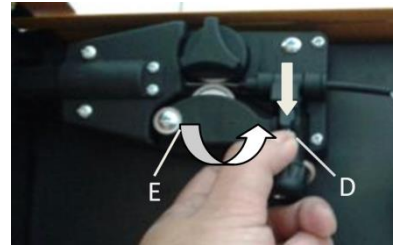
- Check the feed roller (G). The appropriate wire thickness must be specified on the top of the feed roller (G). The feed roller (G) is fitted with two guide grooves. Turn the feed roller (G) over if necessary or replace it.



- Position the feed roller holder (G) again and secure it.
- Remove the gas nozzle (10) from the torch (11) by turning it clockwise, unscrew the contact tube (15). Place the hose package (9) on the floor as straight as possible pointing away from the welding set.
- Cut off the first 10 cm of the welding wire to produce a straight cut with no shoulders, warping or dirt. Deburr the end of the welding wire.
- Push the welding wire through the guide tube (C) between the pressure and feed rollers (G) into the hose package mounting (H). Carefully push the welding wire by hand into the hose package until it projects out of the hose package by approx. 1 cm at the torch.



- Push the pressure roller holder(E) upwards and Pull the pressure roller spring(D) and swing it downward.



- Screw the appropriate contact tube for the welding wire diameter on to the torch and fit the gas nozzle, turning it clockwise.
- Set the adjusting screw for the roller brake (I) so that the wire can still be moved and the roller stops automatically after the wire guide has been braked.



10.Operation

Before any work on the machine itself, remove the mains plug from outlet.

Setting

Since the welding set must be set to suit the specific application, we recommend that the settings be made on the basis of a test weld.

10.1 MIG Welding principles

MIG (Metal Inert Gas) welding allows you to fuse together two similar metals without altering the properties of the metal.

A consumable wire electrode is continuously fed through the welding torch that is fitted with a concentric gas nozzle. the wire is connected to a high voltage supply which creates an electric arc between the electrode (the wire) and the workpiece. The arc is used to create the required heat to turn the metal into a molten state. The wire is used as both the electrode and as a filler.

The gas is used to prevent oxidation and to shield the arc and the weld from atmospheric contamination. The choice of gas is dependent upon the material being welded.

When using the welder in a gasless configuration the shielding gas is created from the flux within the welding wire.

When using the welder outside, you may need to erect a wind break to make sure the shielding gas is not blown away, thereby leaving a poor quality weld.

10.2 Gas/No-Gas Selection (for with DJMMIG195)

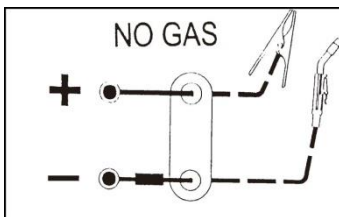
The welder can be configured to weld, with or without a gas supply according to the type of welding wire being used.

- Mild Steel solid core (With Gas),
- Flux Cored (No Gas)



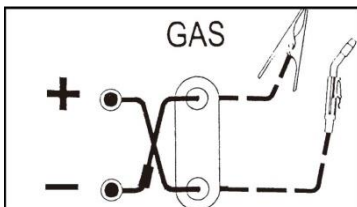
Welding without gas

- If using 0.9mm flux cored wire, connect the terminal as shown.
- The earth cable (Thicker Lead) should be connected to the positive (Red) terminal.
- The cable from torch (Thinner Lead) should be connected to the Negative (Black) terminal



Welding with gas

- If using solid cored wire 0.6/0.8mm mild steel, connect the terminal as shown.
- The earth cable (Thicker Lead) should be connected to the negative (Black) terminal.
- The cable from torch (Thinner Lead) should be connected to the positive (Red) terminal.



CONNECTING THE GAS SUPPLY

- Connect a bottled gas supply to the small tube at the back of the welder.

10.3 OPERATING THE WELDER

Setting the welding current

The welding current can be set to 2 different levels using the welding current adjustment switch. The required welding current depends on the material thickness, the required penetration depth and the welding wire diameter.



Setting the wire feed speed

The wire feed speed is automatically adjusted to the current setting. The final wire feed speed setting can be made on the welding wire speed controller. It is advisable to start with the medium setting and to re-adjust the speed as necessary. The required quantity of wire depends on the material thickness, the penetration depth, the welding wire diameter and also the size of the gap to be bridged between the workpieces you wish to weld.



Electrical connection

- Before you connect the equipment to the mains supply make sure that the data on the rating plate are identical to the mains data.
- The equipment may only be operated from properly earthed and fused shock-proof sockets.

Connecting the earth terminal

Connect the welding set's earth terminal in the immediate vicinity of the welding position if possible. Ensure that the contact point is bare metal.

Welding

- When all the electrical connections for the power supply and welding current circuit have been made, you can proceed as follows:
- The workpieces for welding must be clear of paint, metallic coatings, dirt, rust, grease and moisture in the area where they are to be welded.
- Set the welding current and wire feed

- Hold the welding screen in front of your face and move the welding nozzle to the point on the workpiece where you wish to complete the weld. Now press the torch switch.
- When the arc is burning, the welding set will feed wire into the weld pool. When the weld nugget is large enough, move the torch slowly along the required edge. Move it to and fro if necessary to enlarge the weld pool a little.
- Find the ideal setting of the welding current and wire feed speed by carrying out a test weld. Ideally an even welding noise will be audible. The penetration depth should be as deep as possible, but the weld pool must not be allowed to fall through the workpiece.
- Do not remove the slag until the weld has cooled. If you want to continue a welding job on an interrupted weld seam, the slag from your initial attempt must first be removed.

11.Safety equipment

Thermostat

The welding set is fitted with an overheating guard that protects the welding transformer from overheating. If the overheating guard trips, the control lamp on your set will be lit. Allow the welding set to cool for a time.

12.Maintenance

Frequency of maintenance operations depends on the operating conditions, how intensively the welder is used, and how clean or dirty the welding site is (aggressive atmospheres, etc).

Always inspect the cables, both earth and torch cable, before use to ensure they are in perfect condition.

Ensure the earth clamp is clean and secured correctly to the cable.

Check the hose for security and serviceability.

As a general rule the covers should be removed and the transformer, and other components, should be inspected at least annually.

Consult your dealer for advice if necessary.

Welding shield

Always maintain the welding mask in good condition. If the clear glass protection lens becomes badly pitted, sufficient to interfere with vision, or cracked, have it replaced immediately.

Replacement clear and dark lenses are available from your dealer - see Parts Lists for details. NEVER use any dark filter lens other than that provided by my company, or one with the same certified 'Optical class' (degree of protection).

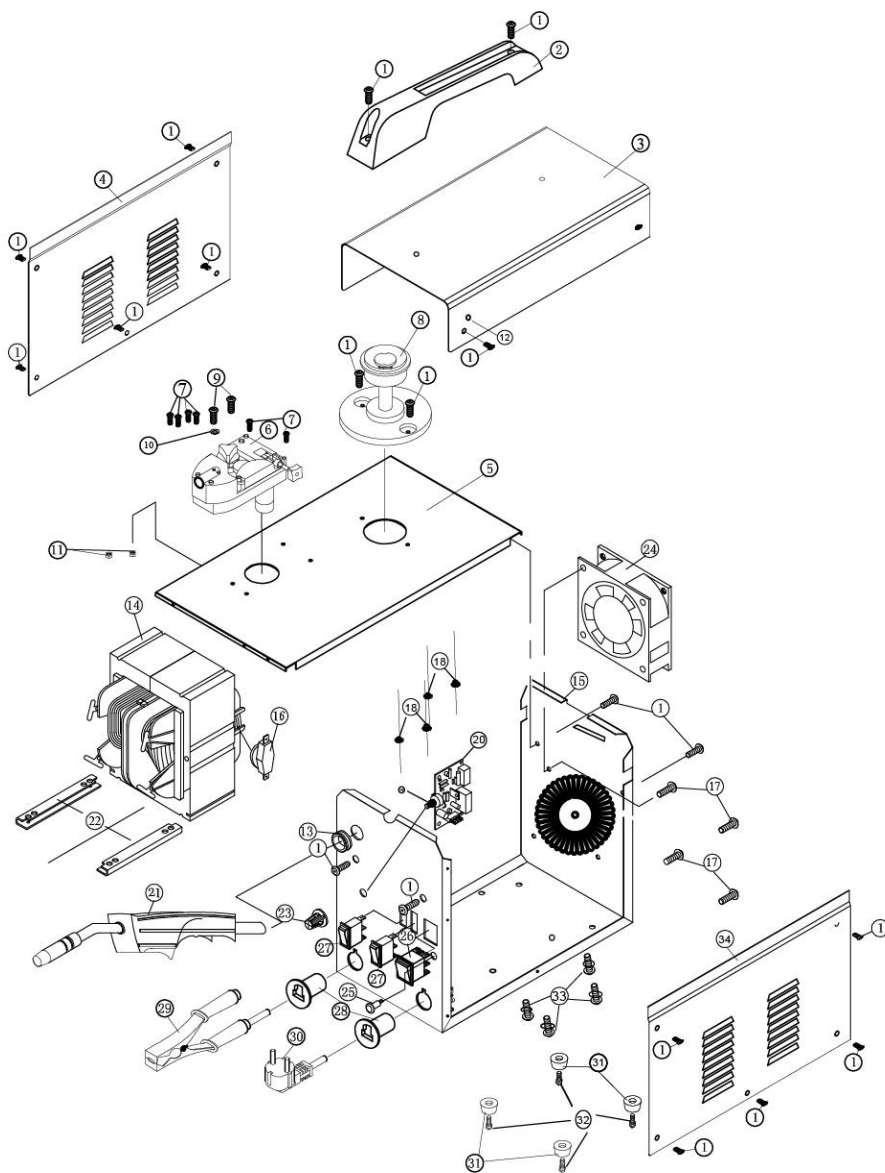
The shield should always be cleaned with a clean soft cloth after use, ensuring the lenses are clean. Remove any dust that may have accumulated and store it in a safe place where it cannot be damaged. NEVER use a shield that is not in perfect condition.

13.Parts List and Parts Diagram

DJMMIG130

No.	Description	No.	Description
1	Screw	10	Spacer
2	Handle	11	Nut
3	Top panel	12	Rivet
4	Left panel	13	Guard ring of torch
5	Middle panel	14	Transformer
6	Wire feed	15	Bottom panel
7	Screw	16	Thermal protection
8	Wire spool holder	17	Screw
9	Screw	18	Nut

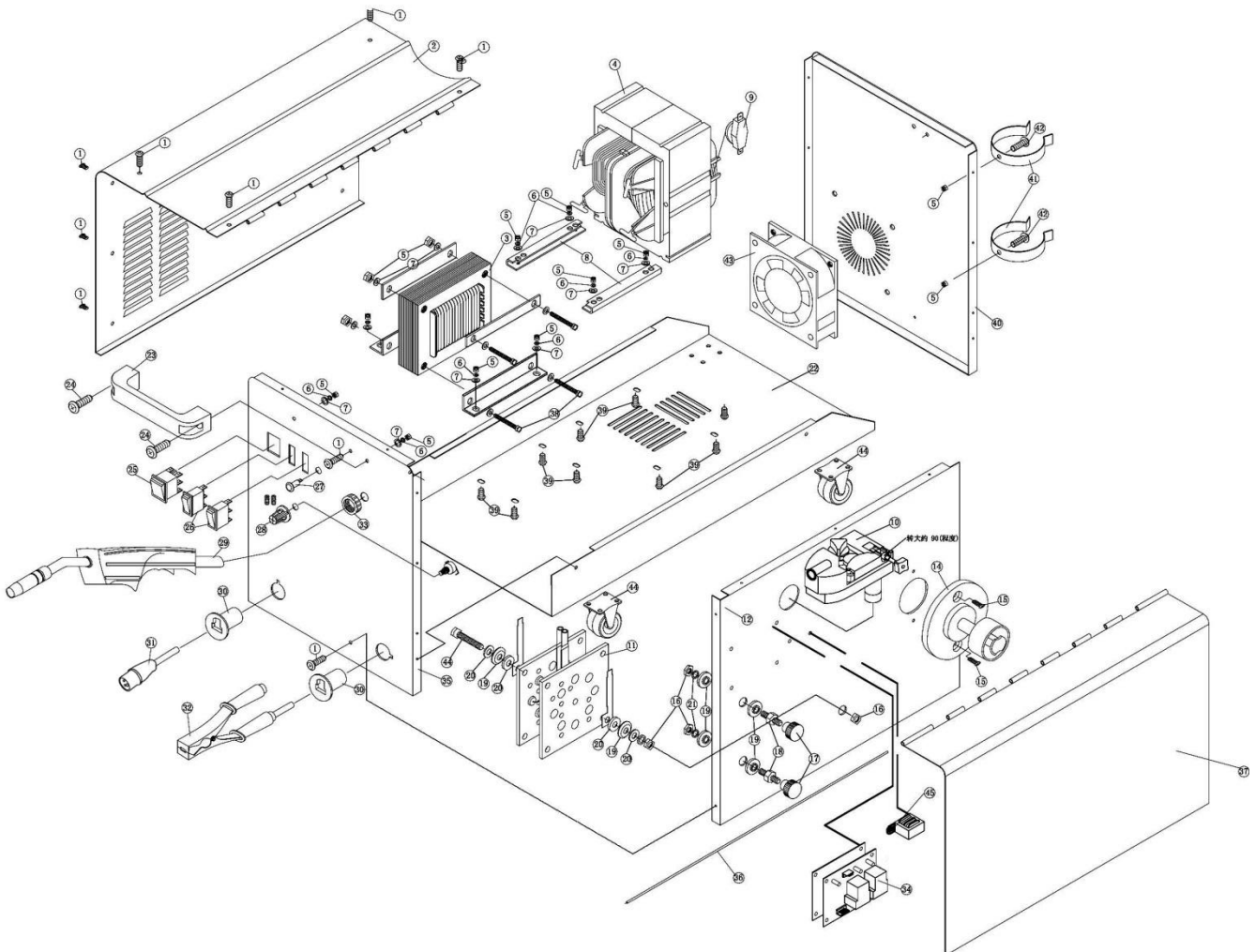
No.	Description	No.	Description
19	Potionmeter	28	Water joint
20	PC board	29	Earth clamp
21	Welding torch	30	Plug
22	Kickstand	31	Screw
23	Knob	32	Plastic foot
24	Fan	33	Screw spacer
25	Overheating indicator light	34	Right panel
26	Power switch		
27	Adjustment switch		



DJMMIG195

No.	Description	No.	Description
1	M4X12 bolt	13	M4x15 bolt
2	Left panel	14	Wire shaft collar
3	Reactor	15	M4x15 bolt
4	Transformer	16	M8 nut
5	M5 nut	17	M8 plastic nut
6	M5 spring cushion	18	Connection terminal
7	M5 plain cushion	19	Plastic insulation cushion
8	Down-bracket	20	M8 plain cushion
9	Heat element	21	M8 spring cushion
10	Wire-feeding motor	22	Bottom panel
11	Rectifier	23	Handle
12	Vertical panel	24	M5x20 bolt

No.	Description	No.	Description
25	Switch	36	Ø3 steel wire
26	Main switch	37	Right panel
27	Indicator light	38	M5x70 bolt
28	Potentiometer handle	39	M5x25 bolt
29	Electrode holder	40	Back panel
30	Infix reed	41	Bottle bracket
31	Plug	42	M5x12 bolt
32	Earth clamp	43	Fan
33	Nut	44	M8x90 bolt
34	Wire-feeding control panel	45	Transformer
35	Front panel		



DECLARATION OF CONFORMITY

Declaration of Conformity

We

DJM Direct
Unit 43-45 Churchill Way
Lomeshaye Ind. Est.
Nelson
Lancashire
BB9 6RT

As the manufacturer's authorised representative within the EC
declare that the

MIG WELDER – Part. No.DJMMIG130 DJMMIG195

Conforms to the requirements of the following directive(s), as indicated.

**2014/35/EU
2014/30/EU**

**Low Voltage Directive
EMC Directive**

And the relevant standard(s), including:

EN IEC 60974-1:2018+A1:2019

EN 50445:2008

EN 60974-10:2014+A1:2015

EN 61000-3-11:2000

EN 61000-3-12:2011

Signed:



Mr Jay McFadden - Director - DJM Direct.

Data: 18/11/2020





Please dispose of packaging for the product in a responsible manner. It is suitable for recycling. Help to protect the environment, take the packaging to the local amenity tip and place into the appropriate recycling bin.



Never dispose of electrical equipment or batteries in with your domestic waste. If your supplier offers a disposal facility please use it or alternatively use a recognised re-cycling agent. This will allow the recycling of raw materials and help protect the environment.

FOR HELP OR ADVICE ON THIS PRODUCT PLEASE CONTACT DJM:

TEL: 01282 694 914

EMAIL: sales@djmdirect.com

WEB: www.djmdirect.com