

# Stealth

## DIGI-MIG 200

Part No. 9000H

# OPERATOR'S MANUAL



# SWP

**IMPORTANT**

**Read this Owner's Manual completely** before attempting to use this equipment. Save this manual and keep it handy for quick reference. Pay particular attention to the safety instructions provided for your protection. Contact your distributor if you do not fully understand this manual.

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# 1 SAFETY

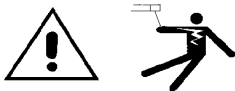


## 1.1 Signal Explanation

- The above icons mean Warning! Notice! Running and thermal parts or receiving an electric shock may harm you or others. The following precautions apply as a guide to working safely.

## 1.2 Arc Welding Damage

- The following icons explanations are to prevent accidents to you or others during the welding process.
- Only experienced personell can install, operate, maintain and repair the equipment.
- During the operation make sure those around you are properly protected.
- After turning off the machine power, please maintain and examine the equipment according to 5 due to DC voltage existing in the electrolytic capacitors.



### ELECTRIC SHOCK CAN KILL

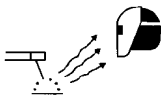
- Never touch live electrical parts.
- Wear dry, hole-free gloves and clothes to insulate yourself.
- Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.
- Take care when using the equipment in a confined space, on uneven surfaces and in damp conditions.
- Shut down the incoming electrical supply prior to the equipment’s installation.
- Ensure the equipment is installed correctly and the work or metal is earthed according to the operation manual.
- The electrode and work (or ground) circuits are ‘hot’ when the machine is on. Do not touch these electrically ‘hot’ parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.
- In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically ‘hot’.
- Always ensure the work cable makes a good electrical connection and is as close as possible to the metal being welded.
- Ensure the electrode holder, work clamp, welding cable and welding machine are in good, safe operating condition. Replace any damaged insulation.
- Never dip the electrode in water for cooling.
- Never simultaneously touch electrically ‘hot’ parts of electrode holders connected to two machines as voltage between the two can be the total of the open circuit voltage of both welders.
- When working above floor level, use a safety belt to protect yourself from a fall should you receive an electric shock.



### FUMES AND GASES CAN BE DANGEROUS

- Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases.

- When welding, keep your head out of fumes. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. When welding with electrodes which require special ventilation such as stainless or hard facing or lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and below Threshold Limit Values using local exhaust or mechanical ventilation. In confined spaces or in some circumstances, outdoors, a respirator may be required. Additional precautions are also required when welding on galvanized steel.
- Do not weld in locations near chlorinated hydrocarbon vapours coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapours to form phosgene – a highly toxic gas – and other irritating products.
- Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to ensure breathing air is safe.
- Read and understand the manufacturer's instructions for this equipment and the consumables to be used, including the material safety data sheet and follow your employer's safety practices.



### ARC RAYS CAN BURN

- Use a shield with the correct filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding.
- Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- Protect nearby personnel with suitable, non-flammable screening and/or warn them to avert their eyes from the arc rays or expose themselves to hot spatter or metal.



### SELF-PROTECTION

- Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.
- Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.



**DO NOT** add fuel near an open flame welding arc or when the engine is running. Stop the machine and allow it to cool before refuelling to prevent spilled fuel from vapourising on contact with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.



### WELDING SPARKS can cause fire or explosion

- Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to

adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.

- Where compressed gases are to be used at the job site, special precautions should be taken to prevent a hazardous situation.
- When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to ensure that any flammable or toxic vapours have been eliminated from within. They can cause an explosion even though they have been 'cleaned'.
- Vent hollow castings or containers before heating, cutting or welding. They may ignite.
- Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuff less trousers, protective shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined space. Always wear safety glasses with side shields when in a welding area.
- Connect the work cable to the work as close to the welding area as practical. Keep work cables connected to the building framework or other locations away from the welding area.



#### **Rotating parts may be dangerous**

- Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.
- Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- Cylinders should be located:
  - Away from areas where they may be struck or subjected to physical damage.
  - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- Never allow the electrode, electrode holder or any other electrically 'hot' parts to touch a cylinder.
- Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.

### 1.3 Electric and Magnetic Fields

- Electric current flowing through any conductor causes localised Electric and Magnetic Fields (EMF). The discussions of the effect of EMF is ongoing globally. Up to now, there is no material evidence that EMF has any adverse effects on health.

Minimise exposure to EMF as far as possible by applying the following procedures:

- Route the electrode and work cables together. Secure them with tape when possible.
- All cables should be stored away from the operator.
- Never coil the power cable around your body.
- Make sure welding machine and power cable are far enough away from the operator according to the working environment.
- Connect the work cable to the workpiece as close as possible to the area being welded.
- Personnel fitted with a heart-pacemaker should keep their distance from the welding area.

## 2 SUMMARY

### 2.1 Brief Introduction

The Digi-Mig 200 arc welding machine adopts the latest Pulse Width Modulation (PWM) technology and Insulated Gate Bipolar Transistor (IGBT) power module, which can change work to medium frequency to create a lightweight medium welding machine. This arc welding machine uses mixed gases Argon/CO<sub>2</sub> as shielded gas for MIG/MAG welding. Pure argon is required for TIG welding.

The Digi-Mig 200 arc welding machine has automatic protection functions with intelligent to over-voltage, over-current and over-heat. If any one of the above problems occurs, the alarm lamp on the front panel lights and the output current is automatically shut off.

### 2.2 Features

1. Digital control system – real-time display the welding parameters
2. High performance multifunction power source (MMA/MIG/MAG)
3. Waveform control – stable welding arc
4. IGBT technology – low power dissipation
5. Rated duty circle is 40% (40°)
6. Synergic control of the welding current and voltage

The Digi-Mig 200 arc welding machine is suitable for all welding positions for various metals: stainless steel; carbon steel; alloyed steel; copper; titanium; etc, with various applications including: pipe installation; mould repair; petrochemical; architectural decoration; car repair; bicycle; handicraft and DIY.

**MAG** – Metal Active Gas welding

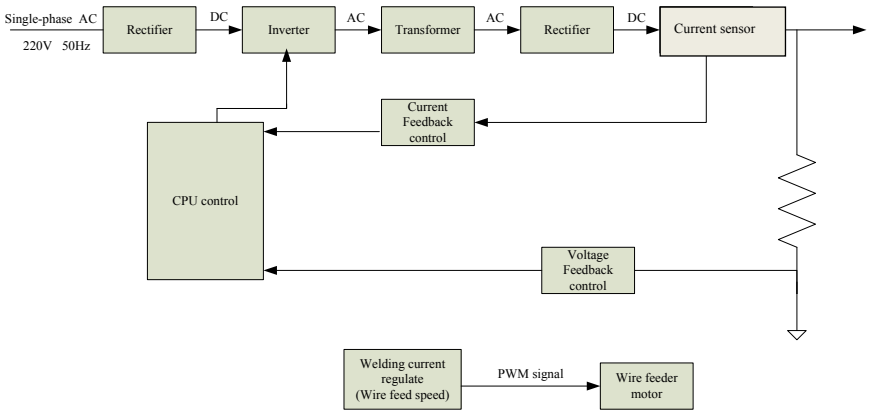
**MIG** – Metal Inert Gas welding



### 2.3 Working Principle

The working principle of the Digi-Mig 200 welding machines is shown as follows: Single-phase 220V work frequency AC is rectified into DC 350V, it is then converted to medium frequency AC (about 40KHz) by the inverter device (IGBT). The reducing of voltage using the medium transformer (the main transformer) whilst rectifying using the medium frequency rectifier (fast recovery diodes) is outputted by inductance filtering.

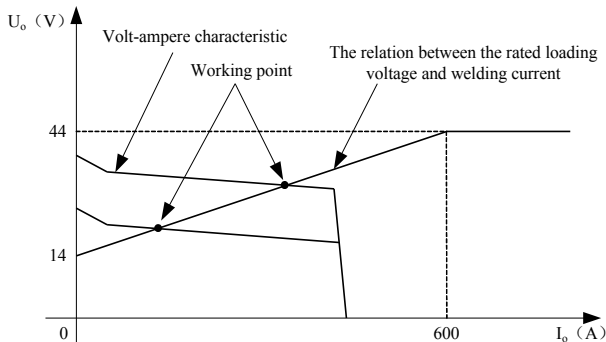
The circuit adopts current feedback control technology to ensure current output is stable when MMA or TIG welding. It also adopts voltage feedback control technology to ensure voltage output is stable when MIG welding. The welding current parameter can be adjusted continuously and infinitely to meet with the requirements of all welding processes..



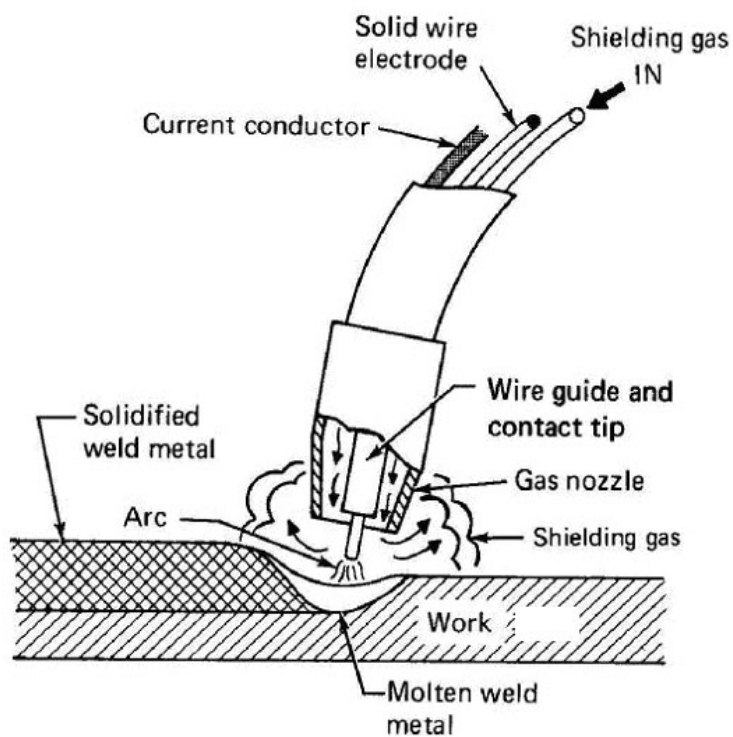
### 2.4 Volt-Ampere Characteristic

The Digi-Mig 200 welding machine has an excellent volt-ampere characteristic, shown in the graph below. The relation between the conventional rated loading voltage  $U_2$  and the conventional welding current  $I_2$  is as follows:

$$U_2 = 14 + 0.05I_2(V).$$



## 2.5 Principles of welding



### 3 INSTALLATION AND ADJUSTMENT

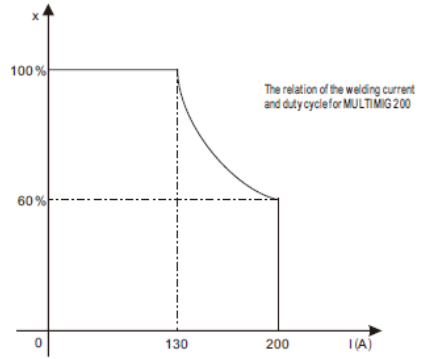
#### 3.1 Parameters

<b>DIGI-MIG 200</b>	
Input Voltage (V)	1~230±10%
Frequency (Hz)	50/60
Input Current (A)	MIG 42 MMA 44 TIG 31
Input Power (Kw)	MIG 5.9 MMA 5.3 TIG 4.3
Welding Current (A)	40-200 (MIG/MAG) 10-200 (MMA/TIG)
Welding Voltage Range (V)	13.5-27
No Load Voltage (V)	63
Duty Cycle (40°C)	40% 200A 60% 165A 100% 130A
Diameter (mm)	Fe: 0.6, 0.8, 0.9, 1.0 S/S: 0.8, 0.9, 1.0 Flux-Cored: 0.6, 0.8, 0.9, 1.0
Protection Class	IP23
Efficiency (%)	85
Insulation Class	H
Power Factor	0.75
Cooling	AF
Dimensions (mm) L × W × H	511 × 213 × 400
Net Weight (Kg)	15

### 3.2 Duty Cycle and Over-heating

The letter 'X' stands for duty cycle, which is defined as the proportion of the time that a machine can work continuously within a certain time (10 minutes). The rated duty cycle means the proportion of the time that a machine can work continuously within 10 minutes when it outputs the rated welding current.

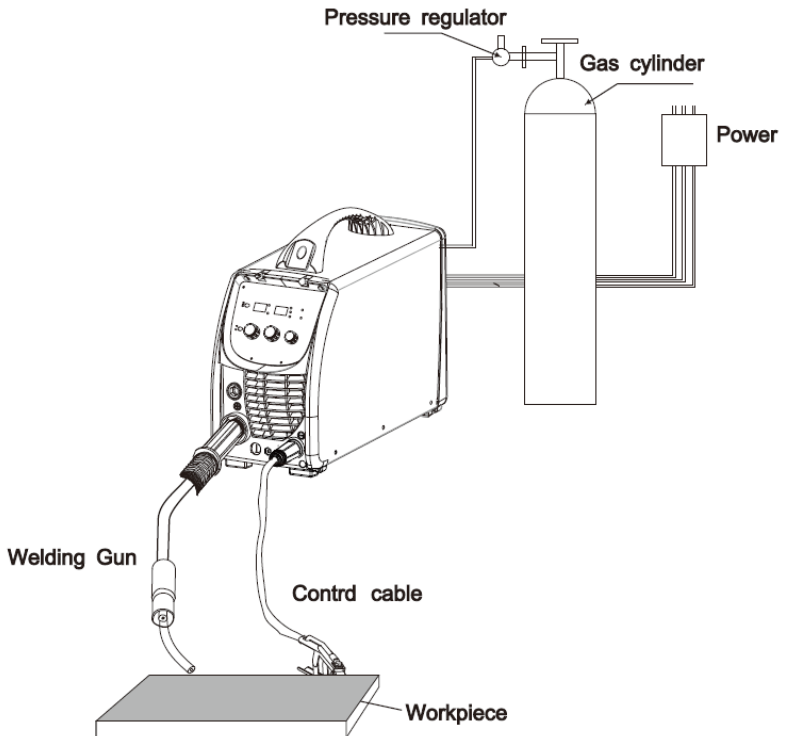
The relation between the duty cycle 'X' and the output welding current 'I' is shown as the figure on the right.



If the transformer over-heats, the heat relay inside will open and send an instruction to the circuit board, cut AC relay and the output welding current. The over-heat pilot lamp in the front panel is lit.

At this point, the machine should be turned off for 15 minutes to cool the fan. When operating the machine again, the welding output current or the duty cycle should be reduced.

### 3.3 Equipment Connection



### 3.4 Operation steps

- 3.4.1 Connect the power source input cable with the output air switch port.
- 3.4.2 Connect the wire feeder cable plug to the positive output of welding machine.
- 3.4.3 Connect the wire feeder control cable plug to the aero socket on the front board.
- 3.4.4 Connect the negative pole to the work piece (base metal).
- 3.4.5 Connect the gas cylinder output pipe to the gas valve input joint on the wire feeder and clamp it.
- 3.4.6 Insert the torch joint into the wire feeder unit output and keep the wire aimed at the wire feeder mouth.

**NOTE** The Torch euro connector should be pushed in firmly and rotated until it locks into position tightly. Ensure the torch connection pins are lined up with the brass gun housing on the machine panel.

- 3.4.7 Connect the torch shielded gas pipe with the front panel output on the wire feeder.
- 3.4.8 Connect the torch control cable pin with the two-lead aero socket on the wire feeder.
- 3.4.9 Ensure the wire diameter corresponds to the wire wheel and torch tip and press the wire with the handle.

### 3.5 Mig gun operation

#### 3.5.1 Service the wire feed mechanism every time the reel is changed:

- Check the wear of the feed roll groove and change the feed roll as necessary.
- Clean the welding gun wire guide with compressed air.

#### 3.5.2 Cleaning the wire guide

Remove all metal dust from the feed rollers which may be caused by over tightening the top tension arm. This will prevent dust from entering the wire guide causing potential wire feed problems. If the wire guide is not cleaned it gradually clogs up and causes wire feed malfunctions. Clean the wire guide in the following manner:

- Remove the welding gun's gas nozzle, contact tip and contact tip's adapter.
- With a pneumatic pistol, blow compressed air through the wire guide.
- Blow the wire feed mechanism and reel housing clean with compressed air.
- Reattach the welding gun's parts. Tighten the contact tip and contact tip's adapter.

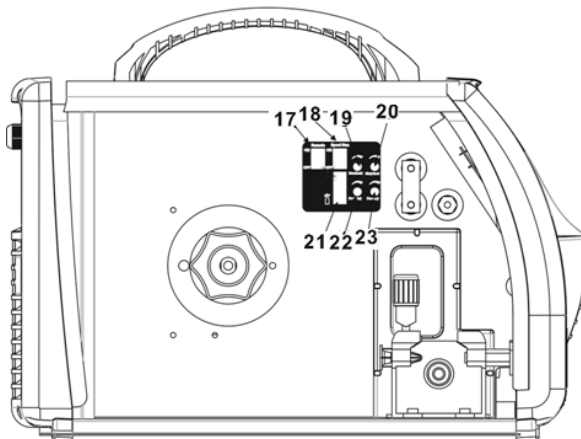
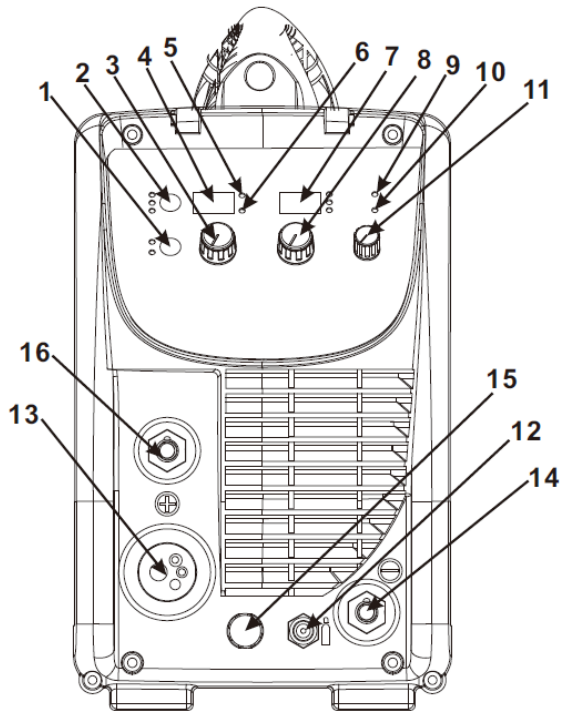
#### 3.5.3 Changing the wire guide

If the wire guide is too worn or totally clogged, replace according to the following instructions:

- Open the mounting nut of the wire guide to expose the end of the wire guide.
- Straighten the welding gun's cable and withdraw the wire guide from the gun.
- Push a new wire guide in to the gun up to the contact tip's adapter until it reaches an O-ring at the machine-end of the guide.
- Tighten the wire guide in place with the mounting nut.
- Cut the wire guide 2mm from the mounting nut and file the sharp edges of the cut round.
- Reattach the gun in place and tighten the parts.

## 4 OPERATION

### 4.1 Layout of the front and rear panel



1. Choose welding mode key:  
On TIG or MIG, press the key to choose 2T or 4T welding mode.
2. Choose welding method key:  
Press the key to choose three functions – MMA/TIG/MIG.
3. Welding current knob:  
Set the welding current.
4. Current display:  
Displays when machine is working. Set current display before welding. Unit A.
5. Wire speed LED:  
Use current setting knob to set the wire speed when LED is lit (MIG).
6. Current LED:  
When the current LED is lit, it displays the actual output welding current (MIG).
7. Voltage display:  
Displays when machine is working Set voltage display to MIG mode before welding. Unit V.
8. Welding voltage / Down slope / Arc force knob:  
On MIG, when the program voltage cannot match the welding current, the knob can adjust voltage. On TIG, the knob can adjust the current down time. On MMA, the knob can adjust the force current.
9. Power LED:  
Power LED is lit when the machine is turned on.
10. Alarm LED:  
When the welder is over voltage, less voltage, over current or over heated, the alarm pilot lamp will light.
11. Wave control knob:  
Controls arc characteristics determines the rate at which the amperage rises when a short circuit is produced.
12. TIG GAS connect.
13. MIG GUN connect.
14. Output cathode:  
When in MIG mode, this polarity must connect to the work piece
15. TIG gun control connecter.
16. Output anode:  
When in TIG mode, this polarity must connect to the work piece.
17. Remote switch.
18. Spool Gun switch.
19. Burnback knob.
20. Slow feed knob.
21. Manual wire switch and air check switch: UP for manual wire and DOWN for air check.
22. Post flow knob.
- 23 Pre-flow knob.



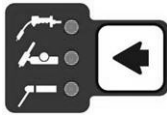
## 4.2 MIG welding operation

### 4.2.1 Shielding gas material selection:

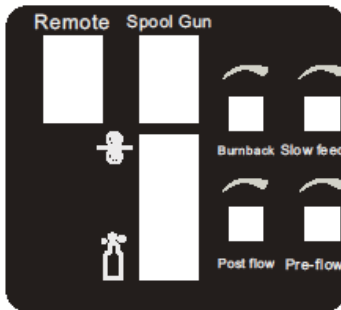
- Ferrous – 80% Ar + 20% CO<sub>2</sub>
- Stainless Steel – 98% Ar + 2% O<sub>2</sub>
- Aluminium – 100% Ar

### 4.2.2 Welding state choice:

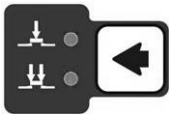
- Press the Weld key and select MIG mode – the LED is lit:



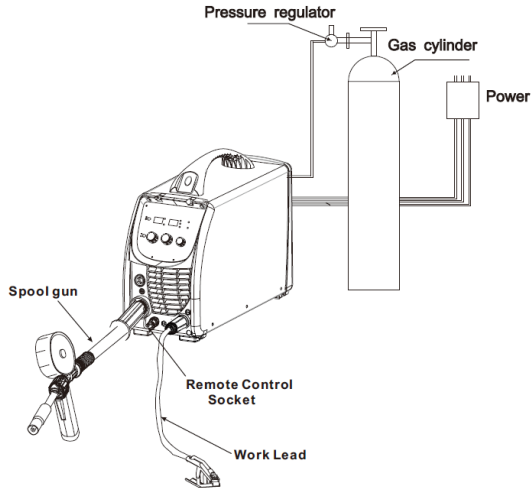
- Turn off Spool Gun switch (down)
- Manual Wire switch and Air Check switch, Burnback adjust, Slow Feed adjust, Post Flow adjust, Pre-Flow adjust:



### 4.2.3 Press the welding mode key, select 2T or 4T:



### 4.2.4 Turn on Spool Gun switch (up)



Setup for spool gun welding with gas shielded MIG wire

#### 4.2.5 Welding parameter adjustment

- For different wire diameters, the minimum welding current available will vary
- Adjust Current knob – the corresponding welding voltage is changed automatically
- When the programmable welding voltage is not suitable for the operator – the voltage can be finely adjusted by the knob
- The arc characteristics can be adjusted using the wave control knob

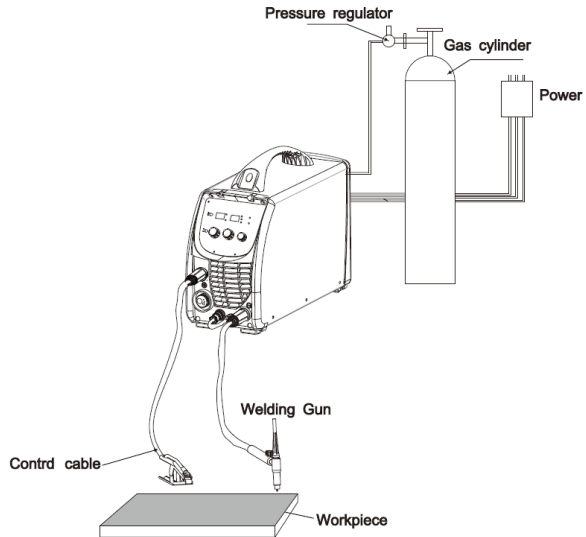
### 4.3 TIG welding operation

4.3.1 Press the welding operation key, select TIG mode – LED is lit

4.3.2 Press the welding mode key, select 2T or 4T

4.3.3 Adjust the current knob to control the welding current

4.3.4 Adjust the down slope knob to control the welding current descend time



#### 4.4 MMA welding operation

4.4.1 Press the weld key, choose MMA mode – LED is lit

4.4.2 Adjust the current knob to control the welding current

4.4.3 Adjust the welding arc force knob to control the arc force current

**NOTE** The current (amps) is set prior to welding, the current displayed when welding will vary slightly as will the welding voltage displayed depending on the arc length maintained.

#### 4.5 Welding parameters

Wire diameter (mm)	Welding current (A)	Plate thickness (mm)
0.6	25-110	1.0-1.6
0.8	35-160(200)	1.0-2.3
0.9	45-160(200)	1.0-2.3
1.0	45-160(200)	1.2-6

#### 4.6 Operation Environment

- Height above sea level below 1000m
- Operation temperature range:  $-10^{\circ}\text{C}\sim+40^{\circ}\text{C}$
- Relative humidity below 90% ( $20^{\circ}\text{C}$ )
- Preferably site the machine above floor level with the maximum angle not exceeding  $15^{\circ}$ .
- Protect the machine against heavy rain, hot environments and direct sunshine
- The content of dust, acid, corrosive gas in the surrounding air or substance should not exceed normal standards
- Take care that there is sufficient ventilation during welding and there is at least 30cm free distance between the machine and wall

#### 4.7 Operation Notices

- Read all notes carefully before attempting to use this equipment
- Connect the ground wire with the machine directly, and refer to 3.5
- If the power switch is accidentally closed, no-load voltage may be exported. Do not touch the output electrode with any part of your body
- Ensure that the input is single-phase: 50/60Hz, 220/230/240V $\pm$ 10%
- Before operation ensure no other personnel is present without proper eye protection
- Ensure good ventilation of the machine to improve duty ratio.
- Turn off the engine when the operation finished to economize energy source.
- If the power switch shuts off accidentally, do not restart until the problem is resolved
- In case of any unresolved problems, contact your authorised dealer

## 5 MAINTENANCE AND TROUBLESHOOTING

### 5.1 Maintenance

In order to guarantee that an arc welding machine works efficiently and safely, it must be maintained regularly. Read and understand the maintenance methods and regularly carry out safety checks. Make any repairs as required in order to extend the service life of the welding machine. Maintenance items are detailed in the following tables.

- **Warning: Safely maintain the machine by shutting off the power supply and waiting for 5 minutes until the capacity voltage drops to a safe voltage of 36V.**

DATE	MAINTENANCE CHECKS
Daily examination	<p>Observe whether panel knob and switch in the front and at the back of arc welding machine are flexible and placed correctly. If the knob has not been correctly installed, please correct. If this is not possible, replace immediately.</p> <p>If the switch is not flexible or it cannot be correctly installed, please replace immediately. Contact your distributor if there are no parts to hand.</p> <p>After switching on power, watch and listen to check the arc welding machine is not shaking, whistling or giving out an unusual odour. If so, investigate and eliminate. If any problem persists please contact your distributor.</p> <p>Observe the LED is working correctly. If the number is not displayed, replace the LED. If it still does not work, maintain or replace the display PCB.</p> <p>Observe whether the min/max value on LED accords with the set value. If there is any difference and it has affected the normal welding process, adjust accordingly.</p> <p>Check fan for damage and correct rotation. If damaged, change immediately. If the fan does not rotate after the arc welding machine is overheated, check the blade is not obstructed. If the fan still does not rotate after eliminating the above, push the blade in the direction the fan rotates. If the fan rotates normally, the start capacity should be replaced. If not, change the fan.</p> <p>Check whether the fast connector is loose or overheated. If so, it should be fastened or changed.</p> <p>Check the current output cable is not damaged. If so, it should be securely insulated or replaced.</p>

DATE	MAINTENANCE CHECKS
Monthly examination	Use dry compressed air to clear the inside of arc welding machine. Pay particular attention to clear any dust on radiator, main voltage transformer, inductance, IGBT module, the fast recover diode and PCB, etc.  Check the arc welding machine bolt. If loose, tighten. Replace if worn. Scrape off any rust to ensure it works efficiently.
Quarterly examination	Check the actual current accords with the displaying value. If not, they should be reconfigured. The actual current value can be measured by the adjusted plier-type ampere meter.
Annual examination	Measure the insulating impedance among the main circuit, PCB and case. If it is below 1MΩ, insulation may be damaged and should be repaired or replaced.

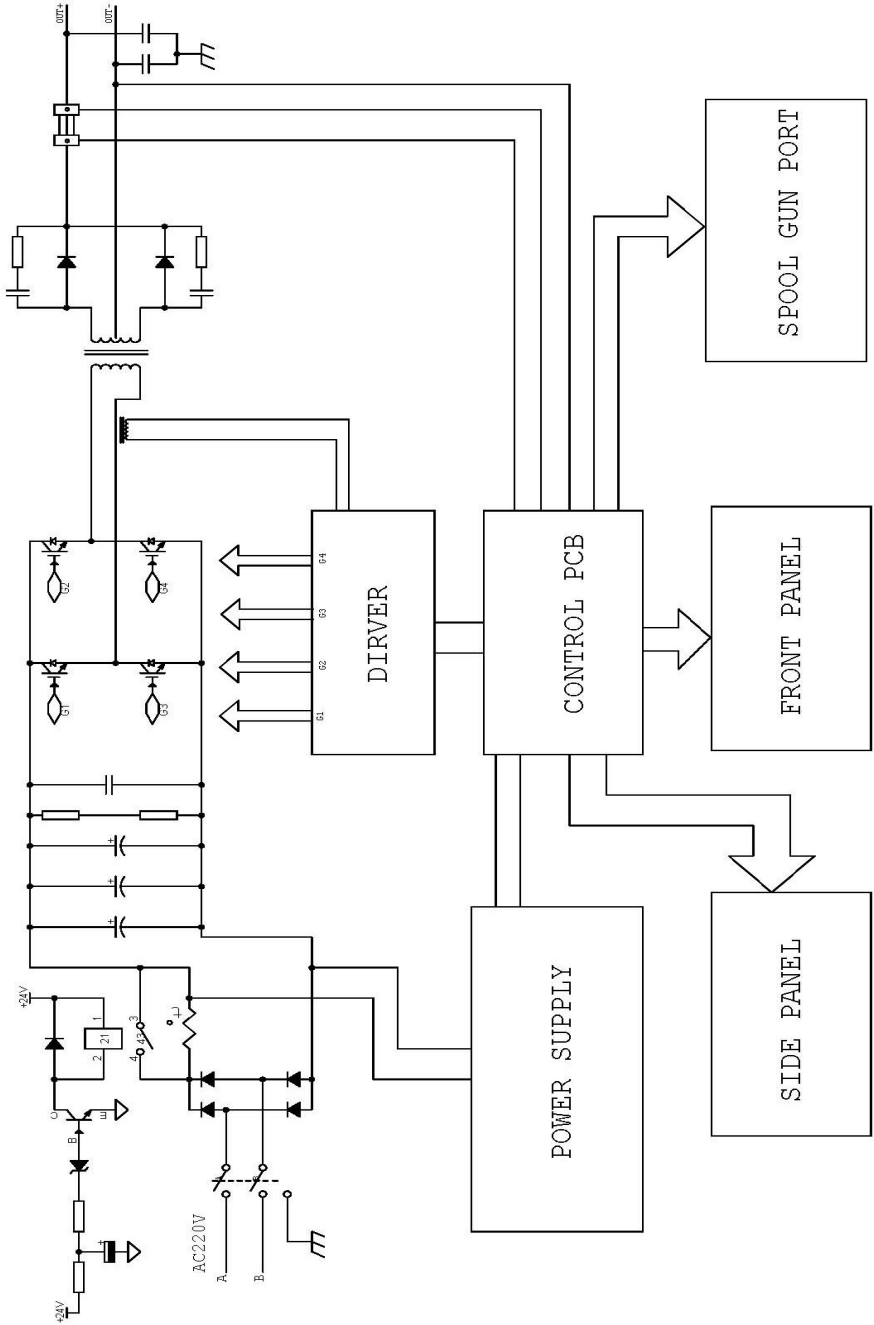
**5.2 Troubleshooting**

- Before arc welding machines are dispatched from the factory, they have already been carefully checked. Do not allow anyone unauthorised to make any alterations to the equipment.
- Maintenance work must be carefully undertaken. If any wire becomes loose or misplaced, it may be a potential danger to the user.
- Only authorised professional maintenance personnel should overhaul the machine.
- Ensure the arc welding machine’s power is switched off before the mains power to the machine is switched on.
- If any problems persist contact an authorised professional or your supplier.

S/N	PROBLEM		REASON	SOLUTION
1	The breaker is closed but the power light is not lit		Breaker damaged	Change breaker
			Fuse damaged	Change fuse
			Check power input	Try another power input
2	After welding the machine is over heated and fan does not work		Fan damaged	Change fan
			Cable is loose	Tighten cable
3	Gun switch pressed but no shielded gas output	No output gas when tested	No gas in the gas cylinder	Change gas cylinder
			Gas pipe leaks gas	Change gas pipe
			Electromagnetic valve damaged	Change valve
		Gas output when tested	Control switch damaged	Change switch
			Control circuit board damaged	Change circuit board

S/N	PROBLEM		REASON	SOLUTION
4	Wire-feeder does not work	Wire reel does not work	Motor damaged	Check and change
			Control circuit board damaged	Change circuit board
	Wire reel works		Press wheel is loose or weld wire skids	Re-tighten
			Wheel does not fit with weld wire diameter	Change wheel
			Wire reel damaged	Change wire reel
			Wire feed pipe jammed	Repair or change
			Tip jammed due to splash	Repair or change
5	No striking arc and no voltage output		Output cable is badly connected or loose	Tighten or replace
			Control circuit board damaged	Change circuit board
6	Welding stops and alarm light is on		Machine is self-protected	Check over-voltage, over-current, over-temperature, lower-voltage and resolve
7	Welding current runs away and cannot be controlled		Potentiometer is damaged	Check and replace
			Control circuit is damaged	Check the circuit and replace
8	The crater current cannot be adjusted		PCB is damaged	Check and replace
9	No post-gas		PCB is damaged	Check and replace

### 5.3 Main Electrical Diagram





## 6 PARTS LIST

9000H-02	DOOR
9000H-03	COVER
9000H-05	REAR PANEL
9000H-07	ON/OFF SWITCH
9000H-12	FAN
9000H-16	ROTARY SWITCH
9000H-17	ROCKER SWITCH
9000H-18	MOTOR
9000H-21	BASE PANEL
9000H-26	FRONT PANEL
9000H-29	EURO SOCKET
9000H-32	DINSE SOCKET
9000H-33	KNOB 21mm
9000H-34	KNOB 16mm
9000H-36	DISPLAY PCB
9000H-38	CONTROL PCB
9000H-40	RECTIFIER
9000H-42	SOLENOID VALVE
9000H-43	ADJUSTMENT PCB
9000H-44	POWER PCB ASSEMBLY







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