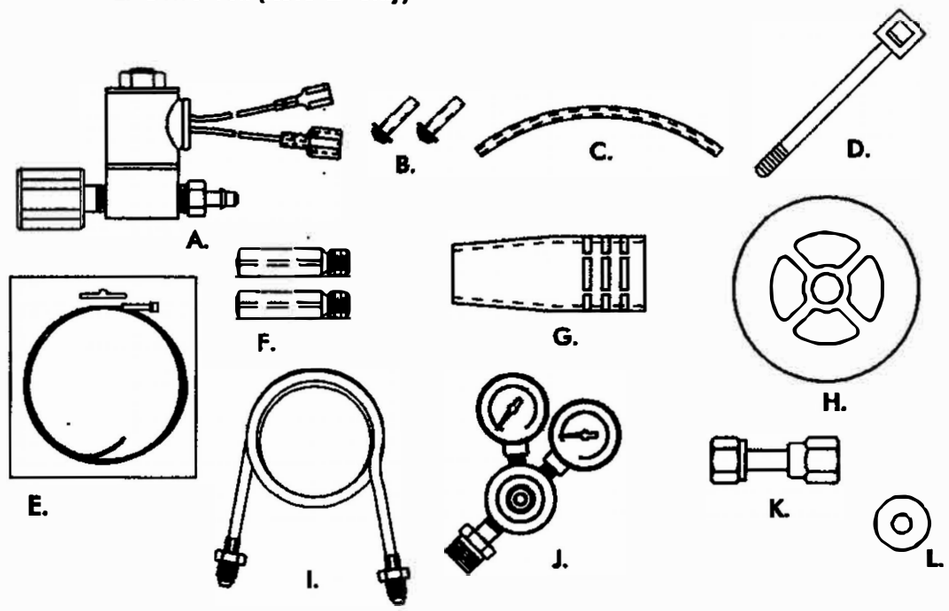
INSTALLATION INSTRUCTIONS FOR THE K610-1 AND K610-2 MIG CONVERSION KITS FOR USE WITH THE "WELD-PAK" AND "PRO" SERIES WELDERS

Be sure you have the correct kit for your machine.
115/120 Volt machines require the K610-1 MIG Conversion Kit with a 120 Volt gas solenoid. (Check label on solenoid.)
208/230 Volt machines require the K610-2 MIG Conversion Kit with a 208 Volt gas solenoid. (Check label on solenoid.)

You should find the following parts included with your kit:

A. Gas solenoid assembly (120 or 208 volt, depending on kit)
B. Two #8 Phillips head machine screws with captive lockwashers
C. 22" plastic tube
D. Nylon cable tie
E. Gun liner for .025-.030" wire
F. Two .025" contact tips
G. Gas nozzle assembly
H. 2 lb. spool of .025" L-56 electrode wire
I. 52" gas hose with brass fittings
J. Gas regulator with gauges
K. Adapter for CO2 gas cylinder
L. Drive roll (K610-2 only)



You will need the following tools for the installation: Phillips head screwdriver, pliers, small cutters, 5/16" (8 mm) nut driver or medium size flathead screwdriver, and an adjustable wrench.

A. INSTALLATION OF GAS SOLENOID

1. Turn off welder and unplug from power source. If machine is still in carton, unpack according to instructions given in instruction manual.

> **CAUTION** The voltage rating of the gas solenoid is different for each kit. Installing the wrong gas solenoid in machine may result in damage to the machine and /or gas solenoid.

K610-1: MIG Conversion Kit (120V solenoid for use with 115/120V input):

Connect one lead from the gas solenoid to the terminal labeled "H1", located on the circuit board in the absolute lower left corner. Refer to Figure 6. Connect remaining lead from the gas solenoid to the terminal labeled "H2", located directly above "H1".

K610-2: MIG Conversion Kit (208V solenoid for use with 208/230V input):

Connection of solenoid valve assembly depends upon whether machine is connected for 230V or 208V. As shipped from the factory, machine is connected for 230V. Refer to your Operator's Manual for information on reconnecting for 208V.

If your machine is connected for 230V input:

Remove the tape that is wrapped around the input cord inside the machine near the case back. Removing this tape should expose a connection consisting of an insulated male connector and an uninsulated female connector. This is the "H3" lead assembly shown on the Wiring Diagram inside the machine cover. Disconnect these leads if they are connected together, and connect the insulated male connector to the mating insulated female connector of the gas solenoid. Insulate the unused uninsulated female connector for 300V and tape it to the input cord. Connect the uninsulated female connector of the gas solenoid to the lowest positioned "H2" terminal located at the far left side of the circuit board. Refer to Figure 6.

If your machine is connected for 208V input:

Connect the uninsulated female connector of the gas solenoid to the lowest positioned "H2" terminal located at the far left side of the circuit board. Refer to Figure 6. Remove only the tape securing the insulated male "H3" lead to the input cord and connect it to the insulated female lead from the gas solenoid. Look for "H3" stenciled in white letters somewhere on the end of the lead near the terminal. Be sure that the "H1" lead is still insulated for 300V and secured to the input cord.

12. Reinstall the hinged side door.
13. Reinstall the top screw which secures the case back to the center panel. (Refer to step 3)
14. Replace the case side and the 8 screws which secure it. This completes the installation of the gas solenoid assembly.

B. INSTALLATION OF MIG WIRE

Refer to instruction manual for details concerning the following conversions which are required when changing wire size and type:

* Change output polarity (to DC[+] for MIG welding).
* Change drive roll and/or orientation for size wire selected.
* Replace gun liner and tip with size corresponding to wire size selected.
* Remove gasless nozzle (if installed) and replace with gas nozzle.
* Load wire into machine and gun cable assembly.

C. INSTALLATION OF GAS REGULATOR AND HOSE

Refer to the operator's manual included with your welder for details on safety, installation and adjustment, of the gas regulator, hose, and CO2 cylinder adapter if required. The included adaptor is required using the regulator with CO2 gas cylinders instead of Argon-mixed gas cylinders.

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You should find the following parts included with your kit:

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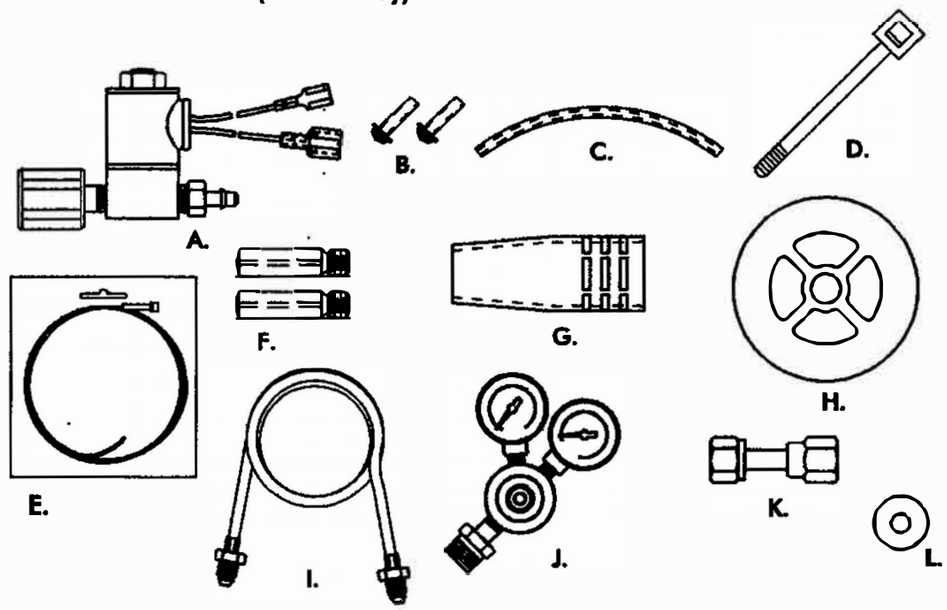

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1. Turn off welder and unplug from power source. If machine is still in carton, unpack according to instructions given in instruction manual.

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K610-1: MIG Conversion Kit (120V solenoid for use with 115/120V input):

Connect one lead from the gas solenoid to the terminal labeled "H1", located on the circuit board in the absolute lower left corner. Refer to Figure 6. Connect remaining lead from the gas solenoid to the terminal labeled "H2", located directly above "H1".

K610-2: MIG Conversion Kit (208V solenoid for use with 208/230V input):

Connection of solenoid valve assembly depends upon whether machine is connected for 230V or 208V. As shipped from the factory, machine is connected for 230V. Refer to your Operator's Manual for information on reconnecting for 208V.

If your machine is connected for 230V input:

Remove the tape that is wrapped around the input cord inside the machine near the case back. Removing this tape should expose a connection consisting of an insulated male connector and an uninsulated female connector. This is the "H3" lead assembly shown on the Wiring Diagram inside the machine cover. Disconnect these leads if they are connected together, and connect the insulated male connector to the mating insulated female connector of the gas solenoid. Insulate the unused uninsulated female connector for 300V and tape it to the input cord. Connect the uninsulated female connector of the gas solenoid to the lowest positioned "H2" terminal located at the far left side of the circuit board. Refer to Figure 6.

If your machine is connected for 208V input:

Connect the uninsulated female connector of the gas solenoid to the lowest positioned "H2" terminal located at the far left side of the circuit board. Refer to Figure 6. Remove only the tape securing the insulated male "H3" lead to the input cord and connect it to the insulated female lead from the gas solenoid. Look for "H3" stenciled in white letters somewhere on the end of the lead near the terminal. Be sure that the "H1" lead is still insulated for 300V and secured to the input cord.

12. Reinstall the hinged side door.
13. Reinstall the top screw which secures the case back to the center panel. (Refer to step 3)
14. Replace the case side and the 8 screws which secure it. This completes the installation of the gas solenoid assembly.

B. INSTALLATION OF MIG WIRE

Refer to instruction manual for details concerning the following conversions which are required when changing wire size and type:

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