

Eastwood

DO THE JOB RIGHT.

Part #13898

SPOOL GUN INSTRUCTIONS

For use with MIG 175 Welder



The **Eastwood Spool Gun** offers professional level MIG welding with aluminum, steel or stainless wire. The flexibility of the spool gun is highlighted when using aluminum wire, as the traditional MIG torch does not feed the softer aluminum wire very well. The spool gun not only feeds the wire at very consistent speeds but also eliminates “birds nests” in the drive roller. Lightweight, comfortable trigger and handle design. Quick change drive roller and wire mounting hardware make this unit a must have for anyone welding aluminum sheet metal or heavier gauge plate.

WARNING – ARC WELDING CAN BE HAZARDOUS!

When using this tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment. Carefully read the operation manual prior to using, installing and maintaining the electric welding machine for the purpose of preventing damages such as fire and electric shock from occurring. Please keep the manual for future reference.

- **ELECTRIC SHOCK CAN KILL!** Improper use of electric arc welders can cause electric shock, injury, and death! Take all precautions described in this manual to reduce the possibility of electric shock.
- **FUMES AND GASES CAN BE DANGEROUS!** Do not breathe fumes that are produced by the arc welding operation. These fumes are dangerous. Always use enough ventilation to insure breathing air is safe.
- **WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!** Do not operate any electric arc welder in areas where flammable or explosive vapors may be present. Take precautions to be sure that flying sparks and heat do not cause flames in hidden areas, cracks, etc. Always keep a fire extinguisher accessible while performing arc welding operations.
- **ARC RAYS CAN BURN!** Use a shield with a minimum of a #11 shade to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87.1 standards. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- **HOT METAL CAN BURN!** Electric arc welding operations cause sparks and heat metal to temperatures that can cause severe burns! Use protective gloves and clothing when performing any metal working operation.
- **ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS!** The electromagnetic field that is generated during arc welding may interfere with the operation of various electrical and electronic devices such as cardiac pacemakers. Persons using such devices should consult with their physician prior to performing any electric arc welding operations.

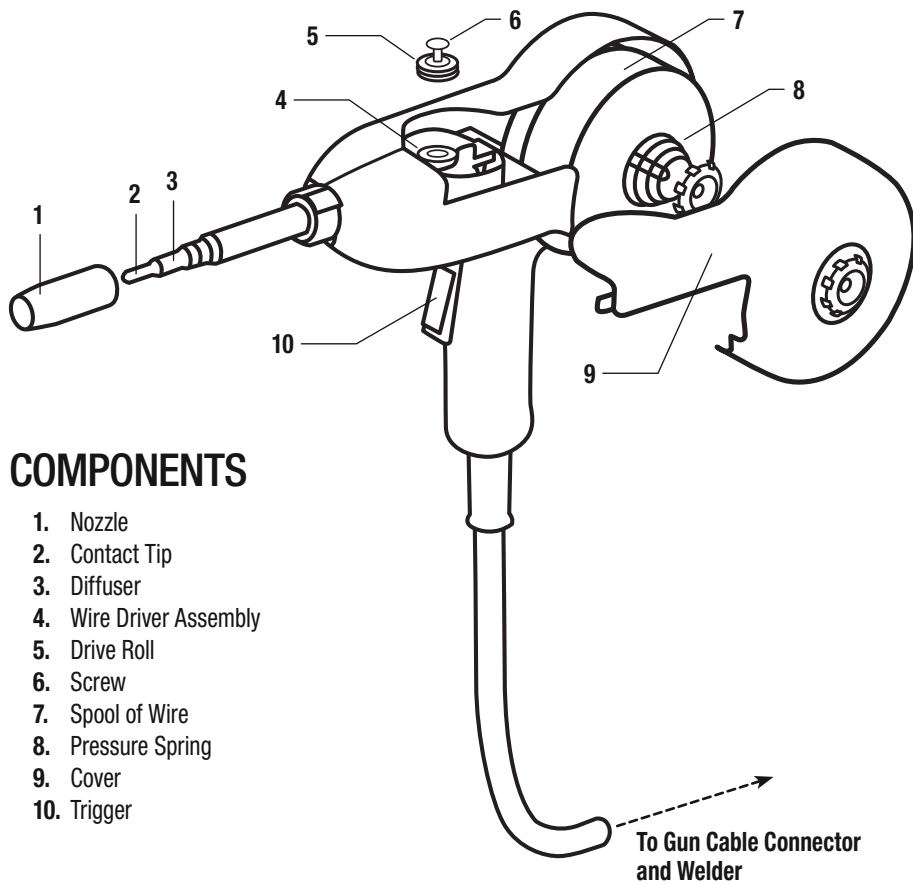
SPECIFICATIONS

- **Welding Process:** Aluminum GMAW (MIG)
- **Wire Sizes (Dia.):** Solid wire 0.030” or 0.035”
- **Spool Size:** 1 lb. weight, 4” dia. spool
- **Rated Welding Current:** 130amps @ 30% duty cycle
- **Rated Input Voltage:** 12V DC
- **Wire Feed Rate:** 1.0-13m/min
- **Shielding Gas:** 100% Argon

INCLUDES

- Torch
- 1 lb. 0.9mm Aluminum Wire
- 0.9mm Contact Tip



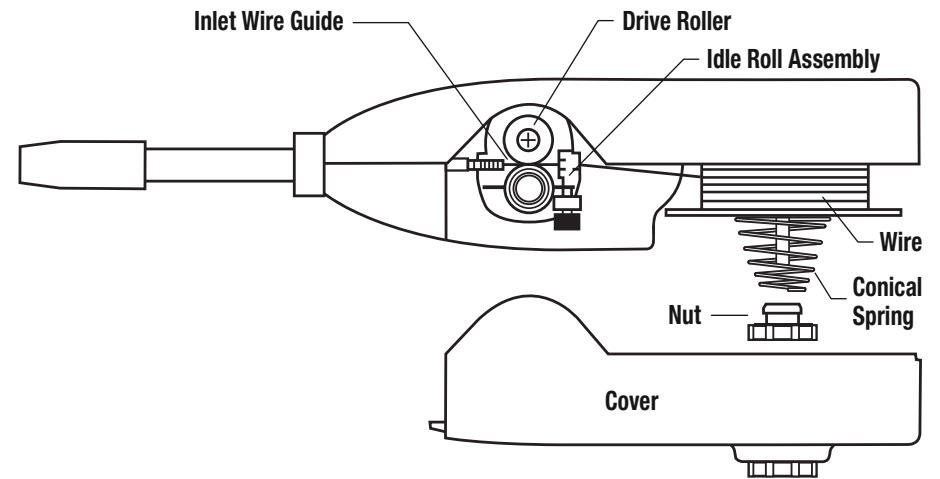


COMPONENTS

1. Nozzle
2. Contact Tip
3. Diffuser
4. Wire Driver Assembly
5. Drive Roll
6. Screw
7. Spool of Wire
8. Pressure Spring
9. Cover
10. Trigger

CONNECTING SPOOL GUN

1. Unplug machine from power supply at wall or extension cord.
2. Fully insert Gun Cable Connector into machine in place of existing MIG Gun. Make sure brass fitting is fully seated to assure no gas leaks. Hand tighten hold-down screw.
3. Plug Electrical Connector Control Leads into the Connector Key Way on the machine.



LOADING ALUMINUM WIRE

1. Remove Cover, Nut, and Conical Spring in sequence. Load 4" wire on the spindle.
NOTE: The direction of the wire running is counterclockwise. Then reinstall parts in reverse order.
2. Cut off bent end of wire, leaving 4" long straight section
3. Gently pull open the Idle Roll Assembly to expose the Drive Roll Groove. Guide straightened wire through Inlet Wire Guide.
4. Release the Idle Roll Assembly and the straightened wire.

WELDING PROCEDURE

1. Connect Input Power to the machine.
2. Remove the Nozzle and Contact Tip.
3. Press the Trigger – the Driver feeds the wire into the gun. Release the Trigger when wire comes out from the end of the gun.
4. Screw on the Contact Tip and Nozzle.
5. Cut off the aluminum wire so that it extends about 1/4" (6-10mm) from the contact tip.

BEFORE WELDING

1. Set Voltage/Wire Speed according to chart below.
2. Work in a "push" motion. A "stitch" type weld works the best on aluminum.

Reference Parameters for Aluminum Welding

Method of Welding	Welding Wire Specs	Shielding Gas	Metal Thickness			
			0.8mm	1.6mm	2.5mm	3mm
MIG DC +	Aluminum Welding Wire with 0.9mm dia.	100% Argon	E-6	G-7	H-10	J-9

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: techhelp@eastwood.com

PDF version of this manual is available online >> eastwood.com/13898manual

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