1.

Assemble welding cart as per the included instructions

2.

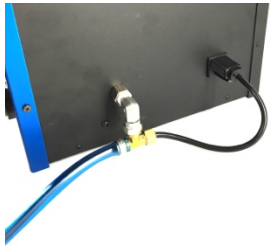
Place Nitrogen tank into rear of welding cart. *Use safety chains to secure tank*

3.

Remove NW650 plastic welder and place on work table

4.

Connect Hot Air / N2 welding torch to main control unit



5.

Connect airless welder to power plug

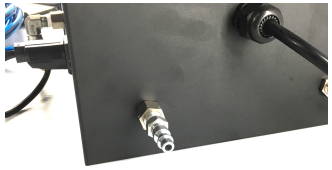
6.

Attach hot air and airless welder holster to right hand side of unit. Place complete unit on welding cart

7.

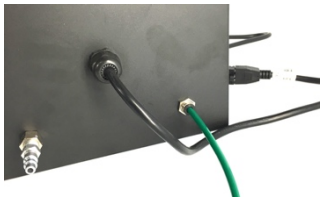
Connect air supply to “Air IN” port

Add ¼” male quick disconnect to Air IN port



8.

Connect Nitrogen to “Nitrogen IN” port



*Connect the supplied tube to your **PRESSURE REGULATOR** of the N2 tank*

9.

Ensure Airless Temp and N2 temp dials are set to “0”

When both temperature settings are at ‘0”, current is < 0.5A

NITROWELD NW650

Quick Start Guide

10.

Connect 110/120V main power supply to unit.

The RED LED will illuminate when the power cable is connected

11.

Switch ON main power switch

Green LED will illuminate on power switch

Check voltage – 110 – 120V

Check current <0.5A

Main green LED ON

This LED will remain ON until the main switch is powered OFF

12.

Airless Welder Test

Turn ON airless welder

- RED LED will illuminate

Check current on multi-meter

DO NOT TOUCH WELDER

Current increases to between 0.6 and 1A

13.

Hot Air Welder Test

Set gas selector to “Air” (pull out knob)

If using N2 tank – use compressed air for pre-heating and cooling off

Open pressure regulator set outlet pressure to between 5 – 10 psi

and

13A.

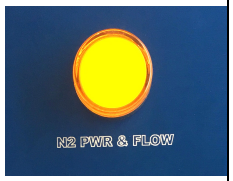
Amber LED will illuminate

Air will flow out of welding torch

Air / N2 will not heat up until the N2 Temperature is adjusted.

See next step for N2 temperature adjustment

NB: if using a N2 tank, always use compressed air for pre-heating and cooling the air welding torch



13B.

Adjust N2 temperature to “7”

- Check current on multi-meter
- **Adjust temperature for different material melting points**

13C.

DO NOT TOUCH WELDER

CAUTION – Air from welding torch extremely HOT

14.

COOL DOWN – SYSTEM SHUT OFF

Turn OFF airless welder

RED LED will switch OFF

14b.

Set N2 Temperature switch to “0”

- Check multi-meter current <1A
- Allow welding torch to cool down before shutting off air supply