

## ***Start Welding***

1. Turn on Gas tank  $\frac{1}{4}$  turn COUNTER-CLOCKWISE
2. Turn butterfly valve CLOCKWISE slowly until gage reads "20"
3. Plug MIG in wall outlet
4. Adjust Voltage according to chart
5. Adjust wire speed according to chart
6. Make sure wire extends  $\frac{1}{2}$  inch out of welding nozzle
7. Clamp ground to work
8. Turn on machine
9. Wear welding helmet

## ***Shutting Down***

1. Disconnect ground
2. Turn both voltage and wire speed knobs to "0"
3. Shut off main tank valve by turning the valve CLOCKWISE
4. Pull nozzle trigger to bleed gas lines
5. When both gages reach "0" release butterfly knob COUNTER-CLOCKWISE until it turns off freely
6. Turn MIG off
7. Coil all wires and store off the floor
8. Unplug MIG