ITEM# 262

# QUICK START GUIDE

Forney

## 1.

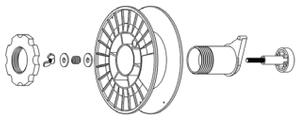
**Read User Manual**




## 2.

**Install wire spool**
0.030" (0,8mm) diameter

8" (200mm) wire spool

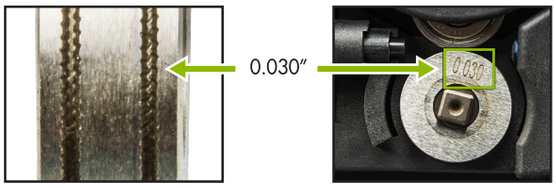


4" (100mm) wire spool



## 3.

**Set Drive Roll**
Ensure the correct wire diameter is visible on the drive roll when installed. Choose between 0.030"-0.035" with included drive roll.



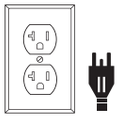

## 4.

**Set Drive Roll Pressure**
For proper tension align the tops of the screw and nut together.



## 5.

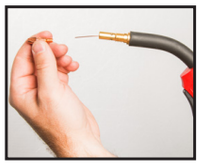
**Connect to 120V Input Power**



- Generator Safe: Use power source with 4000W of continuous output, no low-idle, 5% THD max.
- Extension Cord: #12 AWG or larger, 25' (8m) or shorter.

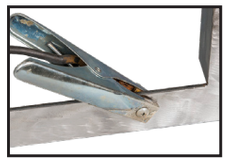
## 6.

**Feed Wire**
Remove consumables and depress trigger until wire comes out. Replace consumables.



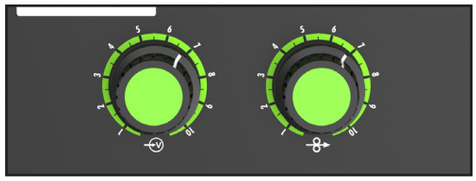
## 7.

**Ground Workpiece**
Connect ground clamp to clean, bare metal.



## 8.

**Adjust Settings**
Adjust the wire feed speed (-8-) and voltage (V). See the chart on the welder for correct settings.



## 9.

**Begin Welding**
With contact tip 1/4" from metal, depress trigger completely to initiate arc.



**FIND MORE INFORMATION AT FORNEYIND.COM**

**QUESTIONS OR TROUBLE?**
**Contact Forney Industries at 1-800-521-6038 customerservice@forneyind.com forneyind.com**

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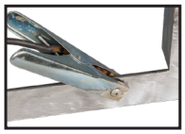
## FLUX-CORED TROUBLESHOOTING TIPS

### Do Not Weld Aluminum



- Welding aluminum requires shielding gas. This machine is only for gas-less flux-cored welding.
- This machine cannot connect to a spool gun, which is recommended for aluminum.

### Workpiece Grounding



Connect the ground clamp to clean, bare metal. No rust, paint or other coatings. Attach the ground clamp directly to the workpiece if you are experiencing issues.

### Too Much Spool Tension

Wire from spool to drive should relax with a slight curve after feeding.





### Incorrect Drive Roll Pressure

Too little pressure = Roll can slip and feed can be erratic.

Too much pressure = can crush wire, causing wire feeding problems and welder damage.



### Frequently Tripping Circuit Breaker or Exceeding Duty Cycle

Trying to weld single pass on material larger than 1/4" (6mm) thick is not possible with this machine. Multi-pass recommended for thicker materials.

Welder should be the only thing plugged into the circuit.

### Low Weld Output or Poor Fusion

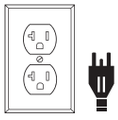
- Usually due to low input power.
- Welder should be only thing plugged into circuit.
- Avoid using extension cords. If one must be used, it must be #12 AWG or larger; 25' (8m) or shorter.
- Generators must be 4000W continuous output and not have a low-idle function (or have it disabled).

### Solid Green AND Solid Yellow Lights



Duty cycle exceeded or insufficient air flow. Allow machine to cool.

Incorrect input power. Verify power source is 120V +/- 10%.



### Solid Green AND Flashing Yellow Lights



The gun was triggered when the machine was powered on. Release the trigger.

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