

# **VEVOR<sup>®</sup>**

**TOUGH TOOLS, HALF PRICE**

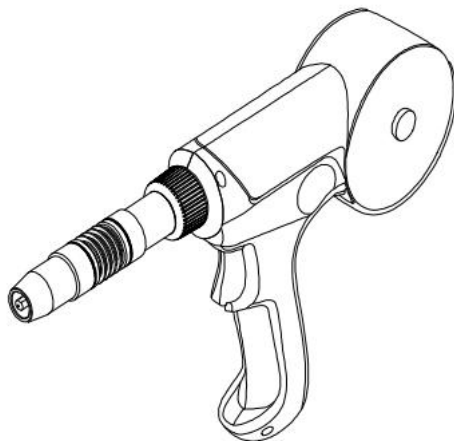
Technical Support and E-Warranty Certificate [www.vevor.com/support](http://www.vevor.com/support)

## **Spool Gun HBT200**

**MODEL: XLHBTSR200**

We continue to be committed to provide you tools with competitive price.  
"Save Half", "Half Price" or any other similar expressions used by us only represents an estimate of savings you might benefit from buying certain tools with us compared to the major top brands and does not necessarily mean to cover all categories of tools offered by us. You are kindly reminded to verify carefully when you are placing an order with us if you are actually Saving Half in comparison with the top major brands.

**MODEL: XLHBTSR200**



**NEED HELP? CONTACT US!**

Have product questions? Need technical support? Please feel free to contact us:

**Technical Support and E-Warranty Certificate**  
**[www.vevor.com/support](http://www.vevor.com/support)**

This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

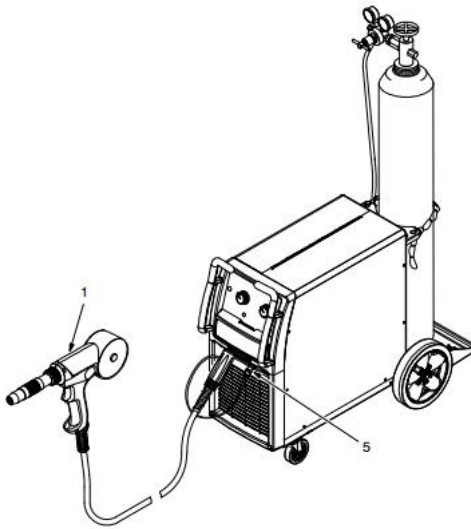
# Operation Manual

Please Carefully read the operation manual prior to using, installing and maintaining the electric welding machine for the purpose of preventing damages such as fire, electric shock and etc from occurring. Please keep the manual for the reference in the future

## Specifications and Parameters

<b>Model</b>	<b>XLHBTSR200</b>
<b>Welding Process</b>	<b>Aluminum GMAW(MIG)</b>
<b>Wire Size(in):</b>	<b>.030"-.035"</b>
<b>Spool Size</b>	<b>4 in. (102 mm) Diameter</b>
<b>Rated Welding Current</b>	<b>200amp (60% duty cycle)</b>
<b>Rated input Voltage</b>	<b>24V DC</b>
<b>Wire Feed Rate</b>	<b>70-875 ipm (1.8-22.2 m/min.)</b>

# 1. Connecting Spool Gun Machine



1 Spool Gun

2 Drive Assembly

3 Gun End

4 Gun Securing Knob

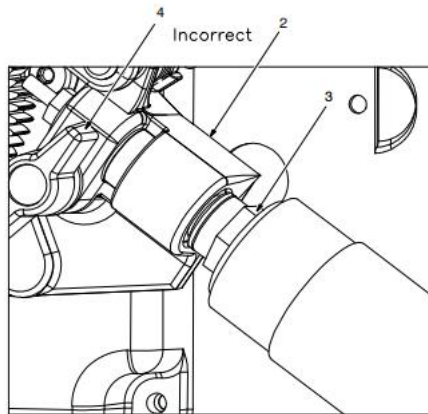
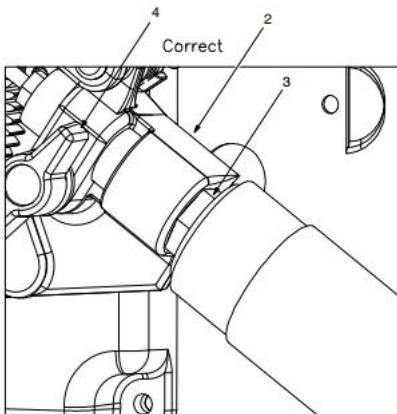
Loosen gun securing knob.

Insert gun end through opening until it bottoms against drive assembly. The black o-rings should not be visible. Tighten the gun securing knob.

5 Gun Trigger Plug

Insert plug into receptacle, and tighten threaded collar.

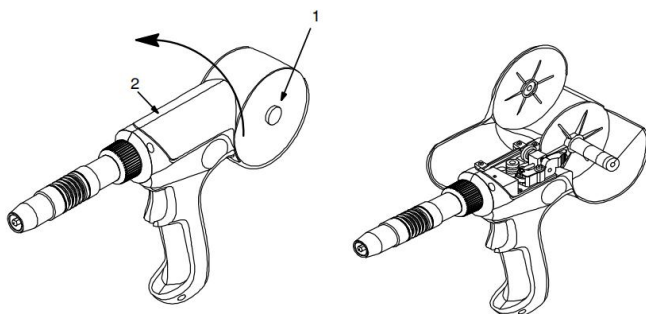
Shielding gas is supplied through gas fitting connection on power source.



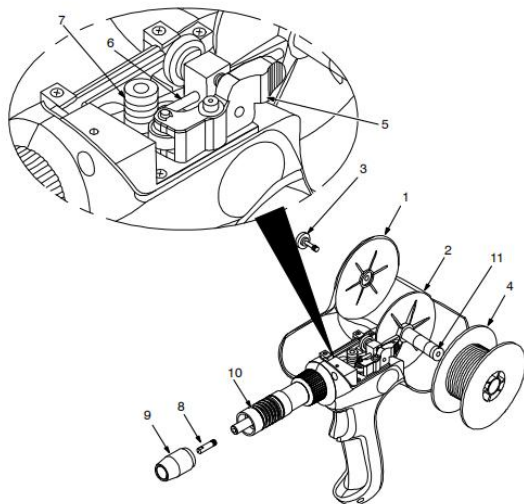
## 2. Opening Cover

1 Thumbscrew    2 Cover

Loosen thumbscrew and rotate cover open.



## 3 Installing Wire Spool And Threading Welding Wire



1 Cover

2 Canister

3 Thumbscrew (Cover)

Cover Canister

Thumbscrew (Cover)

4 Wire Spool

Loosen wire from spool, cut off bent wire, and pull 6 in (150 mm) of wire off spool. Straighten wire as much as possible.

5 Pressure Roll Assembly

Press arm inward to open pressure roll assembly.

6 Wire Inlet Guide

7 Drive Roll Groove

8 Contact Tip

9 Nozzle

10 Barrel Assembly

Remove nozzle and contact tip Thread wire through wire inlet guide, along drive roll groove, and through barrel assembly. Reinstall contact tip and nozzle.

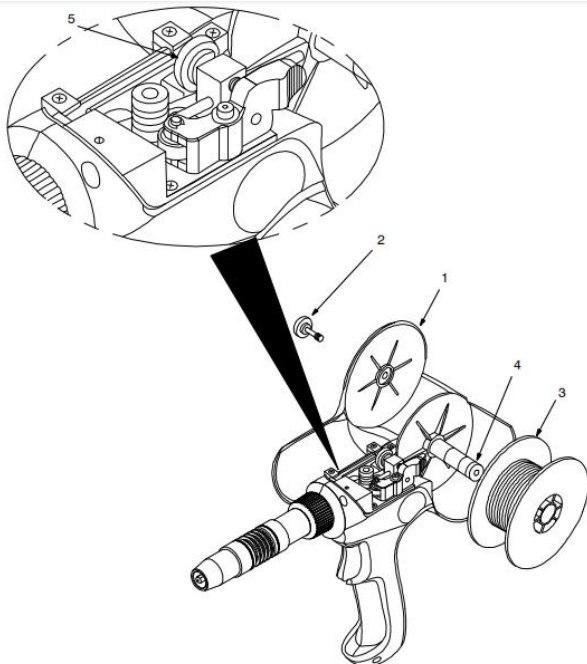
Install spool so wire feeds off top.

11 Spool Brake Thumbnut

If necessary, turn thumbnut counterclockwise slightly to install spool.

Close cover and secure with thumbscrew.

## 4 Adjusting Drive Roll And Spool Brake Pressure



1 Thumbscrew

2 Cover

Loosen thumbscrew and rotate cover open.

3 Spool

Cut welding wire off at contact tip.

Retract wire onto spool and secure.

4 Spool Brake Thumbnut

Grasp spool in one hand and turn while adjusting spool brake thumb-nut. When a slight force is needed to turn spool, tension is set, Do not over tighten.

Thread welding wire (see Section3-7).

5 Drive Roll Tension Thumbnut

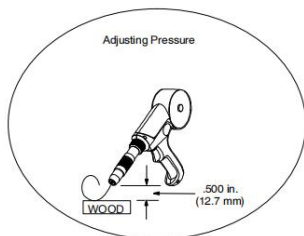
Turn On unit and check drive roll pressure by feeding wire against a wood board or

concrete surface at a 45 degree angle. Wire should feed steadily without slipping.

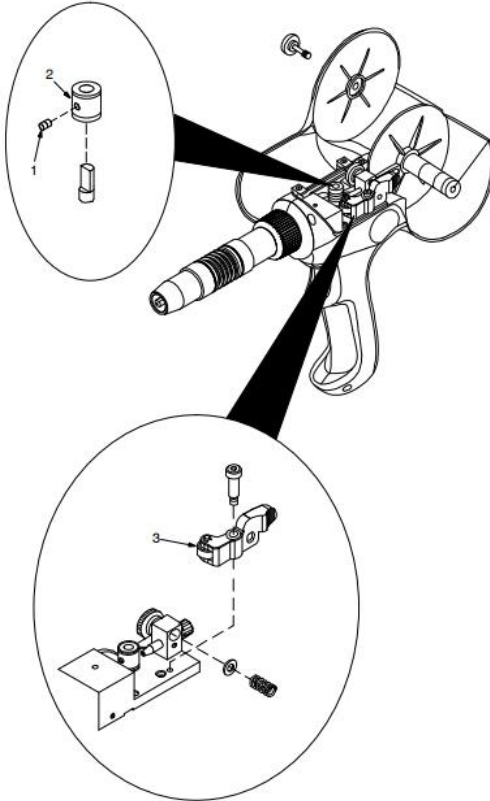
Turn On unit and check drive roll pressure by feeding wire against a wood board or concrete surface at a 45 degree angle. Wire should feed steadily without slipping.

Adjust drive roll tension thumbnut if necessary. Do not over tighten.

Turn Off unit. Close cover.



## 5. Gun Drive Assembly Maintenance



Retract wire onto spool.

1 Setscrew

2 Drive Roll

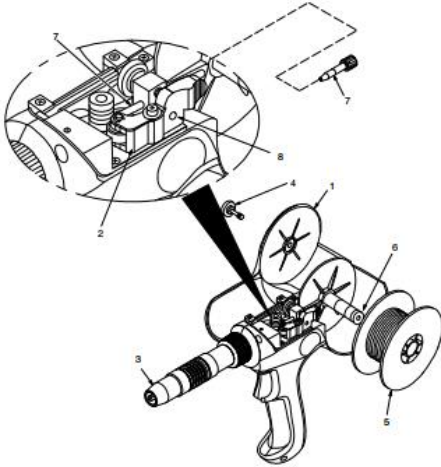
Use stainless steel wire brush to clean drive roll. install drive roll with desired groove down, and turn drive roll so one setscrew faces flat side of shaft.

3 Bearing

Use stainless steel wire brush to clean bearing. Line up drive roll groove with bearing groove and liner opening. Tighten setscrews.

Thread welding wire through gun (see Section 3-7). Adjust drive roll pressure, if necessary (see Section 3-9). Close and secure cover.

## 6. Replacing Inlet Guide



1 Cover

2 Pressure Roll Assembly

Cut off welding wire where it enters pressure roll assembly area.

3 Nozzle

Pull wire out nozzle end.

4 Thumbscrew

Loosen thumbscrew and rotate cover open.

5 Wire Spool

6 Spool Brake Thumbnut

Loosen thumbnut, retract wire onto spool, secure, and remove spool.

7 Inlet Guide

8 Setscrew

Loosen setscrew to remove inlet guide. Install new guide and tighten setscrew.

Reinstall spool and thread welding wire (see Section 3-7).

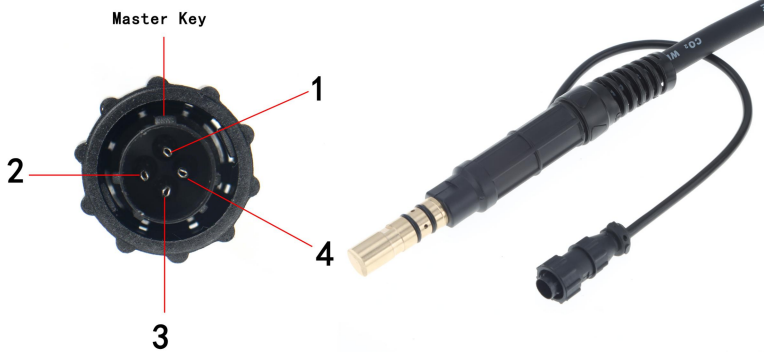
Adjust spool brake pressure and drive roll pressure if necessary (see Section 3-9).

Close and secure cover.



**7. Connector Pin-out(as following picture shows)**

Pin No.	Function	Gun Cable Lead Color
1	Trigger	Blue
2	Trigger	Brown
3	+ Motor	Yellow
4	-Motor	Black



## Product Selling Points:

- |  |                          |
|--|--------------------------|
| 1 Replacement torch model:   | SpoolRunner 200          |
| 2 Adaptive Welding Machines:   | Handler 210 MVP          |
| 3 Maximum rated current:   | 200A                     |
| 4 Lead Length:   | 20 feet                  |
| 5 wire diameter:   | 0.030"/0.035"            |
| 6 Conductive nozzle included:  | 0.030"*2pc / 0.035"*1pc. |
| 7 Suitable for aluminum welding, also for mild and stainless steel wires                   |                          |
| 8 Tool-less removal of header tubes, easy loading and unloading of cords with pressure bar |                          |
| 9 Quick access to wire compartments with hinged flip-top lid                               |                          |
| 10 Monitor cable usage with transparent spool covers                                       |                          |

## FCC INFORMATION

**CAUTION:** Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment!

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions:

- 1) This product may cause harmful interference.
- 2) This product must accept any interference received, including interference that may cause undesired operation.

**WARNING:** Changes or modifications to this product not expressly approved by the party responsible for compliance could void the user's authority to operate the product.

**Note:** This product has been tested and found to comply with the limits for a Class B digital device pursuant to Part 15 of the FCC Rules, These limits are designed to provide reasonable protection against harmful interference in a residential installation.

This product generates, uses and can radiate radio frequency energy, and if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this product does cause harmful interference to radio or television reception, which can be determined by turning the product off and on, the user is encouraged to try to correct the interference by one or more of the following measures.

- Reorient or relocate the receiving antenna.
- Increase the distance between the product and receiver.
- Connect the product to an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for assistance.

## CORRECT DISPOSAL



This product is subject to the provision of European Directive 2012/19/EU. The symbol showing a wheeled bin crossed through indicates that the product requires separate refuse collection in the European Union. This applies to the product and all accessories marked with this symbol. Products marked as such may not be discarded with normal domestic waste, but must be taken to a collection point for recycling electrical and electronic devices.

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**Imported to USA:** Sanven Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

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