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Model: 55010

1. PRODUCT OVERVIEW

The Stark USA 220V Portable Electric Spot Welder Model 55010 is designed for efficient spot welding of various metal sheets, including carbon steel and aluminum. This handheld unit features a single-phase design, durable copper welding tips, and a simple lever mechanism for operation. Its portable design, complete with an attached handle, allows for easy transport to different job locations.



Figure 1: Front view of the Stark USA Portable Electric Spot Welder, Model 55010, showcasing its design and welding tips.

2. SAFETY INSTRUCTIONS

Read and understand all safety warnings and instructions before operating this spot welder. Failure to follow these instructions may result in electric shock, fire, serious injury, or property damage.

- **General Safety:** Keep work area clean and well-lit. Do not operate in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust. Keep children and bystanders away.
- **Electrical Safety:** Connect to a grounded, GFCI-protected power supply only. Do not expose to rain or wet conditions. Do not touch uninsulated electrical parts. Avoid body contact with grounded surfaces.
- **Personal Safety:** Use appropriate personal protective equipment (PPE), including proper eye protection (welding helmet with appropriate shade), welding gloves, and protective clothing. Do not overreach. Stay alert.
- **Welding Hazards:** Fumes and gases can be hazardous to your health. Use in a well-ventilated area. Arc rays can injure eyes and burn skin. Wear proper eye and face protection. Hot slag can cause burns.
- **Fire Safety:** Keep a fire extinguisher nearby. Do not weld near flammable materials.



Figure 2: Side view of the spot welder, highlighting the warning label with important safety information.

3. PACKAGE CONTENTS

Verify that all items are present upon unpacking:

- Stark USA 220V Portable Electric Spot Welder (Main Unit)
- Welding Tips (Pre-installed)
- Extra Pair of Welding Tips
- Instruction Manual

4. SETUP

4.1 Unpacking

Carefully remove the spot welder and all accessories from the packaging. Inspect for any damage that may have occurred during shipping. Report any damage to your supplier immediately.

4.2 Power Connection

Ensure the spot welder is connected to a 220V power outlet. Verify that the power supply meets the specifications listed in Section 7. Specifications. Use a grounded, GFCI-protected circuit.

4.3 Tip Installation and Replacement

The spot welder comes with welding tips pre-installed. To replace tips:

1. Ensure the unit is disconnected from the power supply.

2. Carefully twist the existing welding tips counter-clockwise to remove them.
3. Screw on the new welding tips clockwise until they are securely fastened. Do not overtighten.



Figure 3: Close-up of the durable copper welding tips, showing their conical shape for precise spot welding.

5. OPERATING INSTRUCTIONS

5.1 Basic Operation

The spot welder operates with a simple lever function:

1. Ensure the power cord is securely plugged into a 220V outlet.
2. Position the metal sheets to be welded between the two welding tips.
3. Apply firm pressure by pulling the lever down. This action brings the welding tips together and initiates the welding process.
4. Hold the lever down for the required duration to complete the weld. The duration will vary based on material thickness and type.
5. Release the lever to separate the welding tips and remove the welded material.

5.2 Welding Process Considerations

- **Material Thickness:** The welder is designed for various metal sheet thicknesses. Adjust pressure and welding time as needed for optimal results.
- **Cleanliness:** Ensure the surfaces to be welded are clean and free from oil, rust, or paint for a strong weld.
- **Test Welds:** Always perform test welds on scrap material of similar type and thickness before welding your final workpiece.



Figure 4: Side view of the spot welder with the lever in an open position, ready for material placement.

6. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your spot welder.

- **Cleaning:** Disconnect the power before cleaning. Wipe down the exterior of the unit with a dry cloth. Keep the welding tips and contact areas free from debris and spatter.
- **Tip Inspection:** Regularly inspect welding tips for wear or damage. Worn tips can lead to poor weld quality. Replace tips as needed (refer to Section 4.3).
- **Cable Inspection:** Check the power cord and welding cables for any signs of damage, cuts, or fraying. Replace damaged cables immediately.
- **Storage:** Store the spot welder in a clean, dry place, away from moisture and extreme temperatures.

7. TROUBLESHOOTING

This section addresses common issues you might encounter with your spot welder.

Problem	Possible Cause	Solution
Welder does not power on	No power to outlet; Faulty power cord; Internal fault	Check power supply and circuit breaker; Inspect power cord for damage; Contact customer support

Problem	Possible Cause	Solution
Poor weld quality (weak, inconsistent)	Worn or dirty welding tips; Insufficient pressure; Incorrect welding time; Dirty material surfaces	Clean or replace welding tips; Apply more pressure; Adjust welding time; Clean material surfaces thoroughly
Excessive sparking or arcing	Loose welding tips; Incorrect material contact; Overheating	Tighten welding tips; Ensure proper material contact; Allow unit to cool down if overheating
Unit overheats quickly	Continuous operation without cooling; Blocked ventilation	Allow adequate cooling periods between welds; Ensure ventilation openings are clear

8. SPECIFICATIONS

Feature	Specification
Brand	Stark USA
Model Number	55010
Power Source	Corded Electric
Voltage	220V (implied from title, not explicit in specs but 2.5KVA input)
Rated Input Capacity	2.5 KVA
Maximum Output Current	6750A
Wattage	3840 watts
Item Weight	13.1 kg (28.88 lbs)
Material	Mixed (Copper tips, Plastic/Rubber handle)
Special Feature	Portable
Usage	Industrial Use

9. WARRANTY AND SUPPORT

For warranty information, technical support, or to order replacement parts, please contact Stark USA customer service. Keep your purchase receipt and model number handy for faster service.

Contact Information: Please refer to the official Stark USA website or your purchase documentation for the most current contact details.

