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## HITBOX LSGUN

# HITBOX LSGUN Spool Gun Instruction Manual

Model: LSGUN | Compatible with HITBOX HIM200 Welder

## 1. INTRODUCTION

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This manual provides essential instructions for the safe and effective use of your HITBOX LSGUN Spool Gun. This accessory is designed to enhance the welding capabilities of your HITBOX HIM200 welder, particularly for materials requiring a direct wire feed mechanism. Please read this manual thoroughly before operation to ensure proper setup, safe use, and optimal performance.



Figure 1: HITBOX LSGUN Spool Gun, a direct wire feed accessory for welding applications.

## 2. SAFETY PRECAUTIONS

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**WARNING: Welding can be dangerous. Always follow safety guidelines to prevent injury or death.**

- **Electric Shock:** Welding current can cause fatal electric shock. Ensure proper grounding and insulation. Never touch live electrical parts.
- **Fumes and Gases:** Welding fumes and gases can be hazardous to your health. Work in a well-ventilated area.
- **Arc Rays:** Arc rays can injure eyes and burn skin. Wear a welding helmet with appropriate shade and protective clothing.
- **Fire and Explosion:** Welding sparks can cause fire or explosion. Keep flammable materials away from the welding area.
- **Hot Parts:** Hot metal can cause severe burns. Allow welded materials to cool before handling.

### 3. PACKAGE CONTENTS

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Verify that all items listed below are present in your package:

- HITBOX LSGUN Spool Gun (1 unit)
- Welding Wire Spool (1 unit, .030 wire, 2 pound capacity)
- Contact Tips (4 units)
- Instruction Manual (This document)



Figure 2: Included components: Spool gun, welding wire, and contact tips.

## 4. SPECIFICATIONS

Feature	Specification
Model Number	LSGUN
Amperage	140 Amps
Cable Length	10 ft (3m)
Compatible Wire Spool Size	2 Pound (1KG)
Compatible Wire Diameter	.030 inch
Duty Cycle	60%
Item Weight	5.81 pounds
Package Dimensions	17.09 x 12.76 x 5.04 inches



Figure 3: Spool gun dimensions and compatibility with 1KG welding wire.

## 5. SETUP AND INSTALLATION

### 5.1 Connecting to the Welder

The HITBOX LSGUN Spool Gun is designed for direct compatibility with the HITBOX HIM200 welder. Follow these steps to connect the spool gun:

1. Locate the negative (-) pole connection point on your HIM200 welder.
2. Connect the corresponding cable from the spool gun to the negative (-) pole.
3. Locate the four-pin socket on your HIM200 welder.
4. Connect the four-pin connector from the spool gun cable to this socket. Ensure it clicks firmly into place.

# SPOOL GUN FOR HIM200



Figure 4: Connection points on the HITBOX HIM200 welder for the spool gun.

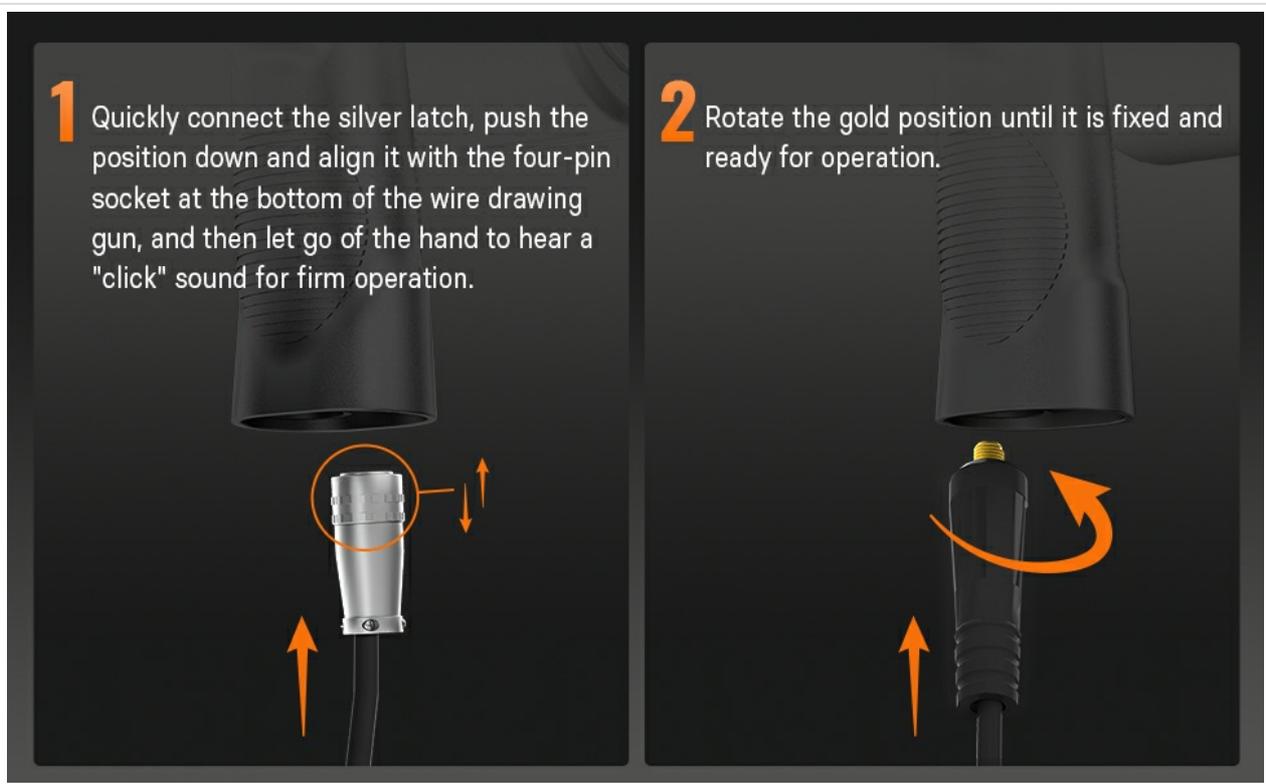


Figure 5: Step-by-step guide for securing the spool gun connections to the welder.

## 5.2 Loading Welding Wire

Properly loading the welding wire is crucial for consistent wire feed. The spool gun is compatible with 2-pound (.030 inch) welding wire spools.

1. Open the lid of the spool gun's wire compartment.
2. Place the welding wire spool onto the spindle inside the compartment. Ensure it sits correctly.
3. Feed the wire through the guide and into the wire feeding mechanism.
4. Close the lid securely.

# EASY TO INSTALL

1 open the lid



2 install the welding wire



3 Turn on the knob of the fixed wire feeding wheel and wire feeding



4 Fixed wire feeding wheel close the lid



unscrew the knob clockwise, Tighten knob counter-clockwise

Figure 6: Visual guide for loading welding wire into the spool gun.

## 5.3 Adjusting Wire Feed Tension

The wire feed tension needs to be adjusted to prevent wire slippage or crushing. A properly set tension ensures smooth and consistent wire delivery.

1. Locate the tension adjustment knob on the spool gun.
2. Turn the knob clockwise to increase tension and counter-clockwise to decrease tension.
3. Adjust the tension so that the wire feeds smoothly without slipping, but is not so tight that it deforms the wire. A good test is to hold the gun with the nozzle pointing up and press the trigger; the wire should feed out without excessive resistance or bird-nesting.



Figure 7: Components of the wire feed tension mechanism, showing the knob for adjustment.

## 6. OPERATION

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### 6.1 Basic Welding Principles

Once the spool gun is connected and wire is loaded, ensure your HITBOX HIM200 welder is set to the appropriate parameters for your welding material and wire type. Always perform test welds on scrap material to fine-tune settings before beginning your main project.

### 6.2 Trigger Mechanism

The spool gun features a positive trigger mechanism designed for responsive control during welding. Press the trigger to initiate wire feed and arc. Release the trigger to stop.

# ERGONOMICS DESIGN



Figure 8: Ergonomic design of the spool gun, highlighting the positive trigger for ease of use.

## 6.3 Duty Cycle

The HITBOX LSGUN Spool Gun has a 60% duty cycle. This means that out of every 10-minute period, the gun can be operated for 6 minutes at its maximum rated amperage (140A) and must then be allowed to cool for the remaining 4 minutes. Exceeding the duty cycle can lead to overheating and damage to the equipment.

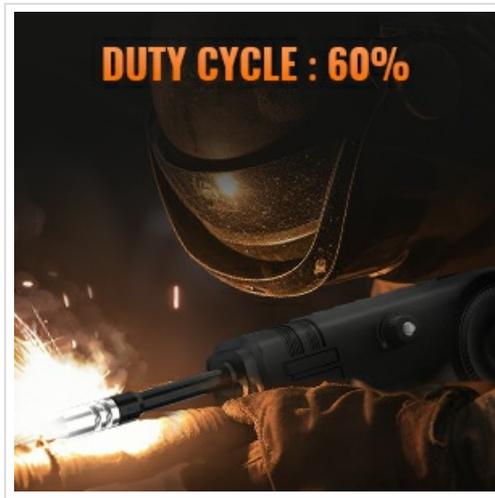


Figure 9: Illustration of the 60% duty cycle for the spool gun.

## 7. MAINTENANCE

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Regular maintenance ensures the longevity and reliable performance of your spool gun.

- **Contact Tip:** Inspect the contact tip regularly for wear and spatter buildup. Replace if the opening is enlarged or if it shows signs of excessive wear.
- **Nozzle:** Clean the nozzle frequently to remove spatter. Ensure it is free from obstructions.
- **Wire Feed Mechanism:** Periodically clean the wire feed rollers and guides to remove any debris or wire shavings that could impede smooth wire flow.
- **Cable Inspection:** Check the cable for any signs of damage, cuts, or fraying. Damaged cables should be replaced immediately by a qualified technician.
- **Storage:** Store the spool gun in a clean, dry environment when not in use.

## 8. TROUBLESHOOTING

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This section addresses common issues you might encounter during operation.

- **No Wire Feed:**
  - Check if the wire spool is correctly installed and not tangled.
  - Verify wire feed tension is adequate (not too loose).
  - Ensure the trigger is fully depressed and the welder is powered on.
  - Inspect the contact tip and nozzle for blockages.
- **Inconsistent Wire Feed:**
  - Adjust wire feed tension. Too loose or too tight can cause issues.
  - Check for debris in the wire feed mechanism.
  - Ensure the wire spool rotates freely.
- **Poor Arc Start/Unstable Arc:**
  - Ensure proper grounding of the workpiece.

- Check for a worn or dirty contact tip; replace if necessary.
- Verify welder settings (voltage, wire speed) are appropriate for the material.
- **Overheating:**
  - Allow the unit to cool down if the duty cycle has been exceeded.
  - Ensure adequate ventilation around the welder and spool gun.

## 9. WARRANTY AND SUPPORT

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For warranty information, technical support, or service inquiries, please refer to the documentation provided with your HITBOX HIM200 welder or visit the official HITBOX website. Keep your purchase receipt as proof of purchase for warranty claims.

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### Related Documents - LSGUN

	<p><a href="#">HITBOX HBM200 Operation Instruction Manual   MIG, MMA, TIG Welder</a></p> <p>Comprehensive operation instruction manual for the HITBOX HBM200 welding machine, covering safety, features, installation, operation, maintenance, and troubleshooting for MIG, MMA, and TIG welding applications.</p>
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