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AZZUNO 15AK-1

AZZUNO 15AK MIG Welding Gun Instruction Manual

Model: 15AK-1

1. INTRODUCTION

This manual provides essential instructions for the safe and effective use, setup, operation, and maintenance of your AZZUNO 15AK MIG Welding Gun. This welding gun is designed for use with AZZUNO MIG-200F, MIG-250F, and MIG-200PRO welding machines. Please read this manual thoroughly before operating the equipment to ensure proper function and safety.

2. SAFETY INFORMATION

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

- Always wear appropriate personal protective equipment (PPE), including a welding helmet with proper shade, flame-resistant clothing, welding gloves, and safety shoes.
- Ensure adequate ventilation to avoid inhaling welding fumes, which can be hazardous to your health.
- Protect yourself and others from electric shock. Ensure the welding machine is properly grounded and all connections are secure.
- Welding arcs produce intense ultraviolet and infrared rays that can burn eyes and skin. Use proper shielding.
- Be aware of fire hazards. Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- Do not operate welding equipment in damp or wet conditions.
- Disconnect power before performing any maintenance or changing parts.

3. PACKAGE CONTENTS

Upon unpacking, verify that all components are present and undamaged. The standard package for the AZZUNO 15AK MIG Welding Gun includes:

- 1 x AZZUNO 15AK MIG Welding Gun with 10-ft (3m) Cable
- 1 x Euro Connector
- Consumables (e.g., contact tip, gas nozzle - typically pre-installed or included separately)

CABLE LENGTH: 10FT/3M



EURO MIG CONNECTOR



Image 1: The AZZUNO 15AK MIG Welding Gun, featuring a 10-foot (3-meter) cable and a standard Euro connector for easy attachment to compatible welding machines. The connector measures approximately 1.3 inches in diameter.

4. PRODUCT OVERVIEW AND COMPONENTS

The AZZUNO 15AK MIG Welding Gun is designed for reliable and comfortable welding operations. Key components include:

- **Welding Torch Body:** Houses the wire feed mechanism and gas flow.
- **Ergonomic Handle:** Provides a comfortable and secure grip, reducing operator fatigue.
- **Trigger:** Activates the wire feed and welding arc.
- **Gas Nozzle:** Directs shielding gas to the weld pool.
- **Contact Tip:** Electrically connects to the welding wire and guides it to the weld pool.
- **Diffuser:** Distributes shielding gas evenly.
- **10-ft (3m) Cable:** Connects the welding gun to the welding machine.

- **Euro Connector:** Standardized connector for quick and secure attachment to compatible welding machines.



Image 2: Close-up view of the ergonomic handle and trigger mechanism of the AZZUNO 15AK MIG Welding Gun, designed for comfortable and precise control during welding.

5. SETUP

5.1 Compatibility Check

Ensure your welding machine is compatible with the AZZUNO 15AK MIG Welding Gun. This gun is specifically designed for AZZUNO MIG-200F, MIG-250F, and MIG-200PRO models.

MIG WELDING TORCH

COMPATIBLE FOR MIG-200F/MIG-250F



Image 3: The AZZUNO 15AK MIG Welding Torch shown connected to compatible AZZUNO MIG-200F and MIG-250F welding machines, highlighting its seamless integration.

5.2 Connecting the Welding Gun

1. **Power Off:** Ensure your welding machine is turned off and disconnected from the power source before making any connections.
2. **Connect Euro Connector:** Align the Euro connector of the welding gun with the corresponding port on your AZZUNO welding machine. Push firmly and twist the locking ring clockwise until it is secure.
3. **Ground Clamp:** Connect the ground clamp from your welding machine to the workpiece or welding table.

5.3 Installing Consumables (Contact Tip, Gas Nozzle)

The welding gun typically comes with consumables pre-installed. If replacement or installation is needed:

1. **Remove Gas Nozzle:** Twist and pull the gas nozzle off the torch head.
2. **Remove Contact Tip:** Unscrew the contact tip from the tip holder.

3. **Install New Contact Tip:** Screw the new contact tip securely into the tip holder. Ensure it is the correct size for your welding wire.
4. **Install Gas Nozzle:** Push the gas nozzle back onto the torch head until it clicks into place.



Image 4: An exploded view demonstrating the easy assembly of the MIG welding gun's front-end components, including the contact tip and gas nozzle.

6. OPERATING INSTRUCTIONS

6.1 Wire Feed

The AZZUNO 15AK MIG Welding Gun is designed for smooth and consistent wire feeding, which is crucial for clean and uniform welds. Refer to your welding machine's manual for specific wire loading and tension adjustments.

- Ensure the wire spool is correctly installed in your welding machine.
- Feed the welding wire through the gun liner until it exits the contact tip.

- Adjust wire feed speed on your welding machine according to the material thickness and wire diameter.

6.2 Initiating a Weld

1. **Prepare Workpiece:** Clean the workpiece thoroughly to remove rust, paint, and grease.
2. **Set Parameters:** Adjust voltage, wire feed speed, and gas flow on your welding machine according to your welding application.
3. **Position Gun:** Hold the welding gun at the correct angle (typically 10-15 degrees push or pull angle) relative to the workpiece.
4. **Activate Trigger:** Press the trigger on the welding gun to initiate wire feed and the welding arc.
5. **Maintain Arc:** Maintain a consistent arc length and travel speed for optimal weld quality.



Image 5: An illustration of stable welding in progress using the AZZUNO 15AK MIG Torch, demonstrating the consistent arc and spatter control.

7. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your AZZUNO 15AK MIG Welding Gun.

- **Clean Gas Nozzle:** Regularly remove spatter from the gas nozzle using a reamer or pliers. Replace if heavily worn or damaged.
- **Inspect Contact Tip:** Check the contact tip for wear, enlargement of the bore, or spatter build-up. Replace as needed to ensure good electrical contact and consistent wire feeding.
- **Check Liner:** Periodically check the wire feed liner for kinks, blockages, or wear. A worn liner can cause inconsistent wire feeding. Replace if necessary.
- **Inspect Cable:** Examine the welding cable for any cuts, abrasions, or damage to the insulation. Damaged cables can pose an electrical hazard.
- **Clean Euro Connector:** Keep the Euro connector clean and free of debris to ensure a secure electrical and gas connection.

8. TROUBLESHOOTING

This section addresses common issues you might encounter with your welding gun.

Problem	Possible Cause	Solution
Inconsistent Wire Feed	<ul style="list-style-type: none">• Worn or incorrect contact tip• Kinked or dirty liner• Incorrect drive roll tension• Wrong drive roll size	<ul style="list-style-type: none">• Replace contact tip with correct size• Clean or replace liner• Adjust drive roll tension• Install correct drive rolls
Excessive Spatter	<ul style="list-style-type: none">• Incorrect voltage or wire feed speed• Insufficient shielding gas• Dirty workpiece	<ul style="list-style-type: none">• Adjust welding parameters• Check gas flow and connections• Clean workpiece thoroughly
No Arc	<ul style="list-style-type: none">• Poor ground connection• Loose Euro connector• No power to welding machine• Faulty trigger	<ul style="list-style-type: none">• Secure ground clamp• Tighten Euro connector• Check power supply and machine settings• Contact AZZUNO support

9. SPECIFICATIONS

Model	15AK-1
Cable Length	10 feet (3 meters)
Connector Type	Euro Connector
Compatible Welders	AZZUNO MIG-200F, MIG-250F, MIG-200PRO
Item Weight	3 pounds
Package Dimensions	16 x 14 x 3 inches
Manufacturer	AZZUNO

10. WARRANTY AND SUPPORT

For warranty information and technical support, please refer to the documentation provided with your AZZUNO welding machine or visit the official AZZUNO website. Keep your purchase receipt as proof of purchase for warranty claims. For direct assistance, you may contact AZZUNO customer service through their official channels.

