

AZZUNO 14AK-Gas Hose

AZZUNO 14AK MIG Welding Gun Instruction Manual

For AZZUNO MIG-155F and MIG-155L Welding Machines

1. INTRODUCTION AND PRODUCT OVERVIEW

This manual provides essential instructions for the safe and effective use of your AZZUNO 14AK MIG Welding Gun. Please read this manual thoroughly before operation to ensure proper setup, usage, and maintenance.

The AZZUNO 14AK MIG Welding Gun is designed for use with AZZUNO MIG-155F and MIG-155L welding machines. It features a 10-ft cable and an integrated gas hose, providing a reliable connection for MIG welding applications.



Figure 1: Overview of the AZZUNO 14AK MIG Welding Gun, showing the torch, cable, and gas hose connection.

Key Features:

- **Compatibility:** Specifically designed for seamless integration with AZZUNO MIG-155F and MIG-155L welders.
- **Durable Construction:** Manufactured with high-quality stainless steel for extended service life and consistent performance.
- **Ergonomic Design:** Features a comfortable grip to minimize operator fatigue during prolonged welding tasks, enhancing control and precision.
- **Consistent Wire Feed:** Engineered to provide a stable and uniform wire feed, contributing to cleaner welds with reduced spatter.

2. SETUP AND INSTALLATION

Before beginning installation, ensure your welding machine is powered off and disconnected from the main power supply.

1. **Connect the Quick Connector:** Insert the quick connector of the MIG welding gun cable into the corresponding receptacle on your AZZUNO MIG-155F or MIG-155L welding machine. Ensure it is securely fastened.
2. **Connect the 2-Pin Plug:** Attach the 2-pin control plug from the welding gun to the designated control

port on the welding machine. This connection enables trigger functionality.

3. **Connect the Gas Hose:** Securely connect the gas hose from the welding gun to the gas outlet on your welding machine. Ensure all connections are leak-free to maintain proper gas shielding.
4. **Install Consumables:**

- Unscrew the gas nozzle from the torch head.
- Screw in the appropriate contact tip for your welding wire diameter.
- Re-attach the gas nozzle, ensuring it is finger-tight.



Figure 2: Details of the 10-ft cable, 2-pin control plug, and quick connector for machine attachment.



Figure 3: Exploded view demonstrating the easy assembly of the nozzle and contact tip components.



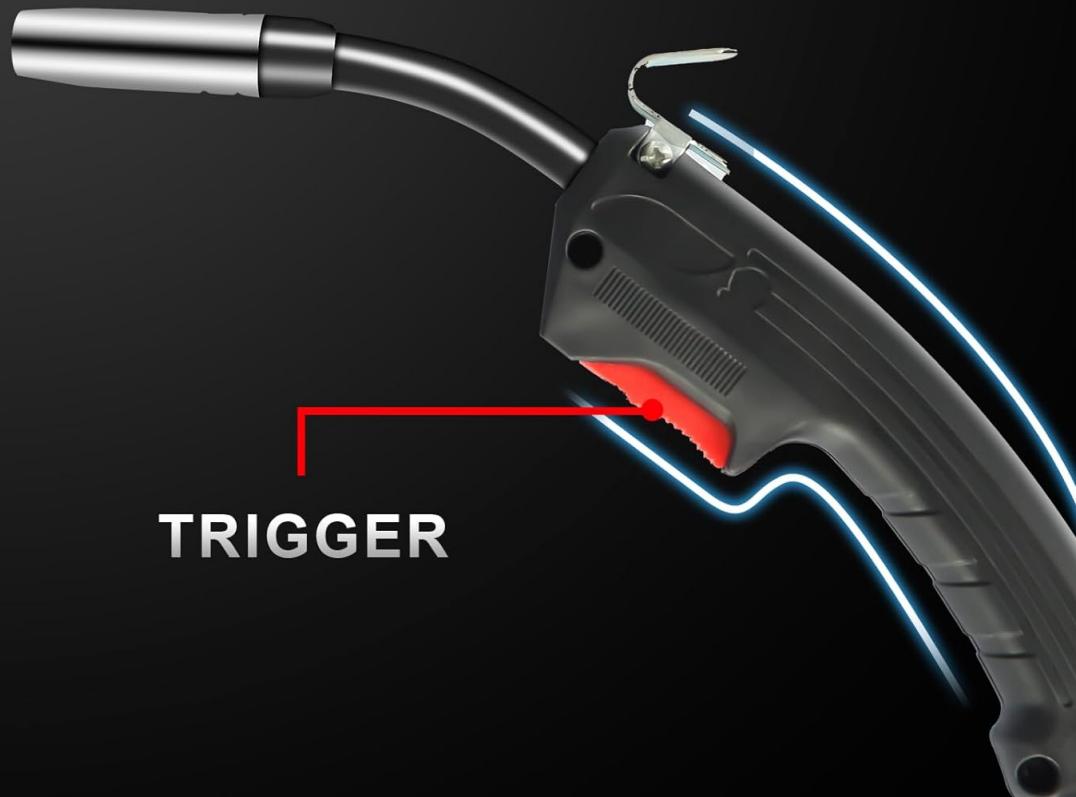
Figure 4: The 14AK MIG torch properly connected to an AZZUNO MIG-155F welding machine.

3. OPERATING INSTRUCTIONS

Always wear appropriate personal protective equipment (PPE) including a welding helmet, gloves, and protective clothing before operating any welding equipment.

- 1. Power On:** Once all connections are secure, power on your AZZUNO welding machine.
- 2. Set Welding Parameters:** Adjust the voltage, wire feed speed, and gas flow rate on your welding machine according to the material thickness and type of welding wire being used. Refer to your welding machine's manual for specific parameter guidelines.
- 3. Initiate Arc:** Position the welding gun over the workpiece. Press the trigger on the ergonomic handle to initiate the wire feed and arc.
- 4. Maintain Arc:** Guide the welding gun along the joint, maintaining a consistent travel speed and arc length for optimal weld quality.
- 5. Release Trigger:** Release the trigger to stop the wire feed and extinguish the arc.

ERGONOMIC HANDLE



TRIGGER

Figure 5: The ergonomic handle design provides a comfortable grip, with the trigger clearly indicated for operation.

STABLE WELDING WITH AZZUNO 14AK MIG TORCH



Figure 6: Demonstrating stable welding with the AZZUNO 14AK MIG torch, highlighting its consistent performance.

4. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your MIG welding gun.

- **Nozzle Cleaning:** Periodically clean spatter from the gas nozzle. Excessive spatter can obstruct gas flow and affect weld quality.
- **Contact Tip Inspection:** Inspect the contact tip for wear or enlargement of the bore. Replace worn tips to ensure proper electrical contact and consistent wire feeding.
- **Diffuser Cleaning:** Clean or replace the gas diffuser if it becomes clogged with spatter or debris.
- **Cable Inspection:** Regularly check the welding cable and gas hose for any signs of damage, cuts, or kinks. Damaged cables can compromise safety and performance.
- **Storage:** Store the welding gun in a clean, dry environment when not in use to prevent damage and corrosion.

5. TROUBLESHOOTING

This section addresses common issues you might encounter during operation.

Problem	Possible Cause	Solution
Inconsistent Wire Feed	Worn contact tip, incorrect wire tension, clogged liner, wrong drive roll size.	Replace contact tip, adjust wire tension, clean or replace liner, ensure correct drive rolls are installed.
Excessive Spatter	Incorrect voltage/wire speed, insufficient gas flow, dirty workpiece, worn contact tip.	Adjust welding parameters, check gas supply and flow rate, clean workpiece, replace contact tip.
No Arc	Poor ground connection, power supply issue, trigger malfunction, no wire feed.	Check ground clamp, verify power to welder, inspect trigger connection, ensure wire is feeding.
Gas Leakage	Loose gas hose connection, damaged hose.	Tighten all gas connections, inspect hose for damage and replace if necessary.

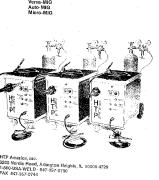
6. SPECIFICATIONS

Attribute	Detail
Model Number	14AK-Gas Hose
Brand	AZZUNO
Compatibility	AZZUNO MIG-155F, AZZUNO MIG-155L
Cable Length	10 feet (approximately 3 meters)
Material	Stainless Steel
Item Weight	2.2 pounds
Package Dimensions	12 x 11.5 x 2.9 inches
Connector Type	2-pin plug, Quick Connector (10-25mm ²)

7. WARRANTY AND SUPPORT

For warranty information or technical assistance, please contact AZZUNO customer support. You can find more information and contact details on the official AZZUNO store page:

[Visit the AZZUNO Store](#)

 <p>Note: Please read this user's manual carefully before using the product.</p>	<p><u>Azzuno MIG-200F User Manual: Multi-Process Welder Guide</u></p> <p>Comprehensive user manual for the Azzuno MIG-200F multi-process welder. Learn about setup, operation, safety, troubleshooting, and welding parameters for MIG, Stick, and Lift TIG welding.</p>
 <p>Note: Please read this user's manual carefully before using the product.</p>	<p><u>Azzuno MIG-200F User Manual: Your Guide to Versatile Welding</u></p> <p>Explore the features and operation of the Azzuno MIG-200F, a versatile dual-voltage, multi-process welder. This user manual provides comprehensive instructions for MIG, Stick, and Lift TIG welding, including setup, operation, safety precautions, and troubleshooting.</p>
 <p>Note: Please read this user's manual carefully before using the product.</p>	<p><u>Azzuno MIG-135F Multi-Process Welder User Manual Flux-Cored, Stick, TIG Welding Guide</u></p> <p>Comprehensive user manual for the Azzuno MIG-135F multi-process welder, covering safety precautions, installation, operation, maintenance, and troubleshooting for MIG (Gasless Flux-Cored), Stick (MMA), and Lift TIG welding.</p>
 <p>Note: Please read this user's manual carefully before using the product.</p>	<p><u>Azzuno MMA-145F User's Manual: Welding Machine Guide</u></p> <p>Comprehensive user manual for the Azzuno MMA-145F welding machine, covering safety precautions, product features, operation, installation, troubleshooting, and maintenance. Features IGBT Inverter technology for MMA and Lift TIG welding.</p>
 <p>HTP America, Inc. 800 North 40th Street, #400 • Lincoln, NE 68501-3000 Phone: 402.464.2746 • Fax: 402.464.2747</p>	<p><u>HTP MIG Welder Owners Manual: Maxi, Versa, Auto, Micro</u></p> <p>Comprehensive owners manual for HTP America's Maxi-MIG, Versa-MIG, Auto-MIG, and Micro-MIG welding machines. Covers operation, safety, maintenance, and troubleshooting for professional welding applications.</p>