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VEVOR XLHBTSR100

VEVOR 100Amp Spool Gun Instruction Manual

Model: XLHBTSR100

1. Introduction

This manual provides essential information for the safe and effective use of your VEVOR 100Amp Spool Gun, Model XLHBTSR100. Please read these instructions carefully before operation and retain for future reference. This spool gun is designed for use with Hobart Handler 210 MVP MIG welders and supports various welding wires including flux-cored, solid, and aluminum wires of 0.023", 0.030", and 0.035" diameters.

2. Safety Information

Always prioritize safety when operating welding equipment. Failure to follow safety guidelines can result in serious injury or damage to equipment.

- **Wear appropriate personal protective equipment (PPE):** This includes welding helmet, gloves, protective clothing, and safety shoes.
- **Ensure proper ventilation:** Welding fumes can be hazardous. Work in a well-ventilated area or use fume extraction.
- **Electrical Safety:** Ensure the welding machine is properly grounded and all connections are secure. Do not operate in wet conditions.
- **Fire Prevention:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Read your welding machine's manual:** This spool gun is an accessory; always follow the safety instructions provided with your primary welding machine.
- **Avoid direct contact with live electrical parts:** This can cause electric shock.

3. Product Features

The VEVOR 100Amp Spool Gun offers several features designed for efficient and precise welding:

- **Smooth Welding Performance:** Designed for 0.023-inch, 0.030-inch, and 0.035-inch wires, ensuring stable arcs, minimal splatter, and high-precision welds. Compatible with flux-cored, solid, and aluminum wires for various materials in automotive, marine, and construction projects.
- **Compatibility:** Specifically designed for use with Hobart Handler 210 MVP MIG welders and supports 1 lb

welding wire spools.

- **Visual Wire Feeding System:** Features a transparent wire feeding mechanism for real-time monitoring of wire levels, reducing jams and bird-nesting.
- **Lightweight & Ergonomic Design:** Weighs approximately 4.9 lbs (2.2 kg) with an ergonomic grip for comfortable handling, reducing fatigue during extended welding sessions.
- **Durable Build:** Equipped with a high-quality 10-foot cable for durability, reliable performance, and extended reach.

4. Compatibility Parameters

This spool gun is compatible with Hobart Handler 210 MVP welders. It supports various wire types and sizes as detailed below.



Image: Welder using the VEVOR 100Amp Spool Gun, highlighting its smooth welding performance.

Supported Wire Types and Sizes:

- **Wire Diameters:** 0.023", 0.030", 0.035"
- **Wire Types:** Flux Core, Solid, Aluminum Welding Wires



Image: Illustration of drive rolls compatible with Flux Welding Wire, Solid Welding Wire, and Aluminum Welding Wire.

5. Setup and Installation

Follow these steps to properly set up your VEVOR 100Amp Spool Gun:

5.1. Wire Installation

1. **Step 01: Open Hatch**

Locate the transparent visual cover on the spool gun. Gently open the hatch to access the wire spool compartment.



Image: Step 1 - Open the transparent hatch on the spool gun.

2. **Step 02: Install the Welding Wire**
   Place the 1 lb welding wire spool onto the spindle inside the compartment. Ensure the wire feeds smoothly into the mechanism.



Image: Step 2 - Install the welding wire spool.

3. **Step 03: Install Wire Feeding Nuts and Close Hatch Door**
   Secure the wire feeding nuts and then close the transparent hatch door firmly. The visual system allows you to monitor wire levels in real-time.



Image: Step 3 - Secure wire feeding nuts and close the hatch.

5.2. Connecting to Welder

Connect the 10-foot cable of the spool gun to the appropriate ports on your Hobart Handler 210 MVP MIG welder. Refer to your welder's manual for specific connection points.



Image: The VEVOR 100Amp Spool Gun with its 10-foot cable, ready for connection.

6. Operating Instructions

Once the spool gun is properly set up and connected to your welding machine, follow these general operating guidelines:

- **Power On:** Turn on your welding machine according to its instructions.
- **Set Welding Parameters:** Adjust the voltage, wire feed speed, and amperage on your welding machine based on the material thickness and wire type you are using.
- **Test Weld:** Always perform a test weld on scrap material to ensure optimal settings and smooth wire feeding.
- **Ergonomic Grip:** Utilize the ergonomic grip for comfortable and stable handling during welding.
- **Monitor Wire:** Keep an eye on the transparent visual cover to ensure continuous wire feeding and prevent interruptions.

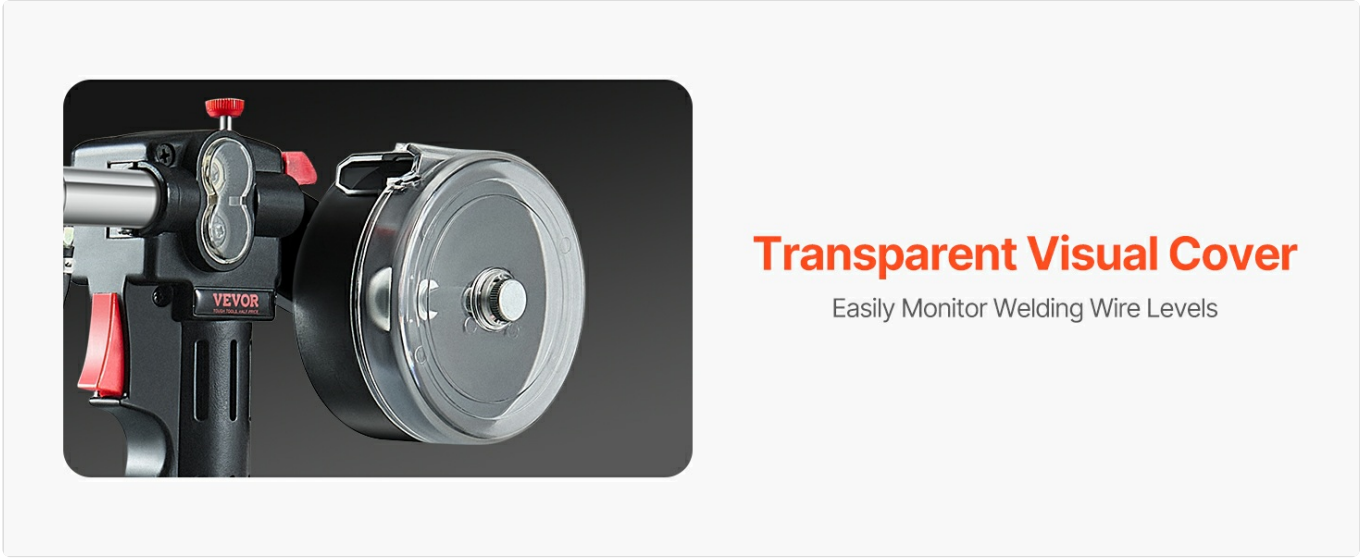

Image: The ergonomic grip of the spool gun designed for comfortable handling.

7. Maintenance

Regular maintenance ensures the longevity and optimal performance of your spool gun:

- **Clean Contact Tip:** Regularly inspect and clean the contact tip to prevent wire feeding issues and ensure good electrical conductivity. Replace if worn.
- **Inspect Wire Feed Rollers:** Check the wire feed rollers for wear or debris. Clean as necessary to maintain consistent wire feeding.
- **Cable Inspection:** Periodically inspect the 10-foot cable for any signs of damage, cuts, or fraying. Replace if damaged to prevent electrical hazards. The cable is designed for high conductivity and breakage resistance.
- **Storage:** Store the spool gun in a clean, dry environment when not in use.

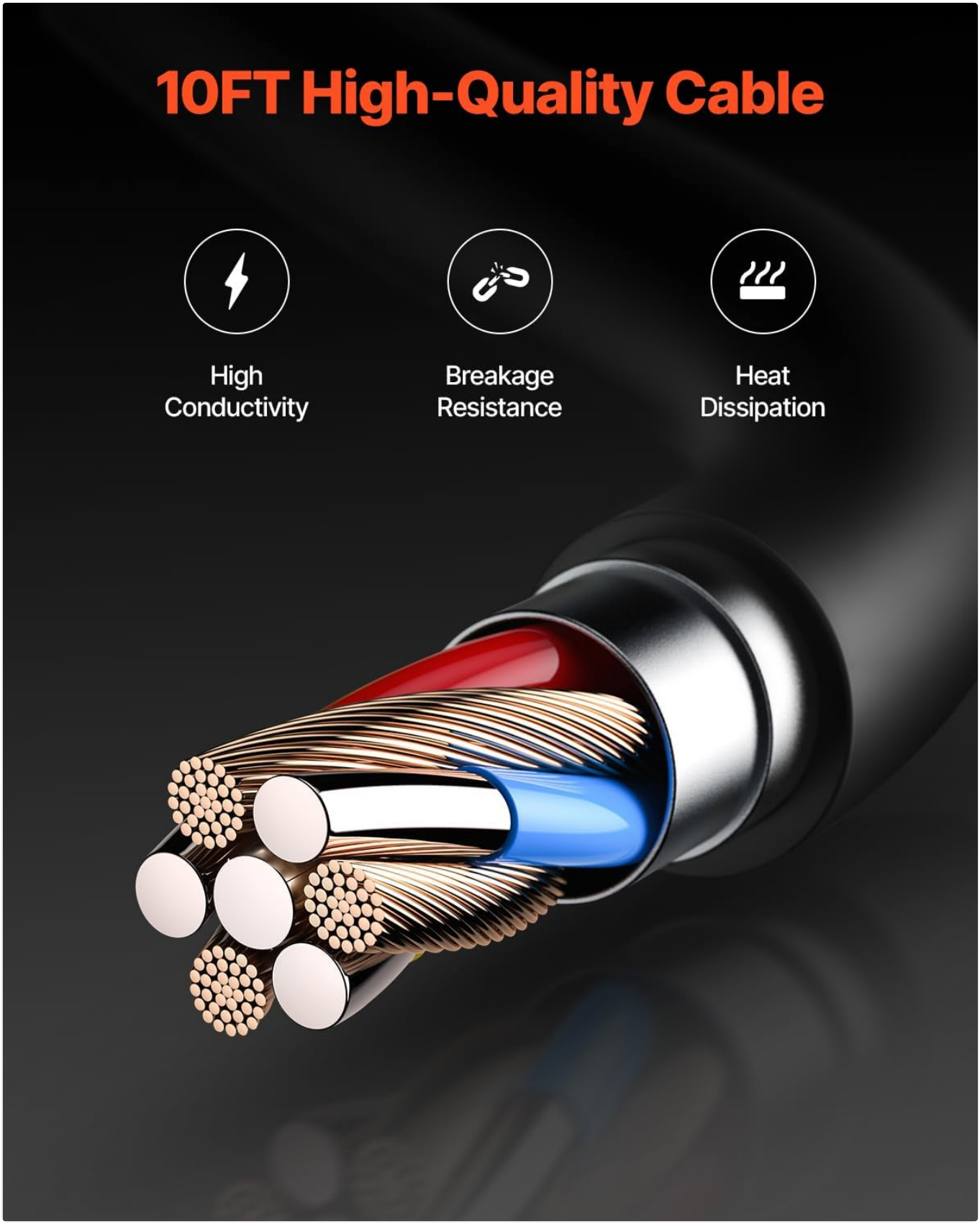

Image: Detailed view of the high-quality, durable 10-foot cable with superior electrical conductivity.

8. Troubleshooting

This section addresses common issues you might encounter:

Problem	Possible Cause	Solution

Problem	Possible Cause	Solution
No Wire Feed	◦ Wire spool empty or jammed. ◦ Drive rollers dirty or improperly tensioned. ◦ Contact tip clogged.	◦ Replace wire spool or clear jam. ◦ Clean drive rollers and adjust tension. ◦ Clean or replace contact tip.
Inconsistent Arc	◦ Poor ground connection. ◦ Worn contact tip. ◦ Incorrect welding parameters.	◦ Check and secure ground clamp. ◦ Replace contact tip. ◦ Adjust voltage and wire feed speed.
Excessive Splatter	◦ Incorrect voltage or wire feed speed. ◦ Improper stick-out.	◦ Adjust welding parameters. ◦ Maintain correct wire stick-out.

9. Specifications

Detailed specifications for the VEVOR 100Amp Spool Gun, Model XLHBTSR100:



Item Model Number: XLHBTSR100

Cable Length: 10 ft

Welding Current: 100AMP

Net Weight: 4.9 lbs / 2.2kg

Wire Diameter:

0.023 in / 0.030 in / 0.035 in

Product Dimensions:

16.9 x 12.6 x 3.1 in / 430 x 320 x 80 mm

Product Content:

1 x 0.030" Contact Tip (Pre-Installed)

1 x 0.023" Contact Tip

1 x 0.035" Contact Tip

Image: Product dimensions and included components.

Specification	Value
Model Number	XLHBTSR100
Cable Length	10 feet
Welding Current	100 AMP

Specification	Value
Wire Diameter Compatibility	0.023", 0.030", 0.035"
Item Weight	4.85 pounds (2.2 kg)
Product Dimensions (L x W x H)	16.93 x 16.93 x 12.6 inches (430 x 430 x 320 mm)
Included Components	1 x 0.030" Contact Tip (Pre-Installed), 1 x 0.023" Contact Tip, 1 x 0.035" Contact Tip
Power Source	Hand-powered (via welding machine)

10. Warranty and Support

For technical support and warranty information, please refer to the official VEVOR website or contact customer service. The product is designed for durability and reliable performance.
Visit: www.vevor.com/support

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