Hasweld 15FT MIG GUN

Hasweld 15FT MIG Welding Gun Instruction Manual

For Eastwood MIG 135/140/175/180 Welders

1. Introduction

This manual provides essential information for the safe and effective use of your Hasweld 15FT MIG Welding Gun. This replacement MIG gun is designed for compatibility with Eastwood MIG 135, 140, 175, and 180 welders, featuring a Tweco-Style connection. Please read this manual thoroughly before installation and operation to ensure proper function and safety.

2. Safety Information

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

- **Electric Shock:** Can kill. Do not touch live electrical parts. Wear dry welding gloves and protective clothing. Ensure your welding machine is properly grounded.
- **Fumes and Gases:** Can be hazardous to your health. Keep your head out of the fumes. Use enough ventilation or exhaust at the arc to keep fumes and gases away from the breathing zone.
- **Arc Rays:** Can burn eyes and skin. Wear a welding helmet with a proper shade filter. Wear safety glasses with side shields under your helmet. Wear protective clothing to protect your skin.
- **Fire and Explosion:** Welding sparks and hot metal can cause fires. Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Hot Parts:** Can cause severe burns. Allow the welding gun and workpiece to cool before handling.

3. Package Contents

Verify that all items are present and undamaged upon opening the package.

- 1 x Hasweld 15FT MIG Welding Gun
- 12 x Contact Tips (various sizes)



Image 3.1: The Hasweld 15FT MIG Welding Gun with a selection of contact tips.

4. Compatibility

This Hasweld 15FT MIG Welding Gun is designed as a direct replacement for:

- Eastwood MIG 135
- Eastwood MIG 140
- Eastwood MIG 175
- Eastwood MIG 180

It features a standard Tweco-Style connection. Ensure your welder uses this connection type for proper fitment.

5. Installation and Setup

Follow these steps to install your new MIG welding gun:

1. **Power Off:** Ensure your welding machine is completely powered off and unplugged from the power source before beginning installation.
2. **Remove Old Gun (if applicable):** Disconnect the existing MIG gun from the welder. This typically involves unscrewing a large nut or collar at the front panel connection and disconnecting any control wires.
3. **Connect New Gun:** Insert the new Hasweld 15FT MIG gun's power pin into the corresponding receptacle on your welder's front panel. Secure it by tightening the retaining nut or collar.
4. **Connect Control Wires:** Locate the 4-pin control connector on the new MIG gun. Align it with the control receptacle on your welder and push firmly until it clicks into place.
5. **Install Wire Spool:** Open the wire feed compartment of your welder and install the appropriate size welding wire spool.
6. **Feed Welding Wire:** Guide the welding wire through the welder's drive rolls and into the liner of the MIG gun. Ensure the drive rolls are set to the correct tension for your wire size.
7. **Install Contact Tip and Nozzle:** Screw the appropriate contact tip onto the gun's diffuser, then slide the gas nozzle over the tip and diffuser.
8. **Gas Connection (if applicable):** If using shielding gas, ensure your gas cylinder is connected to the welder and the gas hose is securely attached to the gun's gas inlet (if separate from the power pin).

6. Operation

Once the MIG gun is installed and the welder is set up, follow these general operating guidelines:

1. **Power On:** Plug in and power on your welding machine.
2. **Set Parameters:** Adjust the voltage and wire feed speed settings on your welder according to the material thickness and wire type you are using. Refer to your welder's manual for recommended settings.
3. **Purge Gas (if applicable):** Briefly press the trigger with the gun pointed away from the workpiece to purge any air from the gas line.
4. **Start Welding:** Position the gun over the workpiece. Press the trigger to initiate the arc and wire feed. Maintain a consistent travel speed and gun angle for optimal weld quality.
5. **Release Trigger:** Release the trigger to stop the arc and wire feed.

7. Maintenance

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

- **Clean Nozzle:** Regularly remove spatter from the gas nozzle using a reamer or pliers. Excessive spatter can impede gas flow and affect weld quality.
- **Inspect Contact Tip:** Check the contact tip for wear, such as an enlarged bore or excessive spatter. Replace worn tips to ensure good electrical contact and consistent wire feeding.
- **Check Liner:** Periodically check the wire liner for kinks or blockages that can cause wire feeding issues. If necessary, replace the liner.
- **Inspect Cable:** Examine the welding cable for any cuts, abrasions, or damage to the insulation. Damaged cables can pose an electrical hazard.
- **Clean Connections:** Ensure all electrical connections, including the power pin and control wire connections, are clean and secure.

8. Troubleshooting

If you encounter issues with your MIG welding gun, refer to the following common problems and solutions:

Problem	Possible Cause	Solution
No arc or wire feed when trigger is pressed	• Welder not powered on • Control wire connection loose or incorrect • Faulty trigger switch • No welding wire	• Ensure welder is powered on and plugged in. • Check the 4-pin control wire connection for proper seating. Verify wiring if possible. • Inspect trigger for damage. • Ensure wire spool is installed and wire is fed through the gun.
Inconsistent wire feed	• Incorrect drive roll tension • Worn contact tip • Kinked or dirty liner • Wrong drive roll size	• Adjust drive roll tension. • Replace contact tip. • Inspect and clean/replace liner. • Ensure correct drive roll size for wire.
Excessive spatter	• Incorrect voltage/wire feed speed • Dirty workpiece • Worn contact tip/nozzle	• Adjust welding parameters. • Clean workpiece thoroughly. • Replace worn consumables.

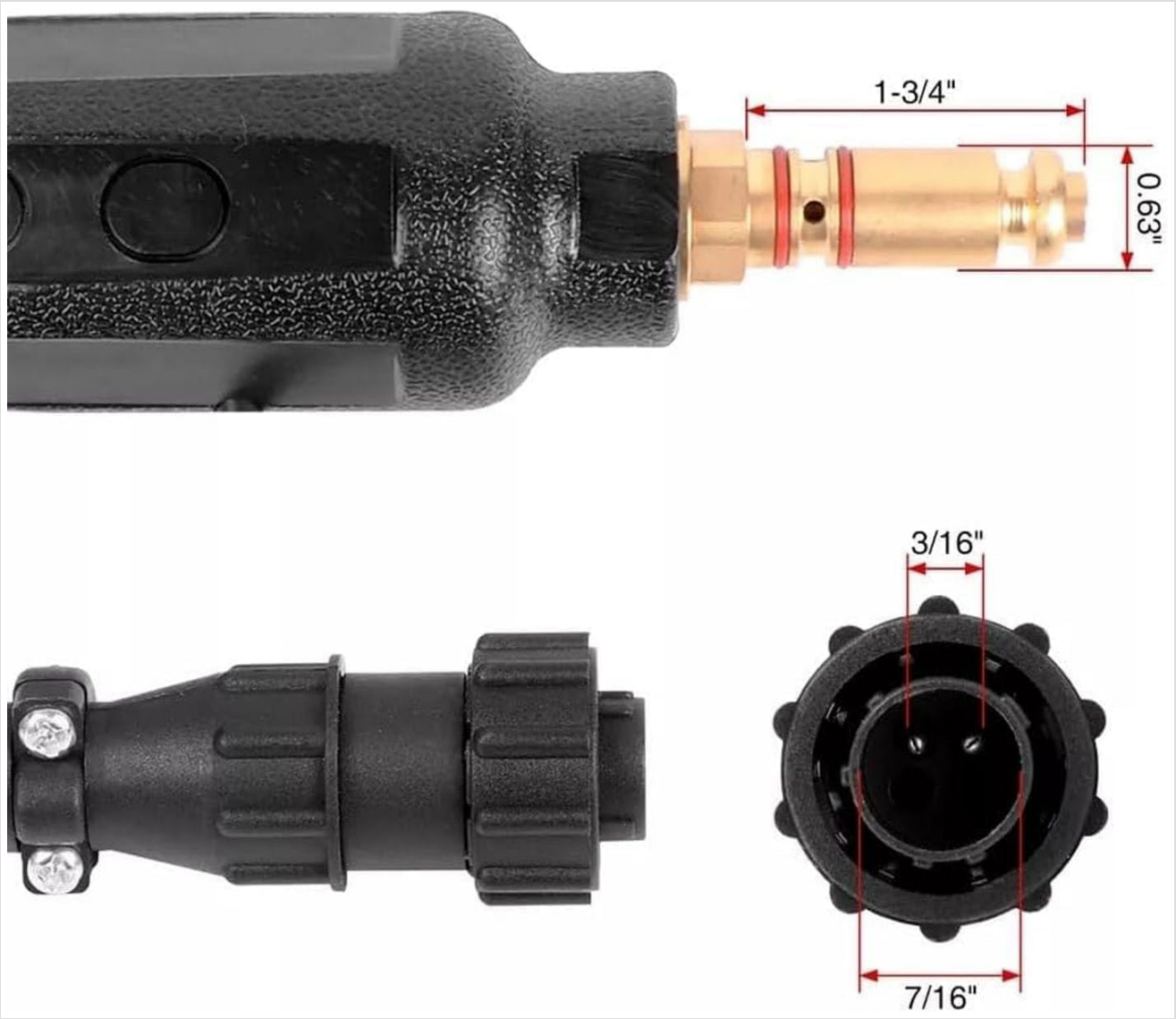


Image 8.1: Detailed view of the MIG gun connector and contact tip dimensions, useful for verifying compatibility and troubleshooting connection issues.

9. Specifications

Feature	Detail
Model Number	15FT MIG GUN
Cable Length	15 feet
Compatibility	Eastwood MIG 135/140/175/180 (Tweco-Style)
Included Components	MIG torch, 12 contact tips
Power Source	AC/DC (dependent on welder)

10. Customer Support

For any questions or concerns regarding your Hasweld MIG Welding Gun, please contact us directly. We are committed to assisting you with any post-sales issues.



Image 10.1: Hasweld customer support information.

Warranty information is not explicitly provided in the product details. Please contact customer support for details regarding product warranty.

Ask a question about this manual

Ask about setup, troubleshooting, compatibility, parts, safety, or missing instructions. Manuals+ will review the question and use this page's manual context to help answer it.

Name

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Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

Submit question