P I T PMAG200-C Three Function Welding Machine Instruction Manual

Contents

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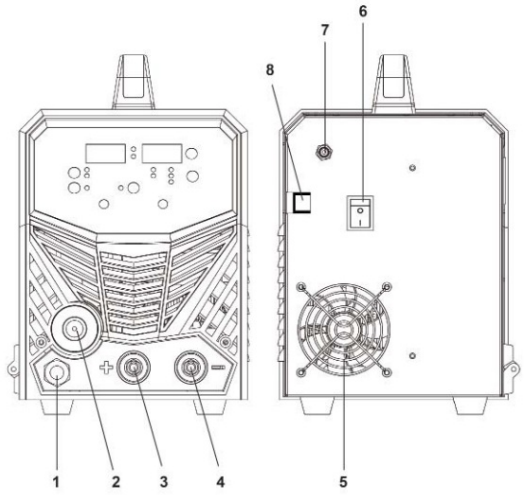
Safety Notes

General Power Tool Safety Warnings WARNING Read all safety warn- ings and all instructions.



Failure to follow the warnings and instructions may result in electric shock, fire and/or seri- ous injury.

Save all warnings and instructions for fu- ture reference.

The term “power tool” in the warnings refers to your main soperated (corded) power tool or battery-operated (cordless) power tool.

Work area safety

- **Keep work area clean and well lit.** Clut- tered or dark areas invite
- **Do not operate power tools in explosive such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ig- nile the dust or fumes.
- **Keep children and bystanders away while operating a power** Distrac- tions can cause you to lose control.

Electrical safety

- **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power** Unmodified plugs and matching outlets will reduce the risk of electric shock.
- **Avoid body contact with earthed or grounded surfaces, such as pipes, radi- ators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or
- **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric
- **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges and moving** Damaged or entangled cords increase the risk of electric shock.
- **When operating a power tool outdoors, use an extension cord suitable for out- door use.** Use of a cord suitable for out- door use reduces the risk of electric
- **If operating a power tool in a damp location is unavoidable, use a residual current device (RCD)**

protected supply. Use of an RCD reduces the risk of electric

Personal safety

- **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influ- ence of drugs, alcohol or** A moment of inattention while operating power tools may result in serious personal injury.
- **Use personal protective Always wear eye protection.** Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protec- tion used for appropriate conditions will reduce personal injuries.
- **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the** Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.
- **Remove any adjusting key or wrench before turning the power tool** A wrench or a key left attached to a rotating part of the power tool may result in person- al injury.
- **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unex- pected
- **Dress Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.
- **If devices are provided for the connec- tion of dust extraction and collection facilities, ensure these are connected and properly used.** Use of dust collection can reduce dust-related
- **Do not let familiarity gained from fre- quent use of tools allow you to become complacent and ignore tool safety prin-** A careless action can cause severe injury within a fraction of a second.

Power tool use and care

- **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job bet- ter and safer at the rate for which it was
- **Do not use the power tool if the switch does not turn on and off.** Any power tool that cannot be controlled with the switch is

dangerous and must be repaired.

- **Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjust- ments ,changing accessories, or stor- ing power tools.** Such preventive safety measures reduce the risk of starting the power tool
- **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained
- **Maintain power Check for mis- alignment or binding of moving parts, breakage of parts and any other con- dition that may affect the power tool's operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- **Keep cutting tools sharp and** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be** Use of the power tool for oper- ations different from

those intended could result in a hazardous situation.

- **Keep handles and grasping surfaces dry, clean and free from oil and grease.** Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected

Service

- **Have your power tool serviced by a qualified repair person using only iden- tical replacement parts.** This will ensure that the safety of the power tool is main-

Safety instructions for electric welding machine

- **Be sure to make sure that the electrical outlet that the inverter is connected to is grounded.**
- **Do not touch exposed electrical parts and electrode with exposed parts of the body, wet gloves or**
- **Do not start work until you are sure that you are insulated from the ground and from the workpiece.**
- **Make sure you are in a safe**
- **Do not inhale welding fumes, they are harmful to health.**
- **Adequate ventilation must be provided in the workplace or special hoods must be used to remove gases generated during welding.**
- **Use a suitable face shield, light filter and protective clothing to protect your eyes and body.** Clothing should be fully buttoned so that sparks and splashes do not fall on the body.
- **Prepare a suitable face shield or curtain to protect the viewer.** To protect other people from arc radiation and hot metals, you must enclose the work area with a fireproof fence.
- **All walls and floors in the work area must be protected from possible sparks and hot metal to avoid smoldering and fire.**
- **Keep flammable materials (wood, paper, rags,) away from the workplace.**
- **When welding, it is necessary to pro- vide the workplace with fire extinguish- ing**
- **IT IS FORBIDDEN:**
- Use the semiautomatic welding machine in damp rooms or in the rain;
- Use electrical cables with damaged insula- tion or poor connections;
- Carry out welding work on containers, containers or pipes that contain liquid or gaseous hazardous substances;
- Carry out welding work on pressure ves- sels;
- Work clothing stained with oil, grease, gas- oline and other flammable
- **Use headphones or other ear protec-**
- **Warn bystanders that noise is harmful to hearing.**
- **If problems occur during installation and operation, please follow this in- struction manual to**
- **If you do not fully understand the man- ual or cannot solve the problem with the manual, you should contact the supplier or service center for profes- sional**
- **The machine must be operated in dry conditions with a humidity level not ex- ceeding 90%.**
- **The ambient temperature should be be- tween -10 and 40 degrees**
- **Avoid welding in the sun or under water droplets.** Do not allow water to enter the inside of the machine.

- **Avoid welding in dusty or corrosive gas**
- **Avoid gas welding in a strong air flow**

- **A worker who has a pacemaker in- stalled should consult a doctor before** Because the electromagnetic field can interfere with the normal opera- tion of the pacemaker.

Product Description and Specifi- cations

Read all safety warnings and all instructions.

Failure to follow the warnings and instructions may result in electric shock, fire and/or seri- ous injury.

Intended use

Semiautomatic inverter type direct current welding machine (hereinafter referred to as the product) is designed for welding using the MIG / MAG methods (welding with electrode wire in a shielded gas) and MMA (manual arc welding with stick fusible covered electrodes). The product can be used for welding various types of metals.

Product features

The numbering of the components shown re- fers to the representation of the power tool on the graphic pages.

1. Polarity reversing cable
2. Torch connection socket
3. Power connector “+”
4. Power connector “-”
5. Fan
6. Power button
7. Connection for shielding gas
8. Power cable inlet

Technical Data\

Model	**PMAG200-C**
3BUFE WPMUBHF	190-250V~ /50 Hz
3BUFE QPXFS	5800 W
Output current range	10-200 A
Wire diameter (MIG)	Ø 0 .8-1.0mm
Electrode diameter (MMA)	Ø 1.6-4.0 mm (1/16” – 5/32”)
Electrode diameter (TIG)	Ø 1.2/1.6/ 2.0mm
Duty cycle (DC)	25 60%
Weight	13 kg

Contents of delivery

Automatic welding machine	1pc
Cable with electrode holder	1pc
Cable with grounding terminal	1pc
Torch cable	1pc
Welding shield	1pc
Hammer brush	1pc
Instruction manual	1pc
Note	

The text and numbers of the instructions may contain technical errors and typographical er- rors.

Since the product is constantly being im- proved, P.I.T. reserves the right to make changes to the specifications and product specifications specified here without prior no- tice.

Preparation for work

Place the machine on a flat surface. The workplace must be well ventilated, the weld- ing machine must not be exposed to dust, dirt, moisture and active steam. To ensure adequate ventilation, the distance from the apparatus to other objects must be at least 50 cm.

ATTENTION! To avoid electric shock, use only electrical mains with a protective earth conductor and grounded receptacles. DO NOT alter the plug if it does not fit into the out- let. Instead, a qualified electrician must install an appropriate outlet.

Ensuring the safety of preparation for work

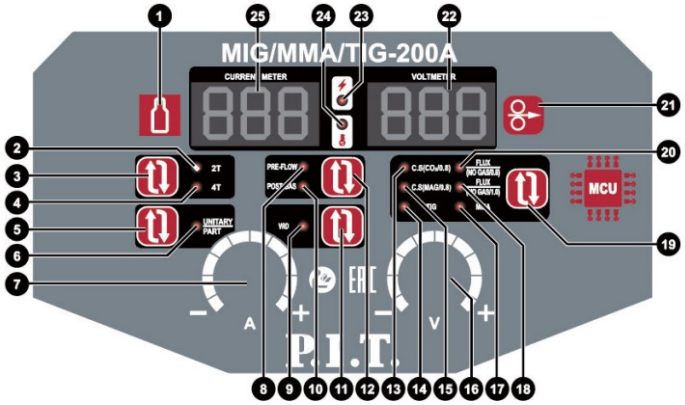
Before turning on the product, set the switch to the “0” position, and the current regulator to the extreme left position.

Prepare for work:

- Prepare the parts to be welded;
- Provide adequate ventilation in the work- place;
- Make sure that there are no solvent vapors, flammable, explosive and chlo- rine-containing substances in the air;
- Check all connections to the product; they must be made correctly and securely;
- Check the welding cable, if damaged it must be replaced;
- The power supply must be equipped with protective

If you encounter problems that you cannot cope with, contact the service center.

Controls and Indicators



1. Gas check function: check whether the gas is connected to the machine and whether there is gas out of the welding torch

   2.2T function indicator: 2T function means to press the gun switch to work, release the gun switch to stop

working

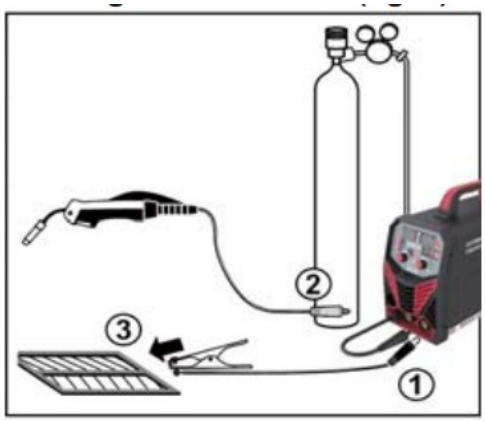
3.2T/4T function switch button: 2T/4T selection function button

4.4T function indicator light: 4T function means to press the gun switch to work, release the gun switch and still work, press the gun switch again to continue working, release the gun switch to stop working

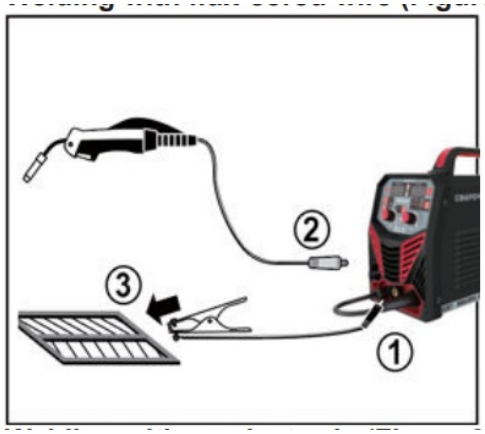
5. Unified adjustment (automatic)/partial (manual) adjustment mode switch button
6. Unified adjustment (automatic)/partial (manual) adjustment mode indicator: the indicator lights up when in the partial adjustment mode. The unified adjustment means that the welding current and the welding voltage are adjusted synchronously (automatically) to match each other, and the partial adjustment means that the welding current and Separate adjustment of welding volt- age (manual adjustment, for professional use)
7. Current regulation
8. Gas pre-blowing mode indicator: first connect the gas, then well
9. VRD status indicator: Anti-shock mode, when the indicator light is on, it is in anti-shock mode, and the output voltage is lower than the safe voltage.
10. Gas blow mode indicator light: continue to blow up the cooling gun head after stopping weld- ing
11. VRD status activation/cancel button: anti-shock function activation/deactivation
12. Gas front blowing/back blowing mode switch button: gas front blowing and back blowing function selection
13. Carbon dioxide gas indicator light, using 8mm welding wire
14. TIG function indicator
15. Mixed gas indicator light, with 8mm welding wire
16. Voltage adjustment: Welding voltage adjustment (valid under partial adjustment mode
17. MMA function indicator light: the light is on, the welder is working in manual welding (MMA) mode
18. Flux-cored wire 0 indicator
19. MMA, MIG, TIG function switch button
20. 8 indicator light for flux-cored welding wire
21. Wire inspection function: Check whether the welding wire is well connected to the machine, and the gun can’t get out of the wire

22. Voltmeter
23. Power on indicator
24. Thermal protection indicator
25. Ammeter

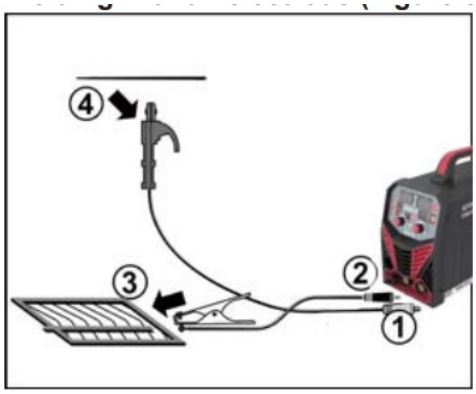
Welding machine connection dia- gram



Welding with solid wire (fi g. 1)

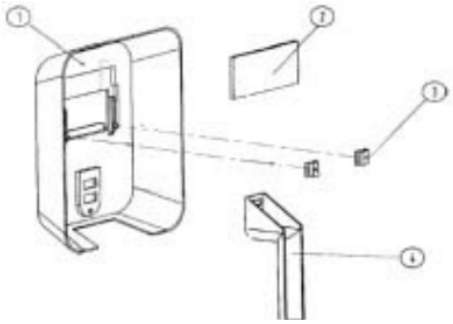


Welding with fl ux-cored wire (Figure 2)



Welding with an electrode (Figure 3)

Assembling the welding shield



Preparing for MIG / MAG Welding Select the required type of welding using the button 15. Also, use the switch 2 to set the welding current on / off mode (2T – welding is carried out with the torch trigger pressed, 4T – the first press of the torch trigger – the start of welding, the second press – the end of weld- ing).

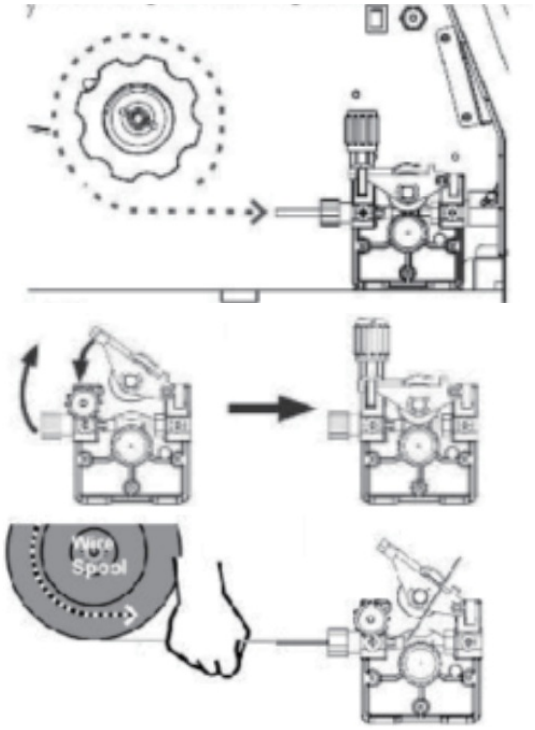
The VRD function is responsible for lowering the open-circuit voltage of the source to 12-24 volts safe for humans, i.e. voltage drops when the machine is turned on, but no welding is performed. As soon as the welding process starts, the VRD restores the operating voltage parameters.
The VRD option is relevant in such cases: The device is operated in conditions of high air humidity; high requirements for safety at the facility; use of welding equipment in small areas.

Burner

The MIG / MAG welding torch consists of a base, a connecting cable and a handle. The base connects the welding torch and wire feeder. Connection cable:
A nylon-covered liner is placed in the center of the hollow cable. The inner part of the channel is for wire feeding. The free space between the duct and the hollow cable is used to sup- ply the shielding gas, while the hollow cable itself is used to supply the current.
ATTENTION! Before assembling and disas- sembling the burner or before replacing com- ponents, disconnect the power supply.

Coil installation

Select the required wire according to the welding procedure. The wire diameter must match the drive roll, wire liner and contact tip. Open the side cover of the machine to insert the wire spool. Unscrew the reel seat adjust- ing screw, put the spool on the reel seat and fix it with the same screw. The end of the wire should be under the drum, opposite the wire feeder. Use the adjusting screw to adjust the retention force of the spool. The coil should rotate freely, but no wire loops should form during operation. If hinges are formed, tighten the adjusting screw more. If the spool is diffi-
cult to turn, loosen the screw.



Inserting the wire into the wire lin- er

Loosen and lower the adjuster towards you. Raise the pinch roller;

Cut off the bent end of the wire and thread the wire into the wire liner of the feeder, align it in the channel of the drive roll. Make sure the bore of the roller matches the diameter of the wire;
Place the wire in the welding torch connector bore, release the pinch roller, and return the adjuster to the vertical position.
Adjust the pressure of the pinch roller.

- When welding with steel wire, the V-groove of the drive roll must be used;
- When using flux-cored wire, the gear groove of the drive roll must be used (availability depends on the model and equipment of the device).
- When using aluminum wire, the U-groove of the drive roll must be used (availability depends on the model and equipment of the machine).

Wire feed into the welding arm

Unscrew the welding tip on the torch.

To feed the wire into the torch sleeve, tem- porarily turn on the power by switching the switch 6 and press the button 16 (wire feed) until it fills the channel of the welding sleeve and leaves the torch. Disconnect the power supply. Note! For free passage of the wire in
the cable, straighten it along its entire length. When feeding the wire, make sure it moves freely in the drive roll channel and that the feed speed is uniform. If the feed rate is un- even, adjust the pressure of the pinch roller. Match and screw in a contact tip that matches the wire diameter and installs the nozzle.

Semi-automatic welding modes This machine can work with two types of welding wires: solid copper-coated wire in a shielding gas environment, and self-shielded flux-cored wire, in which case a gas cylinder is not required.

Different types of filler wire require a different wiring diagram.

Gas welding (GAS) with solid cop- per-plated wire:

- Connect the short cable with the connector located at the bottom of the front panel of the device to the left connector on the front panel (“+” terminal).
- Fix the grounding terminal on the work- piece to be welded, connect the connector on the other end of the cable to the right connector on the front panel (“-” terminal).
- Check the markings on the feed roll ac- cording to the wire diameter being
- Insert the spool of wire into the slot.
- Feed the wire into the torch by folding back the roll clamp and inserting the wire into the channel through the recess in the
- Close the roller clamp by slightly tightening the clamping screw.
- Make sure to match the hole diameter of the gun tip to the wire
- Turn on the machine and run the wire until it exits the tip by pressing the trigger on the torch.
- Connect the hose from the gas regulator to the fitting on the back of the device.
- Open the valve on the shielding gas cylin- der, press the torch trigger and adjust the gas flow with the reducer (usually the gas flow is set as follows: gas flow (l / min) = Wire diameter (mm) x
- Set the required welding mode using the
- Begin

Welding without gas (NO GAS) with self-shielded flux-cored wire:

- Connect the short cable with the connector located at the bottom of the front panel of the device to the right connector on the front panel (“-” terminal).
- Fix the grounding terminal on the work- piece to be welded, connect the connector on the other end of the cable to the left connector on the front panel (“+” terminal).
- Check the markings on the feed roll ac- cording to the wire diameter being
- Insert the spool of wire into the slot.
- Feed the wire into the torch by folding back the roll clamp and inserting the wire into the channel through the recess in the
- Close the roller clamp by slightly tightening the clamping screw.
- Make sure to match the hole diameter of the gun tip to the wire
- Turn on the machine and run the wire until it exits the tip by pressing the trigger on the torch.
- Set the required welding mode using the

Welding process

Set the welding current based on the thick- ness of the material to be welded and the diameter of the electrode wire used. The wire feed speed is automatically synchronized with the welding current. Move the torch to the workpiece so that the wire does not touch the workpiece, but is at a distance of several mil- limeters from it. Press the torch button to light the arc and start welding. The pressed key ensures the feed of the electrode wire and the flow of shielding gas set by the reducer.
The length of the arc and the speed of move- ment of the electrode affect the shape of the weld.

Replaceable polarity operation Initially, the power contact of the welding torch is connected to “+” on the polarity reversal module. This is REVERSE POLARITY. It is used for welding thin sheet steel to stainless steels, alloy steels and high carbon steels, which are very sensitive to overheating.
During DIRECT POLARITY welding, most of the heat is concentrated on the product itself, which causes the root of the weld to deepen. To change the polarity from reverse to direct, it is necessary to switch the output of the power wire on the module from “+” to “-”. And in this case, connect the cable with the earth clamp to the workpiece by inserting the pow- er cable lug into the “+” terminal on the front panel.
For welding with flux-cored wire without shielding gas, DIRECT POLARITY is used. In
this case, more heat goes to the product, and the wire and the welding torch channel heat up less.

At the end of welding:

- Remove the torch nozzle from the seam, interrupting the welding arc;
- Release the torch trigger to stop the wire and gas feed;
- Disconnect the gas supply by shutting off the gas supply valve from the cylinder re- ducer;
- Move the switch to the “off” position – off

Manual arc welding mode (mma)

1. Connect the electrode holder to the “-” terminal of the device, the grounding cable to the “+”

terminal of the device (direct polarity), or vice versa, if required by the welding conditions and / or the brand of electrodes:

In manual arc welding, two types of connec- tion are distinguished: direct polarity and reverse. Connection “direct” polarity: elec- trode – “minus”, welded part – “plus”. Such a connection and a straight polarity current are appropriate for cutting metal and welding large thicknesses that require a large amount of heat to warm them up. “Reverse” polarity (electrode – “plus”, part

- “minus”) is used when welding small thick- nesses and thin-walled The fact is that at the negative pole (cathode) of an electric arc, the temperature is always lower than at the positive (anode), due to which the electrode melts faster, and the heating of the part decreases – and the danger of its burnout is also reduced.

2. Set the mode switch to MMA
3. Set the welding current according to the type and diameter of the electrode and start
4. The welding current is regulated by the cur- rent regulator, the actual value of the current during operation is displayed on the ammeter
5. Excitation of the arc is carried out by brief- ly touching the end of the electrode to the product and withdrawing it to the required dis- Technically, this process can be done in two ways:

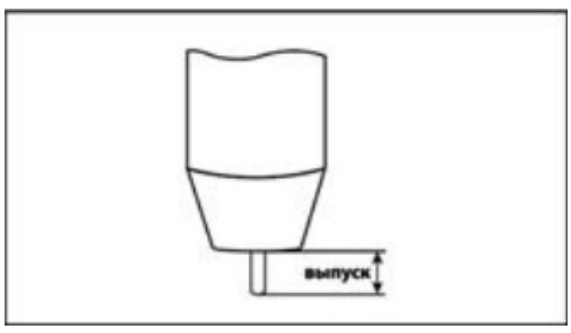
- By touching the electrode back to back and pulling it up;
- By striking the end of the electrode like a match on the surface of the

Attention! Do not knock the electrode on the working surface when trying to ignite the arc, as this can damage it and further complicate the ignition of the arc.

6. As soon as the arc strikes, the electrode must be held at such a distance from the workpiece that corresponds to the diameter of the electrode. To obtain a uniform seam, it is further neces- sary to maintain this distance as constant as possible. It should also be remembered that the inclination of the electrode axis should be approximately 20-30 degrees, for better visual control of the welding seam guidance.
7. When finishing the weld, pull the electrode back a little to fill the welding crater, and then lift it up sharply until the arc

Welding parameter tables (for reference only)

Thickness metal,mm	Recommended wire diameter, mm						
	Solid wire				Flux wire		
	0,6	0,8	0,9	1,0	0,8	0,9	1,2
0,6	+						
0,75	+	+			+		
0,9	+	+			+	+	
1,0	+	+	+		+	+	
1,2		+	+		+	+	+
1,9		+	+	+	+	+	+
3,0		+	+	+		+	+
5,0			+	+		+	+
6,0			+	+			+
8,0				+			+
10,0				+			+
12,0				+			+
For high-quality welding of metal with a thickness of 5 mm or more, it is necessary to chamfer the end edge of t he parts at the point of their joining or to weld in several passes.							



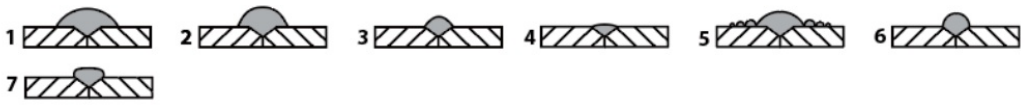
Gas flow settings for MIG, MAG welding

Parameters of current strength and diameter of electrodes when weld- ing MMA

Electrode diameter, mm	Welding current, A Minimum Maximum	
1,6	20	50
2,0	40	80
2,5	60	110
3,2	80	160
4,0	120	200

Weld seam characteristics

Depending on the amperage and speed of the electrode, you can get the following results:



1.too slow movement of the electrode

2.a very short arc

3.Very low welding current 4.too fast electrode movement 5.very long arc

6.Very high welding current 7.normal seam

We recommend that you carry out a few test welds to gain some practical skills.

Turning off the welding machine. Thermal protection

Your welding machine is equipped with ther- mal protection to prevent overheating of the electronic parts of the machine. If the tem- perature is exceeded, the thermal switch will turn off the device. The operation of the ther-

mal protection is indicated by the glow of the indicator.

ATTENTION! When the temperature returns to normal operating temperature, voltage will be supplied to the electrode automatically. Do not leave the product unattended during this time, but the electrode holder lying on the ground or on the parts to be welded.

We recommend that you turn off the device with the switch during this time.

It is normal for the product to heat up during operation.

ATTENTION! In order to avoid breakdowns or premature failure of the welding machine (es- pecially with frequent tripping of the thermal switch), before continuing to work, find out the reason for the tripping of the thermal protec- tion. To do this, disconnect the device from the mains and refer to the “Possible malfunc- tions and methods of their elimination” section of this Manual.

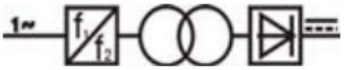
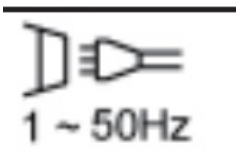
Possible malfunctions and meth- ods of their elimination

Monitor the good condition of the product. In case of appearance of suspicious odors, smoke, fire, sparks, turn off the device, dis- connect it from the mains and contact a spe- cialized service center.
If you find something abnormal in the opera- tion of the product, stop using it immediately. Due to the technical complexity of the product, the limit state criteria cannot be determined by the user independently.
In the case of an apparent or suspected mal- function, refer to the section “Possible mal- functions and methods of their elimination”. If there is no malfunction in the list or.
If you could not fix it, contact a specialized service center.
All other work (including repair) should be car- ried out only by specialists of service centers.

	Problem	**Possible reason**	**Solution**
1	Indicator is on ther mal protec- tion	Voltage too high	Turn off the power source; Check the mai n food; Turn on the machine again when t he voltage is normal.
		Voltage too low	
		Poor air flow	Improve air flow
		The thermal protection of the device has been triggered	Let the device cool down
2	No wire feed	Wire feed knob at minimum	Adjust
		Sticking current tip	Replace tip
		The feed rollers do not match the wir e diameter	Put on the right roller

3	The fan does not work or rotates slowly	Power button does not work	Please contact the service center
		The fan is broken	
		Poor fan connection	Check the connection
4	Unstable arc, large spatter	Poor part contact	Improve contact
		Network cable too thin, power is lost	Change the network cable
		Input voltage too low	Increase the input voltage with a regulator
		Burner parts worn out	Replace burner parts
5	The arc does not strike	Broken welding cable	Check the cable
		The part is dirty, in paint, in rust	Clean the part
6	No shielding gas	The burner is not connected correctly	Connect the burner correctly
		Gas hose kinked or damaged	Check gas hose
		Hose connections are loose	Check hose connections
7	Other		Please contact the service center

Graphic symbols and technical data

U0…….V	This symbol shows the secondary no-load voltage (in volts).
X	This symbol shows the rated duty cycle.
I2……A	This symbol shows the welding current in AMPS.
U2……V	This symbol shows the welding voltage in VOLTS.
U1	This symbol shows the rated supply voltage.
I1max…A	This symbol shows the welding unit’s maximum absorbed current in AMP.
I1eff…A	This symbol shows the welding unit’s maximum absorbed current in AMP.
IP21S	This symbol shows the welding unit’s protection class.
S	This symbol shows that the welding unit is suitable for use in envi- ronments w here there is a high risk of electric shocks.
	This symbol shows read the operating instructions carefully before operation.
	This symbol shows the welding unit is a single phased D.C. welder.
	This symbol shows the supply power phase and line frequency in Hertz.

Maintenance and Service

Maintenance and Cleaning

- **Pull the plug out of the socket before carrying out any work on the power**
- **Remove dust by dry and clean com- pressed air regularly.** If welding machine is operated in environment where strong smoke and polluted air is present, the ma- chine needs to be cleaned at least once a
- **Pressure of compressed air must be within reasonable range in order to prevent damage to small and sensitive components in the**
- **Check internal circuit of welding ma- chine regularly and make sure the circuit connections are connected correctly and tightly (especially plug- in connector and components).** If scale and rust are

found, please clean it, and connect again

- **Prevent water and steam from enter- ing into the machine. If that happens, please blow it dry and check insulation of**
- **If welding machine will not be used for long time, it must be put into the pack- ing box and stored in dry and clean**

In order to avoid safety hazards, if the power supply cord needs to be replaced, this must be done by P.I.T. or by an after-sales service centre that is authorised to repair P.I.T. power tools.

Service

- **Have your power tool repaired only by qualified personnel and only with origi- nal replacement parts. This ensures the safety of the power tool.**

The list of authorized service centers can be viewed on the official website of P.I.T. by the link: https://pittools.ru/servises/

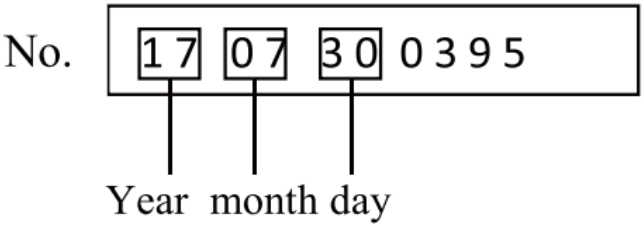
Storage and transportation

The welding machine should be stored in closed rooms with natural ventilation at tem- peratures from 0 to + 40 ° C and relative humidity up to + 80%. The presence of acid vapors, alkalis and other aggressive impuri- ties in the air is not allowed.
Products can be transported by any type of closed transport in the manufacturer's pack- aging or without it, while preserving the prod- uct from mechanical damage, atmospheric precipitation.

Dispose of waste

Damaged power tools, batteries, ac- cessories and waste packaging ma- terials must be recycled and reused in an environmentally friendly manner.
Do not throw power tools and accumulators / batteries into general household waste!

Product serial number interpreta- tion serial number



The first and second digits of the product seri- al number from left to right
Year of production, the third and fourth digits indicate the month of production.
The fifth and sixth digits indicate the produc- tion day.

TERMS OF WARRANTY SERVICE

1. This Warranty Certificate is the only docu- ment that confirms your right to free warranty Without presenting

this certificate, no claims are accepted. In case of loss or dam- age, the warranty certificate is not restored.

2. The warranty period for the electric ma- chine is 12 months from the date of sale, during the warranty period the service depart- ment eliminates manufacturing defects and replaces parts that have failed due to the fault of the manufacturer free of charge. In the war- ranty repair, an equivalent operable product is not provided. Replaceable parts become property of service providers.

P.I.T is not liable for any damage that may be caused by operation of the electric machine.

3. Only clean tool accompanied with the following duly executed documents: this War- ranty Certificate, Warranty Card, with all fields filled out, bearing the stamp of the trade orga- nization and the signature of the buyer, shall be accepted for warranty
4. Warranty repair is not performed in the fol- lowing cases:

- in the absence of a Warranty Certificate and a Warranty Card or their incorrect execution;
- with failure of both a rotor and a stator of the electric engine, charring or melting of primary winding of the welding machine transformer, charging or starting-charging device, with in- ternal parts melting, burn down of electronic circuit boards;
- if a Warranty Certificate or a Warranty Card

does not correspond to this electric machine or to the form established by the supplier;

- upon expiration of the warranty period;
- at attempts of opening or repair of the elec- tric machine outside the warranty workshop; making constructive changes and lubrication of the tool during the warranty period, as ev- idenced, for example, by the creases on the spline parts of the fasteners of non-rotational
- when using electric tools for production or other purposes connected with making a prof- it, as well as in case of malfunctions related to instability of the power network parameters exceeding the norms established by GOST;
- in the events of improper operation (use the electric machine for other than intended pur- poses, attachments to the electric machine of attachments, accessories, not provided by the manufacturer);
- with mechanical damage to the case, pow- er cord and in case of damages caused by aggressive agents and high and low tempera- tures, ingress of foreign objects in the ven- tilation grids of the electric machine, as well as in case of damage resulting from improper storage (corrosion of metal parts);
- natural wear and tear on the parts of the electric machine, as a result of long-term op- eration (determined on the basis of the signs of full or partial depletion of the specified mean life, great contamination, presence of rust outside and inside the electric machine, waste lubricant in the gearbox);
- use of the tool the purposes for other than specified in the operating
- mechanical damages to the tool;
- in the event of damages due to non-obser- vance of the operating conditions specified in the instruction (see chapter “Safety Precau- tions” of the Manual).
- damage to the product due to non-obser- vance of the rules of storage and transporta-
- in case of strong internal contamination of the tool.

Preventive maintenance of electric machines (cleaning, washing, lubrication, replacement of anthers, piston and

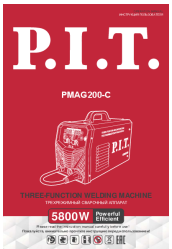
sealing rings) during the warranty period is a paid service.
The service life of the product is 3 years. Shelf life is 2 years. It is not recommended for oper- ation after 2 years of storage from the date of manufacture, which is indicated in the serial number on the label of the instrument, without preliminary verification (for the definition of the

date of manufacture, see the User's Manual earlier).
The owner is notified of any possible viola- tions of the above terms of wa rranty service upon completion of diagnostics in the service center.
The owner of the tool entrusts the diagnostic procedure to be conducted in the service cen- ter in his absence.
Do not operate the electric machine when there are signs of excessive heat, sparking, or noise in the gearbox. To determine the cause of the malfunction, the buyer should contact the warranty service center.
Malfunctions caused by late replacement of carbon brushes of the engine are eliminated at the expense of the buyer.

5. The warranty does not cover:

- replacement accessories (accessories and components), for example: batteries, discs, blades, drill bits, borers, chucks, chains, sprockets, collet clamps, guide rails, tension and fastening elements, trimming device heads, base of grinding and belt sander ma- chines, hexagonal heads, ,
- fast wearing parts, for example: carbon brushes, drive belts, seals, protective covers, guiding rollers, guides, rubber seals, bear- ings, toothed belts and wheels, shanks, brake belts, starter ratchets and ropes, piston rings, Their replacement during the warranty period is a paid service;
- power cords, in case of damage to the insu- lation, power cords are subject to mandatory replacement without the consent of the owner (paid service);
- tool case.

Documents / Resources

	P I T PMAG200-C Three Function Welding Machine [pdf] Instruction Manual PMAG200-C, PMAG200-C Three Function Welding Machine, Three Function Welding Machine, Function Welding Machine, Welding Machine, Machine, MIG-MMA-TIG-200A

References

- PIT GOLBAL
- Электроинструмент и садовая техника P.I.T. | Официальный сайт