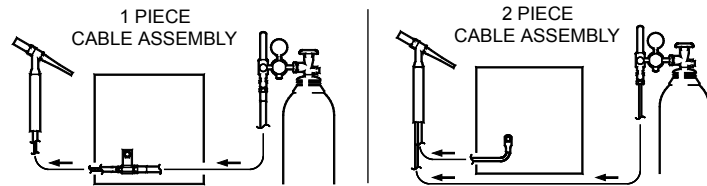


WARRANTY: CK Worldwide, Inc. warrants products manufactured by CK Worldwide, Inc. to be free of defects in materials and workmanship. CK Worldwide, Inc. limits this warranty to replacement of the product or parts thereof and excludes liability for injury, property damage or economic loss attributable to product use or misuse. In any event, CK Worldwide, Inc. will only be responsible for its products when used with accessory items manufactured by CK Worldwide, Inc.

INSTALLATION: Before using this torch, - tighten regulator, hose and power cable fittings with proper wrenches. Using small pliers, securely tighten all knurled hose fittings (Slide the torch handle back for access to the torch connections). Purge the regulator and TIG torch with inert gas at 20 cubic feet per hour. Following these steps will ensure contamination free welds. Repeat this procedure whenever torch or regulator fittings have been detached.

CONNECTION DIAGRAM:

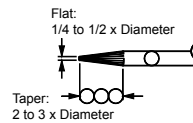


INFORMATION CHART:

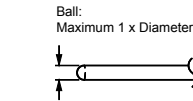
Electrode Diameter in inches (mm)	Cup Size	WELDING CURRENT (AMPS) - TUNGSTEN TYPE				ARGON FLOW - FERROUS METALS		ARGON FLOW - ALUMINUM	
		AC Pure	AC Thoriated	DCSP Pure	DCSP Thoriated	Standard Body (Liters)	Gas Lens Body (Liters)	Standard Body (Liters)	Gas Lens Body (Liters)
.020 (0.50)	4 or 5	5 - 15	5 - 20	5 - 15	5 - 20	5-8 (3-4)	5-8 (3-4)	5-8 (3-4)	5-8 (3-4)
.040 (1.00)	4 or 5	10 - 60	15-80	15 - 70	20 - 80	5-10 (3-5)	5-8 (3-4)	5-12 (3-6)	5-10 (3-5)
1/16 (1.60)	4, 5 or 6	50 - 100	70 - 150	70 - 130	80 - 150	7-12 (4-6)	5-10 (3-5)	8-15 (4-7)	7-12 (4-6)
3/32 (2.40)	6, 7 or 8	100 - 160	140 - 235	150 - 220	150 - 250	10-15 (5-7)	8-10 (4-5)	10-20 (5-10)	10-15 (5-7)
1/8 (3.20)	7, 8 or 10	150 - 210	220 - 325	220 - 330	240 - 350	10-18 (5-9)	8-12 (4-6)	12-25 (6-12)	10-20 (5-10)
5/32 (4.00)	8 or 10	200 - 275	300 - 425	375 - 475	400 - 500	15-25 (7-12)	10-15 (5-7)	15-30 (7-14)	12-25 (6-12)
3/16 (4.80)	8 or 10	250 - 350	400 - 525	475-800	475-800	20-35 (10-17)	12-25 (6-12)	25-40 (12-19)	15-30 (7-14)
1/4 (6.40)	10	325 - 700	500 - 700	750 - 1000	700 - 1100	25-50 (12-24)	20-35 (10-17)	30-55 (14-26)	25-45 (12-21)

TUNGSTEN PREPARATION:

END PREPARATION: DCSP (EN)
General Purpose:

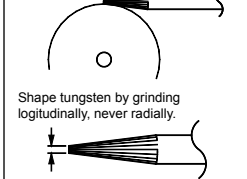


ACHF
General Purpose:

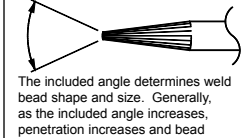


Ball tip by arcing on clean metal at low current DCRP (EP) then slowly increase current to form the desired ball diameter.

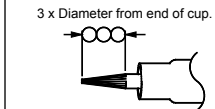
GRINDING PREPARATION:
Use a 60 Grit or finer aluminum oxide wheel



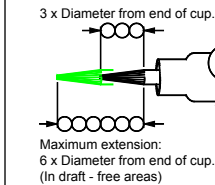
Remove sharp point to leave a truncated point with a flat spot. Diameter of flat spot determines amperage.



EXTENSION INSTRUCTION: STANDARD PARTS
General Purpose:



GAS LENS PARTS
General Purpose:



CAUTION: Personal harm will result from touching the hot parts of a TIG torch without insulative protection, or from looking directly or indirectly at an arc or reflected arc. At no time should bare skin be exposed to a welding arc.



TIG TORCH MANUAL



CK130 & CK130V RIGID

TECHNICAL INFORMATION

RATING @ 100% DUTY CYCLE: 130 AMP ACHF OR DCSP
COOLING METHOD: GAS COOLED

ACCESSORY ITEMS REQUIRED FOR COMPLETE INSTALLATION:

HEAD ACCESSORIES: 2 SERIES HEAD ACCESSORIES
POWER CABLE ADAPTOR: 105Z57 (15PCA)

MODEL SELECTOR - TORCH PACKAGES

HEAD STYLE	CABLE	LENGTH	STANDARD #	SUPERFLEX #
Rigid Head w/o Valve	2 Piece	12½ft (3.8m)	CK1312N RG	CK1312NSF RG
		25ft (7.6m)	CK1325N RG	CK1325NSF RG
Rigid Head with Valve	1 Piece	12½ft (3.8m)	CK1312H RG	CK1312HSF RG
		25ft (7.6m)	CK1325H RG	CK1325HSF RG
Rigid Head with Valve	2 Piece	12½ft (3.8m)	CK1312VN RG	CK1312VNSF RG
		25ft (7.6m)	CK1325VN RG	CK1325VNSF RG
Rigid Head with Valve	1 Piece	12½ft (3.8m)	CK1312VH RG	CK1312VHSF RG
		25ft (7.6m)	CK1325VH RG	CK1325VHSF RG

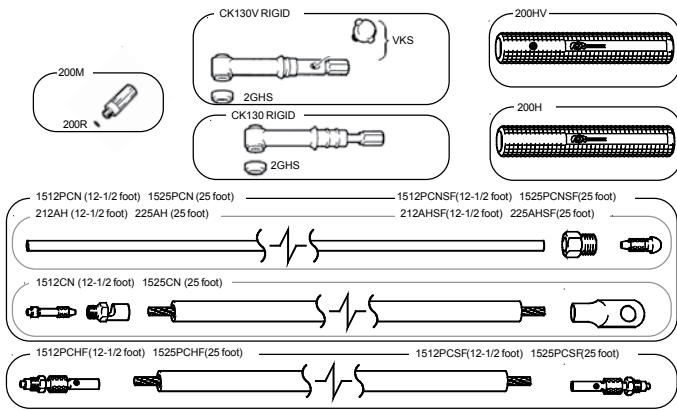
IMPORTANT !!
READ AND UNDERSTAND THE INFORMATION CONTAINED IN THIS MANUAL BEFORE OPERATING THE EQUIPMENT !

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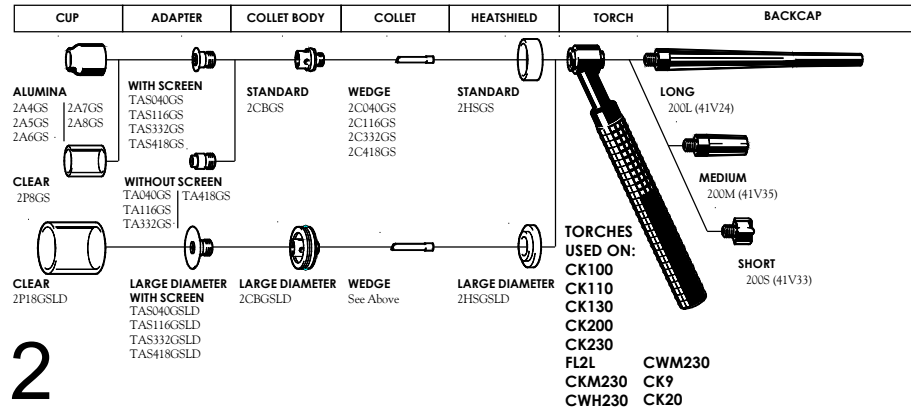
PARTS:



PARTS LIST:

PART NUMBER	DESCRIPTION
CK130 RIGID	Torch Body, Rigid, 70 degree, 130 Amp
CK130V RIGID	Torch Body with Valve, Rigid, 70 degree, 130 Amp
VKS	Gas Valve, Top Mounted
200H	Handle
200HV	Handle for Valve Torch
1512CN	Power Cable with Fittings, 12-1/2 foot.
1525CN	Power Cable with Fittings, 25 foot.
1512PCHF	Power Cable Assembly, Hi-Flex 1 Piece, 12-1/2 foot.
1512PCSF	Power Cable Assembly, Super Flex 1 Piece, 12-1/2 foot.
1525PCHF	Power Cable Assembly, Hi-Flex 1 Piece, 25 foot.
1525PCSF	Power Cable Assembly, Super Flex 1 Piece, 25 foot.
1512PCN	Power Cable Assembly, Hi-Performance 2 Piece, 12-1/2 foot.
1512PCNSF	Power Cable Assembly, Super Flex 2 Piece, 12-1/2 foot.
1525PCN	Power Cable Assembly, Hi-Performance 2 Piece, 25 foot.
1525PCNSF	Power Cable Assembly, Super Flex 2 Piece, 25 foot.
200R	O-Ring
212AH	Gas Hose with Fittings, 12-1/2 foot.
212AHSF	Gas Hose with Fittings, 12-1/2 foot, Super Flex
225AH	Gas Hose with Fittings, 25 foot.
225AHSF	Gas Hose with Fittings, 25 foot, Super Flex
2GHS	Heat Shield, Standard
200R	O-Ring
200S	Backcap, Short

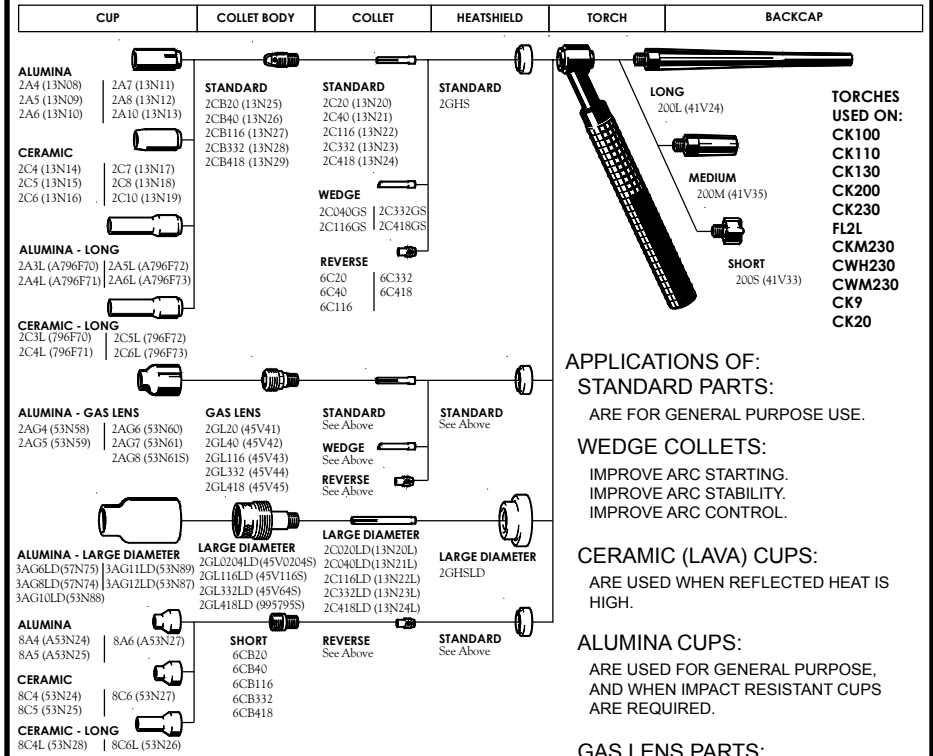
2 SERIES HEAD ACCESSORIES GAS SAVER



2

TORCHES USED ON:
 CK100
 CK110
 CK130
 CK200
 CK230
 FL2L CWM230
 CKM230 CK9
 CWH230 CK20

2 SERIES HEAD ACCESSORIES



CUP	COLLET BODY	COLLET	HEATSHIELD	TORCH	BACKCAP
ALUMINA 2A4 (13N08) 2A5 (13N09) 2A6 (13N10)	CK130V RIGID 2GHS CK130 RIGID 2GHS	STANDARD 2CB20 (13N25) 2CB40 (13N26) 2CB116 (13N27) 2CB332 (13N28) 2CB418 (13N29)	STANDARD 2C20 (13N20) 2C40 (13N21) 2C116 (13N22) 2C332 (13N23) 2C418 (13N24)	STANDARD 2GHS	LONG 200L (41V24) MEDIUM 200M (41V35) SHORT 200S (41V33)
CERAMIC 2C4 (13N14) 2C5 (13N15) 2C6 (13N16)	2C7 (13N17) 2C8 (13N18) 2C10 (13N19)	WEDGE 2C040GS 2C116GS	REVERSE 2C332GS 2C418GS		
ALUMINA - LONG 2A3L (A796F70) 2A4L (A796F71)	2A5L (A796F72) 2A6L (A796F73)		REVERSE 6C20 6C40 6C116		
CERAMIC - LONG 2C3L (796F70) 2C4L (796F71)	2C5L (796F72) 2C6L (796F73)				
ALUMINA - GAS LENS 2AG4 (53N58) 2AG5 (53N59)	2AG6 (53N60) 2AG7 (53N61) 2AG8 (53N61S)	GAS LENS 2GL20 (45V41) 2GL40 (45V42) 2GL116 (45V43) 2GL332 (45V44) 2GL418 (45V45)	STANDARD See Above WEDGE See Above REVERSE See Above	STANDARD See Above	
ALUMINA - LARGE DIAMETER 3AG6LD(57N75) 3AG8LD(57N74) 3AG10LD(53N88)	LARGE DIAMETER 3AG11LD(53N89) 3AG12LD(53N87)	LARGE DIAMETER 2GL020LD(45V0204S) 2GL116LD (45V116S) 2GL332LD (45V64S) 2GL418LD (995795S)	LARGE DIAMETER 2C020LD(13N20L) 2C040LD(13N21L) 2C116LD (13N22L) 2C332LD (13N23L) 2C418LD (13N24L)	LARGE DIAMETER 2GHSLD	
ALUMINA 8A4 (A53N24) 8A5 (A53N25)	8A6 (A53N27)	SHORT 6CB20 6CB40 6CB116	REVERSE See Above	STANDARD See Above	
CERAMIC 8C4 (53N24) 8C5 (53N25)	8C6 (53N27)	6CB332 6CB418			
CERAMIC - LONG 8C4L (53N28)	8C6L (53N26)				

APPLICATIONS OF:
STANDARD PARTS:

ARE FOR GENERAL PURPOSE USE.

WEDGE COLLETS:

IMPROVE ARC STARTING.
 IMPROVE ARC STABILITY.
 IMPROVE ARC CONTROL.

CERAMIC (LAVA) CUPS:

ARE USED WHEN REFLECTED HEAT IS HIGH.

ALUMINA CUPS:

ARE USED FOR GENERAL PURPOSE,
 AND WHEN IMPACT RESISTANT CUPS
 ARE REQUIRED.

GAS LENS PARTS:

ARE USED TO REDUCE TURBULENCE
 AND IMPROVE SHIELD GAS COVERAGE
 PATTERNS,
 INCREASES DUTY CYCLE OF TORCH
 AND INCREASES TUNGSTEN STICK
 OUT.

SHORT (STUBBY) PARTS:

ARE USED TO SHORTEN THE OVERALL
 LENGTH OF THE TORCH HEAD.
 REDUCES DUTY CYCLE OF TORCH

GAS SAVER® PARTS:

ARE USED TO SAVE UP TO 40% ON GAS
 CONSUMPTION.
 ARE USED TO SAVE UP TO 60% ON
 CONSUMABLE PARTS.
 ARE USED TO CLEARLY SEE THE WELD
 PUDDLE.
 ARE USED TO ACHIEVE GAS LENS

3

TUNGSTEN ELECTRODE CONVERSION CHART

Size Suffix	Inches	Millimeters
020	.020"	.5mm
040	.040"	1.0mm
116	1/16"	1.6mm
332	3/32"	2.4mm
418	1/8"	3.2mm
532	5/32"	4.0mm