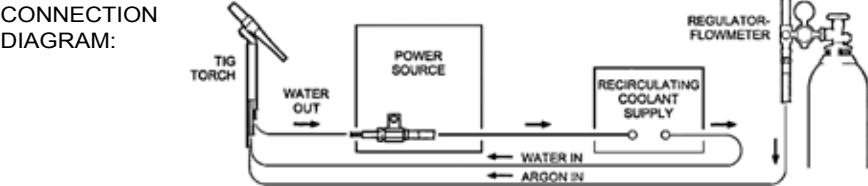


WARRANTY: CK Worldwide, Inc. warrants products manufactured by CK Worldwide, Inc. to be free of defects in materials and workmanship. CK Worldwide, Inc. limits this warranty to replacement of the product or parts thereof and excludes liability for injury, property damage or economic loss attributable 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.



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:

Flat: 1/4 to 1/2 x Diameter

Taper: 2 to 3 x Diameter

ACHF
General Purpose:

Ball: Maximum 1 x Diameter

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

Shape tungsten by grinding longitudinally, never radially.

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

The included angle determines weld bead shape and size. Generally, as the included angle increases, penetration increases and bead width decreases.

EXTENSION INSTRUCTION: STANDARD PARTS
General Purpose:

3 x Diameter from end of cup.

GAS LENS PARTS
General Purpose:

3 x Diameter from end of cup.

Maximum extension: 6 x Diameter from end of cup. (In draft - free areas)

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



CK200 & CK200V FLEX

TECHNICAL INFORMATION

RATING @ 100% DUTY CYCLE: 250 AMP ACHF OR DCSP
COOLING METHOD: WATER COOLED

ACCESSORY ITEMS REQUIRED FOR COMPLETE INSTALLATION:

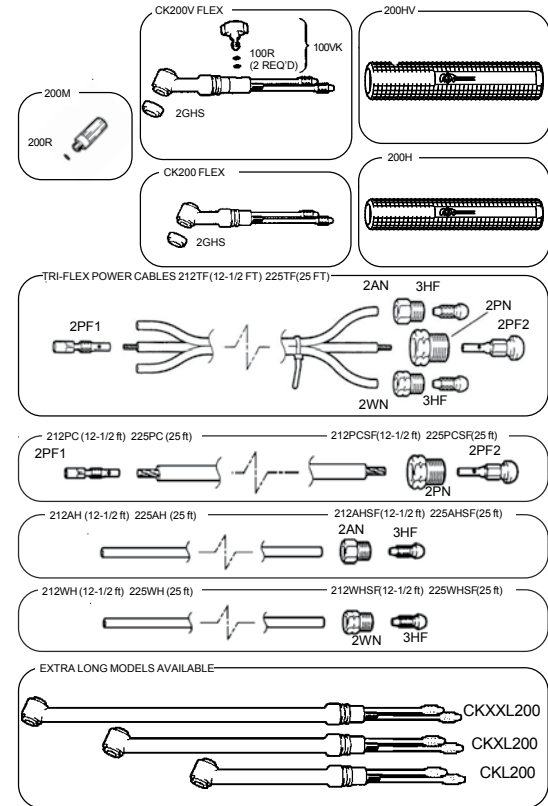
HEAD ACCESSORIES: 2 SERIES HEAD ACCESSORIES
POWER CABLE ADAPTOR: 45V11 (2PCA)

MODEL SELECTOR - TORCH PACKAGES

HEAD STYLE	CABLE STYLE	CABLE LENGTH	STANDARD CABLE	SUPERFLEX CABLE
FLEX HEAD -w/ VALVE	TRI-FLEX	12-1/2 ft. (3.8 m)	CK212 FX	CK212SF FX
		25 ft. (7.6 m)	CK225 FX	CK225SF FX
FLEX HEAD -w/o VALVE	TRIFLEX	12-1/2 ft. (3.8 m)	CK212V FX	CK212VSF FX
		25 ft. (7.6 m)	CK225V FX	CK225VSF FX

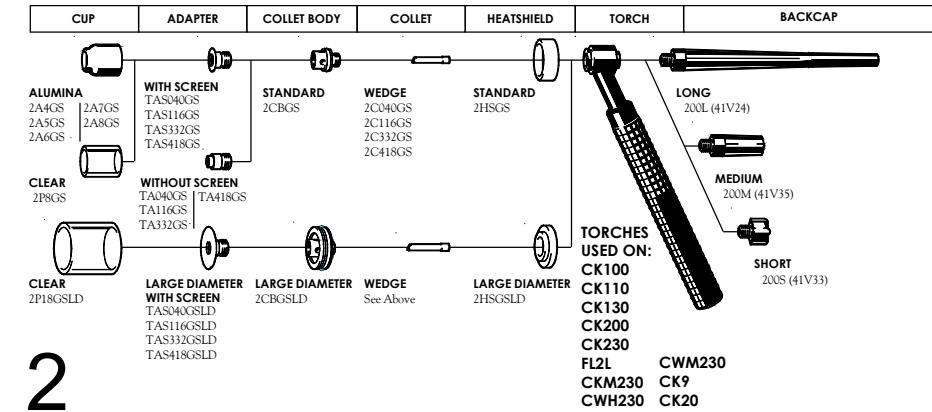
IMPORTANT !!
READ AND UNDERSTAND THE
INFORMATION CONTAINED IN THIS
MANUAL BEFORE OPERATING THE EQUIPMENT !

PARTS:

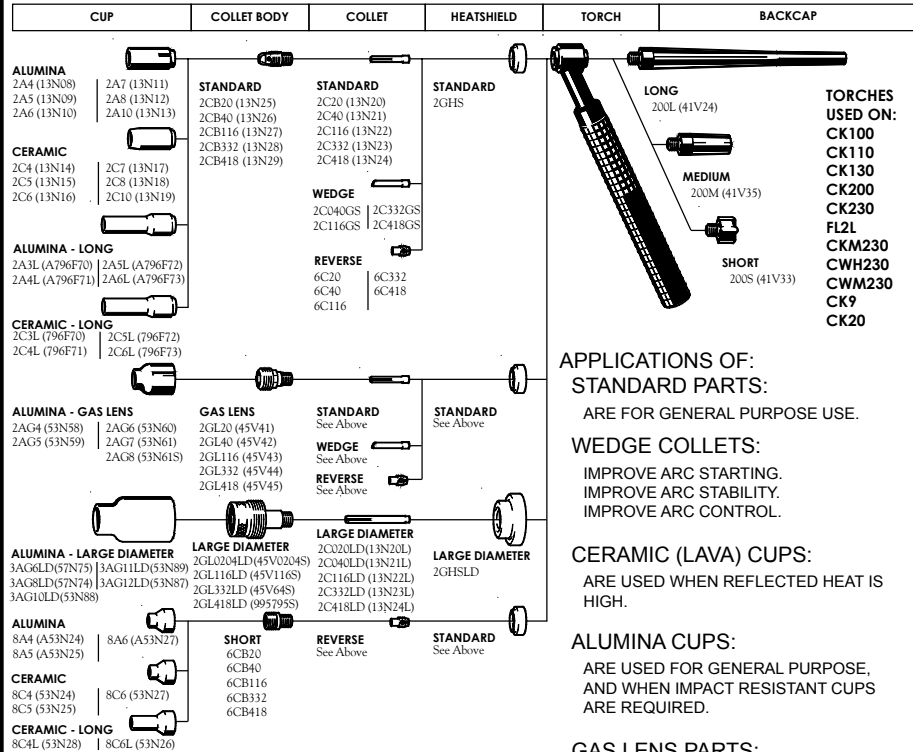


PART #	DESCRIPTION
TORCH	
CK200 FLEX.....	TORCH BODY
CK200V FLEX.....	TORCH BODY VALVED
200H.....	HANDLE
200HV.....	HANDLE FOR VALVED
TRI-FLEX POWER CABLE	
212TF.....	TRI-FLEX POWER CABLE & HOSE ASSEMBLY -12-1/2 FOOT (INCLUDES FITTINGS)
225TF.....	TRI-FLEX POWER CABLE & HOSE ASSEMBLY -25 FOOT (INCLUDES FITTINGS)
01-0032.....	CABLE TIE
2AN.....	GAS HOSE NUT
2PF1.....	POWER CABLE FITTING
2PF2.....	POWER CABLE FITTING
2PN.....	POWER CABLE NUT
2WN.....	WATER HOSE NUT
3HF.....	HOSE FITTING (2 REQUIRED)
INDIVIDUAL CABLE, HOSES	
212AH (45V09).....	GAS HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
212AHHSF (45V09SF).....	GAS HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
212PC (45V03).....	POWER CABLE-12-1/2 FOOT (INCLUDES FITTINGS)
212PCSF (45V03SF).....	POWER CABLE-12-1/2 FOOT (INCLUDES FITTINGS)
212WH (45V07).....	WATER HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
212WHHSF (45V07SF).....	WATER HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
225AH (45V10).....	GAS HOSE-25 FOOT (INCLUDES FITTINGS)
225AHHSF (45V10SF).....	GAS HOSE-25 FOOT (INCLUDES FITTINGS)
225PC (45V04).....	POWER CABLE-25 FOOT (INCLUDES FITTINGS)
225PCSF (45V04SF).....	POWER CABLE-25 FOOT (INCLUDES FITTINGS)
225WH (45V08).....	WATER HOSE-25 FOOT (INCLUDES FITTINGS)
225WHHSF (45V08SF).....	WATER HOSE-25 FOOT (INCLUDES FITTINGS)
ACCESSORIES	
2PCA (45V11).....	POWER CABLE ADAPTER (ORDER SEPARATELY) SAFE LOCK QUICK CONNECT
SLWHAT-T.....	TWECO POWER CABLE ADAPTER
SLWHAT-25.....	DINSE 25 POWER CABLE ADAPTER
SLWHAT-35.....	DINSE 35 POWER CABLE ADAPTER
SLWHAT-35M.....	DINSE 35 FLOW-THRU GAS POWER CABLE ADAPTER
200R.....	O-RING
200M.....	BACKCAP
2GHS.....	HEATSHIELD
EXTRA LONG TORCH HEADS	
CKXXL200.....	10-1/2" LONG MODEL
CKXL200.....	7-1/2" LONG MODEL
CKL200.....	4-1/2" LONG MODEL
NOTE: TRI-FLEX CABLE CAN BE SEPERATED TO REPLACE GAS HOSE, WATER HOSE OR POWER CABLE INDIVIDUALLY	

2 SERIES HEAD ACCESSORIES GAS SAVER



2 SERIES HEAD ACCESSORIES



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

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