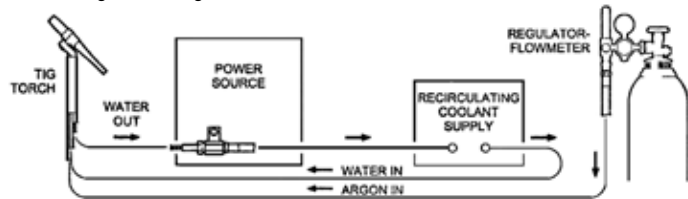


WARRANTY: CK Worldwide, Inc. warrants products manufactured by CK Worldwide, Inc. to be free of defects in materials and workmanship. CK Worldwide, Inc. limits this warranty to replacement of the product or parts thereof and excludes liability for injury, property damage or economic loss attributable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

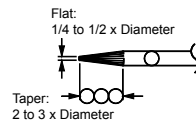


INFORMATION CHART:

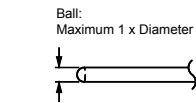
Electrode Diameter in inches (mm)	Cup Size	WELDING CURRENT (AMPS) - TUNGSTEN TYPE				ARGON FLOW - FERROUS METALS		ARGON FLOW - ALUMINUM	
		AC Pure	AC Thoriated	DCSP Pure	DCSP Thoriated	Standard Body (Liters)	Gas Lens Body (Liters)	Standard Body (Liters)	Gas Lens Body (Liters)
.020 (0.50)	4 or 5	5 - 15	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:

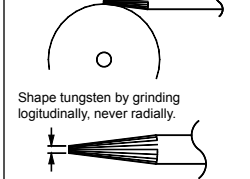


ACHF
General Purpose:

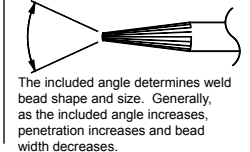


Ball tip by arcing on clean metal at low current DCRP (EP) then slowly increase current to form the desired ball diameter.

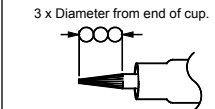
GRINDING PREPARATION:
Use a 60 Grit or finer aluminum oxide wheel



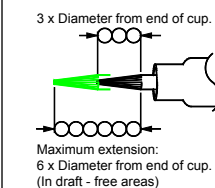
Remove sharp point to leave a truncated point with a flat spot. Diameter of flat spot determines amperage.



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



CK300 & CK300V RIGID

TECHNICAL INFORMATION

RATING @ 100% DUTY CYCLE: 350 AMP ACHF OR DCSP
COOLING METHOD: WATER COOLED

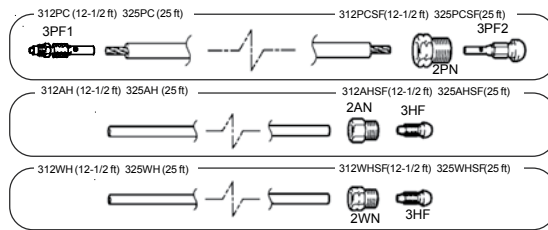
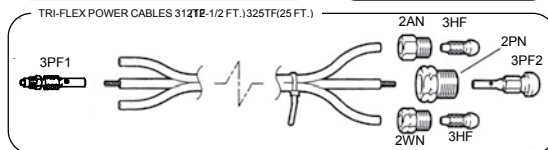
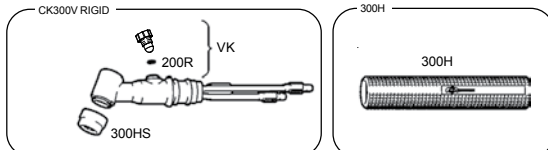
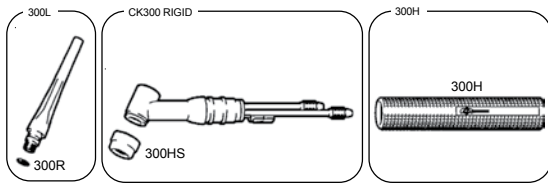
ACCESSORY ITEMS REQUIRED FOR COMPLETE INSTALLATION:

HEAD ACCESSORIES: 3 SERIES HEAD ACCESSORIES
POWER CABLE ADAPTOR: 45V11 (2PCA)

MODEL SELECTOR - TORCH PACKAGES

BODY STYLE	CABLE STYLE	CABLE LENGTH	STANDARD CABLE	SUPERFLEX CABLE
Rigid Head -w/o Valve	3 Piece Cable	12-1/2 ft. (3.8m)	CK312	CK312SF
		25 ft (7.6m)	CK325	CK325SF
Rigid Head -w/ Valve	3 Piece Cable	12-1/2 ft. (3.8m)	CK312V	CK312VSF
		25 ft (7.6m)	CK325V	CK325VSF

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



PART #	DESCRIPTION
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TORCH
 CK300 RIGID..... TORCH BODY ASSEMBLY
 CK300V RIGID..... TORCH BODY
 3 0 0 H HANDLE

TRI-FLEX POWER CABLE
 312TF..... TRI-FLEX POWER CABLE & HOSE ASSEMBLY -12-1/2 FOOT (INCLUDES FITTINGS)
 325TF..... TRI-FLEX POWER CABLE & HOSE ASSEMBLY -25 FOOT (INCLUDES FITTINGS)
 01-0032..... CABLE TIE
 2AN..... GAS HOSE NUT
 3PF1..... POWER CABLE FITTING
 3PF2..... POWER CABLE FITTING
 2PN..... POWER CABLE NUT
 2WN..... WATER HOSE NUT
 3HF..... HOSE FITTING (2 REQUIRED)

INDIVIDUAL CABLE HOSES
 312AH (40V75)..... GAS HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 312AHSF (40V75SF)..... GAS HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 312PC (40V64)..... POWER CABLE-12-1/2 FOOT (INCLUDES FITTINGS)
 312PCSF (40V64SF)..... POWER CABLE-12-1/2 FOOT (INCLUDES FITTINGS)
 312WH (40V74)..... WATER HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 312WHSF (40V74SF)..... WATER HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 325AH (41V30)..... GAS HOSE-25 FOOT (INCLUDES FITTINGS)
 325AHSF (41V30SF)..... GAS HOSE-25 FOOT (INCLUDES FITTINGS)
 325PC (41V28)..... POWER CABLE-25 FOOT (INCLUDES FITTINGS)
 325PCSF (41V28SF)..... POWER CABLE-25 FOOT (INCLUDES FITTINGS)
 325WH (41V32)..... WATER HOSE-25 FOOT (INCLUDES FITTINGS)
 325WHSF (41V32SF)..... WATER HOSE-25 FOOT (INCLUDES FITTINGS)

ACCESSORIES
 2PCA (45V11)..... POWER CABLE ADAPTER (ORDER SEPARATELY)
SAFE-LOC 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
 300R..... O-RING
 300L..... BACKCAP
 300HS..... HEATSHIELD

NOTE:
 TRI-FLEX CABLE CAN BE SEPARATED TO REPLACE GAS HOSE, WATER HOSE OR POWER CABLE INDIVIDUALLY

3 SERIES HEAD ACCESSORIES GAS SAVER

CUP	ADAPTER	COLLET BODY	COLLET	HEATSHIELD	TORCH	BACKCAP
ALUMINA 3A4GS 3A5GS 3A6GS 3A7GS 3A8GS	WITH SCREEN TAS04GCS TAS116GCS TAS332GCS TAS418GCS TAS532GCS	STANDARD 3CBGS	WEDGE 3C04GCS 3C116GCS 3C332GCS 3C418GCS 3C532GCS	STANDARD 3HSGS	LONG 300L (57Y02)	MEDIUM 300M (34015)
CLEAR 3P8GS	WITHOUT SCREEN TA04GCS TA418GCS TA116GCS TA532GCS TA332GCS					SHORT 300S (57Y04)
ALUMINA 2A4GS 2A5GS 2A6GS	WITH SCREEN See Above	SHORT 4CBGS	SHORT WEDGE 4C04GCS 4C116GCS 4C332GCS 4C418GCS 4C532GCS	SHORT 3HSGS		
CLEAR 2P8GS	WITHOUT SCREEN See Above					
CLEAR 4P18GSLD	LARGE DIAMETER WITH SCREEN TAS04GSLD TAS116GSLD TAS332GSLD TAS418GSLD TAS532GSLD	LARGE DIAMETER 4CBGSLD	SHORT WEDGE 4C04GCS 4C116GCS 4C332GCS 4C418GCS 4C532GCS	LARGE DIAMETER 4HSGSLD		

2

3 SERIES HEAD ACCESSORIES

CUP	COLLET BODY	COLLET	HEATSHIELD	TORCH	BACKCAP
ALUMINA 3A4 (10N50) 3A5 (10N49) 3A6 (10N48) 3A7 (10N47)	STANDARD 3CB20 (10N29) 3CB40 (10N30) 3CB116 (10N31) 3CB332 (10N32) 3CB418 (10N28) 3CB532 (406488)	STANDARD 3C20 (10N21) 3C40 (10N22) 3C116 (10N23) 3C332 (10N24) 3C418 (10N25) 3C532 (54N20)	STANDARD 300HS		LONG 300L (57Y02) MEDIUM 300M (34015) SHORT 300S (57Y04)
ALUMINA - LONG 3A5L (10N49L) 3A6L (10N48L)	ALUMINA - LONG 3A7L (10N47L)				
CERAMIC 3C4 (105243) 3C5 (105242) 3C6 (105244) 3C7 (105245)	WEDGE 3C8 (08N78) 3C10 (08N79) 3C12 (08N80)	WEDGE 3C04GCS 3C116GCS 3C332GCS	REVERSE 7C20 7C40 7C116	REVERSE 7C332 7C418 7C532	
CERAMIC - LONG 3C4L (12N03) 3C5L (105260)	CERAMIC - LONG 3C6L (12N02) 3C7L (105261)				
ALUMINA - GAS LENS 3AG4 (54N18) 3AG5 (54N17) 3AG6 (54N16)	GAS LENS 3GL20 (45V29) 3GL40 (45V24) 3GL116 (45V25) 3GL332 (45V26) 3GL418 (45V27) 3GL532 (45V28)	STANDARD See Above	GAS LENS 3GH5		
ALUMINA LONG - GAS LENS OVERALL LENGTH 3 IN. 3AG5L (54N17L) 3AG6L (54N16L) 3AG7L (54N15L) 3AG8L (54N14L)					
CERAMIC - GAS LENS 3CG4 (54N35) 3CG5 (54N34) 3CG6 (54N33) 3CG7 (54N32) 3CG8 (54N31)	CERAMIC - GAS LENS 3CG11 (54N36) 3CG12 3CG14 3CG16				
ALUMINA - LARGE DIAMETER 3AG6LD (57N75) 3AG8LD (57N74) 3AG10LD (53N88) 3AG11LD (53N89) 3AG12LD (53N87)	LARGE DIAMETER 3GL116LD (45V116) 3GL332LD (45V64) 3GL418LD (995795) 3GL532LD (45V63)	STANDARD See Above	LARGE DIAMETER 3GHSLD		
ALUMINA LONG - LARGE DIAMETER OVERALL LENGTH 2.75 IN. 3AG6LDL (57N75L) 3AG8LDL (57N74L) 3AG10LDL (53N88L) 3AG12LDL (53N87L)					

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

3