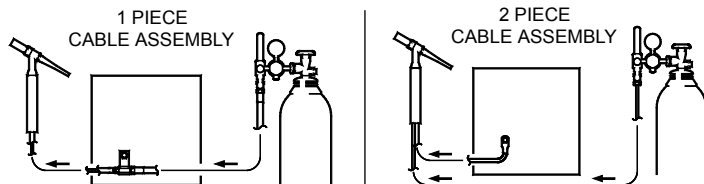


**CK WORLDWIDE INC.**

**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.

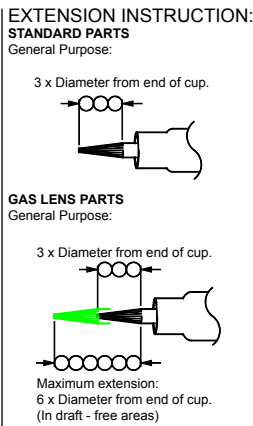
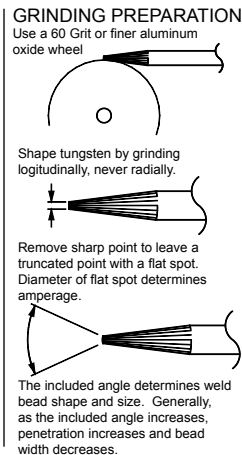
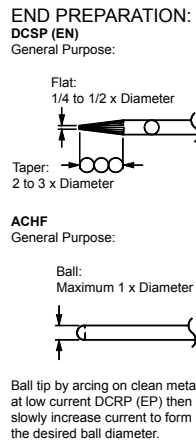
**CONNECTION DIAGRAM:**



**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:**



**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**



**TECHNICAL INFORMATION**

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

**ACCESSORY ITEMS REQUIRED FOR COMPLETE INSTALLATION:**

HEAD ACCESSORIES: A2 SERIES HEAD ACCESSORIES  
POWER CABLE ADAPTOR: APCA10

**MODEL SELECTOR - TORCH PACKAGES**

HEAD STYLE	CABLE STYLE	CABLE LENGTH	STANDARD CABLE	SUPERFLEX CABLE
Rigid Head - w/o valve	Hi-Flex 1 Piece	12-1/2 ft. (3.8 m)	CKA102	CKA102 SF
		25 ft. (7.6 m)	CKA105	CKA105 SF
Rigid Head - w/ valve	Hi-Flex 1 Piece	12-1/2 ft. (3.8 m)	CKA102V	CKA102V SF
		25 ft. (7.6 m)	CKA105V	CKA105V SF

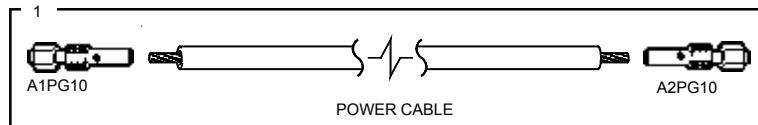
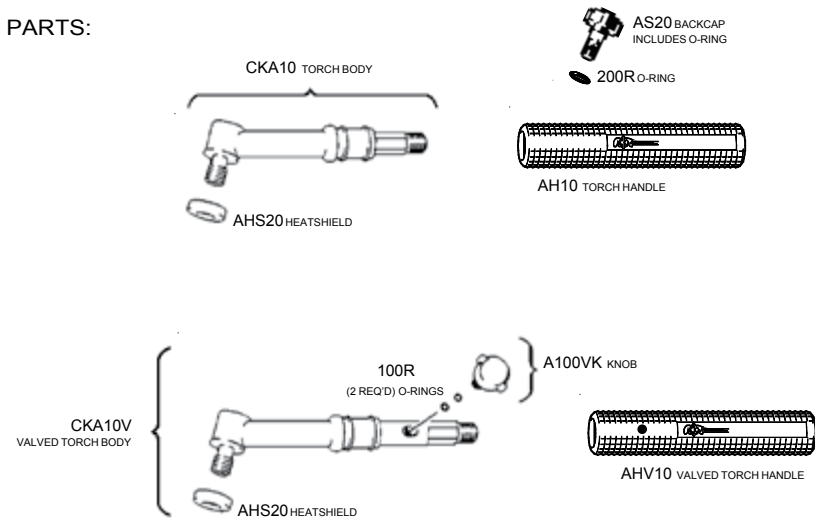
**IMPORTANT !!**  
**READ AND UNDERSTAND THE INFORMATION CONTAINED IN THIS MANUAL BEFORE OPERATING THE EQUIPMENT !**

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PARTS:



PARTS LIST:

PART NUMBER	DESCRIPTION
CKA10 RIGID	Torch Body
CKA10V RIGID	Torch Body With Valve
210VK	Gas Valve, Top Mounted
AH10	Handle
AHV10	Handle for Valved
A2PC10	Power Cable Assembly, HI-Flex 1 Piece, 12-1/2 foot.
A2PC10SF	Power Cable Assembly, Super Flex 1 Piece, 12-1/2 foot.
A5PC10	Power Cable Assembly, HI-Flex 1 Piece, 25 foot.
A5PC10SF	Power Cable Assembly, Super Flex 1 Piece, 25 foot.
200R	O-Ring
AHS20	Heat Shield, Standard
200R	O-Ring
AS20	Backcap, Short

FOR USE WITH THE FOLLOWING CK TIG TORCHES:  
CKA10, CKA20

COLLET



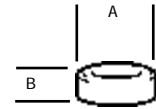
STANDARD		
SIZE in. (mm)	CROSS REF.	ORDER NUMBER
.020 (.50)	2304-0138	A20C20
.040 (1.00)	2304-0137	A40C20
1/16 (1.60)	2304-0136	A116C20
3/32 (2.40)	2304-0135	A332C20
1/8 (3.20)	2304-0068	A418C20

COLLET BODY



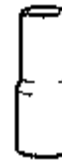
NOSE BLOCK		
SIZE in. (mm)	CROSS REF.	ORDER NUMBER
ALL	2310-1810	ANT20

HEAT SHIELD



STANDARD		
A	B	ORDER NUMBER
7/8" (22.23)	1/4" (6.35)	AHS20

CUP (NOZZLE)



ALUMINA - STANDARD				
SIZE	ORIFICE in. (mm)	LENGTH in. (mm)	CROSS REF.	ORDER NUMBER
4	1/4 (6.35)	1-9/16" (39.69)	2304-0069	A4A2
5	5/16 (7.94)	1-9/16" (39.69)	2304-0070	A5A2
6	3/8 (9.53)	1-9/16" (39.69)	2304-0073	A6A2
7	7/16 (11.12)	1-9/16" (39.69)	2304-0074	A7A2



CERAMIC (LAVA) - STANDARD				
SIZE	ORIFICE in. (mm)	LENGTH in. (mm)	CROSS REF.	ORDER NUMBER
4	1/4 (6.35)	1-9/16" (39.69)	2304-0002	A4C2
5	5/16 (7.94)	1-9/16" (39.69)	2304-0004	A5C2
6	3/8 (9.53)	1-9/16" (39.69)	2304-0049	A6C2
7	7/16 (11.12)	1-9/16" (39.69)	2304-0050	A7C2

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