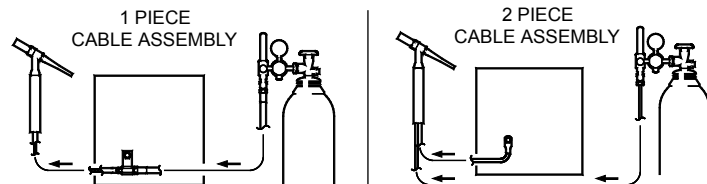


WARRANTY: CK Worldwide, Inc. warrants products manufactured by CK Worldwide, Inc. to be free of defects in materials and workmanship. CK Worldwide, Inc. limits this warranty to replacement of the product or parts thereof and excludes liability for injury, property damage or economic loss attributable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

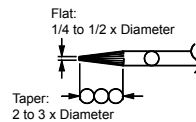


INFORMATION CHART:

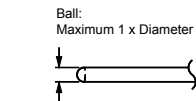
| Electrode Diameter in inches (mm) | Cup Size | WELDING CURRENT (AMPS) - TUNGSTEN TYPE | | | | ARGON FLOW - FERROUS METALS | | ARGON FLOW - ALUMINUM | |
|-----------------------------------|------------|--|--------------|------------|----------------|-----------------------------|------------------------|------------------------|------------------------|
| | | 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:

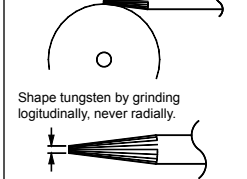


ACHF
General Purpose:



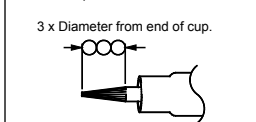
Ball tip by arcing on clean metal at low current DCRP (EP) then slowly increase current to form the desired ball diameter.

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

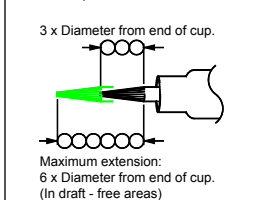


Remove sharp point to leave a truncated point with a flat spot. Diameter of flat spot determines amperage.
The included angle determines weld bead shape and size. Generally, as the included angle increases, penetration increases and bead width decreases.

EXTENSION INSTRUCTION: STANDARD PARTS
General Purpose:



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



TL26 & TL26V FLEX

TECHNICAL INFORMATION

RATING @ 100% DUTY CYCLE: 200 AMP ACHF OR DCSP
COOLING METHOD: GAS COOLED

ACCESSORY ITEMS REQUIRED FOR COMPLETE INSTALLATION:

HEAD ACCESSORIES: 3 SERIES HEAD ACCESSORIES
POWER CABLE ADAPTOR: 45V62 (ONE-PIECE POWER CABLE ONLY)

MODEL SELECTOR - TORCH PACKAGES

| HEAD STYLE | CABLE | LENGTH | STANDARD # | SUPERFLEX # |
|-----------------------|---------|--------------|---------------|-----------------|
| Rigid Head w/o Valve | 2 Piece | 12½ft (3.8m) | TL26-12-2 FX | TL26-12-2SF FX |
| | | 25ft (7.6m) | TL26-25-2 FX | TL26-25-2SF FX |
| Rigid Head with Valve | 2 Piece | 12½ft (3.8m) | TL26-12-R FX | TL26-12-RSF FX |
| | | 25ft (7.6m) | TL26-25-R FX | TL26-25-RSF FX |
| Rigid Head with Valve | 1 Piece | 12½ft (3.8m) | TL26V-12-2 FX | TL26V-12-2SF FX |
| | | 25ft (7.6m) | TL26V-25-2 FX | TL26V-25-2SF FX |
| Rigid Head with Valve | 1 Piece | 12½ft (3.8m) | TL26V-12-R FX | TL26V-12-RSF FX |
| | | 25ft (7.6m) | TL26V-25-R FX | TL26V-25-RSF FX |

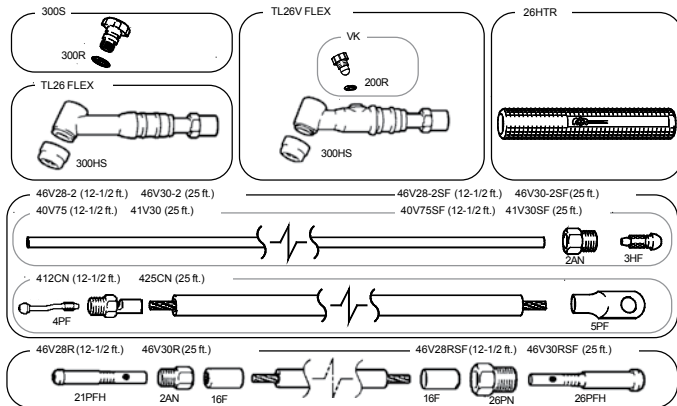
IMPORTANT !!
READ AND UNDERSTAND THE INFORMATION CONTAINED IN THIS MANUAL BEFORE OPERATING THE EQUIPMENT !

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www.ckworldwide.com
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PARTS:



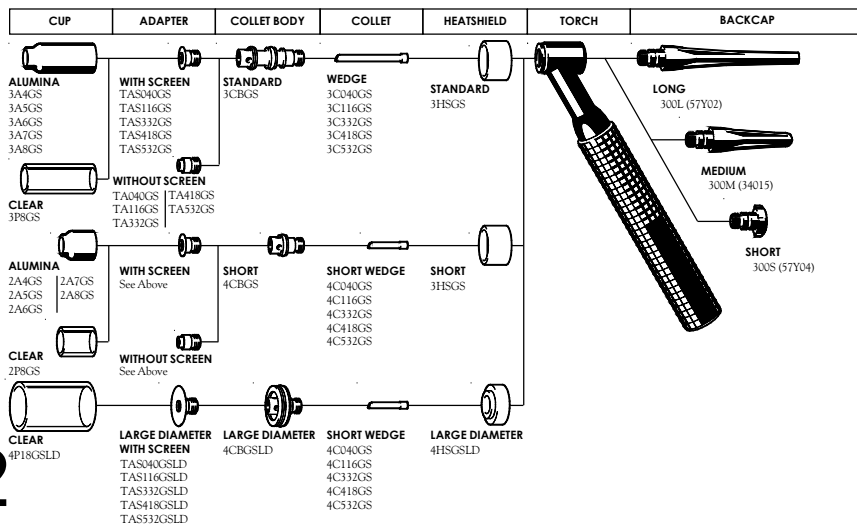
PARTS LIST:

| PART NUMBER | DESCRIPTION |
|-------------|--|
| TL26 FLEX | TORCH BODY, FLEX, 70 DEGREE, 200 AMP |
| TL26V FLEX | TORCH BODY WITH VALVE, FLEX, 70 DEGREE, 200 AMP |
| VK | GAS VALVE, TOP MOUNTED |
| 26HTR | HANDLE |
| 412CN | POWER CABLE WITH FITTINGS, 12-1/2 FT. |
| 425CN | POWER CABLE WITH FITTINGS, 25 FT. |
| 46V28 | POWER CABLE ASSEMBLY, HI-FLEX 1 PIECE, 12-1/2 FT. |
| 46V28RSF | POWER CABLE ASSEMBLY, SUPER FLEX 1 PIECE, 12-1/2 FT. |
| 46V30R | POWER CABLE ASSEMBLY, HI-FLEX 1 PIECE, 25 FT. |
| 46V30RSF | POWER CABLE ASSEMBLY, SUPER FLEX 1 PIECE, 25 FT. |
| 46V28-2 | POWER CABLE ASSEMBLY, HI-PERFORMANCE 2 PIECE, 12-1/2 FT. |
| 46V28-2SF | POWER CABLE ASSEMBLY, SUPER FLEX 2 PIECE, 12-1/2 FT. |
| 46V30-2 | POWER CABLE ASSEMBLY, HI-PERFORMANCE 2 PIECE, 25 FT. |
| 46V30-2SF | POWER CABLE ASSEMBLY, SUPER FLEX 2 PIECE, 25 FT. |
| 200R | O-RING |
| 40V75 | GAS HOSE WITH FITTINGS, 12-1/2 FT. |
| 40V75SF | GAS HOSE WITH FITTINGS, 12-1/2 FT., SUPER FLEX |
| 41V30 | GAS HOSE WITH FITTINGS, 25 FT. |
| 41V30SF | GAS HOSE WITH FITTINGS, 25 FT., SUPER FLEX |
| 300HS | HEAT SHIELD, STANDARD |
| 300R | O-RING |
| 300S | BACKCAP, SHORT |

ACCESSORIES:

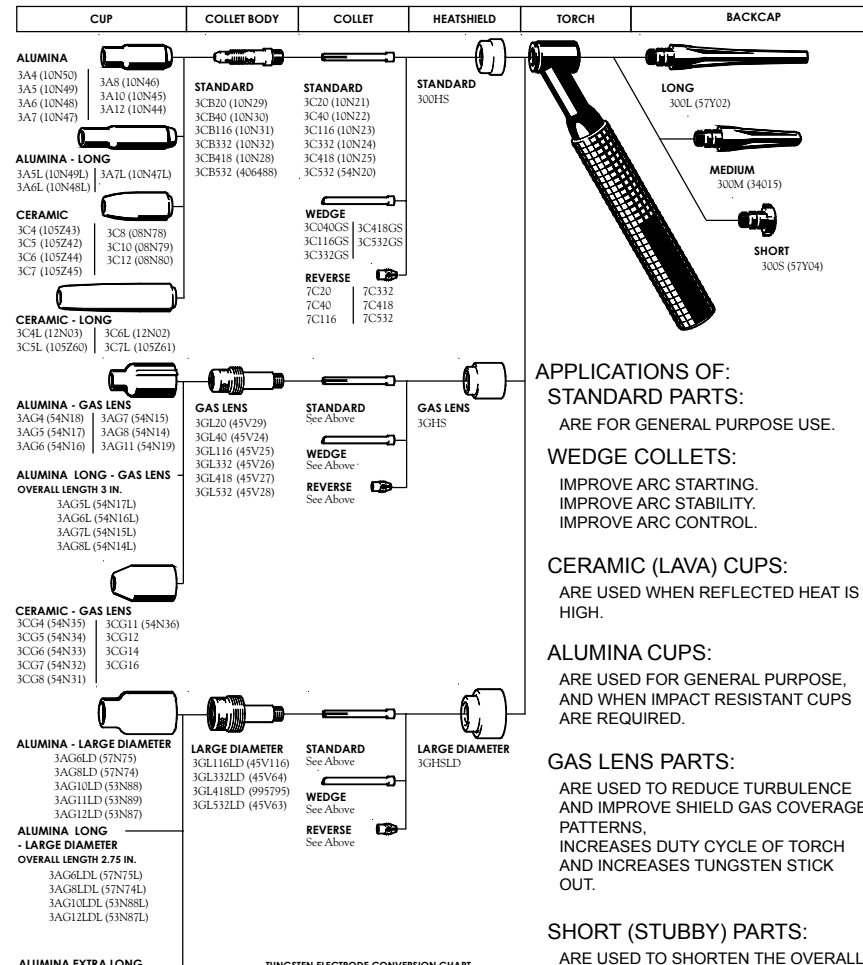
| PART NUMBER | DESCRIPTION |
|-------------|--|
| 4 5 V 6 2 | POWER CABLE ADAPTER ONE PIECE POWER CABLE ONLY |
| SL2 | TWECO POWER CABLE ADAPTER |
| SL2-25 | DINSE-25 POWER CABLE ADAPTER |
| SL2-35 | DINSE-35 POWER CABLE ADAPTER |
| SL2-35M | DINSE 35 FLOW-THRU GAS POWER CABLE ADAPTER |
| 2AN | ARGON NUT |
| 3HF | HOSE FITTING |
| 21PFH | POWER CABLE FITTING |
| 26PFH | POWER CABLE FITTING |
| 4PF | POWER CABLE FITTING |
| 5PF | POWER CABLE FITTING |
| 16F | CABLE FITTING |
| 26PN | POWER CABLE NUT |

3 SERIES HEAD ACCESSORIES GAS SAVER



2

3 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 |

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