Before using this product, read all instructions with understanding and keep it for future use.

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1. SAFETY PRECAUTIONS SYMBOLS

It is essential to read these signs and safety precautions to protect the health and life of their own and other people.

Read instructions before starting the machine. Use only original accessories supplied by the manufacturer.

Some components may explode. Always use face shields and protective clothing with long sleeves.

Static electricity can damage electronic components.

Use approved face shields and welding shields. Always use protective clothing designed for welders. Metal splinters can injure your eyes. Always use safety glasses.

Electrical shock can result in death. Do not touch electrical components when the device is connected to the power supply. Use dry and complete protective gloves and protective clothing.

Gases and vapors can be hazardous to health. During the process of extracting welding gases and welding fumes. Inhalation of these substances can be dangerous to your health.

Eye protection welding filters. Depending on the current intensity, use shields with appropriate filters.

Moving parts can cause injuries unit.
Too long continuous operation may cause overheating. Wait until the device cool down. Follow the guidelines in the "efficiency and thermal protection."

Damaged cylinders with technical gases can explode. The bottled gas is accumulated under high pressure. Make sure the bottles are handled and stored in accordance with the requirements of safety and fire.

Welded components could burn.

Wire protruding from the burner is sharp and can cause skin puncture.

Risk of fire and explosion. During welding work may lead to a fire. Welding station must be separated and protected from flammable materials and explosives.

The magnetic field can disrupt the functioning of pacemakers. Before starting work, consult your physician.

Do not weld at height without adequate protection.

Overturning or falling unit can cause serious injury.

* It is prohibited to the misuse

Welding may be carried out by qualified personnel with current training and authorization for the selected method of welding.
ATTENTION!

Heating test was carried out at ambient temperature and the duty cycle (ratio Load) at 40°C has been appointed by the simulations.

The device is designed to carry out welding work in professional conditions compatible with the applicable standards.

⚠️

WARNING: This Class A equipment is not intended for use in residential locations where electricity is supplied by system of public low-voltage network. There may be potential difficulties in ensuring electromagnetic compatibility in those locations, due to conducted and radiated disturbances.

The device should be used in accordance with the Regulation of the Minister of Economy of 27.04.2000r. on health and safety at work welding (Dz. U. No. 40 item. 470).

The behavior of this manual and following the guidelines set out in the instructions will enable proper maintenance of equipment in the future. These warnings are intended to ensure user safety and operation in an environmentally friendly manner. Before installation and use of the device, read carefully the contents of the entire instructions.

- After opening the package, make sure the device has not been damaged during transport. If in doubt, please contact our service department.
- Equipment should only use trained employee or consumer.
- During installation all activities related to electricity should be carried out only by a qualified electrician.
2. DESTINY

KRAMER equipment technician MIG / MMA 185 for manual arc welding in the GMAW (Gas Metal Arc Welding) - MIG / MAG and MMA (Metal Manual Arc Welding).

3. DESCRIPTION OF THE DEVICE

KRAMER technician MIG / MMA 185

Suitable for single-phase mains 230V, 50 / 60Hz. The device has, continuous adjustment of the welding current and is equipped with thermal overload protection system to prevent overheating.

KRAMER MIG 185 is equipped with functions option electrode welding MMA and additionally has the ability to self-shielded welding wire FCAW (Flux).

4. TECHNICAL DATA

Table 1. Technical data

<table>
<thead>
<tr>
<th>Parameter</th>
<th>KRAMER MIG / MMA 185</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage [V]</td>
<td>1 – 230</td>
</tr>
<tr>
<td>Current frequency [Hz]</td>
<td>50/60</td>
</tr>
<tr>
<td>Tolerance variations in the power [%]</td>
<td>± 10</td>
</tr>
<tr>
<td>Protection [A]</td>
<td>16 / 230V</td>
</tr>
<tr>
<td>Power consumption [KVA]</td>
<td>5.5</td>
</tr>
<tr>
<td>Rated output voltage [V]</td>
<td>16.5 - 23</td>
</tr>
<tr>
<td>Load voltage [V]</td>
<td>58</td>
</tr>
<tr>
<td>MIG Welding current range [A]</td>
<td>30 - 160</td>
</tr>
<tr>
<td>Welding current range MMA [A]</td>
<td>30 - 160</td>
</tr>
<tr>
<td>Output voltage regulation ego</td>
<td>smooth</td>
</tr>
<tr>
<td>Duty cycle MIG / MAG</td>
<td>60% 160A</td>
</tr>
<tr>
<td></td>
<td>100% 128A</td>
</tr>
<tr>
<td>Duty cycle MMA</td>
<td>60% 160A</td>
</tr>
<tr>
<td></td>
<td>100% 128A</td>
</tr>
<tr>
<td>The diameter of the welding wire [mm]</td>
<td>0.6 - 0.8</td>
</tr>
<tr>
<td>type of feeder</td>
<td>2R</td>
</tr>
<tr>
<td>insulation class</td>
<td>F</td>
</tr>
<tr>
<td>Level of security</td>
<td>IP21S</td>
</tr>
<tr>
<td>Mass [kg]</td>
<td>6.5</td>
</tr>
<tr>
<td>Dimensions [mm]</td>
<td>310x230x135</td>
</tr>
</tbody>
</table>
Unit nameplate:

The accessories supplied with the device:

1. Source of electricity
2. Torch MIG / MAG integrated device
3. Cable to the common terminal
4. Cable with electrode holder
5. gas pipe
6. Welding mask
7. Brush
8. Operating instructions in j. Polish

5. OPERATION

AND. BEFORE WORK:

- Before starting work, you must specify the place where the device is to be operated.

- Check voltage value, phase and frequency of the supply current before switching the machine to the mains.

- Parameters supply voltage are given in the section of the technical data and on the nameplate.

- Check the grounding wire connection device from the mains.
- Remove all flammable material from the welding area.
- Do not use the device on a surface, which may cause it to tip over
- Welding use suitable protective clothing: gloves, lab coat, shoes, helmet or mask having a corresponding certificate.
Front description

**KRAMER MIG / MAG 185**

Figure 1. Front panel

- Warning LED thermal protection
- Socket positive polarity (+)
- LCD display
- Adjusting dial wire feed speed
- Intensity control knob of welding current and voltage
- The integrated welding torch for MIG / MAG
- Mode switch MIG - MMA
- Socket negative polarity (-)
B. COIL ASSEMBLY WITH welding wire

Before mounting a spool of welding wire, please refer to the data contained in the table below:

<table>
<thead>
<tr>
<th>The diameter of the welding wire</th>
<th>The maximum size of a spool of wire welding</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.6 - 0.8 mm</td>
<td>≤D100 - 1kg</td>
</tr>
</tbody>
</table>

- Raise the housing cover side welding machine.
- Make sure that the rollers mounted in the drive unit correspond to the type and diameter of the wire used.
- Place the spool of welding wire spool mounting mechanism, paying attention to the direction of unwinding the wire was in line with the direction of the entrance to the wire drive unit Lock reels from slipping by tightening the nut on the body mounting a reel.
- End of the wire should be flat or cut off the bent section.
- In order to introduce the wire into the feeder release the pressure feed rollers.
- End of the wire inserted into the guide at the back of the tray and carry it over the driving roller introducing nozzle of the welding gun.
- Push the wire in the groove drive roll and tighten.
- Remove the gas burner nozzles, and unscrew the contact tip.
- Switch on the device.
- Open wire welding torch so that it is simple. ATTENTION! Do not direct the tip of the welding torch in the direction of the face or other people.
- If the gas is connected to - close the gas valve. Press the button in the handle MIG / MAG, which will result in the development of welding wire in the holder.
- When the end of the welding wire passes through a connector in the burner, a distance of approx. 5 cm and release the torch.
- Screw the tip and replace the current gas burner nozzles.
- Adjust the contact pressure roller by rotating the knob to the right - increase the biasing force to the left - decrease the pressing force. Too little downforce, will cause slippage of the drive roller. Too high pressure causes an increase in resistance of administration and the deformation of the wire.
c. INSTALLATION shielding gas bottle

- Connect with semiautomatic bottle with a suitable cable.
- Unscrew the regulator valve prior to welding.
- After completion of welding, the cylinder valve should always turn off.
Figure 3. Back of the device

- Switch ON / OFF
- Power cord
- Gas connection MIG / MAG
- Warning sign
- Nameplate
- Fan

INPUT 230V–50/60HZ
6. WELDING PROCESS MIG / MAG

Arc welding shielding gases (indicated by MIG / MAG) is one of the most widely used process for producing weldments. Abbreviation MAG (metal active gas) includes in its description of the active shielding gases. Abbreviation MIG (Metal Inert Gas), refers to inert gas shroud. Semi-automatic welding process involves melting the edge of the work piece and the material of the consumable electrode arc heat glowing between the electrode in the form of a solid wire and the welded workpiece, in inert gas or active.

Primary shielding gases for welding MIG inert gases such as argon, helium, and active gases in the MAG CO₂ H₂ ABOUT 2 N₂ and NO, for the addition to argon or helium.

The consumable electrode is in the form of the solid wire, typically having a diameter of 0.6 to 1.2 mm and is fed continuously by a special supply system, a speed of 2.5 m / min and above. The welding may be water-cooled or gas shielding. Welding is carried out mainly constant current of positive polarity as a semi-automatic welding, mechanized, automated or robotic using specialized equipment. Glowing shield arc between the consumable electrode and the weld material for forming the weld in a very favorable thermal and chemical conditions. Welding of this type can be used to make high quality of the connections of all the metals which may be joined by arc welding. These include: carbon and low-alloy steels and corrosion resistant.

Figure 4. MIG / MAG - scheme
Self-shielded Flux-Cored Welding Wire

This is a method using samoosłonowego core wire for welding (all positions) of normal steel and high strength exceeding 510 MPa. Samoosłonowy wire can be used in welding processes single and multi-layer by using current sources of both flat and falling characteristics. The wire is designed for general production work, also in the field, and for construction welding, where there are no requirements regarding impact. Welding current: DC (-).

7. CURRENT OPERATING UNIT

AND WORKING CONDITIONS

Optimum ambient temperature range from -10 °C to 40 °C.

Avoid welding in conditions of sunlight and the rain, do not allow the water to penetrate into the interior of the device.

Avoid working in the environment of flammable gas, dust and aggressive. Avoid strong winds, which can cause loss of protection gas.

B. WORK SAFETY

Actually the installed device with overvoltage protection, overcurrent protection and overtemperature switches off automatically under the conditions beyond the defined as the standard. However, long-term use (eg. Surges) can cause damage to the welder. Therefore, you should follow the instructions listed below:

C. PRECAUTIONS:

- They provide good ventilation

Welding is a device through which a large current is flowing, and the natural ventilation does not provide the necessary cooling. Therefore, to maintain stability, welder equipped with an internal cooling system. The operator should check if the vent is not blocked. The distance between the welder and the welded object should not be less than 0.3m. The operator should always pay attention to ventilation devices, since they depend on it not only achieved welding quality and performance, but also the life of the device.

- Avoiding overload

The operators should follow (load designated as the maximum permissible load for a given current) or the welding current exceeds the maximum permissible electric current to the load. Electrical overload can significantly shorten the life of welders, and even lead to the burning of its elements.
• Preventing surges

Keep values in the line supply voltage in the Table "Technical specifications". In normal operation, the automatic alignment circuit voltage ensures the maintenance of tension in the acceptable range. The supply voltage higher than the permissible value can damage the welding machine. Operators should be fully aware of this risk and be able to take appropriate steps.

If a standard load is exceeded, the welder can enter a protective mode and suddenly stop working. This means that the standard load is exceeded, the heat has launched a thermal switch, which caused the machine to stop. Lamp lights up on the operating panel welding machine. In such a situation, do not remove the power plug to allow the fan to cool the welding machine. Exclusion of the lamp indicates the temperature drop to a normal level. You can take further work.

ATTENTION!

When welding components which form an integral part of the vehicle it is essential to disconnect the battery or use special protection. Otherwise, the electronic parts of the vehicle can be permanently damaged. When welding to connect the handle mass close as possible to the weld site.

D. MAINTENANCE

Regularly remove dust with clean compressed air. If the unit is in working conditions in the smoke, in the heavily polluted air every day remove accumulated dust.

Air pressure should be maintained at a level not to damage the small components inside the machine max. 2-4 bar.

Inspect the internal welder circuits, check the accuracy and reliability of connections (in particular equipment and parts). In the case of notice of rust and loosening of the connection remove rust and oxide coating with abrasive paper, and re-connect securely. Avoid situations where water or steam could get into the device. In the case of welding moisture should dry it, and then check the insulation of the device (also between calls and contacts). After checking that everything is in order, you can continue working.
8. TROUBLESHOOTING

Table 2. Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Possible cause</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>The device does not turn on</td>
<td>The device is not connected to the mains, device does not receive input voltage, faulty switch</td>
<td>• Check whether the device is connected to the mains&lt;br&gt;• Check the voltage in the socket with the help of a specialized meter&lt;br&gt;• Check the condition of the fuses</td>
</tr>
<tr>
<td>Uneven wire feeding or wire will not move</td>
<td>The problem with the work feed roller, damage to the cartridge guide wire or contact tip</td>
<td>• Check the pressing force feed roller&lt;br&gt;• Check whether the feed roll groove is not damaged - if so, replace the roll with a new one&lt;br&gt;• Check that the contribution of the wire is not broken / blocked&lt;br&gt;• Check that the end of the current contribution and the guide wire is selected according to the diameter and type of welding wire</td>
</tr>
<tr>
<td>The device has stopped welding, lit the lamp thermal protection</td>
<td>Attached himself system protective device</td>
<td>• Check for excessive voltage drops in the socket, check if the machine is not overheated, if so - wait until the welder has cooled</td>
</tr>
<tr>
<td>Weld quality is unsatisfactory</td>
<td>The problem with the proper conduct of the welding process</td>
<td>• Check that the wire feed speed is adjusted accordingly (non-uniform wire feeding)&lt;br&gt;• Check the shielding gas, check the gas flow is adequate&lt;br&gt;• Check the settings on the type of wire welding (Material, diameter)&lt;br&gt;• Make sure, that the material is properly cleaned&lt;br&gt;• Check that the ground terminal is properly attached to the workpiece</td>
</tr>
</tbody>
</table>

* If the fault is not eliminated after the application of the in / in tips, contact an authorized service center. Contact information and operating instructions are on the warranty card [p. 21]
9. ELECTRICAL DIAGRAM

Figure 5. electrical scheme

10. ECOLOGY

Do not dispose of electrical equipment together with normal waste!

According to a DIRECTIVE OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL 2012/19 / EU of 4 July 2012, on waste electrical and electronic equipment (WEEE) and its implementation in accordance with national regulations, subject to the Waste Electrical and separate collection should hit the recycling facilities, providing processing in an environmentally friendly manner. As the owner of the equipment should obtain information on approved collection systems from our local representative. By following these guidelines protect environment and human health.

Accordingly, the company PROFESSIONAL FHW Zenon Świętek adapted to the requirements / regulations in and registered in the register of the Chief Inspector of Environmental Protection under the number: E0007441WZ and signed a contract with CCR REEEE Recovery Organization Electrical and Electronic Equipment SA with its seat in Warsaw, ul. Transfer 4/49 (now RELECTRA CCR). Company entrusted with the duties incumbent on FACHOWIEC FHW Zenon Świętek to the collection of waste equipment electrical and electronic equipment.

Waste equipment can also be delivered directly to the company PROFESSIONAL.
Clause:

Despite making every effort to ensure that the information contained in this manual was complete and in accordance with the actual situation, the company PROFESSIONAL FHW Zenon Świętek shall not be liable for any errors or omissions. We reserve the right to change the specifications of the products described at any time without prior notice.

ATTENTION!

The content of this manual has been prepared by a team of engineers skilled in the art. Copying and distribution of the manual, in whole or in part, without the written consent of The skilled person is prohibited.

MADE FOR:
FHW FACHOWIEC Zenon Świętek Street.
Stefanski 29, 61-415 Poznan

www.fachowiec.com
Made In China
11. DECLARATION OF CONFORMITY

DECLARATION OF CONFORMITY

KRAM-16 / FC / 01

The last 2 digits of the year in which the CE mark is applied: 16

<table>
<thead>
<tr>
<th>Name and address</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>PROFESSIONAL FHW Zenon Świętek Street.</td>
<td></td>
</tr>
<tr>
<td>Stefanksi 29, 61-415 Poznan</td>
<td></td>
</tr>
</tbody>
</table>

declares that the product:

<table>
<thead>
<tr>
<th>Name</th>
<th>Device MIG / MAG + MMA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Type / model:</td>
<td>KRAMER 185 TECHNIQUES</td>
</tr>
</tbody>
</table>

conforms with the following standards and standards harmonized


and meets the essential requirements of the following directives:

1. 2014/35 / EC Low Voltage Directive (LVD)
2. 2014/30 / EC Electromagnetic compatibility (EMC)

This declaration of conformity is the basis for marking the product trademark

This declaration relates exclusively to the machine in the state in which it was introduced to the market, and excludes components which are added by the end user or carried out by his subsequent actions.

A person authorized to prepare and store technical documentation Zenon Świętek.

Zenon Świętek

Poznan, 11/04/2016

Place and date of issue:

www.fachowiec.com
WARRANTY CARD

(Issued for sale after December 25, 2014)

IMPORTANT!

We offer you a professional product designed for use only by trained personnel and appropriate qualifications.

Each device, product distribution machine before it passes the initial quality control in our company. Before operating the device, please carefully read the attached instructions for proper start-up and read the requirements for the equipment!

WARNING - FAILURE!

Before sending equipment use our SERVICE CENTER
http://pomoc.fachowiec.com That allows technical support, contact our service to you and automated assistance in the receipt of the consignment !!!

<table>
<thead>
<tr>
<th>NAME OF EQUIPMENT</th>
<th>WELDING EQUIPMENT</th>
</tr>
</thead>
<tbody>
<tr>
<td>TYPE / MODEL</td>
<td>MIG 185 KRAMER</td>
</tr>
<tr>
<td>Serial number / HOLOGRAM</td>
<td></td>
</tr>
<tr>
<td>SALE DATE</td>
<td></td>
</tr>
<tr>
<td>NOTES / STAMP AND SIGNATURE</td>
<td></td>
</tr>
</tbody>
</table>

1. The guarantee of the quality of the machine as manufacturer, importer and distributor is:
Guarantor declares that covered by this guarantee card subject of the guarantee has been issued free of defects and is made in accordance with applicable standards.

2. Warranty covers the territory of the Polish Republic. Our products purchased abroad must be delivered to the site in Poland.

3. The company has skilled person is liable for physical defects in materials and workmanship inherent in the device for a period of: 12 months

4. In the case of purchase by individuals for use not related to operations apply the current provisions of the Act: Official
5. The warranty on goods sold does not exclude, limit or suspend the buyer's rights resulting from the provisions of the warranty for defects in the goods sold.

6. disclosed defects during the warranty period will be removed in no more than 14 days from the date of delivery of the faulty device to the Service Importer.

7. The advertised within the warranty of the machine should be delivered to the Seller with a full standard equipment, clean and - if the device has - with a clear plate.

8. advertised device must be returned in the box properly packed protected against damage in transit needs to be determined if required "up - down" or "caution glass"

9. The company skilled in the art does not accept complaints and returns sent to the address of the Company for downloading!

10. The guarantee document is valid if you have correctly completed entries regarding: the date of sale, the name of the device sold, stamp and signature of the seller and the customer acknowledges his signature.

11. The warranty does not cover the activities foreseen in the manual, the execution of which the user is obliged to own and at their own expense, for example. Start-up, maintenance, replacement batteries, and other supplies.

12. Said faulty equipment and parts become the property of the Guarantor.

**REFUSAL OF COMPLAINTS:**

The guarantor may refuse to accept the complaint if:

- statement using the unit misused and instruction operation,
- delivery device dirty, no standard equipment, without the nameplate and seal or hologram
- determine the cause of the fault other than manufacturing or material defect inherent in the device,
- formal defects associated with the sales documents, Warranty, lack of proof of purchase.

**ARE NOT COVERED BY WARRANTY:**

1. The parts which, when aligned with the recommendations of operation are subject to wear and tear within the warranty period, such as welding torches, the mass handles, nozzles, burners, batteries, belts, filters, oil, electrodes, gaskets, o-rings, and other elements related to directly to the operation.

2. Disadvantages caused by mechanical damage, thermal or chemical plant and equipment.

3. Damage due to improper transport and storage,

4. Damage related to work at too low or too high a temperature,

5. Damage caused by faulty electrical installation, liquid or moisture electrical components water,

6. Wrong connection to a power source (eg. Poor polarity, poor connection 230 or 400 V, there are no phases or too loosely clamped connection cables)
7. Damage caused by overloading equipment overheating,
8. Incorrect setting of the welding parameters, the interference in the control panel screw compressors. 
9. The problem with selecting the parameters of supply pressure for operating the device, 
10. Damage due to lack of recommended maintenance procedures contained in this manual,

11. Cleaning with high pressure or too aggressive chemicals
12. Damage caused by too strong a tightening or causing damage to the components niedokręcaniem connections or over capacity (spray guns).
13. Improper use.

LOSS OF WARRANTY AS FOLLOWS

Loss of warranty in the event;
1. non-compliance with the operating instructions
2. misuse,
3. overloading the machinery
4. operation without lubricants
5. dismantling unauthorized
6. breaking holograms

WEBSITE ADDRESS
One skilled FHW Zenon Świętek 60-169 Poznań ul Grunwaldzka 390 phone: + 48/81 66-18-152
e-mail: serwis@fachowiec.com

important:
In the case of unjustified complaint the applicant must bear the costs of transport and a review in accordance with the service price list.

REPAIR WARRANTY:

<table>
<thead>
<tr>
<th>Date of adoption</th>
<th>release date</th>
<th>The scope of repairs</th>
<th>Stamp and signature service</th>
</tr>
</thead>
<tbody>
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<td>Date of adoption</td>
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<td>Stamp and signature service</td>
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