



ITEM# 363

QUICK START GUIDE

Forney®

1.



Read User Manual



2.

Set Polarity



Solid Wire DCEP
Ground -
Jumper +



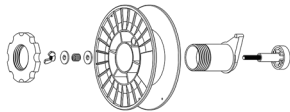
Flux-Core Wire DCEN
Ground +
Jumper -

3.

Install Wire Spool

0.024" (0.6mm) - 0.035" (0.9mm) diameter.

8" (200mm)
wire spool



4" (100mm)
wire spool

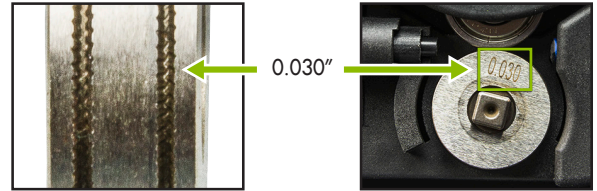


See manual for detailed installation instructions.

4.

Set Drive Roll

Ensure the correct wire diameter is visible on the drive roll when installed. Choose between 0.030" - 0.035" with included drive roll.



For additional wire diameters, additional drive rolls are needed.

5.

Set Drive Roll Pressure

For proper tension align the tops of the screw and nut together.



6.

Attach Gas, if Necessary

Solid wire MIG requires shielding gas, set the gas flow to approximately 20 - 35 CFH.



7.

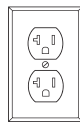
Ground Workpiece

Connect ground clamp to clean, bare metal.



8.

Connect to 120V Input Power



- Generator Safe: Use power source with 4000W of continuous output, no low-idle, 5% THD max.
- Extension Cord: #12 AWG or larger, 25' (8m) or shorter.

9.

Select Process

(For TruSet™, see back.)



10.

Adjust Settings

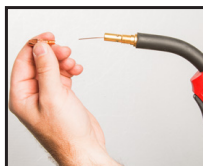
Adjust the wire feed speed (WFS) and voltage (Volts). See the chart on the welder for correct settings.



11.

Feed Wire

Remove consumables and depress trigger until wire comes out. Replace consumables.



12.

Begin Welding

With contact tip 1/4" from metal, depress trigger completely to initiate arc.



QUESTIONS OR TROUBLE?

Contact Forney Industries at 1-800-521-6038 customerservice@forneyind.com forneyind.com



ITEM# 363

QUICK START GUIDE



TruSet™ MIG

1. Select, TruSet™.
2. Follow steps 1-9 of the Manual MIG setup.
3. Push the button under GAS MIX to cycle through the available wire type and shielding gas options, choose the appropriate combination.
4. Push the button under WIRE DIAMETER to cycle through the available wire diameter options, choose the appropriate diameter.
5. Adjust the RIGHT KNOB to cycle through the available workpiece thickness, choose the appropriate thickness.
6. The machine will set optimal voltage and WFS. Continue with step 11 of the Manual MIG setup.
7. The automatic settings can be trimmed up or down with the left knob if you want to refine the weld settings.



Expert-Tech Tips:

- Best performance is at a trim setting between -5 and +5.
- Step up to the next material thickness to get more penetration.



MIG TROUBLESHOOTING TIPS

Do Not Weld Aluminum



- This machine cannot connect to a spool gun, which is recommended for aluminum.

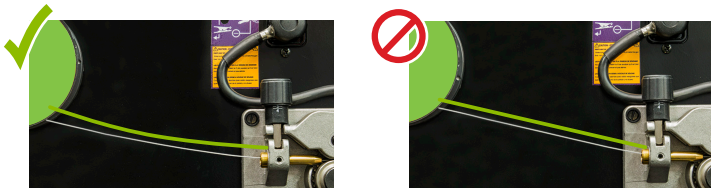
Workpiece Grounding



Connect the ground clamp to clean, bare metal. No rust, paint or other coatings. Attach the ground clamp directly to the workpiece if you are experiencing issues.

Too Much Spool Tension

Wire from spool to drive should relax with a slight curve after feeding.



Incorrect Drive Roll Pressure

Too little pressure = Roll can slip and feed can be erratic

Too much pressure = can crush wire, causing wire feeding problems and welder damage



Frequently Tripping Circuit Breaker or Exceeding Duty Cycle



Trying to weld single pass on material larger than 1/4" (6mm) thick is not possible with this machine. Multi-pass recommended for thicker materials.



Welder should be the only thing plugged into the circuit.

Low Weld Output or Poor Fusion

- Usually due to low input power.
- Welder should be only thing plugged into circuit.
- Avoid using extension cords. If one must be used, it must be #12 AWG or larger; 25' (8m) or shorter.
- Generators must be 4000W continuous output and not have a low-idle function (or have it disabled).

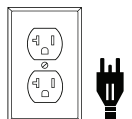


Duty cycle exceeded or insufficient air flow. Allow machine to cool.



The gun was triggered when the machine was powered on. Release the trigger.

Incorrect input power. Verify power source is 120V +/- 10%.



FIND MORE INFORMATION AT FORNEYIND.COM

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