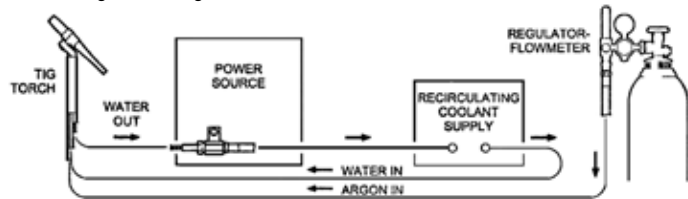


CK WORLDWIDE INC.

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:

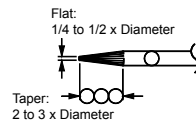


INFORMATION CHART:

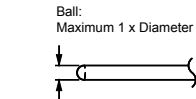
Electrode Diameter in inches (mm)	Cup Size	WELDING CURRENT (AMPS) - TUNGSTEN TYPE				ARGON FLOW - FERROUS METALS		ARGON FLOW - ALUMINUM	
		AC Pure	AC Thoriated	DCSP Pure	DCSP Thoriated	Standard Body (Liters)	Gas Lens Body (Liters)	Standard Body (Liters)	Gas Lens Body (Liters)
.020 (0.50)	4 or 5	5 - 15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

END PREPARATION: DCSP (EN)
General Purpose:

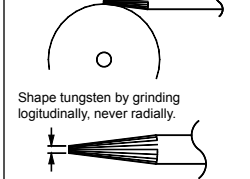


ACHF
General Purpose:

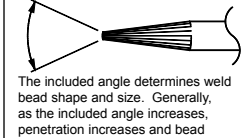


Ball tip by arcing on clean metal at low current DCRP (EP) then slowly increase current to form the desired ball diameter.

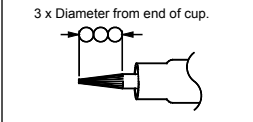
GRINDING PREPARATION:
Use a 60 Grit or finer aluminum oxide wheel



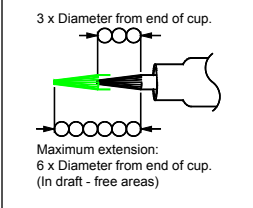
Remove sharp point to leave a truncated point with a flat spot. Diameter of flat spot determines amperage.



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



CK180 & CK180V RIGID

TECHNICAL INFORMATION

RATING @ 100% DUTY CYCLE: 180 AMP ACHF OR DCSP
COOLING METHOD: WATER COOLED

ACCESSORY ITEMS REQUIRED FOR COMPLETE INSTALLATION:

HEAD ACCESSORIES: 8 SERIES HEAD ACCESSORIES
POWER CABLE ADAPTOR: 2PCA (45V11)

MODEL SELECTOR - TORCH PACKAGES

HEAD STYLE	CABLE	LENGTH	STANDARD #	SUPERFLEX #
Rigid Head w/o Valve	TRI-FLEX	12½ft (3.8m)	CK1812	CK1812SF
		25ft (7.6m)	CK1825	CK1825SF
Rigid Head with Valve	TRI-FLEX	12½ft (3.8m)	CK1812V	CK1812VSF
		25ft (7.6m)	CK1825V	CK1825VSF

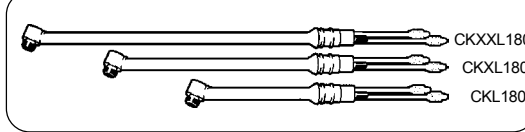
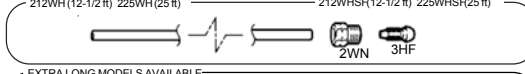
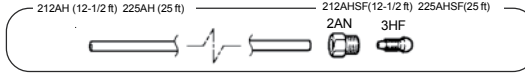
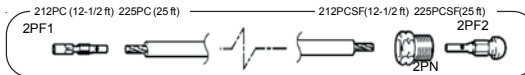
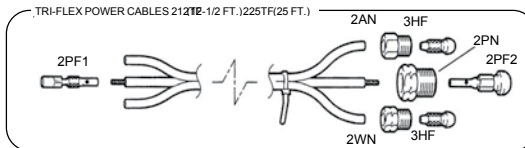
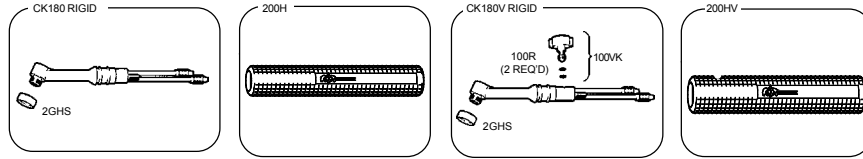
IMPORTANT !!
READ AND UNDERSTAND THE INFORMATION CONTAINED IN THIS MANUAL BEFORE OPERATING THE EQUIPMENT !

CK WORLDWIDE INC.
3501 "C" ST. N.E.
AUBURN, WA. 98002
USA

PHONE: (253) 854-5820
PHONE: (800) 426-0877
FAX: (253) 939-1746

www.ckworldwide.com
ck@ckworldwide.com

PARTS:



PART #	DESCRIPTION	PART #	DESCRIPTION
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TORCH
 CK180 RIGID..... TORCH BODY
 CK180V RIGID..... TORCH BODY VALVED
 200H..... HANDLE
 200HV..... HANDLE FOR VALVED

TRI-FLEX POWER CABLE
 212TF..... TRI-FLEX POWER CABLE & HOSE ASSEMBLY-12-1/2 FOOT (INCLUDES FITTINGS)
 225TF..... TRI-FLEX POWER CABLE & HOSE ASSEMBLY -25 FOOT (INCLUDES FITTINGS)
 01-0032..... CABLE TIE
 2AN..... GAS HOSE NUT
 2PF1..... POWER CABLE FITTING
 2PF2..... POWER CABLE FITTING
 2PN..... POWER CABLE NUT
 2WN..... WATER HOSE NUT
 3HF..... HOSE FITTING (2 REQUIRED)

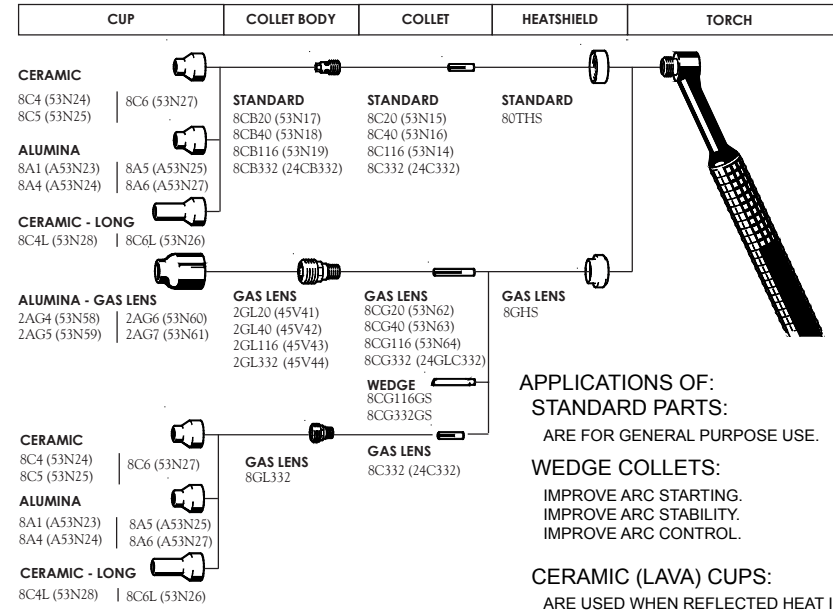
EXTRA LONG TORCH HEADS
 CKXXL180..... 10-1/2" LONG MODEL
 CKXL180..... 7-1/2" LONG MODEL
 CKL180..... 4-1/2" LONG MODEL

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

INDIVIDUAL CABLE, HOSES
 212AH (45V09)..... GAS HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 212AHSF (45V09SF)..... GAS HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 212PC (45V03)..... POWER CABLE-12-1/2 FOOT (INCLUDES FITTINGS)
 212PCSF (45V03SF)..... POWER CABLE-12-1/2 FOOT (INCLUDES FITTINGS)
 212WH (45V07)..... WATER HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 212WHSF (45V07SF)..... WATER HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 225AH (45V10)..... GAS HOSE-25 FOOT (INCLUDES FITTINGS)
 225AHSF (45V10SF)..... GAS HOSE-25 FOOT (INCLUDES FITTINGS)
 225PC (45V04)..... POWER CABLE-25 FOOT (INCLUDES FITTINGS)
 225PCSF (45V04SF)..... POWER CABLE-25 FOOT (INCLUDES FITTINGS)
 225WH (45V08)..... WATER HOSE-25 FOOT (INCLUDES FITTINGS)
 225WHSF (45V08SF)..... WATER HOSE-25 FOOT (INCLUDES FITTINGS)

ACCESSORIES
 2PCA (45V11)..... POWER CABLE ADAPTER (ORDER SEPARATELY) SAFE LOCK 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
 200R..... O-RING
 200M..... BACKCAP
 2GHS..... HEATSHIELD

8 SERIES HEAD ACCESSORIES



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

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