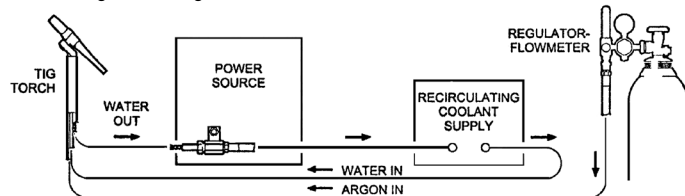


CK WORLDWIDE INC.

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:

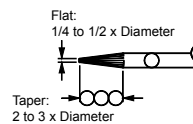


INFORMATION CHART:

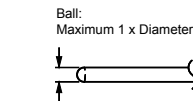
Electrode Diameter in inches (mm)	Cup Size	WELDING CURRENT (AMPS) - TUNGSTEN TYPE				ARGON FLOW - FERROUS METALS		ARGON FLOW - ALUMINUM	
		AC Pure	AC Thoriated	DCSP Pure	DCSP Thoriated	Standard Body (Liters)	Gas Lens Body (Liters)	Standard Body (Liters)	Gas Lens Body (Liters)
.020 (0.50)	4 or 5	5 - 15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

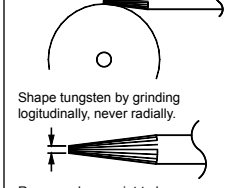


ACHF
General Purpose:

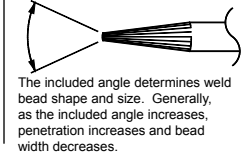


Ball tip by arcing on clean metal at low current DCRP (EP) then slowly increase current to form the desired ball diameter.

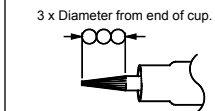
GRINDING PREPARATION:
Use a 60 Grit or finer aluminum oxide wheel



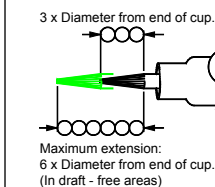
Remove sharp point to leave a truncated point with a flat spot. Diameter of flat spot determines amperage.



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.



CK230F

TIG TORCH MANUAL



CK230 & CK230V FLEX

TECHNICAL INFORMATION

RATING @ 100% DUTY CYCLE: 300 AMP ACHF OR DCSP
COOLING METHOD: WATER COOLED

ACCESSORY ITEMS REQUIRED FOR COMPLETE INSTALLATION:

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

MODEL SELECTOR - TORCH PACKAGES

HEAD STYLE	CABLE STYLE	CABLE LENGTH	STANDARD CABLE	SUPERFLEX CABLE
FLEX HEAD W/O VALVE	3 Piece	12-1/2 ft. (3.8 m)	CK2312 FX	CK2312SF FX
		25 ft. (7.6 m)	CK2325 FX	CK2325SF FX
FLEX HEAD W/ VALVE	3 Piece	12-1/2 ft. (3.8 m)	CK2312V FX	CK2312VSF FX
		25 ft. (7.6 m)	CK2325V FX	CK2325VSF FX

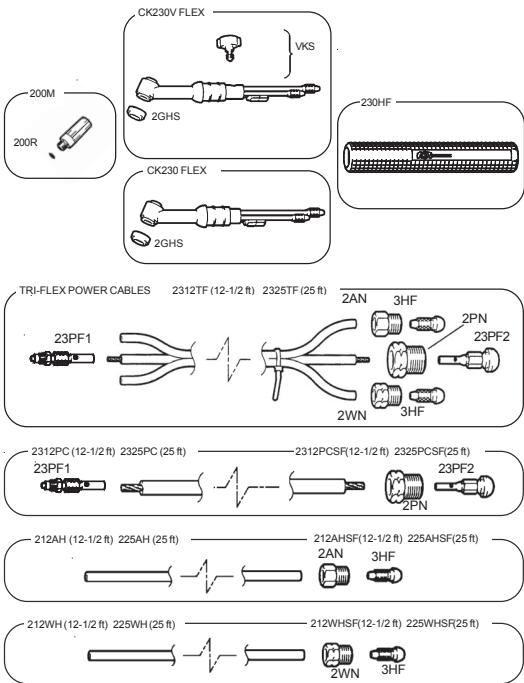
IMPORTANT !!
READ AND UNDERSTAND THE INFORMATION CONTAINED IN THIS MANUAL BEFORE OPERATING THE EQUIPMENT !

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
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TORCH
 CK230 FX..... TORCH BODY
 CK230V FX..... TORCH BODY VALVED
 230HF..... HANDLE

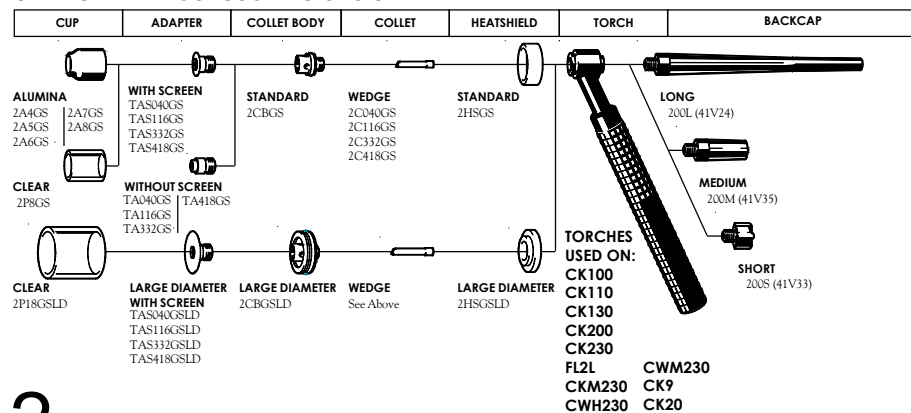
TRI-FLEX POWER CABLE
 2312TF..... TRI-FLEX POWER CABLE & HOSE ASSEMBLY -12-1/2 FOOT (INCLUDES FITTINGS)
 2325TF..... TRI-FLEX POWER CABLE & HOSE ASSEMBLY -25 FOOT (INCLUDES FITTINGS)
 01-0032..... CABLE TIE
 2AN..... GAS HOSE NUT
 23PF1..... POWER CABLE FITTING
 23PF2..... POWER CABLE FITTING
 2PN..... POWER CABLE NUT
 2WN..... WATER HOSE NUT
 3HF..... HOSE FITTING (2 REQUIRED)

INDIVIDUAL CABLE HOSES
 212AH..... GAS HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 212AHSF..... GAS HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 2312PC..... POWER CABLE-12-1/2 FOOT (INCLUDES FITTINGS)
 2312PCSF..... POWER CABLE-12-1/2 FOOT (INCLUDES FITTINGS)
 212WH..... WATER HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 212WHSF..... WATER HOSE-12-1/2 FOOT (INCLUDES FITTINGS)
 2312TF..... TRI-FLEX WATER, GAS, AND POWER-12-1/2 FOOT
 2312SF..... SUPERFLEX WATER, GAS, AND POWER-12-1/2 FOOT
 225AH..... GAS HOSE-25 FOOT (INCLUDES FITTINGS)
 225AHSF..... GAS HOSE-25 FOOT (INCLUDES FITTINGS)
 2325PC..... POWER CABLE-25 FOOT (INCLUDES FITTINGS)
 2325PCSF..... POWER CABLE-25 FOOT (INCLUDES FITTINGS)
 225WH..... WATER HOSE-25 FOOT (INCLUDES FITTINGS)
 225WHSF..... WATER HOSE-25 FOOT (INCLUDES FITTINGS)
 2325TF..... TRI-FLEX WATER, GAS, AND POWER-25 FOOT
 2325SF..... SUPERFLEX WATER, GAS, AND POWER-25 FOOT

ACCESSORIES
 2PCA (45V11)..... POWER CABLE ADAPTER (ORDER SEPARATELY)
 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

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

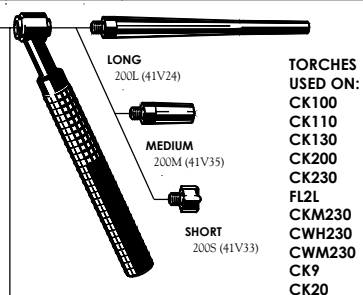
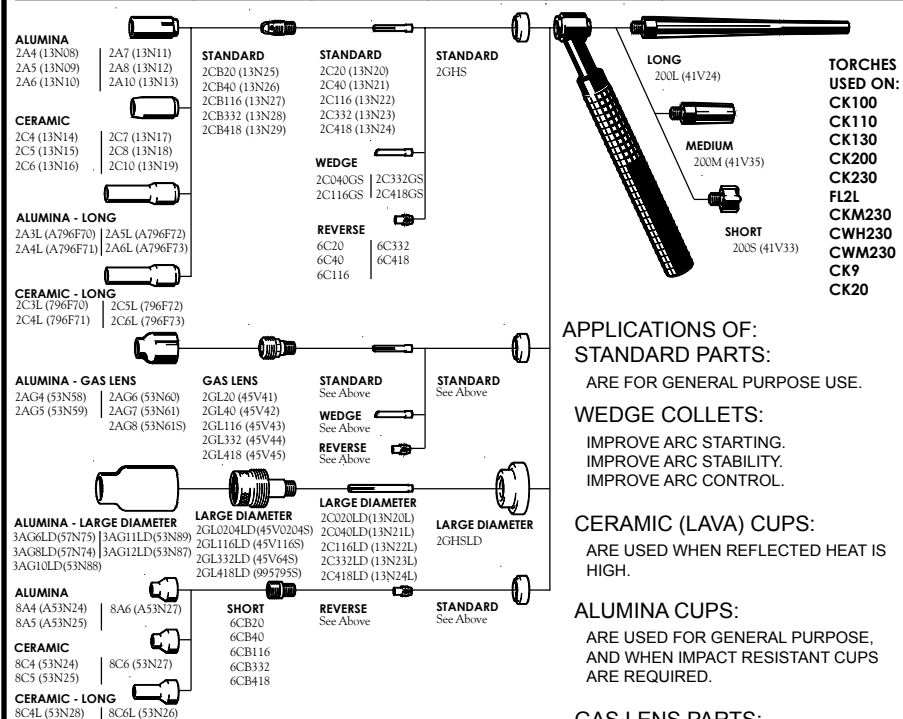
2 SERIES HEAD ACCESSORIES GAS SAVER



2

2 SERIES HEAD ACCESSORIES

CUP	COLLET BODY	COLLET	HEATSHIELD	TORCH	BACKCAP
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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

3