

**Duragrip Auto-Voltage Spool-On Mig Series  
OWNER'S HANDBOOK**

## Duragrip Auto-Voltage Spool-On Mig Torch

### Contents of this box

- Auto-Voltage Spool-On Mig / Mag welding torch
- Operation instruction
- Drive Roll

Duragrip Auto-Voltage Spool-On 15 series: 0.8mm U groove for aluminum wire.

Duragrip Auto-Voltage Spool-On 24/25/36 series: 1.0mm U groove for aluminum wire.

Product supplied by



## Basic product data and conformity information



### Basic product data to IEC/EN60974-7

**Process:** This is an Auto-Voltage Spool-On Mig/Mag welding torch

**Guidance:** This is a manually guided motorized wire feed torch

**Voltage rating:** 100V peak value

**Rating:** Please refer to the specification sheet for your model.

**Gas:** Argon, CO<sub>2</sub> and mixed gas

**Torch length:** 6 or 8m. Up to 16m upon request

**Wear parts:** Have been supplied in accordance with your order and the torch part number.

**Type of cooling:** Gas (Air-Cooled)

**Maximum spool size:** 4" (102mm) diameter

**Rating of electrical controls incorporated in the torch:**

The switch is rated at 1A 250V AC

**Requirements for connection of the torch:** Easy to connect (no need for qualified personnel to connect the torch to a machine).

### Conformity information

A sample of this product has been tested and found to be in conform with the following standards

- IEC/ EN 60974-7 Arc welding equipment Part 7 Torches
- Low voltage amendment to LVD 2014/35/EU
- Supporting documentation in accordance with EN ISO/IEC 17050-2:2004
- RoHS2 compliance to 2011/65/EU, amend 2015/863/EU
- REACH compliance to 1907/2006/EC
- Manufacturing systems to ISO 9001: 2015



## Auto-Voltage Spool-On Mig Torch Overview

Thank you for purchasing a Parker Auto-Voltage Spool-On welding torch. The torch has been made under the most stringent manufacturing conditions and the following will explain how it works together with some easy set-up instructions to get you going.

The Parker Auto-Voltage Spool-On torch is designed to act as a motorized on-torch feed system for long distances and precise control of soft wires. The torch is equipped with conventional industry standard machine connections.

The torch incorporates a self-contained spool of welding wire. This arrangement dispenses with the need to connect the torch to a separate wire feeder.

Wire is pulled off this spool of welding wire by the motorized drive and pressure roll.

A tension knob provides sideways load on the drive roll so that the torch motor exerts sufficient power to pull the wire off the spool and feed it to the contact tip.

The tension knob is factory set and does not need adjustment.

The spool cover is made from a clear engineering polymer to enable the user to easily see how much wire remains on the spool.

Adjustment and control of the wire speed is made directly from the potentiometer located on the left hand side of the main torch body.

Parker Auto-Voltage Spool-On torches are supplied with a 24V motor together with a potentiometer to suit all machines.

No separate control box is required allowing for easy set-up. These torches work on all MIG/MAG machines or CV power sources without the need for complicated wiring set-ups.



### Important Safety Instructions

#### **Read all instructions before using this product.**

Parker Auto-Voltage Spool-On torches are safe products to use, but like all modern tools, they can be dangerous in untrained hands. Therefore, we have assumed that you know how to use these products and know the dangers of misuse. These Spool-On torches have the ability to inflict serious injuries if used by untrained personnel.

You must never point these products at anyone and operate the trigger.

We strongly recommend that you are completely conversant with Spool-On welding techniques before you use this product. If you do not know, or are unsure, then you must contact your dealer or a trained person for advice.

#### **Pacemaker users.**

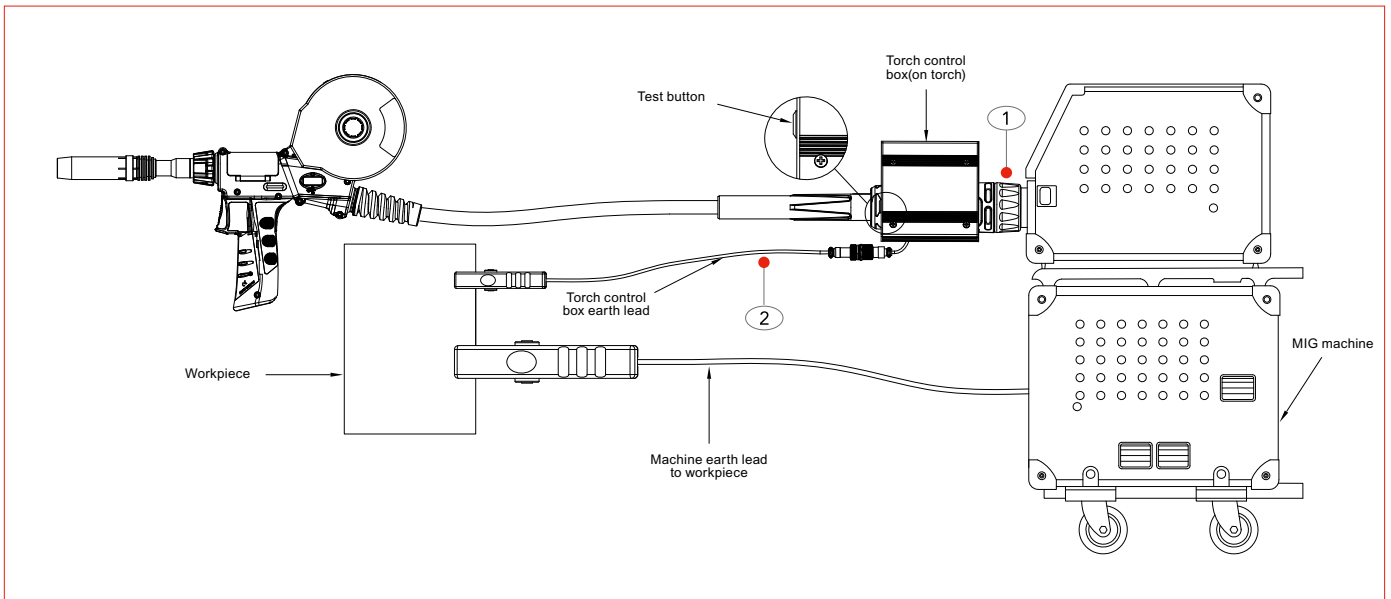
All welding operations give off some form of magnetic and electrical interference; if you have a Pacemaker or some other medical device controlled by an electric current; we recommend you consult your doctor before using any welding or cutting equipment.

Note:

- The welding wire will have been purchased on a spool ready to use.
- Before starting work make sure that the end of the welding wire has been dressed with burrs and sharp edges removed to prevent internal scoring of the torch components.

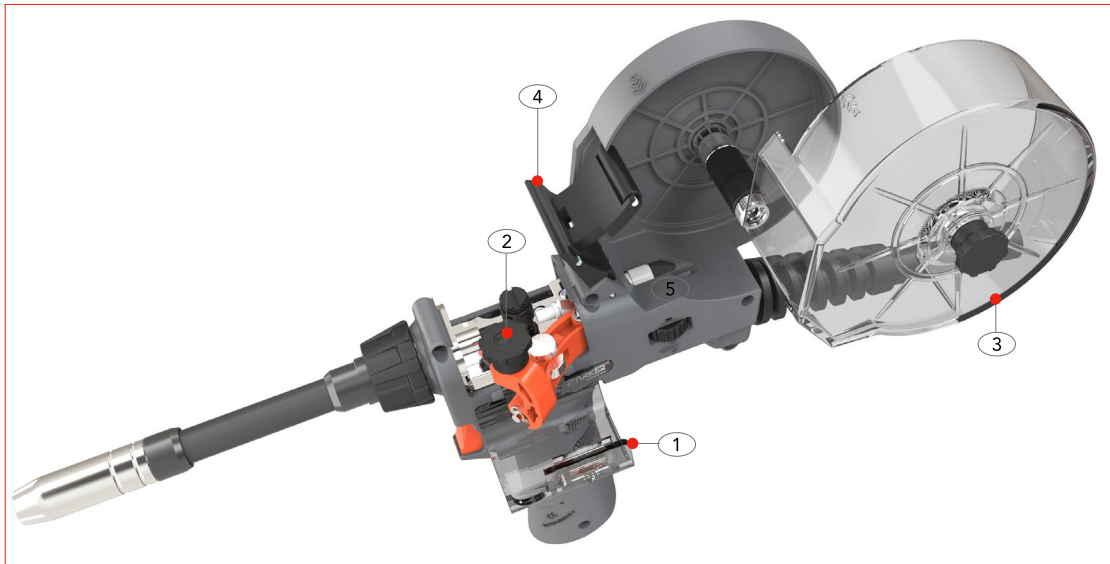
**WIRING METHOD**

- Connect the torch to MIG machine Euro connector: ①
- Connect the torch earth lead to the workpiece or machine earth lead: ②



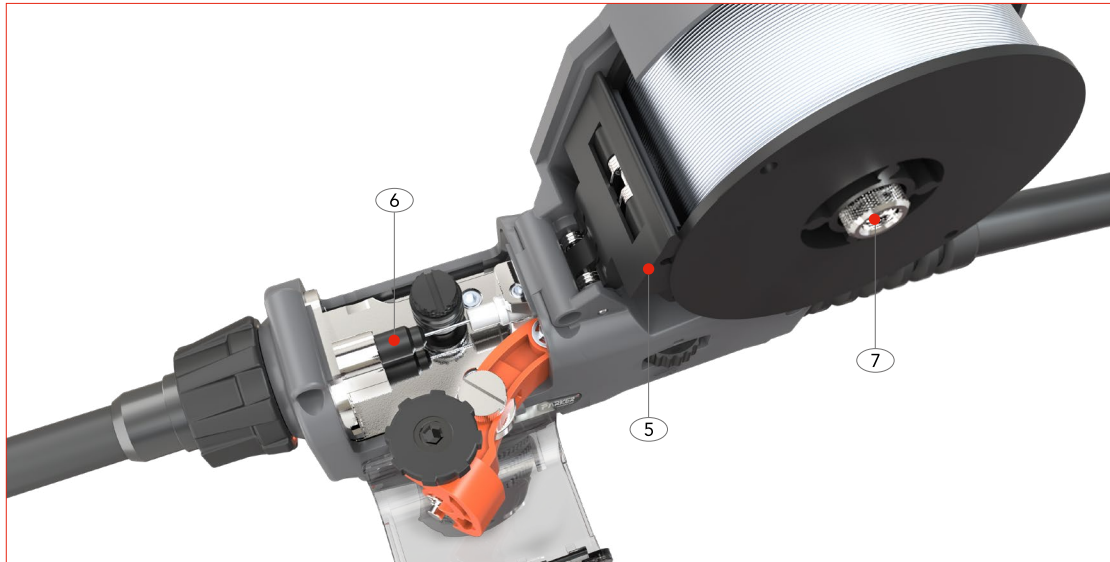
**Opening the system**

- Open the Handle cover ①
- Unscrew the tension knob and open the pressure arm assembly ②
- Remove the Clear spool cover ③
- Open the wire brake mechanism ④



## Fitting a wire spool

- Hand feed the wire from the spool into the nylon wire guide and over the drive roll
- Fit the wire spool to the centre pillar.
- Push the wire brake mechanism assembly downwards after fitting the spool. (5) This brake prevents the spool overrunning and “bird nesting” inside the cover.
- Feed the wire over the drive roll and into the neck nipple (6)
- When using aluminium wires the brake system (5) alone will exert enough force on the spool to prevent the wire spool overrunning.
- When using steel wires the wire tension nut (7) should be hand tightened until there is no overrunning of the spool



## Ready to use

- Close the pressure arm assembly, adjust the tension knob to take up the slack in the pressure arm. A light closure pressure is all that is required, Do not overtighten the pressure arm.
- Close the handle cover .
- Close the spool cover making sure the position marks <<< are lined up.
- Inch the wire through the neck to the contact tip, trim the wire to make it ready to use.



## Drive rolls

Drive Rolls can be supplied in sizes to suit 0.8, 0.9, 1.0 and 1.2mm diameter soft wire sizes (with 'U' groove) and 0.8, 0.9 and 1.0mm diameter hard wires sizes (with 'V' groove). Your torch will have been supplied with 0.8mm or 1.0mm 'U' type drive roll unless a different size has been specified on your order.

It's easy to replace a drive roll. Just loosen the slot headed screw over the drive roll and slide the roll up to replace it.

The drive rolls are double grooved to add service life to each roll. The unused groove can be used by inverting the drive roll.

Replacing the Drive roll.

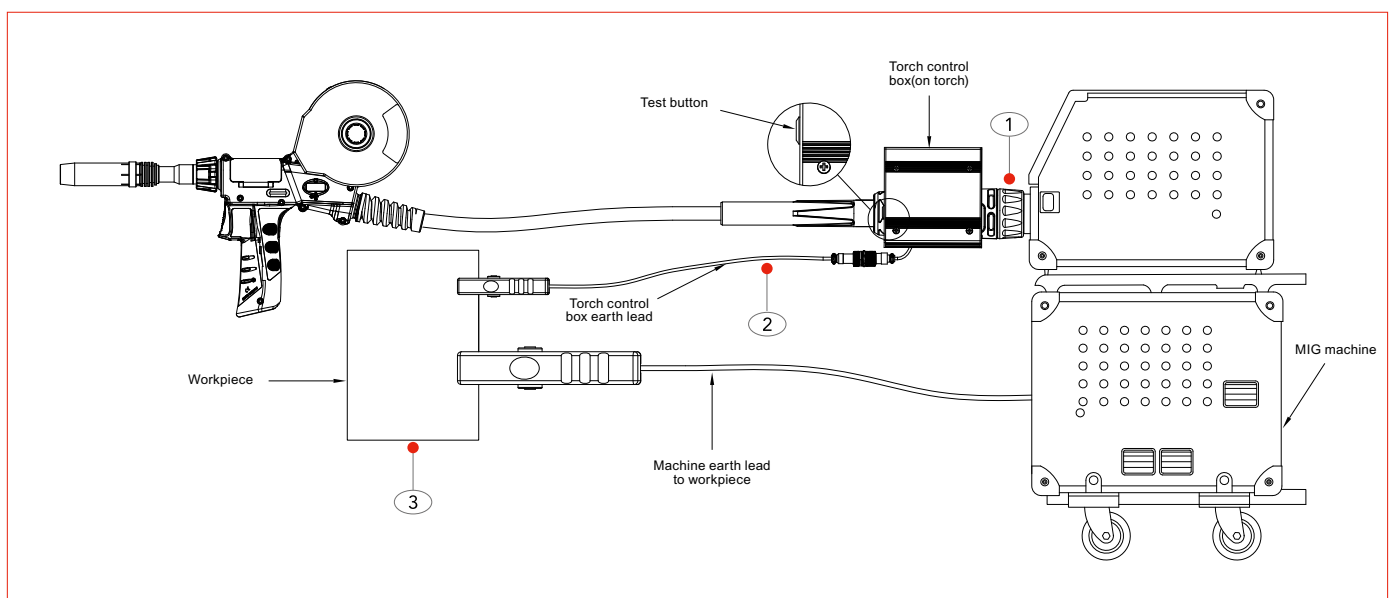
Use a 9mm A/F spanner to hold the motor shaft and with a blade screwdriver, remove the screw with an anti-clockwise direction.

## TO OPERATE

- You will have already connected the Spool-On torch to the welding power source with Euro connector ①.
- The wire feeder on the welding machine should be disabled (**alternately open the drive rollers to stop the wire being pushed into the Spool-On gun**).
- The electronic module (part of the torch control box near the euro connector) has a wire socket that needs a connection to the welding earth (negative) with the crocodile clamp ②. The wire can be attached directly to the workpiece ③ or welding clamp or directly onto the negative output socket on the power source.

Welding can now be carried out using the torch like a conventional MIG torch, the speed of the wire is set by the torch potentiometer, welding voltage is set on the welding power source as normal. Adjust the rollers pressure if necessary to make sure the feed is consistent and not slipping. Do not overtighten the tension knob as this leads to unnecessary pressure on the motor and drive system.

Note: Test button: The test button checks the connection between torch and machine, it is also useful to check that the machine wire feed system is disconnected.





## Maintenance, Fault Finding and Warranty.

### Maintenance, Fault Finding and Warranty

Used correctly, you can expect a long life from a Parker Auto-Voltage Spool-On torch. In order to ensure long life, there are a few precautions you should take note of when using and servicing your torch.

We would recommend that you should pay attention to the following:

#### O Ring care

Swan necks are fitted with O-rings to seal the gas channels. The condition of these rings is critical to the smooth operation of a Parker Auto-Voltage Spool-On torch. Damage to these O-rings may affect the weld performance particularly with aluminum wires.

Great care should always be taken when removing or replacing the neck. Each time the neck is withdrawn from the body, the O-rings should be inspected. If any wear or damage is suspected, the O-rings must be replaced.

#### Front-end consumables

The nozzle, contact tip and diffuser all run at very high temperatures and you should regularly inspect them for wear and operational damage. When changing a contact tip, always use a contact tip spanner to prevent over tightening. Repeated over tightening will destroy the threads in the tip adaptor.

#### Drive Rolls

Always make sure you have the correct drive roll for the type and size of wire you are using. The drive roll and pressure roll should be inspected regularly for wear.

The area around the drive roll should be regularly dusted off to prevent dust and workshop debris from accumulating. We do not recommend lubricating the drive shaft or pressure roll. These are sealed for life units and lubrication oils or greases will only pick up dust and turn these oils and greases into a grinding paste. A simple dust off is all that is required.

Its easy to replace a drive roll. Use a 9mm A/F spanner to hold the motor shaft and with a blade screwdriver, remove the screw with an anti-clockwise direction.

The gearbox, drive motor and shaft top bearing are also sealed for life. No maintenance is required.

#### Torch Neck

The torch neck can easily be removed by the operator to assist with feeding problems. Always make sure the large nut which fixes the neck is tight.

#### Parker Spool-On Warranty

Every Parker Auto-Voltage Spool-On welding torch is manufactured to the highest standards and carries a 3 month warranty from the date of sale to the end-user. The warranty covers and is limited to a fault developing as a result of faulty workmanship or faulty materials.

#### What is covered?

- Defective materials used in the manufacture of the product.
- Faulty workmanship in the manufacture of the product

#### What is not covered?

- Incorrect use or damage.
- Normal wear and tear to either the product or the consumables supplied with the product.
- Faults arising from using non Parker Torchology spare parts.
- Direct or indirect costs of any form arising as a result of a suspected, or actual, defective product.

#### How to make a claim

This warranty is limited to the original purchaser of the product, it is not transferable. If a fault is suspected, the dealer or Parker Torchology must be contacted and informed of the fault before the product is returned.

You can contact us by

✉ Mail: [sales@parkertorchology.com](mailto:sales@parkertorchology.com)

#### How will we handle any claim?

Parker Torchology sales office may ask you to return the product with a copy of your proof of purchase, (If you are the end-user) or a copy of proof of sale (If you are a distributor).

Depending on the nature of the claim, we may ask one of our technical staff to discuss the problem with you to get a quick resolution.

Once the cause of the problem is established and at our discretion, we will either repair or replace the defective product free of charge.

We will refund the costs incurred in returning the product if a defect is found, but will only refund normal transport costs. We will not pay for UPS, Express deliveries or any other high speed carriers.

If we believe the product failure is as a result of any reason other than defective materials or manufacture, we will issue a written report to you detailing our findings.

#### Other issues

Whilst Parker Auto-Voltage Spool-On welding torches will give long and lasting service. We do understand the harsh and demanding working environment in which our products operate, therefore Parker Torchology retain the right to deal with any fault in a manner that best suits Parker Torchology.

This warranty is an addition to Parker Torchology standard terms and conditions and Parker Torchology standard Terms and Conditions of Sale will take precedence over this warranty.



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