



AIRCRAFTER T-250™

DIGITAL TURNTABLE

Owner's Manual

Product:	AirCrafterT-250™ Digital Turntable
Manual:	091-0728
Serial:	16110001
Voltage Rating:	120 VAC
Revision:	-A-
Model Number:	127-007



Table of Contents

Safety Considerations i-iii

Specifications Section A

Unit Specifications 1

Load Specifications 1

Dimensions 2

Operation Section B

Initial Setup 3

Operating Procedure 4

Calibration Procedure 5

Controls and Connections 6

Accessories Section C

Kits 7

Appendices Section D

Diagrams / Parts List 8

 Main Assembly 9

 Front Panel Assembly 11

 Electrical 12

Safety Warnings

Warranty

THIS PAGE INTENTIONALLY BLANK

SAFETY CONSIDERATIONS

ELECTRIC ARC WELDING EQUIPMENT

CAUTION : READ BEFORE ATTEMPTING INSTALLATION, OPERATION OR MAINTENANCE OF THIS EQUIPMENT

1-1 INTRODUCTION

This equipment is intended for ultimate application by commercial/industrial users and for operation by persons trained and experienced in the use and maintenance of welding equipment. Operation should not be undertaken without adequate training in the use of such equipment. Training is available from many public and private schools or similar facilities.

Safe practices in the installation, operation and maintenance of this equipment requires proper training in the art, a careful study of the information provided with the equipment, and the use of common sense. Rules for safe use are generally provided by suppliers of welding power sources, compressed gas suppliers, and electrode suppliers. Careful compliance with these rules will promote safe use of this equipment.

The following Safety Rules cover some of the more generally found situations. READ THEM CAREFULLY. In case of any doubt, obtain qualified help before proceeding.

1-2 GENERAL PRECAUTIONS

A. Burn Prevention

ELECTRIC ARC WELDING PRODUCES HIGH INTENSITY HEAT AND ULTRAVIOLET RADIANT ENERGY WHICH MAY CAUSE SERIOUS AND PERMANENT EYE DAMAGE AND WHICH MAY DAMAGE ANY EXPOSED SKIN AREAS.

Wear helmet with safety goggles or glasses with side shields underneath, appropriate filter lenses or plates (protected by clear cover glass). This is a must for welding or cutting (and chipping) to protect the eyes from radiant energy and flying metal. Replace cover glass when broken, pitted, or spattered.

Medical first aid and eye treatment. First aid facilities and a qualified first aid person should be available for each shift unless medical facilities are close by for immediate treatment of flash burns of the eyes and skin burns.

Wear protective clothing - leather (or asbestos) gauntlet gloves, hat, and high safety-toe shoes. Button shirt collar and pocket flaps, and wear cuffless trousers to avoid entry of sparks and slag.

Avoid oily or greasy clothing. A spark may ignite them.

Flammable hair preparations should not be used by persons intending to weld or cut.

Hot metal such as electrode stubs and

work pieces should never be handled without gloves.

Ear plugs should be worn when working on overhead or in a confined space. A hard hat should be worn when others work overhead.

B. Toxic Fume Prevention

WARNING: The use of this product may result in exposure to chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

Adequate ventilation. Severe discomfort, illness or death can result from fumes, vapors, heat, or oxygen enrichment or depletion that welding (or cutting) may produce. Prevent them with adequate ventilation. NEVER ventilate with oxygen.

Lead-, cadmium-, zinc-, mercury-, beryllium-bearing and similar materials, when welded or cut, may produce harmful concentrations of toxic fumes. Adequate local exhaust ventilation must be used, or each person in the area, as well as the operator, must wear an air-supplied respirator. For beryllium, both must be used.

Metals coated with or containing materials that emit toxic fumes should not be heated unless coating is removed from the work surface, the area is well ventilated, or the operator wears an air-supplied respirator.

Work in a confined space only while it is being ventilated and, if necessary, while wearing an air-supplied respirator.

Gas leaks in a confined space should be avoided. Leaked gas in large quantities can change oxygen concentration dangerously. Do not bring gas cylinders into a confined space.

Leaving confined space, shut OFF gas supply at source to prevent possible accumulation of gases in the space if downstream valves have been accidentally opened or left open. Check to be sure that the space is safe before reentering it.

Vapors from chlorinated solvents can be decomposed by the heat of the arc (or flame) to form PHOSGENE, a highly toxic gas, and other lung and eye irritating products. The ultraviolet (radiant) energy of the arc can also decompose trichloroethylene and perchloroethylene vapors to form phosgene. DO NOT WELD or cut where solvent vapors can be drawn into the welding or cutting atmosphere or where the radiant energy can penetrate to atmospheres containing even minute amounts of trichloroethylene or perchloroethylene.

C. Fire and Explosion Prevention

Causes of fire and explosion are: combustibles reached by the arc, flame, flying sparks, hot slag, or heated material, misuse

of compressed gases and cylinders, and short circuits.

BE AWARE THAT flying sparks or falling slag can pass through cracks, along pipes, through windows or doors, and through wall or floor openings, out of sight of the goggled operator. Sparks can fly many feet.

To prevent fires and explosion:

Keep equipment clean and operable, free of oil, grease, and (in electrical parts) of metallic particles that can cause short circuits.

If combustibles are in area, do NOT weld or cut. Move the work if practicable, to an area free of combustibles. Avoid paint spray rooms, dip tanks, storage areas, ventilators. If the work cannot be moved, move combustibles at least 35 feet away, out of reach of sparks and heat; or protect against ignition with suitable and snug-fitting, fire-resistant covers or shields.

Walls touching combustibles on opposite sides should not be welded on (or cut). Walls, ceilings, and floor near work should be protected by heat-resistant covers or shields.

Fire watcher must be standing by with suitable fire extinguishing equipment during and for some time after welding or cutting if:

1. Appreciable combustibles (including building construction) are within 35 feet.
2. Appreciable combustibles are further than 35 feet, but can be ignited by sparks.
3. Openings (concealed or visible) in floors or walls within 35 feet may expose combustibles to sparks.
4. Combustibles adjacent to walls, ceilings, roofs, or metal partitions can be ignited by radiant or conducted heat.

Hot work permit should be obtained before operation to ensure supervisor's approval that adequate precautions have been taken.

After work is done, check that area is free of sparks, glowing embers, and flames.

An empty container that held combustibles, or that can produce flammable or toxic vapors when heated, must never be welded on or cut, unless container has first been cleaned in accordance with industry standards.

This includes: a thorough steam or caustic cleaning (or a solvent of water washing, depending on the combustible's solubility), followed by purging and inerting with nitrogen or carbon dioxide, and using protective equipment.

Water-filling just below working level may substitute for inerting.

A container with unknown contents should be cleaned (see paragraph above). Do NOT depend on sense of smell or sight to determine if it is safe to weld or cut.

Hollow castings or containers must be vented before welding or cutting. They can explode.

Explosive atmospheres. NEVER weld or cut where the air may contain flammable dust, gas, or liquid vapors (such as gasoline).

D. Compressed Gas Equipment

The safe handling of compressed gas equipment is detailed in numerous industry publications. The following general rules cover many of the most common situations.

1. Pressure Regulators

Regulator relief valve is designed to protect only the regulator from overpressure; it is not intended to protect any downstream equipment. Provide such protection with one or more relief devices.

Never connect a regulator to a cylinder containing gas other than that for which the regulator was designed.

Remove faulty regulator from service immediately for repair (first close cylinder valve). The following symptoms indicate a faulty regulator:

Leaks - if gas leaks externally.

Excessive Creep - if delivery pressure continues to rise with downstream valve closed.

Faulty Gauge - if gauge pointer does not move off stop pin when pressurized, nor returns to stop pin after pressure release.

Repair. Do NOT attempt repair. Send faulty regulators for repair to manufacturer's designated repair center, where special techniques and tools are used by trained personnel.

2. Cylinders

Cylinders must be handled carefully to prevent leaks and damage to their walls, valves, or safety devices:

Avoid electrical circuit contact with cylinders including third rails, electrical wires, or welding circuits. They can produce short circuit arcs that may lead to a serious accident. (See 1-3C)

ICC or DOT marking must be on each cylinder. It is an assurance of safety when the cylinder is properly handled.

Identifying gas content. Use only cylinders with name of gas marked on them; do not rely on color to identify gas content. Notify supplier if unmarked. NEVER DEFACE or alter name, number, or other markings on a cylinder. It is illegal and hazardous.

Empties: Keep valves closed, replace caps securely; mark MT; keep them separate from FULLS, and return promptly.

Prohibited use. Never use a cylinder or its contents for other than its intended use, NEVER as a support or roller.

Locate or secure cylinders so they cannot be knocked over.

Passageways and work areas. Keep cylinders clear of areas where they may be stuck.

Transporting cylinders. With a crane, use a secure support such as a platform or cradle. Do NOT lift cylinders off the ground by their valves or caps, or by chains, slings, or magnets.

Do NOT expose cylinders to excessive heat, sparks, slag, and flame, etc. that may cause rupture. Do not allow contents to exceed 55 degrees C (130 degrees F.) Cool with water spray where such exposure exists.

Protect cylinders, particularly valves from bumps, falls, falling objects, and weather. Replace caps securely when moving cylinders.

Stuck valve. Do NOT use a hammer or wrench to open a cylinder valve that cannot be opened by hand. Notify your supplier.

Mixing gases. NEVER try to mix any gases in a cylinder.

NEVER refill any cylinder.

Cylinder fittings should never be modified or exchanged.

3. Hose

Prohibited use. Never use hose other than that designed for the specified gas. A general hose identification rule is: red for fuel gas, green for oxygen, and black for inert gases.

Use ferrules or clamps designed for the hose (not ordinary wire or other substitute) as a binding to connect hoses to fittings.

No copper tubing splices. Use only standard brass fittings to splice hose.

Avoid long runs to prevent kinks and abuse. Suspend hose off ground to keep it from being run over, stepped on, or otherwise damaged.

Coil excess hose to prevent kinks and tangles.

Protect hose from damage by sharp edges, and by sparks, slag, and open flame.

Examine hose regularly for leaks, wear, and loose connections. Immerse pressured hose in water; bubbles indicate leaks

Repair leaky or worn hose by cutting area out and splicing. Do NOT use tape.

4. Proper Connections

Clean cylinder valve outlet of impurities that may clog orifices and damage seats before connecting regulator. Except for hydrogen, crack valve momentarily, pointing outlet away from people and sources of ignition. Wipe with a clean, lintless cloth.

Match regulator to cylinder. Before connecting, check that the regulator label and cylinder marking agree, and that the regulator inlet and cylinder outlet match. NEVER Connect a regulator designed for a particular gas or gases to a cylinder contain-

ing any other gas.

Tighten connections. When assembling threaded connections, clean and smooth seats where necessary. Tighten. If connection leaks, disassemble, clean, and retighten, using properly fitting wrench.

Adapters. Use a CGA adapter (available from your supplier) between cylinder and regulator, if one is required. Use two wrenches to tighten adapter marked RIGHT and LEFT HAND threads.

Regulator outlet (or hose) connections may be identified by right hand threads for oxygen and left hand threads (with grooved hex on nut or shank) for fuel gas.

5. Pressurizing Steps:

Drain regulator of residual gas through suitable vent before opening cylinder (or manifold valve) by turning adjusting screw in (clockwise). Draining prevents excessive compression heat at high pressure seat by allowing seat to open on pressurization. Leave adjusting screw engaged slightly on single-stage regulators.

Stand to side of regulator while opening cylinder valve.

Open cylinder valve slowly so that regulator pressure increases slowly. When gauge is pressurized (gauge reaches regulator maximum) leave cylinder valve in following position: for oxygen and inert gases, open fully to seal stem against possible leak; for fuel gas, open to less than one turn to permit quick emergency shut-off.

Use pressure charts (available from your supplier) for safe and efficient recommended pressure settings on regulators.

Check for leaks on first pressurization and regularly thereafter. Brush with soap solution. Bubbles indicate leaks. Clean off soapy water after test; dried soap is combustible.

E. User Responsibilities

Follow all Safety Rules.

Remove leaky or defective equipment from service immediately for repair. Read and follow user manual instructions.

F. Leaving Equipment Unattended

Close gas supply at source and drain gas.

G. Rope Staging-Support

Rope staging-support should not be used for welding or cutting operation; rope may burn.

1-3 ARC WELDING

Comply with precautions in 1-1, 1-2, and this section. Arc Welding, properly done, is a safe process, but a careless operator invites trouble. The equipment carries high currents at significant voltages. The arc is very bright and hot. Sparks fly, fumes rise, ultraviolet and infrared energy radiates, weldments are hot, and compressed gases may be used. The wise operator avoids unnecessary risks and protects himself and others from accidents.

A. Burn Protection

Comply with precautions in 1-2.

The welding arc is intense and visibly bright. Its radiation can damage eyes, penetrate lightweight clothing, reflect from light-colored surfaces, and burn the skin and eyes. Skin burns resemble acute sunburn; those from gas-shielded arcs are more severe and painful. **DON'T GET BURNED; COMPLY WITH PRECAUTIONS.**

1. Protective Clothing

Wear long-sleeve clothing in addition to gloves, hat, and shoes. As necessary, use additional protective clothing such as leather jacket or sleeves, flameproof apron, and fire-resistant leggings. Avoid outer garments of untreated cotton.

Bare skin protection. Wear dark, substantial clothing. Button collar to protect chest and neck, and button pockets to prevent entry of sparks.

2. Eye and Head Protection

Protect eyes from exposure to arc. Eyes may be damaged by radiant energy when exposed to the electric arc, even when not looking in the direction of the arc. Never look at an electric arc without protection.

Welding helmet or shield containing a filter plate shade no. 12 or denser must be used when welding. Place over face before striking arc.

Protect filter plate with a clear cover plate.

Cracked or broken helmet or shield should NOT be worn; radiation can be passed through to cause burns.

Cracked, broken, or loose filter plates must be replaced IMMEDIATELY. Replace clear cover plate when broken, pitted, or spattered.

Flash goggles with side shields MUST be worn under the helmet to give some protection to the eyes should the helmet not be lowered over the face before an arc is struck. Looking at an arc momentarily with unprotected eyes (particularly a high intensity gas-shielded arc) can cause a retinal burn that may leave a permanent dark area in the field of vision.

3. Protection of Nearby Personnel

Enclose the welding area. For production welding, a separate room or enclosed bay is best. In open areas, surround the operation with low-reflective, noncombustible screens or panels. Allow for free air circulation, particularly at floor level.

Viewing the weld. Provide face shields for all persons who will be looking directly at the weld.

Others working in area. See that all persons are wearing flash goggles.

Before starting to weld, make sure that screen flaps or bay doors are closed.

B. Toxic Fume Prevention

Comply with precautions in 1-2B.

Generator engine exhaust must be vented to the outside air. Carbon mon-

oxide can kill.

C. Fire and Explosion Prevention

Comply with precautions in 1-2C.

Equipment's rated capacity. Do not overload arc welding equipment. It may overheat cables and cause a fire.

Loose cable connections may overheat or flash and cause a fire.

Never strike an arc on a cylinder or other pressure vessel. It creates a brittle area that can cause a violent rupture or lead to such a rupture later under rough handling.

D. Compressed Gas Equipment

Comply with precautions in 1-2D.

E. Shock Prevention

Exposed electrically hot conductors or other bare metal in the welding circuit, or in ungrounded, electrically-HOT

equipment can fatally shock a person whose body becomes a conductor. **DO NOT STAND, SIT, LIE, LEAN ON, OR TOUCH** a wet surface when welding without suitable protection.

To protect against shock:

Keep body and clothing dry. Never work in damp area without adequate insulation against electrical shock. Stay on a dry duckboard, or rubber mat when dampness or sweat cannot be avoided. Sweat, sea water, or moisture between body and an electrically HOT part - or grounded metal - reduces the body surface electrical resistance, enabling dangerous and possibly lethal currents to flow through the body.

1. Grounding the Equipment

When installing, connect the frames of each unit such as welding power source, control, work table, and water circulator to the building ground. Conductors must be adequate to carry ground currents safely. Equipment made electrically HOT by stray currents may shock, possibly fatally. **DO NOT GROUND** to electrical conduit, or to a pipe carrying ANY gas or a flammable liquid such as oil or fuel.

Three-phase connection. Check phase requirement of equipment before installing. If only three-phase power is available, connect single-phase equipment to only two wires of the three-phase line. **DO NOT** connect the equipment ground lead to the third (live) wire, or the equipment will become electrically HOT - a dangerous condition that can shock, possibly fatally.

Before welding, check ground for continuity. Be sure conductors are touching bare metal of equipment frames at connections.

If a line cord with a ground lead is provided with the equipment for connection to a switch box, connect the ground lead to the grounded switch box. If a three-prong plug is added for connection to a grounded mating receptacle, the ground lead must be connected to the ground prong only. If the line cord comes with a three-prong plug, connect to a grounded mating receptacle. Never remove the ground prong from a plug, or use a plug with a broken ground prong.

2. Connectors

Fully insulated lock-type connectors should be used to join welding cable lengths.

3. Cables

Frequently inspect cables for wear, cracks, and damage. **IMMEDIATELY REPLACE** those with excessively worn or damaged insulation to avoid possibly lethal shock from bared cable. Cables with damaged areas may be taped to give resistance equivalent to original cable.

Keep cable dry, free of oil and grease, and protected from hot metal and sparks.

4. Terminals and Other Exposed Parts

Terminals and other exposed parts of electrical units should have insulating covers secured before operation.

5. Electrode Wire

Electrode wire becomes electrically HOT when the power switch of gas metal-arc welding equipment is ON and welding gun trigger is pressed. Keep hands and body clear of wire and other HOT parts.

6. Safety Devices

Safety devices such as interlocks and circuit breakers should not be disconnected or shunted out.

Before installation, inspection, or service of equipment, shut OFF all power, and remove line fuses (or lock or red-tag switches) to prevent accidental turning ON of power. Disconnect all cables from welding power source, and pull all 115 volts line-cord plugs.

Do not open power circuit or change polarity while welding. If, in an emergency, it must be disconnected, guard against shock burns or flash from switch arcing.

Leaving equipment unattended. Always shut OFF, and disconnect all power to equipment.

Power disconnect switch must be available near the welding power source.

Thank You

For selecting a quality product. We want you to take pride in operating this product...as much pride as we have in bringing the product to you!

Please Examine Carton and Equipment For Damage Immediately

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

Please record your equipment identification information below for future reference. This information can be found on your machine nameplate.

Model Name & Number _____

Code & Serial Number _____

Date of Purchase _____

Whenever you request replacements parts for, or information on this equipment always supply the information you have recorded above.

Read this Owner's Manual completely before attempting to use this equipment. Save this manual and keep it handy for quick reference. Pay particular attention to the safety instructions we have provided for your protection.

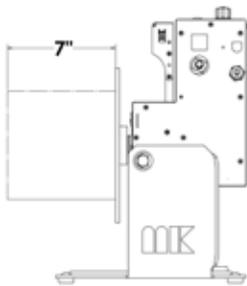
Visit our website to download digital copy of this manual, www.mkprod.com.

Section A Specifications

Unit Specifications

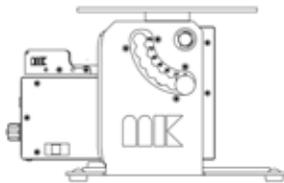
Model	Turntable Diameter	Degrees Tilt	Speed Range R.P.M.		Ground Capacity AMPS	Input Voltage	Weight	Transmission
			Low	High				
127-007	10"	0° to 90°	0.1	10	400A 60% Duty Cycle	120VAC 50/60 Hz	38 lbs	Gear w/ De-clutch

Load Specifications



Turntable Vertical

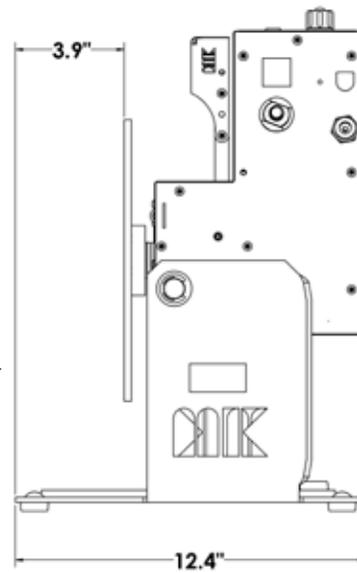
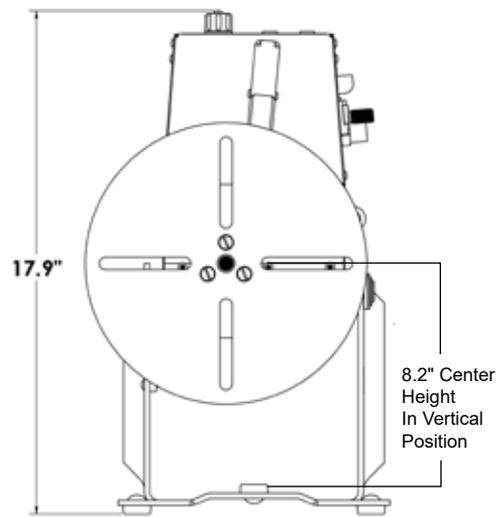
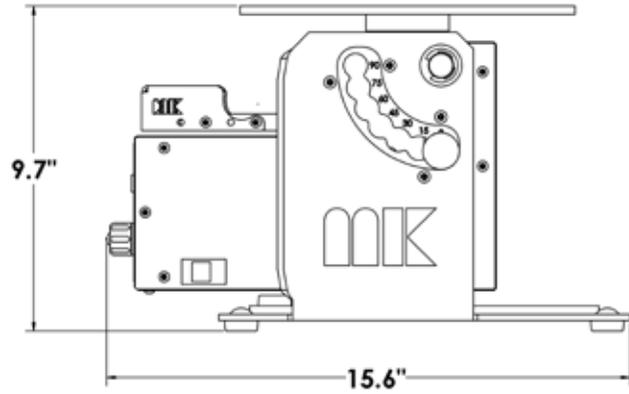
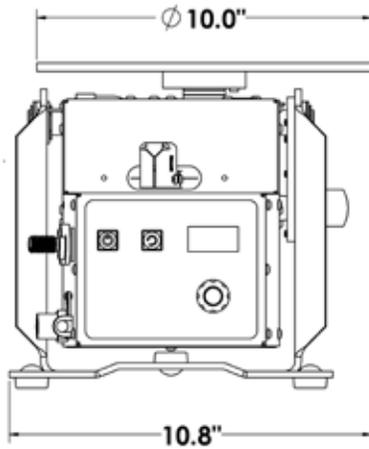
- 125 lbs in the vertical position from 0.1-10 RPM with a balanced & centered load, 7" max from table surface



Turntable Horizontal

- 250 lbs in the horizontal position from 0.1-10 RPM with a balanced & centered load

Dimensions

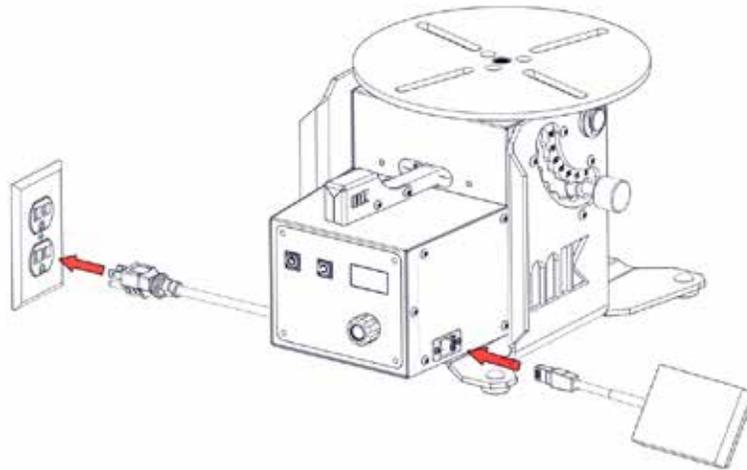


Section B

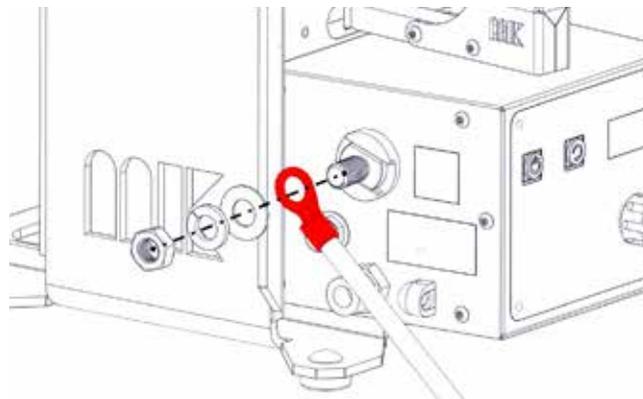
Operation

Initial Setup

1. Unbox unit from packaging. Save packaging for future transportation of unit.
2. Plug the unit's power cord into a standard 120VAC outlet.



3. If you desire to use the provided foot pedal, plug the pedal cable into connector on the side of the unit.
4. Attach a ground cable with a 1/2" ring lug to the ground terminal on the unit.



Warning: Not attaching a ground cable directly to the unit while welding on the turntable, may cause damage to the unit. Reversely, leaving the ground cable attached to the unit while welding a part not on the turntable, may cause damage to the unit.



ON/OFF
Button



Rotation
Direction
Button



Knob / Push
Button (Start,
Stop, Jog)

Operating Procedure

1. Push On / Off button to switch the unit on.

NOTE: If unit doesn't turn on, check power connection and the fuse.

2. The display will briefly show the firmware version and then show the last rotational speed used. If you see any other message, please see the Troubleshooting section.
3. To adjust display brightness press and hold the rotation direction button (the turntable must be stopped). After ~1 sec., the display changes and shows the brightness value (1 to 63), rotate knob to adjust brightness of the display. Release the rotation direction button when done.
4. Push the rotation direction button to switch between clockwise and counter clockwise rotation. When the button is lit the table will rotate clockwise. When it is not lit the rotation is counter clockwise.
5. Establish desired speed setting using the knob while reading the LED display on the turntable.
6. To start turntable with the set speed press the push button in the center of the knob and release within 1 sec., the motor will start and the button lights green. Press the button again to stop and the button flashes red then turns blue. If the button is held longer than 1 sec., the turntable starts jogging (10 RPM), button flashes green and turntable jogs until released.

NOTE: When knob is pressed, the knob rotation is ignored to prevent value changes while pressing.

With the foot pedal plugged in, the speed setting displayed is the maximum speed the foot pedal will use. While pressing the foot pedal, the display shows speed of the foot pedal setting.

NOTE: When the foot pedal is plugged in, the Start/Stop function of the knob is disabled.

7. Press and hold the On / Off button (display shows "OFF") until power is turned to standby mode. If released sooner, the display returns to normal.

NOTE: The unit is not completely off unless it is unplugged from power source.

NOTE:

Pressing invalid key causes "Err" message displayed for ~2 sec.

NOTE:

Pressing invalid key while foot pedal is plugged in, displays "PdL" and key is ignored.

NOTE:

All turntable settings and calibration are preserved when power is turned off.

8. To adjust the angle of the table press and hold in the push knob on the right side of the machine. Lift table to desired degree then release the push knob, thus locking the table in position.

Additional Display Messages

- **nEE:** This means the turntable memory was not set or lost. Power cord needs to be unplugged to reset. If this error persists, please contact MK support.
- **bAd:** This message is displayed for about 3 seconds and default settings are restored and self-testing continues. **WARNING:** The turntable **SHOULD** be recalibrated.
- **CAL:** If the display shows "CAL", the hardware calibration needs to be performed (never calibrated or corrupted).

Calibration Procedure

Your AirCrafter T-250 comes calibrated from the factory, but if you suspect the unit's RPM readings are off, follow the procedure below to re-calibrate the unit:

1. Make sure the unit is off.
2. Press and **hold down** the direction button, then press the power button.
3. Next release the power button and then the direction button.
4. If done correctly, "CAL" will be displayed as shown.



5. Begin the calibration by pressing the start button (knob / push button). Calibration will take about 20 minutes as the table turns and records RPM and time data.
6. After the data is recorded, the letters "SLo" will be flashing on the display, **slowly turn** the speed knob until the turntable barely begins to rotate.



7. Finally press the stop button (knob / push button) to finish and save the calibration.

Controls and Connections



Section C

Accessories

Kits



005-0677 (*standard*)
10" Turntable, With Hardware



005-0747 (*standard*)
On/Off Foot Switch



005-0040 (*optional*)
3-Jaw 4" Chuck With 7/8" Hole
Inside And Outside Jaws, Hardware,
Tools Included



005-0746 (*optional*)
Heavy Duty
Variable Speed Foot Control

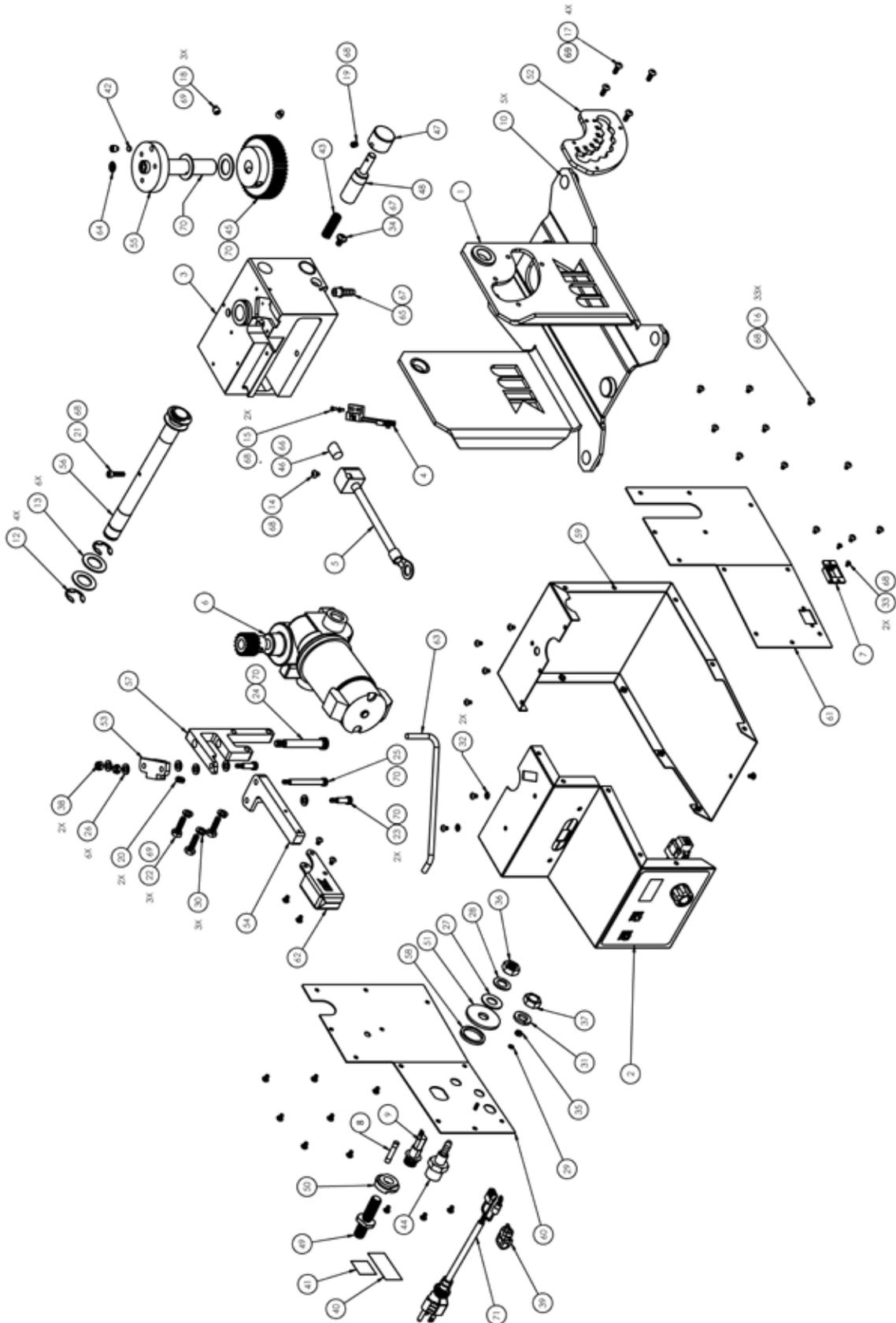
Section D

Appendices

Diagrams / Parts List

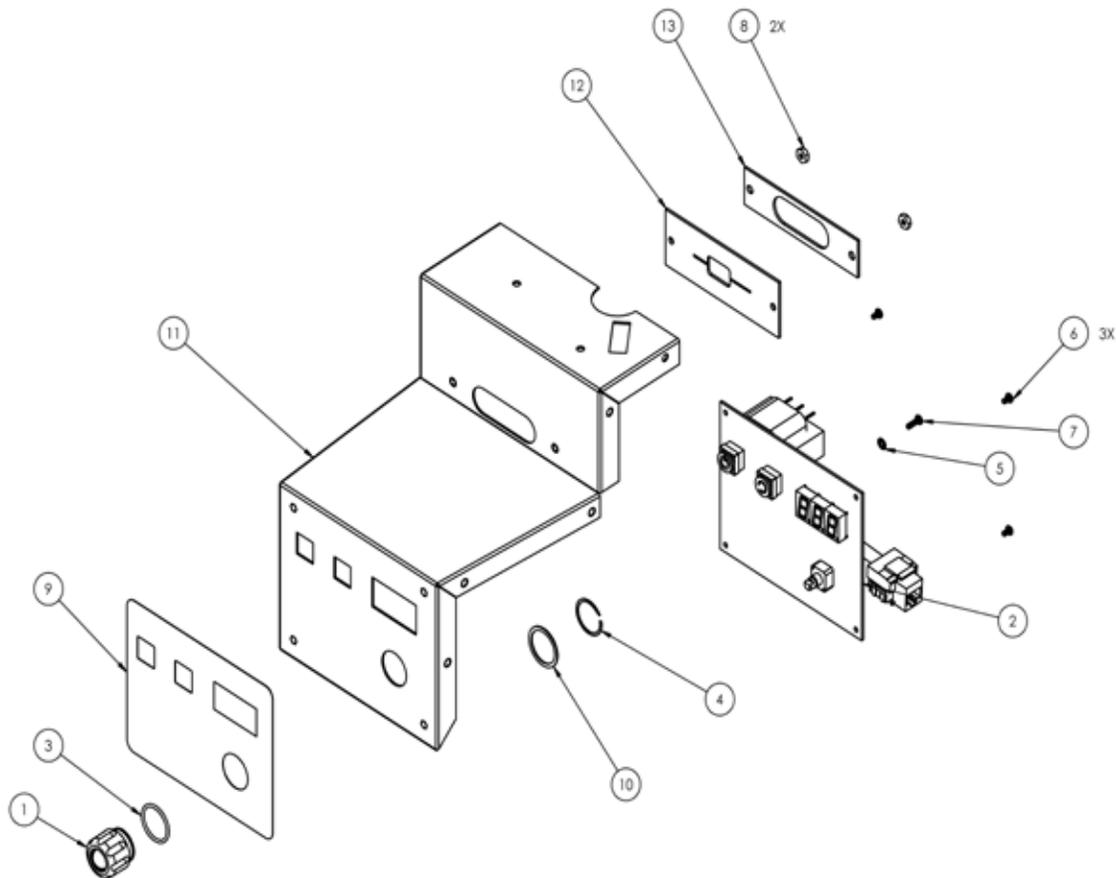
Main Assembly.....	9
Front Panel Assembly.....	11
Electrical	12

AirCrafter™ T-250 Main Assembly



MAIN ASSEMBLY PARTS LIST			
NO.	QTY.	PART NO.	DESCRIPTION
1	1	003-2668	ASSY BASE AIRCRAFTER T250
2	1	003-2669	ASSY FRONT PANEL AIRCRAFTER T250
3	1	003-2670	ASSY HOUSING BLOCK AIRCRAFTER T250
4	1	003-2672	ASSY SENSOR T-250
5	1	003-2673	ASSY GROUND AIRCRAFTER T250
6	1	003-2675	ASSY MOTOR AIRCRAFTER T-250
7	1	145-0044	BEZEL KEYSTONE PNL ADPTR
8	1	151-0197	FUSE GLASS TUBE 5 AG (SOLD IN PACK OF 5)
9	1	152-0059	FUSE HOLDER PANEL MOUNT .5 DIA
10	5	301-0115	FOOT RUBBER (SOLD IN PACK OF 5)
12	4	005-0799	E-RING 3/4ID
13	6	315-0030	BRG SLV THRUST 3/4IDX1-1/4ODX1/16LG (SOLD IN PACK OF 6)
14	1		SCR TR P 8-32X1/4 SST
15	2		SCREW FLAT HEAD 4-40 X .250
16	33		SCR BHSC 8-32 X 1/4 ST BLK ZINC
17	4		SCR BHSC 10-24X1/2 ST BLK ZINC
18	3		SSCR HLF 5/16-18X3/8 ST
19	1		SSCR CONE 1/4-20X3/8 SS
20	2		SSCR CUP 1/4-28 X 1/2 W/NYLON LKG ST
21	1		SCR SHC 10-24X3/4
22	3		SCR HEX 1/4-20X7/8
23	2		SCR SHDR 10-24 X 1/4 X 5/8
24	1		SCR SHDR 3/8X2-1/4 5/16-18
25	1	INCLUDED	SCR SHDR 1/4 X 2.0 10-24 ST
26	6	IN KIT	WSHR F #1/4 .50X.265X.063 ST
27	2	005-0799	WSHR F 1.125X0.50X0.08 BS
28	1		WASHER FL 0.525ID X 0.875ODX0.063T BRASS
29	1		WASHER, SPRING LOCK #6
30	3		WSHR SPR LK #1/4
31	3		WSHR SPR LK #1/2
32	4		WSHR LK #8 INTL STAR STL
33	2		SCR PN P 4-40X3/8 SS
34	1		PLUG BRASS 1/8-27 NTP HEX
35	1		NUT HX PLAIN, #6-32 UNC
36	1		NUT HX 1/2-13UNC 5/16THK BRS
37	1		NUT JAM 1/2-20 BS
38	2		NUT HX LK #10-24UNC W/INSR NYLON
39	1	351-0266	STRAIN RELIEF 90 DEG.
40	1	405-1365	LABEL WARNING ELECTRIC SHOCK
41	1	405-1366	WARNING GROUND LABEL
42	1	409-0031	NEODYMIUM DISC MAGNET (SOLD IN PACK OF 5)
43	1	419-0130	SPR COMP 0.437 OD X 0.05 W X 1.380 LG STL
44	1	431-0568	FTG GAS PSNR 4
45	1	431-1603	GEAR MOD 48T PSNR 4A
46	1	431-2061	COPPER BRUSH TURNTABLE
47	1	431-2065	KNOB PUSH TURNTABLE
48	1	431-2072	PLUNGER LOCK TURNTABLE
49	1	431-2160	STUD PS CV300
50	1	431-2161	ISOLATOR PS CM300
51	1	431-2162	ISO WASHER
52	1	431-2186	POSITION PLATE AIRCRAFTER TURNTABLE
53	1	431-2187	OFFCENTER LOCK PLATE AIRCRAFTER TURNTABLE
54	1	431-2188	LEVER PLATE AIRCRAFTER TURNTABLE
55	1	431-2189	MAIN AXLE AIRCRAFTER TURNTABLE
56	1	431-2190	SHAFT AXLE TURNTABLE
57	1	431-2193	MOTOR MOUNT AIRCRAFTER TURNTABLE
58	1	431-2194	GROUND ALUM SPACER T250
59	1	435-1345	SHEET METAL BOTTOM AIRCRAFTER T-250
60	1	435-1348	SHEET METAL SIDES AIRCRAFTER TURNTABLE
61	1	435-1349	SIDE LEFT AIRCRAFTER T250
62	1	435-1350	HANDLE AIRCRAFTER T250
63	9.5 IN	551-0015	TUBE CLR PLSTC 1/4 ID
64	1	716-0009	DISC WIRE CLOTH SS 0.5OD
65	1	757-0009	FTG HOSE 1/8NPT TO 1/4 ID
66	A/R	823-0029	COMPOUND JOINT NOALOX
67	A/R	823-0044	THREAD SEALANT HIGH STRENGTH
68	A/R	823-0050	LOCTITE 222 PURPLE
69	A/R	823-0068	LOCTITE 243 BLUE
70	A/R	835-0018	GREASE
71	1	843-0757	ASSY POWER CABLE T-250

AirCrafter™ T-250 Front Panel Assembly



FRONT PANEL PARTS LIST

NO.	QTY.	PART NO.	DESCRIPTION
1	1	003-2504	ASSY KNOB TURNTABLE
2	1	005-0798	ASSY PCB FR PNL CNTLR TURNTABLE
3	1	303-0110	O-RING BUNA 019 A50 (SOLD IN PACK OF 12)
4	1		RET. RING EXT. 13/16" ID
5	1	INCLUDED	WSHR LK #4 INTL STAR STL
6	3	IN KIT	SCR PN P 4-40X3/16 SS
7	1	005-0799	SCR PN P 4-40X3/8 SS
8	2		NUT HX PLAIN, #6-32 UNC
9	1	405-1568	DECAL FRONT AIRCRAFTER
10	1	431-2055	WASHER DELRIN TURNTABLE
11	1	435-1344	SHEET METAL TOP AIRCRAFTER TURNTABLE
12	1	435-1346	RUBBER COVER LEVER AIRCRAFTER TURNTABLE
13	1	435-1347	LEVER COVER AIRCRAFTER T-250

			
WARNING	<ul style="list-style-type: none"> Do not touch electrically live parts or electrode with skin or wet clothing. Insulate yourself from work and ground. 	<ul style="list-style-type: none"> Keep flammable materials away. 	<ul style="list-style-type: none"> Wear eye, ear and body protection.
Spanish AVISO DE PRECAUCION	<ul style="list-style-type: none"> No toque las partes o los electrodos bajo carga con la piel o ropa mojada. Aislese del trabajo y de la tierra. 	<ul style="list-style-type: none"> Mantenga el material combustible fuera del área de trabajo. 	<ul style="list-style-type: none"> Protéjase los ojos, los oídos y el cuerpo.
French ATTENTION	<ul style="list-style-type: none"> Ne laissez ni la peau ni des vêtements mouillés entrer en contact avec des pièces sous tension. Isoler-vous du travail et de la terre. 	<ul style="list-style-type: none"> Gardez à l'écart de tout matériel inflammable. 	<ul style="list-style-type: none"> Protégez vos yeux, vos oreilles et votre corps.
German WARNUNG	<ul style="list-style-type: none"> Berühren Sie keine stromführenden Teile oder Elektroden mit Ihrem Körper oder feuchter Kleidung! Isolieren Sie sich von den Elektroden und dem Erdboden! 	<ul style="list-style-type: none"> Entfernen Sie brennbares Material! 	<ul style="list-style-type: none"> Tragen Sie Augen-, Ohren- und Körperschutz!
Portuguese ATENÇÃO	<ul style="list-style-type: none"> Não toque partes elétricas e electrodos com a pele ou roupa molhada. Isole-se da peça e terra. 	<ul style="list-style-type: none"> Mantenha inflamáveis bem guardados. 	<ul style="list-style-type: none"> Use proteção para a vista, ouvido e corpo.
Japanese 注意事項	<ul style="list-style-type: none"> 通電中の電気部品、又は溶材にヒフやぬれた布で触れないこと。 施工物やアースから身体が絶縁されている様にして下さい。 	<ul style="list-style-type: none"> 燃えやすいものの側での溶接作業は絶対にしてはなりません。 	<ul style="list-style-type: none"> 目、耳及び身体に保護具をして下さい。
Chinese 警告	<ul style="list-style-type: none"> 皮肤或湿衣物切勿接觸帶電部件及錫條。 使你自已與地面和工件絕緣。 	<ul style="list-style-type: none"> 把一切易燃物品移離工作場所。 	<ul style="list-style-type: none"> 佩戴眼、耳及身體勞動保護用具。
Korean 위험	<ul style="list-style-type: none"> 전도체나 용접봉을 젖은 환경 또는 피부로 절대 접촉치 마십시오. 모재와 접지를 접촉치 마십시오. 	<ul style="list-style-type: none"> 인화성 물질을 접근 시키지 마십시오. 	<ul style="list-style-type: none"> 눈, 귀와 몸에 보호장구를 착용하십시오.
Arabic تحذير	<ul style="list-style-type: none"> لا تلمس الأجزاء التي يمر بها التيار الكهربائي أو الأقطاب بجلد الجسم أو بالمعاطن المبللة بالماء. ضع عازلاً على جسمك خلال العمل. 	<ul style="list-style-type: none"> ضع المواد القابلة للاشتعال في مكان بعيد. 	<ul style="list-style-type: none"> ضع أدوات وملابس واقية على عينيك وأذنيك وجسمك.

READ AND UNDERSTAND THE MANUFACTURER'S INSTRUCTION FOR THIS EQUIPMENT AND THE CONSUMABLES TO BE USED AND FOLLOW YOUR EMPLOYER'S SAFETY PRACTICES.

SE RECOMIENDA LEER Y ENTENDER LAS INSTRUCCIONES DEL FABRICANTE PARA EL USO DE ESTE EQUIPO Y LOS CONSUMIBLES QUE VA A UTILIZAR, SIGA LAS MEDIDAS DE SEGURIDAD DE SU SUPERVISOR.

LISEZ ET COMPRENEZ LES INSTRUCTIONS DU FABRICANT EN CE QUI REGARDE CET EQUIPMENT ET LES PRODUITS A ETRE EMPLOYES ET SUIVEZ LES PROCEDURES DE SECURITE DE VOTRE EMPLOYEUR.

LESEN SIE UND BEFOLGEN SIE DIE BETRIEBSANLEITUNG DER ANLAGE UND DEN ELEKTRODENEINSATZ DES HERSTELLERS. DIE UNFALLVERHÜTUNGSVORSCHRIFTEN DES ARBEITGEBERS SIND EBENFALLS ZU BEACHTEN.

			
<ul style="list-style-type: none"> ● Keep your head out of fumes. ● Use ventilation or exhaust to remove fumes from breathing zone. 	<ul style="list-style-type: none"> ● Turn power off before servicing. 	<ul style="list-style-type: none"> ● Do not operate with panel open or guards off. 	WARNING
<ul style="list-style-type: none"> ● Los humos fuera de la zona de respiración. ● Mantenga la cabeza fuera de los humos. Utilice ventilación o aspiración para gases. 	<ul style="list-style-type: none"> ● Desconectar el cable de alimentación de poder de la máquina antes de iniciar cualquier servicio. 	<ul style="list-style-type: none"> ● No operar con panel abierto o guardas quitadas. 	Spanish AVISO DE PRECAUCION
<ul style="list-style-type: none"> ● Gardez la tête à l'écart des fumées. ● Utilisez un ventilateur ou un aspirateur pour ôter les fumées des zones de travail. 	<ul style="list-style-type: none"> ● Débranchez le courant avant l'entretien. 	<ul style="list-style-type: none"> ● N'opérez pas avec les panneaux ouverts ou avec les dispositifs de protection enlevés. 	French ATTENTION
<ul style="list-style-type: none"> ● Vermeiden Sie das Einatmen von Schweißrauch! ● Sorgen Sie für gute Be- und Entlüftung des Arbeitsplatzes! 	<ul style="list-style-type: none"> ● Strom vor Wartungsarbeiten abschalten! (Netzstrom völlig öffnen; Maschine anhalten!) 	<ul style="list-style-type: none"> ● Anlage nie ohne Schutzgehäuse oder Innenschutzverkleidung in Betrieb setzen! 	German WARNUNG
<ul style="list-style-type: none"> ● Mantenha seu rosto da fumaça. ● Use ventilação e exaustão para remover fumo da zona respiratória. 	<ul style="list-style-type: none"> ● Não opere com as tampas removidas. ● Desligue a corrente antes de fazer serviço. ● Não toque as partes elétricas nuas. 	<ul style="list-style-type: none"> ● Mantenha-se afastado das partes moventes. ● Não opere com os painéis abertos ou guardas removidas. 	Portuguese ATENÇÃO
<ul style="list-style-type: none"> ● ヒュームから顔を離すようにして下さい。 ● 換気や排煙に十分留意して下さい。 	<ul style="list-style-type: none"> ● メンテナンス・サービスに取りかかる際には、まず電源スイッチを必ず切って下さい。 	<ul style="list-style-type: none"> ● パネルやカバーを取り外したまま機械操作をしないで下さい。 	Japanese 注意事項
<ul style="list-style-type: none"> ● 頭部遠離煙霧。 ● 在呼吸區使用通風或排風器除煙。 	<ul style="list-style-type: none"> ● 維修前切斷電源。 	<ul style="list-style-type: none"> ● 儀表板打開或沒有安全罩時不準作業。 	Chinese 警告
<ul style="list-style-type: none"> ● 얼굴로부터 용접가스를 멀리하십시오. ● 호흡지역으로부터 용접가스를 제거하기 위해 가스제거기나 통풍기를 사용하십시오. 	<ul style="list-style-type: none"> ● 보수전에 전원을 차단하십시오. 	<ul style="list-style-type: none"> ● 관널이 열린 상태로 작동치 마십시오. 	Korean 위험
<ul style="list-style-type: none"> ● بعد رأسك بعيداً عن الدخان. ● استعمل التهوية أو جهاز ضغط الدخان للخارج لكي تبعد الدخان عن المنطقة التي تتنفس فيها. 	<ul style="list-style-type: none"> ● قطع التيار الكهربائي قبل القيام بأية صيانة. 	<ul style="list-style-type: none"> ● لا تشغيل هذا الجهاز إذا كانت الاغطية الحديدية الوالفة ليست عليه. 	Arabic تحذير

LEIA E COMPREENDA AS INSTRUÇÕES DO FABRICANTE PARA ESTE EQUIPAMENTO E AS PARTES DE USO, E SIGA AS PRÁTICAS DE SEGURANÇA DO EMPREGADOR.

使う機械や溶材のメーカーの指示書をよく読み、まず理解して下さい。そして貴社の安全規定に従って下さい。

請詳細閱讀並理解製造廠提供的說明以及應該使用的銀焊材料，並請遵守貴方的有關勞動保護規定。

이 제품에 동봉된 작업지침서를 숙지하시고 귀사의 작업자 안전수칙을 준수하시기 바랍니다.

اقرأ بتمعن وافهم تعليمات المصنع المنتج لهذه المعدات والمواد قبل استعمالها واتبع تعليمات الوقاية لصاحب العمل.

LIMITED WARRANTY

This warranty supersedes all previous MK Products warranties and is exclusive, with no other guarantees or warranties expressed or implied.

LIMITED WARRANTY - MK Products Inc., Irvine, California warrants that all new and unused equipment furnished by MK Products is free from defects in workmanship and material as of the time and place of delivery by MK Products. No warranty is made by MK Products with respect to trade accessories or other items manufactured by others. Such trade accessories and other items are sold subject to the warranties of their respective manufacturers, if any.

MK Products' warranty does not apply to components having normal useful life of less than one (1) year, such as relay points, wire conduit, tungsten, and welding gun parts that come in contact with the welding wire, including gas cups, gas cup insulators, and contact tips where failure does not result from defect in workmanship or material.

MK Products shall, exclusively remedy the limited warranty or any duties with respect to the quality of goods, based upon the following options:

- (1) repair
- (2) replacement
- (3) where authorized in writing by MK Products, the reasonable cost of repair or replacement at our Irvine, California plant.

As a matter of general policy only, MK Products may honor an original user's warranty claims on warranted equipment in the event of failure resulting from a defect within the following periods from the date of delivery of equipment to the original user:

1. Power Supplies and Wire Feed Cabinets 3 years
2. Weldheads, Coolers, Positioners, and Push-Pull Guns ... 1 year
3. Spool Guns, and Spool Gun Modules 180 days
4. Repairs/Exchanges/Parts 90 days

Classification of any item into the foregoing categories shall be at sole discretion of MK Products. Notification of any failure must be made in writing within 30 days of such failure.

A copy of the invoice showing the date of sale must accompany product returned for warranty repair or replacement.

All equipment returned to MK Products for service must be properly packaged to guard against damage from shipping. MK Products will not be responsible for any damages resulting from shipping.

Normal surface transportation charges (one way) for products returned for warranty repair or replacement will be borne by MK Products, except for products sold to foreign markets.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTEE, OR REPRESENTATION AS TO PERFORMANCE AND ANY REMEDY FOR BREACH OF CONTRACT WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE, OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR OF FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY MK PRODUCTS, IS EXCLUDED AND DISCLAIMED BY MK PRODUCTS.

EXCEPT AS EXPRESSLY PROVIDED BY MK PRODUCTS IN WRITING, MK'S PRODUCTS ARE INTENDED FOR ULTIMATE PURCHASE BY COMMERCIAL/INDUSTRIAL USERS AND FOR OPERATION BY PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT AND NOT FOR CONSUMERS OR CONSUMER USE. MK PRODUCTS' WARRANTIES DO NOT EXTEND TO, AND NO RESELLER IS AUTHORIZED TO EXTEND MK PRODUCTS' WARRANTY TO ANY CONSUMER.

USE OF OTHER THAN **GENUINE** MK PRODUCTS' CONSUMABLES, PARTS, AND ACCESSORIES MAY INVALIDATE YOUR PRODUCT WARRANTY.



16882 Armstrong Ave.
Irvine, CA 92606
Tel (949)863-1234
Fax (949)474-1428
www.mkproducts.com

August 1, 2010

THIS PAGE INTENTIONALLY BLANK



PRODUCTS

16882 Armstrong Ave.

Irvine, CA 92606

Tel (949)863-1234 Fax (949)474-1428

www.mkproducts.com