

METAL MAN[®]

WORK GEAR

THREE-TIER WELDING CART & CABINET

OWNER'S MANUAL



10/2016



WARNING:

Read carefully and understand all **ASSEMBLY AND OPERATION INSTRUCTIONS** before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

WARRANTY

METAL MAN WORK GEAR CO

EFFECTIVE JANUARY 1, 2013

LIMITED WARRANTY

This warranty applies to the original purchaser and is subject to the terms and conditions listed below. This Limited Warranty is for new equipment sold after the above date, providing coverage for defects in material and workmanship at the time it is shipped from the factory.

Limited to the warranty periods below, Metal Man Work Gear Co will repair or replace the item under warranty that fails due to defects in material and workmanship. Metal Man Work Gear must be notified within 30 days of the failure, so as to provide instructions on how to proceed with the repair of your welder and warranty claim processing. Warranty period begins at the time the welder is purchased from and Authorized Reseller of Metal Man Work Gear Co. products. **Keep your receipt as proof of purchase.**

Warranty Periods

Limited Warranty is divided into three categories. No Warranty, 90 days, 1 year and 3 year.

No Warranty

Normal wear items, MIG gun parts (contact tips, nozzle, contact tip adapter, MIG gun liner), drive roll, electrode holder, ground clamps, Plasma torch parts (nozzle, electrode, diffuser, cover) are considered consumable items and are not covered under warranty.

90 days

Parts for Metal Man Work Gear welding carts and welding cabinets. This warranty covers the absence of or defective parts.

1 year

Parts and Labor on MIG gun parts (except those listed under normal wear items), cables, regulator, and plasma torch (except those listed under normal wear items). Any shipping related to warranty repair is the responsibility of the customer.

1 year/3 year

Please see your product information to determine if your product has a 1 year or 3 year warranty. This warranty covers parts and Labor on items such as: transformer, reactor, rectifier, solenoid valve, PC Board, switches, controls, gas valve, drive motor, drive system other than drive roll and any other component that requires the removal of the sheet metal to access. Any shipping related to warranty repair is the responsibility of the customer.

Voiding Warranty

Warranty does not apply to: Shipping Damage, Misuse and abuse of the unit, alteration of the unit in any way.

Warranty Claim

This is a parts and labor warranty. **Do not return your unit to the retailer you purchased it from.** Retain your receipt in the case a warranty claim is needed. No warranty will be provided without the original receipt from an authorized reseller of Metal Man Work Gear Products. To make a warranty claim, call our welder help line at 888-762-4045, M-F 8:00 am to 5:00 PM Central time or email sales@metalmangear.com.

GENERAL SAFETY RULES



WARNING: Read and understand all instructions. Failure to follow all instructions listed below may result in serious injury.



CAUTION: Do not allow persons to operate or assemble this Flux Core 125 until they have read this manual and have developed a thorough understanding of how the Flux Core 125 works.



WARNING: The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions or situations that could occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

SAVE THESE INSTRUCTIONS

IMPORTANT SAFETY CONSIDERATIONS

1.1 Your Welding Environment

- Keep the environment you will be welding in free from flammable materials.
- Always keep a fire extinguisher accessible to your welding environment.
- Always have a qualified person install and operate this equipment.
- Make sure the area is clean, dry and ventilated. Do not operate the welder in humid, wet or poorly ventilated areas.
- Always have your welder maintained by a qualified technician in accordance with local, state and national codes.
- Always be aware of your work environment. Be sure to keep other people, especially children, away from you while welding.
- Keep harmful arc rays shielded from the view of others.
- Mount the welder on a secure bench or cart that will keep the welder secure and prevent it from tipping over or falling.

1.2 Your Welder's Condition

- Check ground cable, power cord and welding cable to be sure the insulation is not damaged. Always replace or repair damaged components before using the welder.
- Check all components to ensure they are clean and in good operating condition before use.

1.3 Use of Your Welder

CAUTION

Do not operate the welder if the output cable, electrode, torch, wire or wire feed system is wet. Do not immerse them in water. These components and the welder must be completely dry before attempting to use them.

- Follow the instructions in this manual.
- Keep welder in the off position when not in use.
- Connect ground lead as close to the area being welded as possible to ensure a good ground.
- Do not allow any body part to come in contact with the welding wire if you are in contact with the material being welded, ground or electrode from another welder.
- Do not weld if you are in an awkward position. Always have a secure stance while welding to prevent accidents. Wear a safety harness if working above ground.
- Do not drape cables over or around your body.
- Wear a full coverage helmet with appropriate shade (see ANSI Z87.1 safety standard) and safety glasses while welding.
- Wear proper gloves and protective clothing to prevent your skin from being exposed to hot metals, UV and IR rays.
- Do not overuse or overheat your welder. Allow proper cooling time between duty cycles.
- Keep hands and fingers away from moving parts and stay away from the drive rolls.
- Do not point MIG gun at any body part of yourself or anyone else.
- Always use this welder in the rated duty cycle to prevent excessive heat and failure.

1.4 Specific Areas of Danger, Caution or Warning



Electrical Shock

▲ WARNING

Electric arc welders can produce a shock that can cause injury or death. Touching electrically live parts can cause fatal shocks and severe burns. While welding, all metal components connected to the wire are electrically hot. Poor ground connections are a hazard, so secure the ground lead before welding.

- Wear dry protective apparel: coat, shirt, gloves and insulated footwear.
- Insulate yourself from the work piece. Avoid contacting the work piece or ground.
- Do not attempt to repair or maintain the welder while the power is on.
- Inspect all cables and cords for any exposed wire and replace immediately if found.
- Use only recommended replacement cables and cords.
- Always attach ground clamp to the work piece or work table as close to the weld area as possible.
- Do not touch the welding wire and the ground or grounded work piece at the same time.
- Do not use a welder to thaw frozen pipes.



Fumes and Gases

▲ WARNING

- Fumes emitted from the welding process displace clean air and can result in injury or death.
- Do not breathe in fumes emitted by the welding process. Make sure your breathing air is clean and safe.
- Work only in a well-ventilated area or use a ventilation device to remove welding fumes from the environment where you will be working.
- Do not weld on coated materials (galvanized, cadmium plated or containing zinc, mercury or barium). They will emit harmful fumes that are dangerous to breathe. If necessary use a ventilator, respirator with air supply or remove the coating from the material in the weld area.
- The fumes emitted from some metals when heated are extremely toxic. Refer to the material safety data sheet for the manufacturer's instructions.
- Do not weld near materials that will emit toxic fumes when heated. Vapors from cleaners, sprays and degreasers can be highly toxic when heated.



UV and IR Arc Rays

▲ DANGER

The welding arc produces ultraviolet (UV) and infrared (IR) rays that can cause injury to your eyes and skin. Do not look at the welding arc without proper eye protection.

- Always use a helmet that covers your full face from the neck to top of head and to the back of each ear.
- Use a lens that meets ANSI standards and safety glasses. For welders under 160 Amps output, use a shade 10 lens; for above 160 Amps, use a shade 12. Refer to the ANSI standard Z87.1 for more information.
- Cover all bare skin areas exposed to the arc with protective clothing and shoes. Flame-retardant cloth or leather shirts, coats, pants or coveralls are available for protection.
- Use screens or other barriers to protect other people from the arc rays emitted from your welding.
- Warn people in your welding area when you are going to strike an arc so they can protect themselves.



Fire Hazards

▲ WARNING

Do not weld on containers or pipes that contain or have had flammable, gaseous or liquid combustibles in them. Welding creates sparks and heat that can ignite flammable and explosive materials.

- Do not operate any electric arc welder in areas where flammable or explosive materials are present.
- Remove all flammable materials within 35 feet of the welding arc. If removal is not possible, tightly cover them with fireproof covers.
- Take precautions to ensure that flying sparks do not cause fires or explosions in hidden areas, cracks or areas you cannot see.
- Keep a fire extinguisher close in the case of fire.
- Wear garments that are oil-free with no pockets or cuffs that will collect sparks.
- Do not have on your person any items that are combustible, such as lighters or matches.
- Keep work lead connected as close to the weld area as possible to prevent any unknown, unintended paths of electrical current from causing electrical shock and fire hazards.
- To prevent any unintended arcs, cut wire back to ¼" stick out after welding.

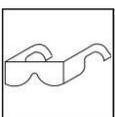


Hot Materials

▲ CAUTION

Welded materials are hot and can cause severe burns if handled improperly.

- Do not touch welded materials with bare hands.
- Do not touch MIG gun nozzle after welding until it has had time to cool down.



Sparks/Flying Debris

▲ CAUTION

Welding creates hot sparks that can cause injury. Chipping slag off welds creates flying debris.

- Wear protective apparel at all times: ANSI-approved safety glasses or shield, welder's hat and ear plugs to keep sparks out of ears and hair.



Electromagnetic Field

⚠ CAUTION

-Electromagnetic fields can interfere with various electrical and electronic devices such as pacemakers.

- Consult your doctor before using any electric arc welder or cutting device
- Keep people with pacemakers away from your welding area when welding.
- Do not wrap cable around your body while welding.
- Wrap MIG gun and ground cable together whenever possible.
- Keep MIG gun and ground cables on the same side of your body.



Shielding Gas Cylinders Can Explode

⚠ WARNING

High pressure cylinders can explode if damaged, so treat them carefully.

- Never expose cylinders to high heat, sparks, open flames, mechanical shocks or arcs.
- Do not touch cylinder with MIG gun.
- Do not weld on the cylinder
- Always secure cylinder upright to a cart or stationary object.
- Keep cylinders away from welding or electrical circuits.
- Use the proper regulators, gas hose and fittings for the specific application.
- Do not look into the valve when opening it.
- Use protective cylinder cap whenever possible

1.5 Proper Care, Maintenance and Repair

⚠ DANGER

- Always have power disconnected when working on internal components.
- Do not touch or handle PC board without being properly grounded with a wrist strap. Put PC board in static proof bag to move or ship.
- Do not put hands or fingers near moving parts such as drive rolls of fan

USE AND CARE

- **Do not modify this unit in any way.** Unauthorized modification may impair the function and/or safety and could affect the life of the equipment. There are specific applications for which this unit was designed.
- **Always check of damaged or worn out parts before using this unit.** Broken parts will affect the operation. Replace or repair damaged or worn parts immediately.
- **Store idle.** When this unit is not in use, store it in a secure place out of the reach of children. Inspect it for good working condition prior to storage and before re-use.

SPECIFICATIONS

Item	Description
Overall Dimensions	32-1/2 in. x 19 in. x 34-1/4 in.
Top Shelf Space	13-1/4 in. x 19 in.
Bottom Shelf Space	13-3/4 in. x 19-3/4 in. x 16-1/2 in. Clearance
Product Weight	45 lbs.
Load Capacity	100 lbs.

DESCRIPTION

The Metal Man Three-Tier Welding Cabinet is a great way to organize your welding tools. The top shelf has ample space for most brands of welders. The shelf is 34 inches off the floor putting your welder at a good working height. The slight backwards slope gives the operator easy view of the welder controls. A reversible tow handle allows you to position it best for your welder. The tall second shelf is well positioned for that second welding tool. Maybe it's a plasma cutter or a small stick welder. This cart allows you to store both welders on one cart. The lockable cabinet at the bottom of the cart gives you secure storage for your welding helmet and other welding accessories.



ASSEMBLY

For Assistance with component identification, please refer to the parts drawing.

1. Place the base panel on a sturdy surface with the side lips facing up. Find the long slots at the back of the base unit. Insert the Axle Clips into the slots from the top, then slide the axle through the large hole in the clip. Repeat for both clips.
2. Slide a wheel on each side.
3. Secure each wheel with a flat washer and cotter pin.
4. Find the left side panel of the cabinet. Align the pre-drilled holes in the lip of the left side panel with the pre-drilled holes in the base of the cabinet. The holes in the front of the cabinet base are where the casters will attach. First secure the left side panel to the base using 4 of the supplied screws. Then repeat for the right side panel of the cabinet.
5. Take a supplied 10 mm bolt and push it through the pre-drilled holes in the lip of the left side panel and through the pre-drilled holes in the base of the cabinet and then through the pre-drilled holes in the flange of the caster. Secure with a 10 mm nut. Repeat for all 4 mounting holes for this caster. Then repeat for the right side caster.
6. Place the middle shelf on top of the side panels. Secure with supplied screws.
7. Using the supplied Philips head bolt, slide on a flat washer and insert it into the pre-drilled holes in the right side of the plastic door hinge. Then insert this assembly into the pre-drilled holes in the front of the cabinet. Add a flat washer, lock washer, and nut onto the back to secure. Repeat for the other right side hole in that hinge. Then repeat for the other hinge.
8. Using the Phillips head bolt, add a flat washer and slide it through the pre-drilled holes in the left side of the hinge and through the pre-drilled holes on the front door. Add a flat washer, lock washer, and nut onto the back to secure. Repeat for the other left side hole in that hinge. Then repeat for the other hinge.
9. Find the left side vertical panel. With the lips out and the wide end to the bottom, align the bottom two pre-drilled holes in the vertical panel with the threaded holes in the cabinet base. They are located right above the left side caster. Secure with a 10 mm bolt in both mounting holes. Do not completely tighten these bolts at this time.
10. Going up the left side vertical panel, align the next two pre-drilled holes with the pre-drilled holes in the lip of the middle shelf. Secure these mounting holes with a 10 mm bolt and a 10 mm nut. Then tighten the bolts in the previous step.
11. Repeat the last two steps to mount the right side vertical panel.
12. Install the vertical cylinder securement panel on the back of the cabinet box. This panel will slide between the cabinet box and the lip of the bottom panel. Align the pre-drilled holes in the left side of the vertical cylinder securement panel and the pre-drilled holes in the lip of the bottom panel with the threaded holes in the cabinet box. You may need to use a small screwdriver to help align all three holes. Slide in a 10 mm bolt and leave it slightly loose at this point. Repeat for the mounting holes on the right side of the vertical cylinder securement panel. Then tighten all four bolts.

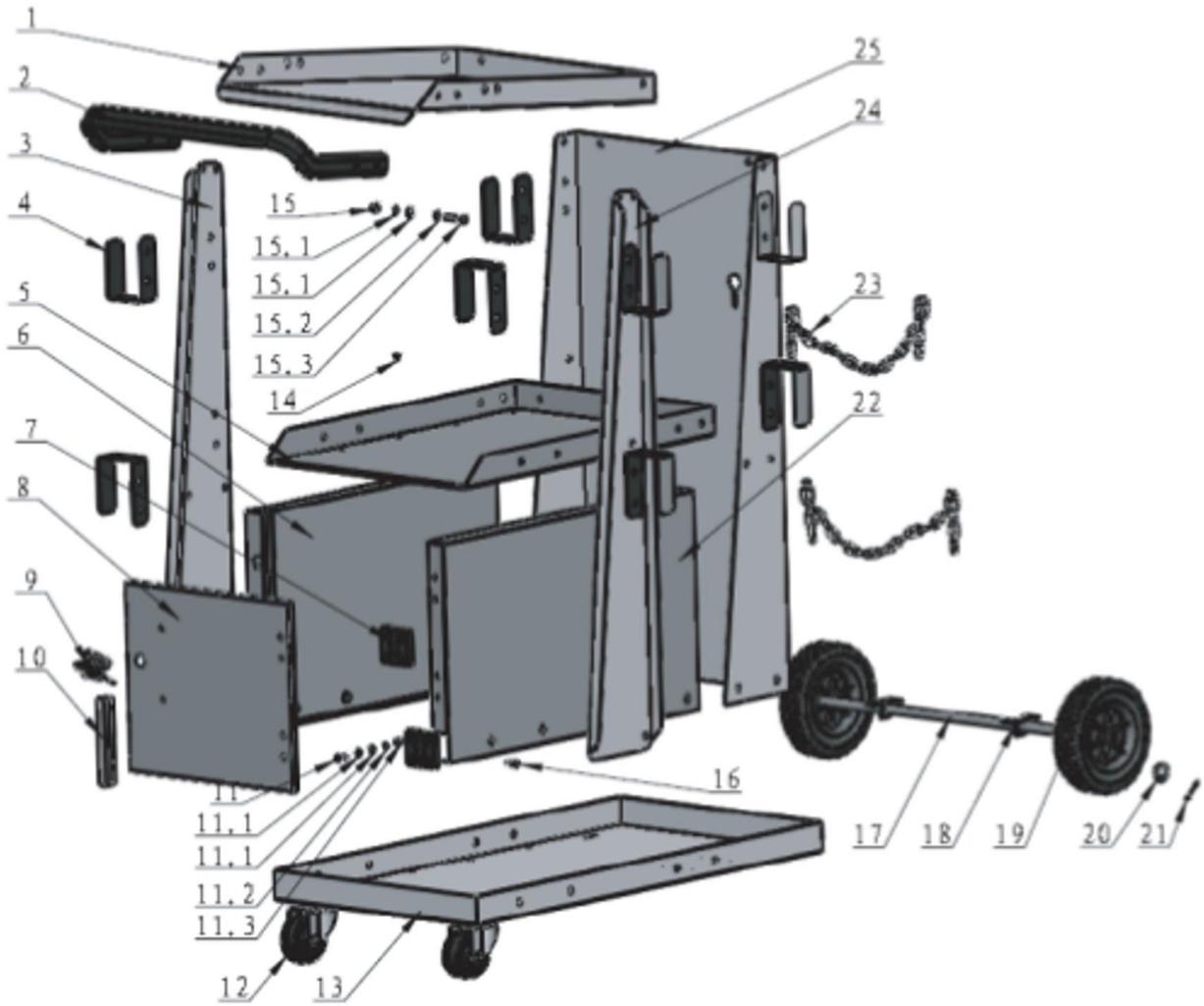
ASSEMBLY (Continued)

13. Going up the vertical cylinder securement panel, align the pre-drilled holes in the left side with the pre-drilled holes in the lip of the middle shelf. Secure each mounting hole with a 10 mm bolt and a nut. Repeat for both holes and then again for the one on the back. Then repeat for all three mounting holes on the right side of the vertical cylinder securement panel.
14. Align the pre-drilled holes on the back of the top shelf lip with the pre-drilled holes in the vertical cylinder securement panel. There is one on the back and one on the side for both the right and left sides. Secure with a 10 mm bolt and a nut. Leave these slightly loose at this time.
15. Align the pre-drilled holes on the front of the top shelf lip with the pre-drilled holes in the front vertical panels. Secure with a 10 mm bolt and a nut. Then tighten all the bolts from the previous step.

NOTE: The tow handle is reversible. The orientation of the handle will vary depending on the equipment and operator preference.

16. Using the longer 10 mm bolts, slide on a flat washer and slide it through one of the pre-drilled holes on the left side of the handle. Then slide it through the matching pre-drilled hole on the left lip of the top shelf. Add a flat washer, lock washer, and secure it with a nut. Leave this nut slightly loose at this time. Repeat for both pre-drilled holes in the left side of the handle. Then repeat for the two mounting holes in the right side of the panel. Then tighten all the nuts holding the handle.
17. You will notice four pre-drilled holes remain in the front vertical panels and on each side of the vertical cylinder securement panel. These mounting holes are for cable wraps. For the top set of holes, the cable wrap should be mounted with the opening up. For the bottom set of holes, the cable wrap should be mounted with the opening down. Using a 10 mm nut, slide it through the pre-drilled holes in the cable wrap and then through the pre-drilled hole in the vertical panel. Secure with a nut. Repeat this for all mounting holes on all eight cable wraps on both side of the cart.
18. Find the 3/4 inch holes in the back of the vertical cylinder securement panel. Place one end of the securement chain in one hole and slide a link down into the bottom groove. Then wrap the chain around the cylinder you are securing and place it in the other 3/4 inch hole on the other side of the cylinder.

DIAGRAM & PARTS LIST



Reference #	Part#	Description	Qty.
1	105100109	TOP SHELF	1
2	105100110	HANDLE	1
3	105100111	LEFT SIDE VERTICAL PANEL	1
4	105100112	CABLE WRAP	8
5	105100113	MIDDLE SHELF	1
6	105100114	LEFT SIDE CABINET PANEL	1
7	105100115	PLASTIC HINGE	2
8	145100004	DOOR	1
9	105100027	LOCK SET	1
10	105100026	DOOR HANDLE	1
11	105100116	PHILLIPS HEAD BOLT M5*16	8
11.1	105100046	FLAT WASHER M5	16
11.2	105100045	LOCK WASHER M5	8
11.3	105100053	HEX NUT M5	8
12	105100009	CASTER 65 MM × 27 MM	2
13	105100117	BASE PANEL	1
14	105100029	SCREW 4.2 MM X 9.5 MM	18
15	105100118	10 MM BOLT LONG M6*30	4
15.1	105100046	FLAT WASHER M6	8
15.2	105100045	LOCK WASHER M6	4
15.3	105100053	HEX NUT M6	4
16	105100119	10 MM BOLT SHORT M6*12	50
17	105100120	AXLE	1
18	105100121	AXLE CLIP	2
19	105100003	WHEEL 150 MM × 35 MM	2
20	105100002	FLAT WASHER M12	4
21	105100001	COTTER PIN 2.5 MM X 25 MM	2
22	105100122	RIGHT SIDE CABINET PANEL	1
23	105100007	CYLINDER SECUREMENT CHAIN 4 MM	2
24	105100123	RIGHT SIDE VERTICAL PANEL	1
25	105100124	VERTICAL CYLINDER SECUREMENT PANEL	1
	145100005	OWNER'S MANUAL	1
	145200001	METAL MAN TECHNICAL HELP STICKER	1

For replacement parts or technical questions, please contact our welder help line at **1-888-762-4045**.

METAL MAN[®]
WORK GEAR

METAL MAN WORK GEAR COMPANY

1760 PROSPECT CT #120

APPLETON WI 54914

www.metalmangear.com

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