



Thermadyne Holdings Corporation
Suite 300, 16052 Swingley Ridge Road
St. Louis, MO 63017, USA
Telephone: 1-800-426-1888 • Fax: 1-800-535-0557
Email: sales@thermalarc.com
www.thermalarc.com

Welding Equipment Basic Utility Cart for Fabricator 181i / 211i / 252i

Part Number: W4014700

Assembly Instructions



WARNING

Maximum Gas Cylinder 9" (230mm) Diameter.



WARNING

Do Not Lift Cart with Power Source, Gas Cylinder or any other equipment attached.

NOTE

Power Source MUST be mounted onto base assembly before mounting wire feeder to handle assembly.



WARNING

Do Not Exceed a maximum weight of 110 lb (50 kg) on the top shelf of the base assembly.

Do Not Exceed a maximum weight of 88 lb (40 kg) on the bottom shelf.



CAUTION

Do Not Exceed the Cart total load capacity of 298 lb (135 kg).

General Information

The Thermal Arc Welding Equipment Basic Utility Cart is specifically designed for the Fabricator 181i/211i/252i to allow easy transport for the power source, gas cylinder*, welding torch and various accessories. These instructions will guide you through the proper assembly procedure of the cart.

*Maximum Gas Cylinder 9" (230 mm) Diameter.

Recommended Tools







- Metric Hex Key Size 4 and 6
- Open End Wrench Metric 19mm-22mm or 8" Adjustable Wrench
- Pliers

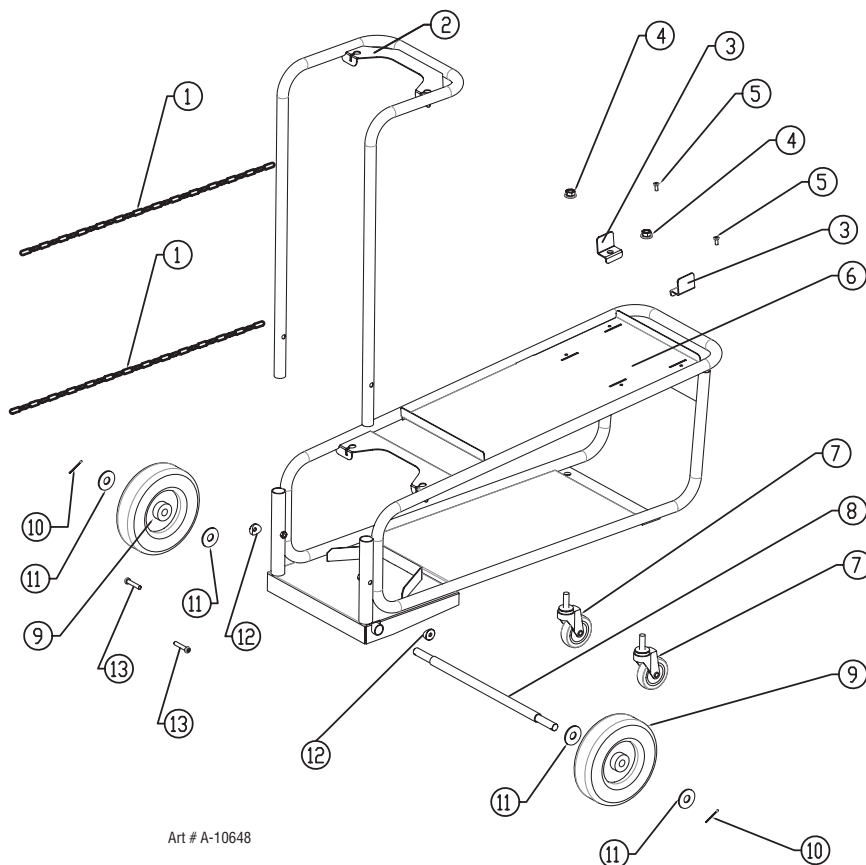
This page left blank intentionally

WELDING EQUIPMENT BASIC UTILITY CART ASSEMBLY INSTRUCTIONS

Supplied Parts

The following components are included in this kit:

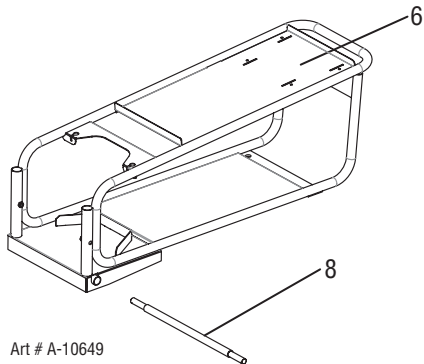
Item	Description	Qty	
1	CHAIN, .16" x 1.36" x 28"	2	
3	SIDE BRACKET	2	
4	HEXAGON NUT WITH FLANGE, M6	2	
5	SCREW, M6 X 16mm TORQUE FORCE: 14 - 17 ft lb (19 - 23 N.m)	2	
6	BASE ASSEMBLY	1	
7	CASTOR	2	
8	AXLE	1	
9	WHEEL	2	
10	COTTER PIN	2	
11	PLAIN WASHER	4	
12	SADDLE WASHER	2	
13	BOLT, M8 X 40 TORQUE FORCE: 19 - 22 ft lb (26 - 30 N.m)	2	



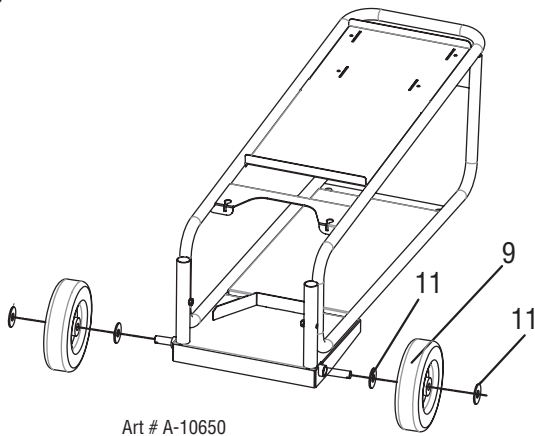
Art # A-10648

WELDING EQUIPMENT BASIC UTILITY CART ASSEMBLY INSTRUCTIONS**A. Insert Axle**

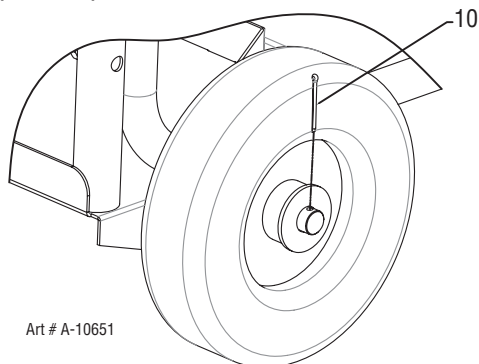
Insert the axle (8) through the holes in the bottom of the base assembly (6).

**B. Install Wheels on Axle**

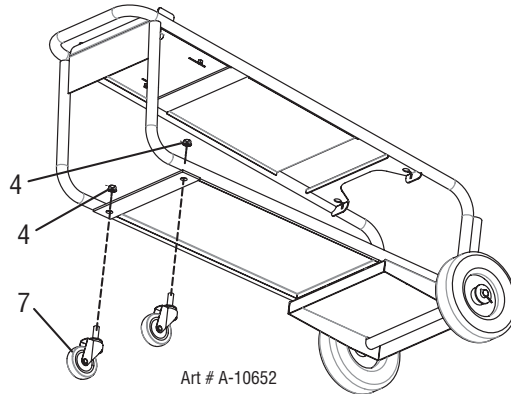
1. Attach a plain washer (11) to the axle.
2. Slide a wheel (9) over the axle followed by a washer (11) as shown.

**C. Install Wheels**

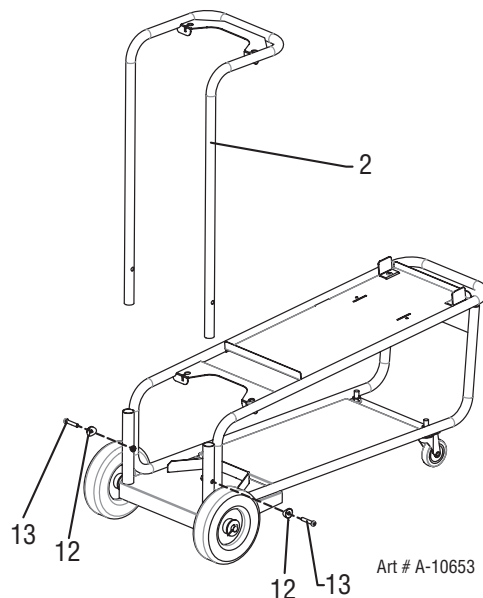
1. Insert a cotter pin (10) through the hole in the axle from the top down as shown.
2. Spread the cotter pin apart by using a pair of pliers.
3. Repeat steps B and C with the other wheel.

**D. Install Castors**

1. Insert a castor (7) through the hole in the bottom of the base assembly.
2. Fasten the castor using the castor nut (4) as shown.
3. Install the other castor following steps 1 and 2.

**E. Attach Handle Assembly**

1. Attach handle assembly (2) to base assembly and line up its 2 holes with the 2 holes in the base assembly.
2. Fasten the handle assembly using saddle washers (12) and bolts (13) as shown.

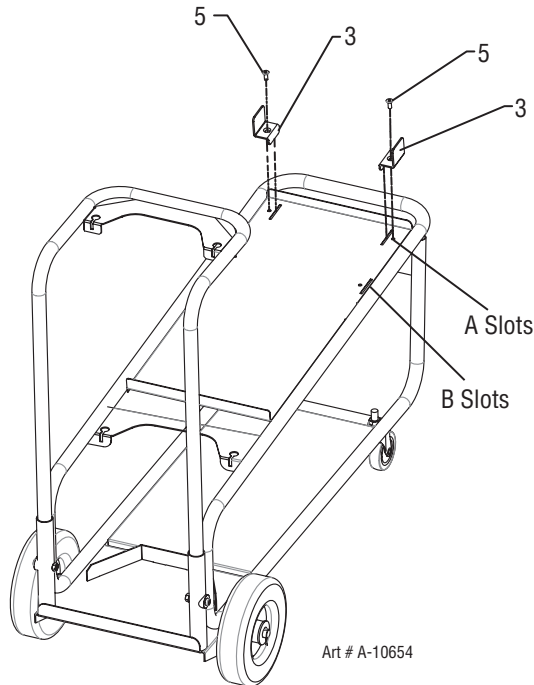


WELDING EQUIPMENT BASIC UTILITY CART ASSEMBLY INSTRUCTIONS

F. Install Side Brackets

1. Insert the side brackets (3) into the two slots on the top of the base assembly.
2. Use the screws (5) to fasten the brackets as shown.

A slots are designed for the Fabricator 211i & 252i
 B slots are designed for the Fabricator 181i

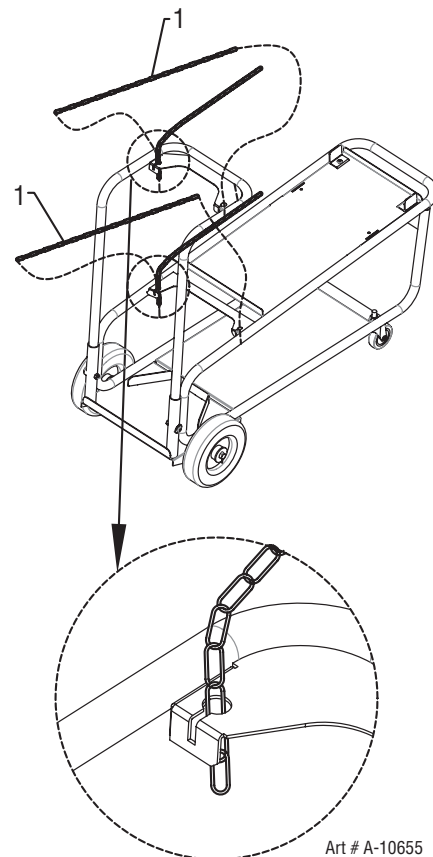


G. Tighten All Hardware

Fully tighten all the fasteners at this time but do not over-tighten. Refer to torque force in supplied parts section.

H. Hang Chain

1. Insert one end of the Chain (1) through the chain hole on the left side of the Handle Assembly and secure it by turning and sliding the second link into the slot (top hole as shown).
2. Wrap the chain around the upper part of the Gas Cylinder and pull the other end through the chain hole on the right side of the Handle Assembly.
3. Pull the chain as tight as it will go and secure it by turning and sliding the closest link into the slot.
4. Wrap and secure the other chain around the lower part of the gas cylinder following steps 1 to 3.



WELDING EQUIPMENT BASIC UTILITY CART ASSEMBLY INSTRUCTIONS**I. Installation of Shielding Gas for MIG (GMAW) or TIG (GTAW) Processes****1. Cylinder positioning**

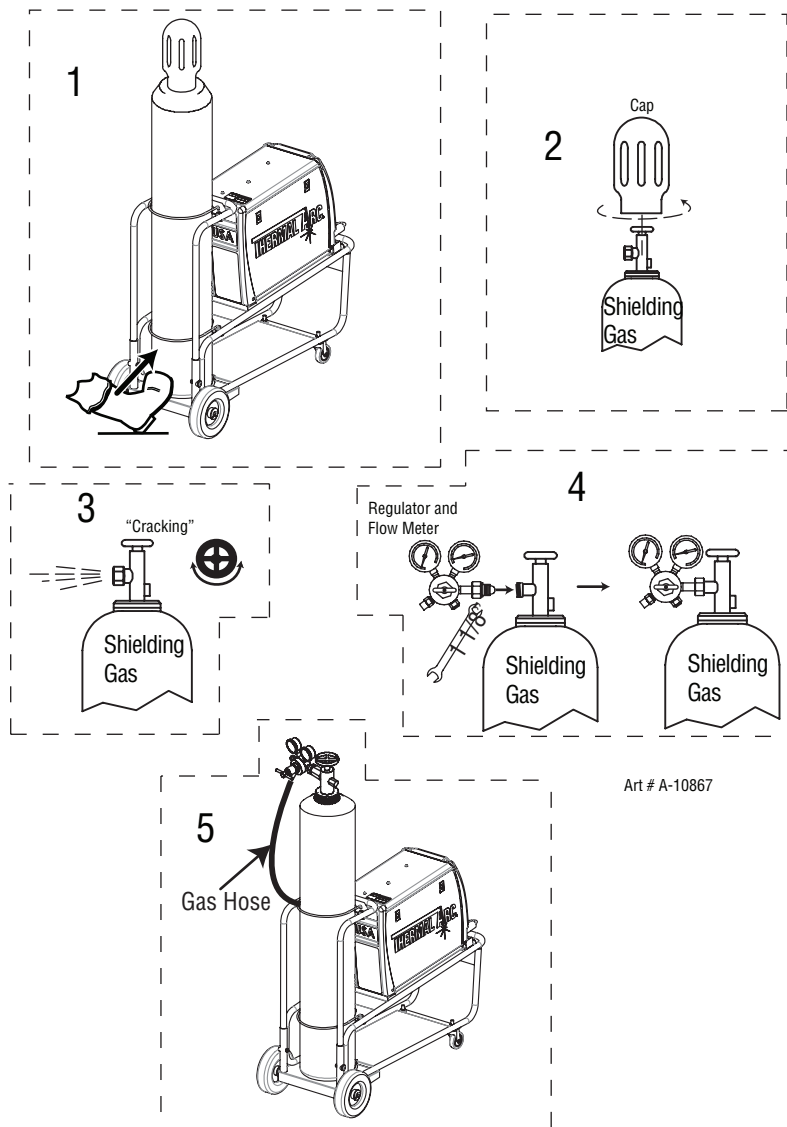
Fit the Power Source to the cart BEFORE attempting to position the cylinder on the cart. Block the wheels of the unit so it cannot roll. Carefully stand the cylinder on the tray and with one foot, press against the bottom of the cylinder to assure it is against the back of the unit. Chain the cylinder in place. Refer to Figure below.

2. Cracking

Remove the large metal cap on top of the cylinder by rotating counter clockwise. Next remove the dust seal. Position yourself so the valve is pointed away from you and quickly open and close the valve for a burst of gas. This is called "Cracking" and is done to blow out any foreign matter that may be lodged in the fitting.

3. Fit Regulator/Flow Meter to cylinders

Screw the gas regulator into the appropriate cylinder. The nuts on the regulator and hose connections are right hand (RH) threaded and need to be turned in a clockwise direction in order to tighten. Tighten with a wrench.



Gas Cylinder Installation

This page left blank intentionally

Printed in: China

U.S. Customer Care: 800-426-1888 / FAX 800-535-0557 • Canada Customer Care: 905-827-4515 / FAX 800-588-1714
International Customer Care: 940-381-1212 / FAX 940-483-8178 • www.thermalarc.com



WORLD HEADQUARTERS: 16052 Swingley Ridge Road, Suite 300 • St. Louis, Missouri 63017 U.S.A.

A Global Cutting & Welding Market Leader™

THE AMERICAS

Denton, TX USA
U.S. Customer Care
Ph: 1-800-426-1888 (tollfree)
Fax: 1-800-535-0557 (tollfree)
International Customer Care
Ph: 1-940-381-1212
Fax: 1-940-483-8178

Miami, FL USA
Sales Office, Latin America
Ph: 1-954-727-8371
Fax: 1-954-727-8376

Oakville, Ontario, Canada
Canada Customer Care
Ph: 1-905-827-4515
Fax: 1-800-588-1714 (tollfree)

EUROPE

Chorley, United Kingdom
Customer Care
Ph: +44 1257-261755
Fax: +44 1257-224800

Milan, Italy
Customer Care
Ph: +39 0236546801
Fax: +39 0236546840

ASIA/PACIFIC

Cikarang, Indonesia
Customer Care
Ph: 6221-8990-6095
Fax: 6221-8990-6096

Rawang, Malaysia
Customer Care
Ph: +603 6092-2988
Fax: +603 6092-1085

Melbourne, Australia
Australia Customer Care
Ph: 1300-654-674 (tollfree)
Ph: 61-3-9474-7400
Fax: 61-3-9474-7391

International
Ph: 61-3-9474-7508
Fax: 61-3-9474-7488

Shanghai, China
Sales Office
Ph: +86 21-64072626
Fax: +86 21-64483032

Singapore
Sales Office
Ph: +65 6832-8066
Fax: +65 6763-5812