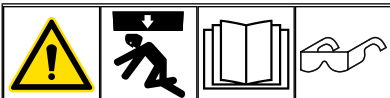


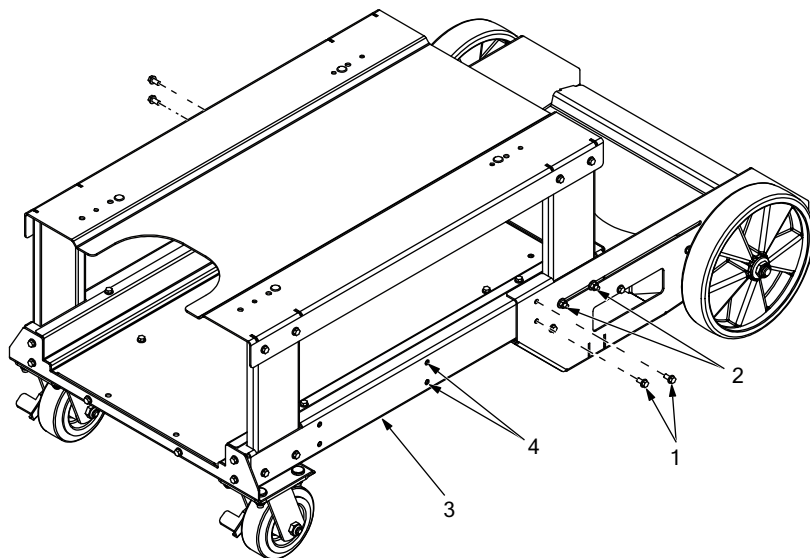
1. Safety Symbol Definitions

	DANGER! - Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text. DANGER! - Indique une situation dangereuse qui, si elle n'est pas évitée, entraînera la mort ou des blessures graves. Les éventuels risques sont représentés par les symboles joints ou expliqués dans le texte.	CALIFORNIA PROPOSITION 65 WARNINGS WARNING: Cancer and Reproductive Harm - www.P65Warnings.ca.gov PROPOSITION CALIFORNIENNE 65 AVERTISSEMENTS AVERTISSEMENT : cancer et troubles de la reproduction - www.P65Warnings.ca.gov.
	Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text. Indique une situation dangereuse qui, si elle n'est pas évitée, entraînera la mort ou des blessures graves. Les éventuels risques sont représentés par les symboles joints ou expliqués dans le texte.	 Falling equipment can injure, and damage equipment. Use lifting eye to lift unit and properly installed accessories only, NOT gas cylinders. Do not exceed maximum lifting eye weight rating. Lift and support unit only with proper equipment and correct procedures. Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication No. 94-110) when manually lifting heavy parts or equipment. Oversized cylinder can cause tipping. Properly install and secure all equipment onto cart before using cart. Always secure or remove any tools stored on cart before moving unit. Do not lift cart in any manner when equipment and cylinder(s) are installed - use handles to move cart. Do not overload handles with cables - use standard 10 to 15 foot cables as maximum lengths. Un appareillage en chute peut blesser le personnel et endommager d'autres appareils. Utiliser l'anneau de levage pour lever l'appareil et les accessoires correctement installés seuls, PAS les bouteilles de gaz. Ne pas dépasser le poids nominal maximal de l'œillet. Soulever et soutenir l'appareil avec le matériel et les procédures appropriées. Lors du levage de pièces ou d'équipements lourds, suivre les recommandations de la dernière révision du manuel des applications de levage du NIOSH (Publication No. 94-110). Les bonbonnes surdimensionnées peuvent causer les renversements. Installer et assujettir adéquatement tout l'équipement sur le chariot avant d'utiliser ce dernier. Toujours assujettir ou retirer les outils rangés sur le chariot avant de déplacer l'unité. Ne jamais soulever le chariot, peu importe la manière, lorsqu'il contient de l'équipement et des bouteilles - utiliser les poignées pour déplacer le chariot. Ne pas surcharger les poignées avec des câbles - utiliser des câbles standard de 3 à 4,5 m (10 à 15 pi).
NOTICE –  AVIS – 	<i>Indicates statements not related to personal injury.</i> <i>Indicates special instructions.</i> <i>Signale des consignes non associées aux dommages corporels.</i> <i>Fournit des instructions spéciales.</i>	
	Have only trained and qualified persons install, operate, or service this unit. Read the safety information at the beginning of these instructions and in each section. Call your distributor if you do not understand the directions. For WELDING SAFETY and EMF information, read owner's manual(s). Ne confiez l'installation, l'exploitation ou l'entretien de cet appareil qu'à des personnes compétentes et qualifiées. Lire les directives de sécurité au début de ces instructions et dans chaque section. Appeler votre distributeur si vous ne comprenez pas les directives. Lire le(s) manuel(s) d'utilisateur pour des renseignements sur la SÉCURITÉ DE SOUDAGE et les champs électromagnétiques.	
	Wear safety glasses with side shields. Porter des lunettes de sécurité avec écrans latéraux.	

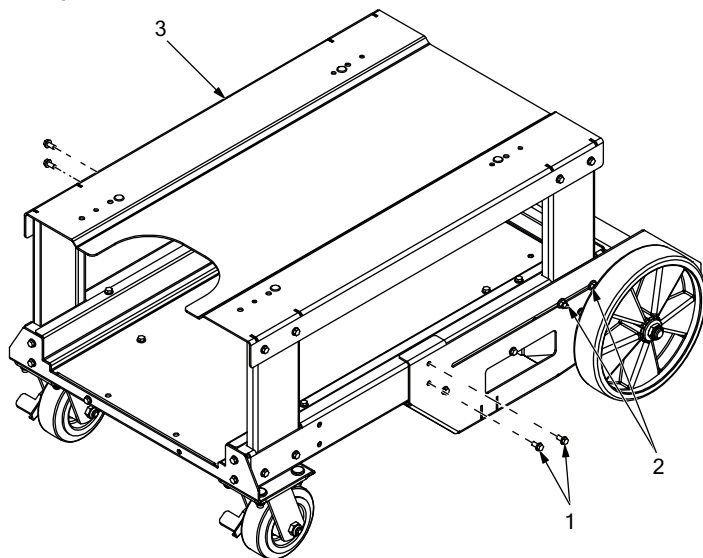
2. Collapsing and Extending Cart



Extended Position



Collapsed Position



 *Cart must remain extended if attaching gas cylinder(s) to cart.*

Cart may be collapsed if gas cylinders are not installed.

If power source is installed when collapsing/extending, weight of cart and power source may be supported to aid in collapsing/extending.

- 1 Screw 250–20 X .50 Hex (4)
- 2 Nut (4)
- 3 Cart
- 4 Screw holes

Remove four screws from cart.

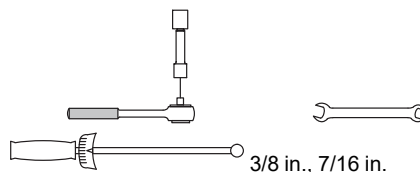
Loosen nuts enough to allow cart to slide together/apart. Do not remove nuts.

Slide two pieces of cart together/apart until screw holes align for collapsed/extended position.

NOTICE – All hardware must be installed and torqued prior to using power source or cart.

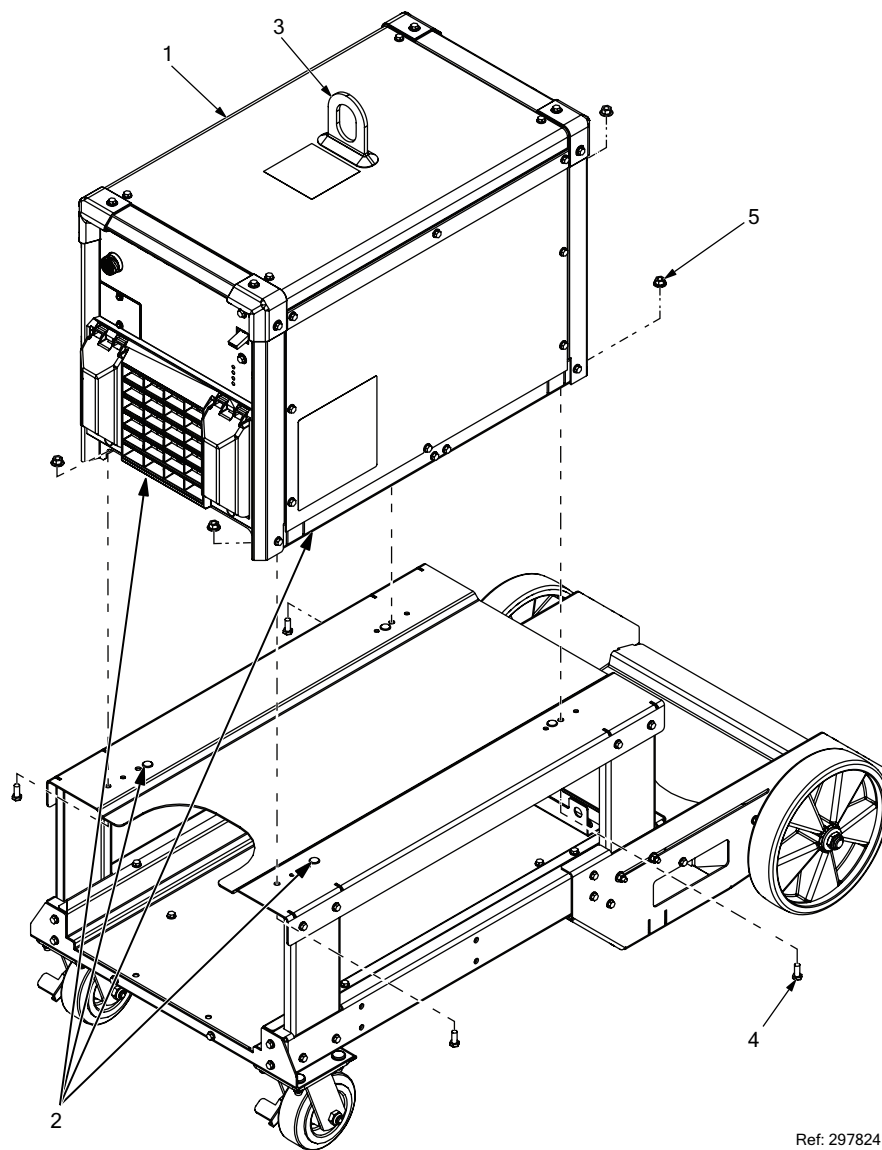
If no threads are present in screw holes, tighten to 70 in lb (7.9 N·m). If threads are present in screw holes, tighten screws to 50 in lb (5.6 N·m).

Tighten four nuts to 60 in lb (6.8 N·m).



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3. Attaching Power Source To Cart



 Masking dots must be removed from cart and power source prior to placing power source on cart.

- 1 Power Source
- 2 Masking Dot (4)
- 3 Lift Eye

Remove two masking dots from cart.

Use lift eye and hoist to raise power source.

Remove two masking dots from power source.

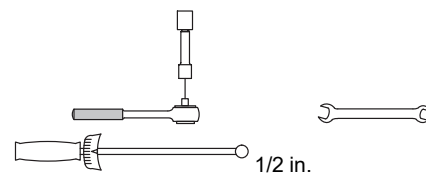
Lower power source onto cart.

- 4 Screw, 5/16 in x .75 in (4)

- 5 Nut (4)

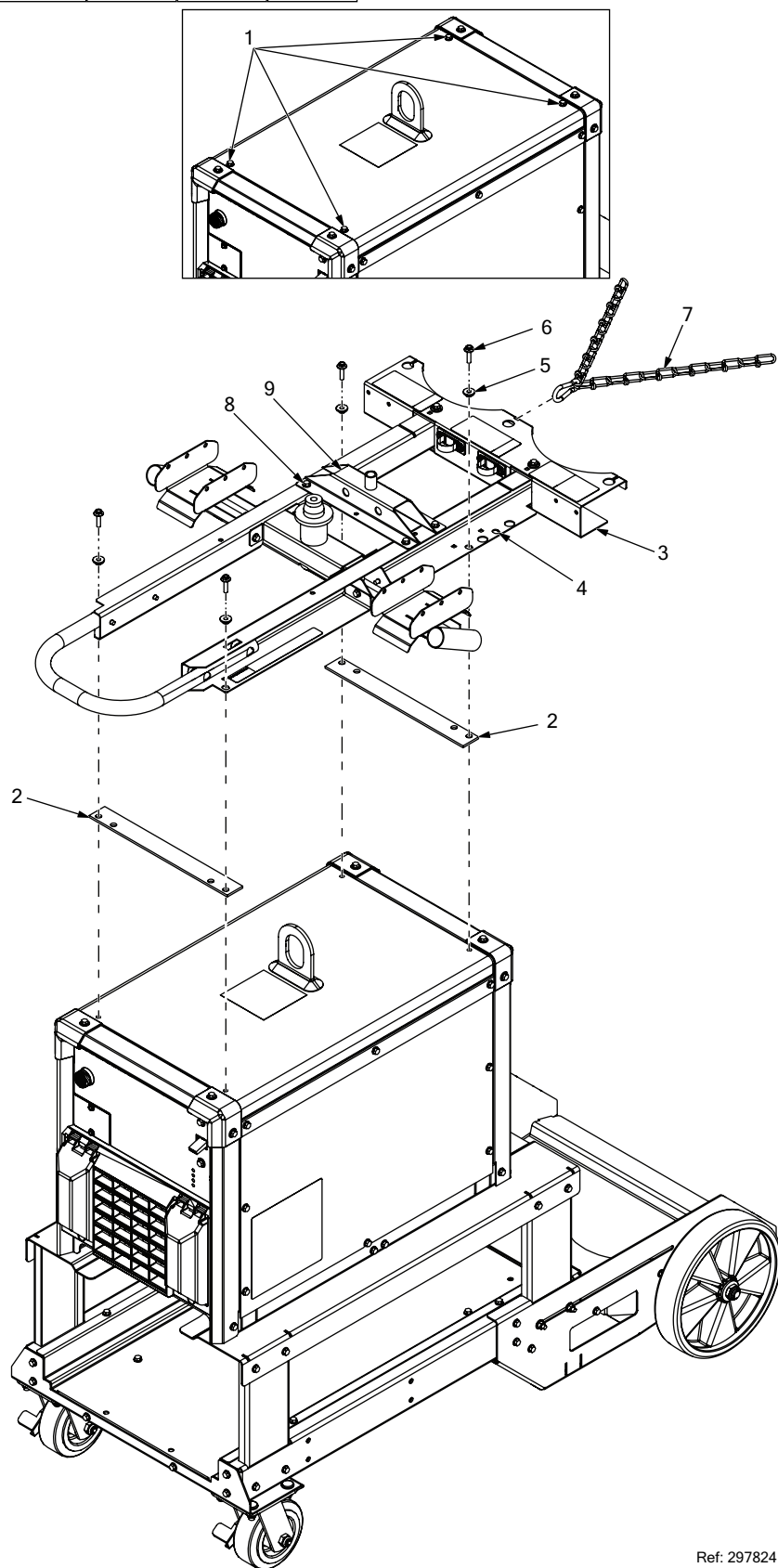
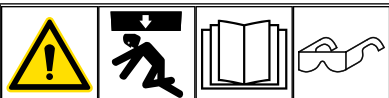
 Screws must be installed from the bottom to allow clearance for optional cooler.

Secure power source to cart using 4 supplied screws and nuts. Tighten nuts to 100 in lb (11.3 N·m).



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4. Attaching Swivel Bracket To Power Source



1 Screw (4)

Remove four screws from top of power source.

Insulators and shoulder washers must be installed.

2 Insulator, Plate Swivel Assy

Place insulators on top of power source.

3 Swivel Assembly

4 Deltaweld 500 mounting holes

Set swivel assembly on top of power source. Align holes in swivel assembly with insulators and holes in power source.

Assembly is shown for Deltaweld 350 models. If using Deltaweld 500 model, use holes in swivel assembly indicated in drawing.

5 Washer, Shoulder Nylon (4)

6 Screw, 250-20 X 1.00 Hex (4)

Insert washers into swivel assembly mounting holes. Use four screws from hardware kit to secure. Torque to 50 in lb (5.6 N·m).

7 Cylinder Chain

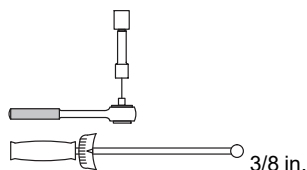
Fasten chain to swivel assembly as shown.

For Dual Feeder Only

8 Screws (4)

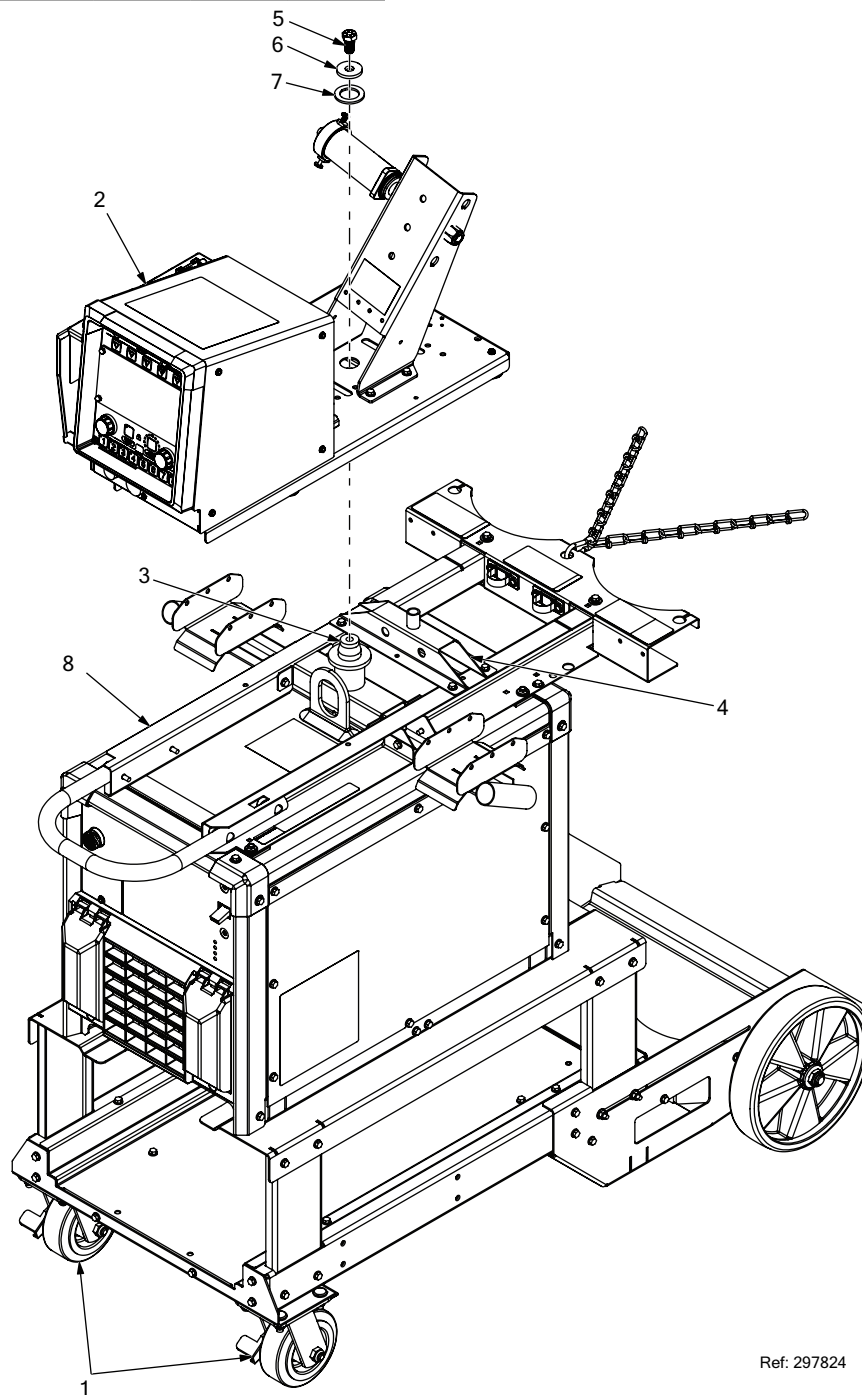
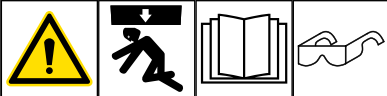
9 Swivel Stop Bracket

Remove four screws and swivel stop bracket from swivel assembly. Discard bracket and screws.



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5. Attaching Single Feeder To Swivel Bracket



- 1 Casters
- 2 Wire Feeder
- 3 Swivel Post
- 4 Swivel Stop Bracket
- 5 1/2 in. Bolt
- 6 Washer
- 7 Spacer
- 8 Swivel Base

Lock casters to prevent cart from moving.

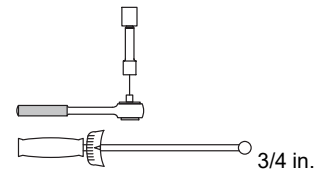
Remove wire feeder and wire feeder Owner's Manual from box. Discard packaging.

Obtain 1/2 in. bolt, washer, and spacer from hardware kit.

Align hole under wire feeder spool support with swivel post on top of cart. Lower feeder onto swivel post.

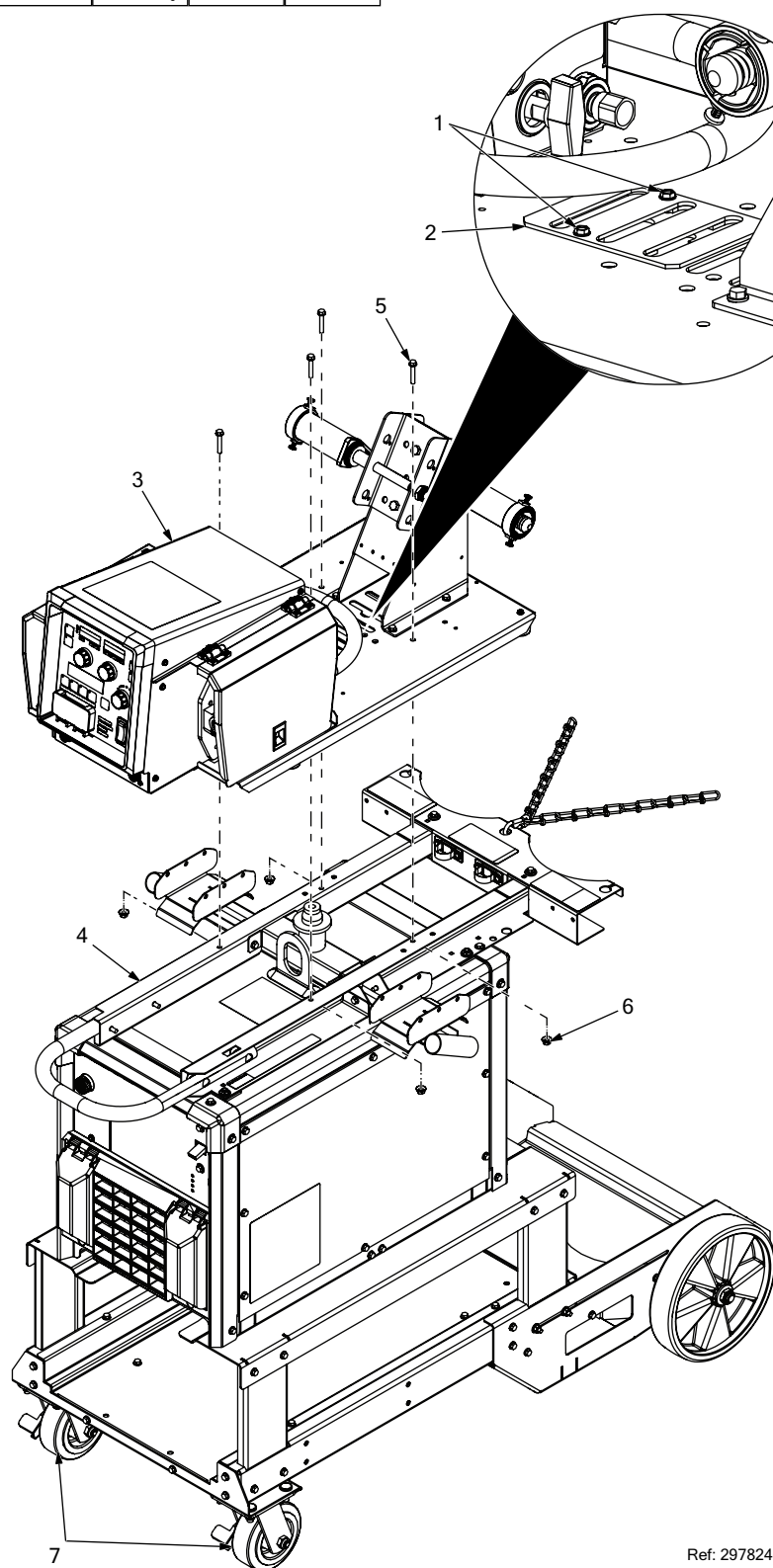
Use 1/2 in. bolt, washer, and spacer to secure feeder to swivel post. Torque to 300 in lb or 25 ft lb (33.9.N·m).

Insert pin through hole in feeder base into swivel stop bracket.



Ref: 297824

6. Attaching Dual Feeder To Swivel Bracket



See Section 4 for information on removing swivel stop from swivel base.

- 1 Screw - 10 x .375 (2)
- 2 Cover Plate
- 3 Dual Wire Feeder
- 4 Swivel Base
- 5 Screw - 1/4 in. X 1-1/2 in. (4)
- 6 Nut (4)
- 7 Casters

Lock casters to prevent cart from moving.

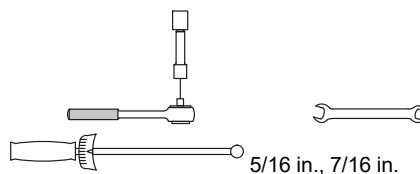
Remove wire feeder and wire feeder Owner's Manual from box. Discard packaging.

Remove the two 10 x .375 screws attaching the cover plate to base of feeder. Discard the screws and cover plate.

Obtain four 1/4 in. X 1-1/2 in. screws and nuts from hardware kit.

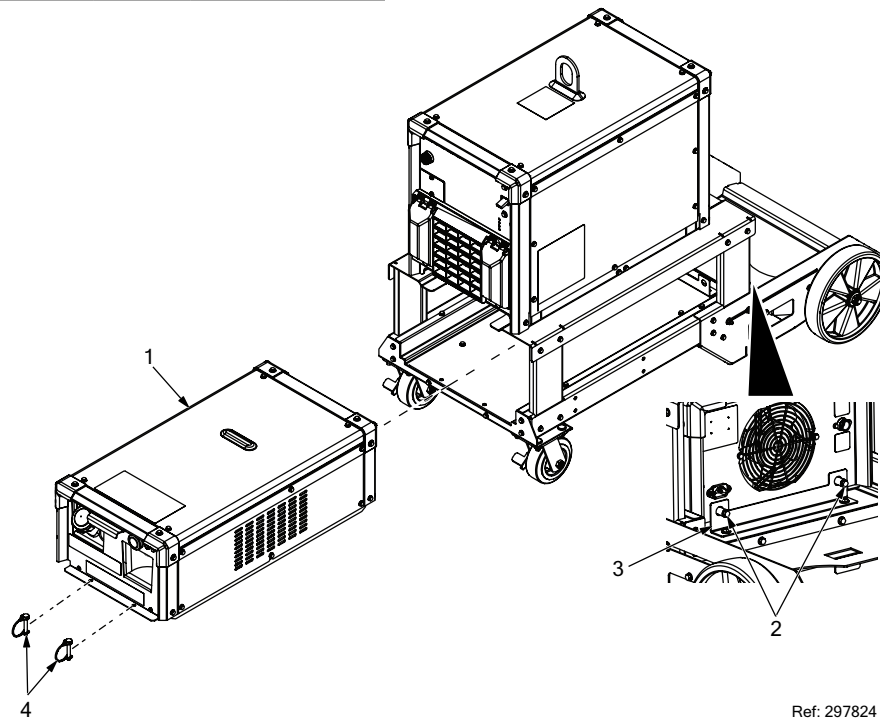
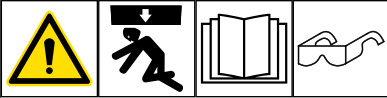
Align larger hole in wire feeder base with swivel post on top of cart. Lower feeder so the swivel post passes thru the hole in base.

Align four holes in wire feeder base and secure with four 1/4 in. X 1-1/2 in. screws and nuts. Tighten nuts to 75 in lb (8.5 N·m).



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7. Installing Optional Cooler



- 1 Optional Cooler
- 2 Guide Posts
- 3 Stop Bracket
- 4 Clevis Pin (2)

 Stop bracket and mounting hardware is supplied with cooler. Install bracket per instructions in cooler Owner's Manual.

Slide cooler into cart until guide posts are fully seated into stop bracket.

Secure with two clevis pins in front.

Ref: 297824

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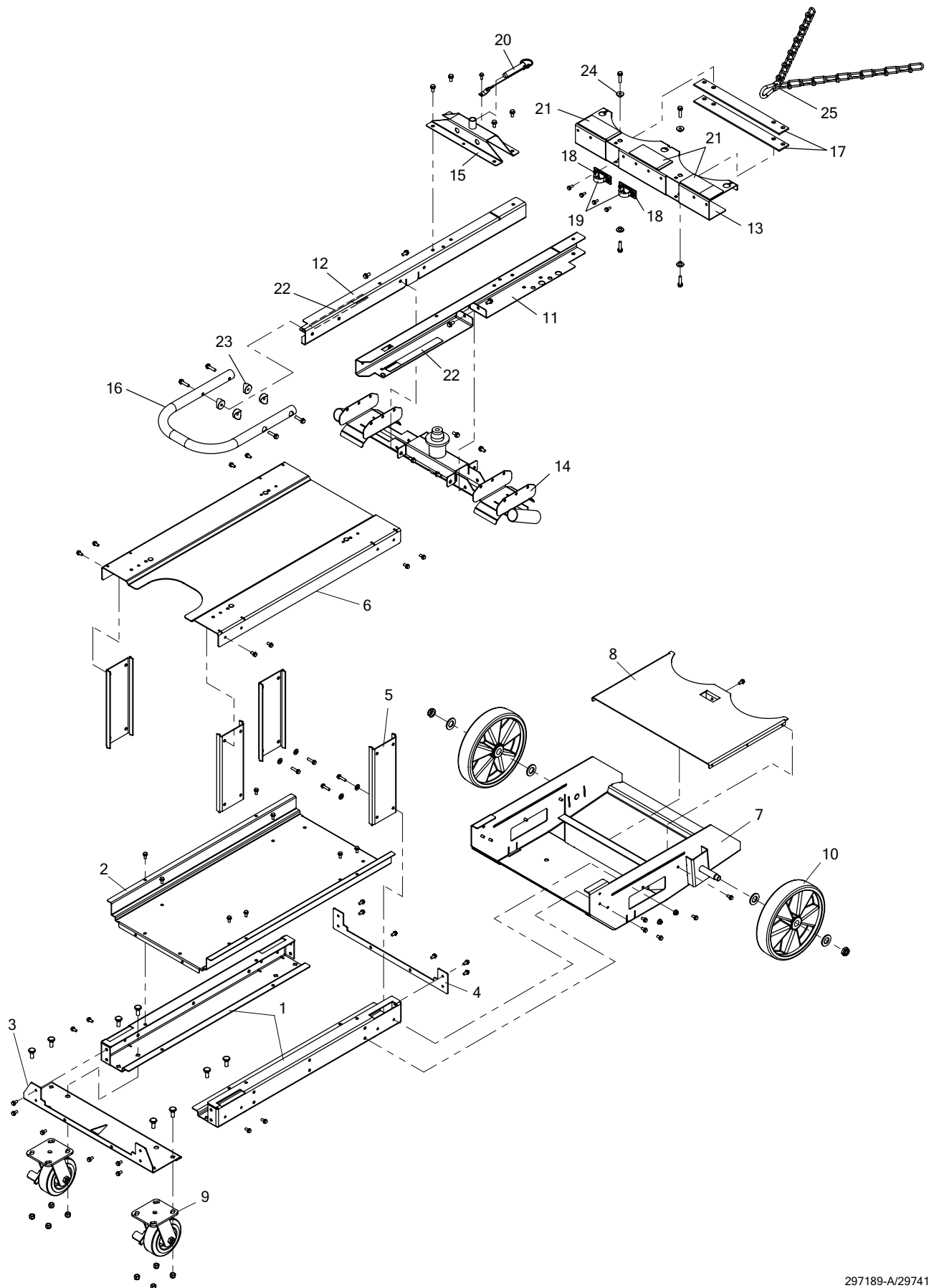


- Route cable between cart and power source, then up through Velcro strap on gas cylinder bracket, and underneath spool support.

- ## 6 Gas Cylinder

See Owner's Manual for your specific welding power source, wire feeder, and other accessories for information on connecting input power and operating equipment.

9. Parts List



297189-A/297418-A

Figure 9-1. Deltaweld Integrated Cart Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
		297189	Base Assy, Cart (Includes)	1
1		297190	—Rail, Cart Frame	2
2		297191	—Base, Cart Frame	1
3		297192	—Bracket, Caster	1
4		297193	—Plate, Rear	1
5		297194	—Upright, Base Cart	4
6		297195	—Top, Cart W/Cable Clearance	1
7		297196	—Tray Assy, Gas Lower Welded	1
8		297206	—Bracket, Lower Dual Cylinder	1
9		263925	—Caster, Swvl 5.00 In X 2.00 In Wd W/Brake	2
10		263859	—Wheel, Rbr 10.000 Od X 2.000 Wd X .750 Bore Blk Hub	2
		297418	Swivel Assy (Includes)	1
11		+297420	—Rail, Feeder Swivel Rh	1
12		+297421	—Rail, Feeder Swivel Lh	1
13		+297422	—Bracket, Upper Dual Cylinder	1
14		297423	—Swivel Assy, Welded	1
15		297429	—Assy, Swivel Stop	1
16		297433	—Handle, Tube	1
17		298064	—Insulator,	2
18		287211	—Holder, Tie Grip	2
19		287210	—Strap, Velcro .500 Wide X 8.000 Lg Black	2
20		281549	—Pin, Quick Release W/Lanyard .500 Od X 2.000 Lg Sst	1
21		298021	—Label, Warning Cyl May Explode If Damaged (En/Sp/Fr)	1
22		298065	—Label, Warning Falling Equipment (En/Fr/Sp)	2
23		283113	—Spacer, Nylon 1.000 Od X .260 Id X .250 Lg Tube Blk	4
24		280966	—Washer, Shldr .266 Id 0.750 Od X .093t .380 Od X .218lg Nyl	4
25		206117	Chain, Cyl Double	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.