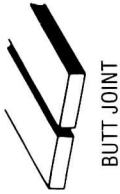


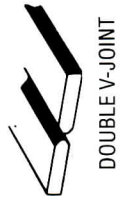
## TYPES OF JOINTS



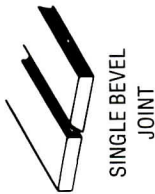
BUTT JOINT



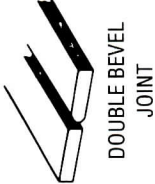
SINGLE V-JOINT



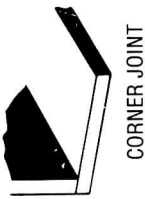
DOUBLE V-JOINT



SINGLE BEVEL JOINT



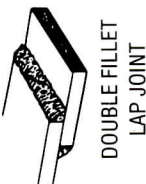
DOUBLE BEVEL JOINT



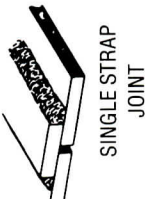
CORNER JOINT



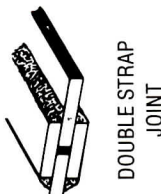
SINGLE FILLET LAP JOINT



DOUBLE FILLET LAP JOINT



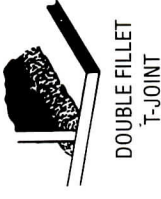
SINGLE STRAP JOINT



DOUBLE STRAP JOINT



SINGLE FILLET T-JOINT



DOUBLE FILLET T-JOINT

2 to 3 mm.



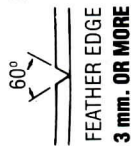
CLOSED JOINT



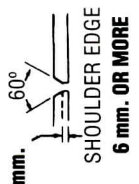
OPEN JOINT



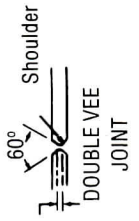
VEE JOINT



FEATHER EDGE  
3 mm. OR MORE



SHOULDER EDGE  
6 mm. OR MORE



DOUBLE VEE JOINT

## Assembly (See diagram 1)

- 1) Remove the side panel by sliding upwards and check that all the accessories listed below are included:

MIG 85 NO GAS, MIG 90 NO GAS  
AND MIG 100 NO GAS

- 4 Rubber feet with screws and washers
- 1 Spool of flux-cored welding wire
- 1 Spare welding tip
- 1 Face shield body
- 1 Face shield handle
- 1 Face shield window
- 2 Window fasteners

MIG 150 NO GAS

- 1 Foot with screw and washer
- 2 Wheels with retaining clips
- 1 Axle
- 1 Handle with screw
- 2 Spare welding tips
- 1 Face shield body
- 1 Face shield handle
- 1 Face shield window
- 1 Spool of flux-cored welding wire
- 2 Window fasteners

Should any parts be missing or damaged contact, your local dealer or **Clarke International** (telephone 071/2543860) for replacement.

North America - Please call Clarke Power Products - Inc. at (419) 352-2299.

- 2) Place the welding machine gently on its side and affix the four rubber feet to the underside of the machine using the four screws and washers provided (B).

MIG 150EN NO GAS:

Slide axle (C) through the two holes at the rear of the base of the machine, then push the wheel (D) onto each end of the axle. Secure wheels in position by gently tapping the retaining washers (E) onto the ends of the axle. Place the welding machine gently on its side and affix the rubber foot (F) to the front of the base using the screw and washer provided.

Stand the machine upright again and slot the handle arm (G) into the front of the carry handle and secure with the screw provided.

- 3) To assemble face shield, first place the darkened plastic window in the recessed window area in the body. Secure in place using the two plastic screw fasteners provided. Locate the handle fitting into the slot in the shield body, press firmly and rotate the handle through 90° until the lug locates into the hole in the shield body.

**WARNING:** Never look direct at welding arc, it can seriously damage your eyes. Always use the face-shield provided or any proper welding mask or helmet.