

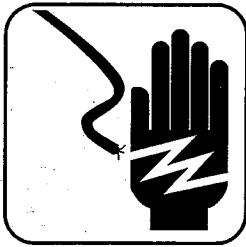


OWNER'S MANUAL/OPERATING INSTRUCTIONS L-950 UNI-SPOT III

WARNINGS & SAFEGUARDS FOR WELDING & CUTTING OPERATIONS

The operator, supervisor, and helper must read and understand all warning and safety information provided in these instructions and the power source manual used with this equipment. **Serious injury or death** could result if welding equipment is not properly installed, used, and maintained.

Training and proper supervision are most important for a safe work place. Installation, operation, repair work, and maintenance must be performed by qualified personnel. Retain these instructions for future use. Additional recommended safety and operating information is referenced in each section.



ELECTRICAL SHOCK CAN CAUSE INJURY OR DEATH

Electrical equipment must be installed and maintained in accordance with the National Electrical Code, NFPA 70, and all local codes. Maintain Electrode Holders, Work Clamp, Welding Cable, and Welding Machines in good, safe operating condition. Replace worn or damaged insulation. Do not try to repair or service equipment while the power is still on. Do not service or repair equipment unless you are trained and qualified to do so. The Electrode and Work (or Ground) circuits are electrically "HOT" when the trigger is pulled.

At no time should you touch the Electrode and Electrical Ground at the same time with bare skin while the trigger is pulled.

Always be sure the work cable makes a good electrical connection with the metal being welded.

Never touch electrically "HOT" parts of electrode holders.

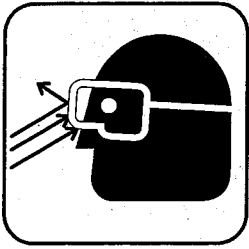
References: See Safety and Operating References A, F, H, and I.



SMOKE, FUMES, AND GASES CAN BE DANGEROUS TO YOUR HEALTH

Keep smoke, fumes, and gases from your breathing zone and the general area. Smoke, fumes, and gases from the welding process are of various types and strengths, depending on the kind of base metal being welded on. To ensure your safety, do not breath these fumes or gases. Ventilation must be adequate to remove smoke, fumes, and gases during the welding procedure to protect operators and others in the immediate area.

References: See Safety and Operating References A, B, C, H, and I.



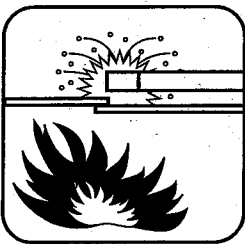
MOLTEN MATERIAL, AND SPARKS CAN CAUSE EYE AND SKIN INJURY

Always wear approved eye, ear and body protection. Remove any and all combustible material from the work area. Never attempt to weld without proper eye protection that conforms to federal guidelines.

Protect other nearby personnel from sparks. Use approved shielding curtains and appropriate goggles. Warn them not to watch the arc or expose themselves to arc rays, sparks, or molten material.

Always wear protective gloves which will not allow skin to come in contact with heat, or molten material. Wear ear plugs to protect ears from sparks.

References: See Safety and Operating References A, B, H, and I.



SPOT WELDING SPARKS CAN CAUSE FIRES AND EXPLOSIONS

Remove any and all combustible materials from the work area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Causes of fire and explosion are any combustibles reached by flying sparks or heated materials. Do not wear any gloves or clothing that has oil or a fuel type material on it. Always have a properly working and OSHA recognized Fire Extinguisher near and be sure everyone has proper training in its use.

All hollow spaces, cavities, and containers should be vented prior to welding for they may explode. Make sure proper steps have been taken to ensure that venting procedures will not form flammable or toxic vapors from substances inside containers.

References: See Safety and Operating References A, D, E, F, G, and H.

SAFETY AND OPERATING REFERENCES

- A) ANSI Z49.1, "Safety in Welding and Cutting"
- B) ANSI Z87.1, "Practice for Occupational and Educational Eye and Face Protection"
- C) ANSI Z88.2, "Standard Practice for Respiratory Protection" ANSI: American National Standard Institute, 1430 Broadway, New York, NY 10018
- D) AWS F4.1, "Recommended Safe Practices for Welding and Cutting Containers" AWS: The American Welding Society, P.O. Box 351040, 550 NW Lejeune Rd., Miami, FL 33135
- E) NFPA 51B, "Fire Prevention in Cutting and Welding Processes"
- F) NFPA-70, "National Electrical Code" NFPA: National Fire Protection Association, Batterymarch Park, Quincy, MA 02269
- G) GGA P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders" CGA: Compressed Gas Association, 1235 Jefferson Davis Hwy., Arlington, VA 22202
- H) Code of Federal Regulations (OSHA) 29 CFR 1910 US: U.S. Government Printing Office, Washington, DC 20402
- I) CSA Standard W117.2, "Safety in Welding, Cutting and Allied Processes" CSA: Canadian Standards Association, 178 Rexdale Blvd., Rexdale, Ontario, Canada M9W 1R3

OPERATING INSTRUCTIONS - L-950 (UNI-SPOT III)

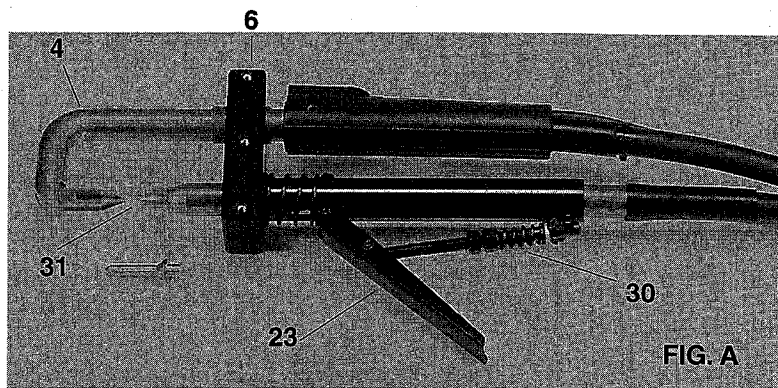
The L-950 is an accessory for the L-4000, 3000 (Models A and C), and L-5000 (A CK-35 Conversion kit may be required). The L-950 has a 9 ft. reach from the front of the welder to the welding area. It comes complete with cable and pinch gun assembly with two tips (UL-201 and US-202 installed), a UD-203 drip rail tip, two 5/16-2" bolts, two 5/16" lock washers, four 5/16" flat washers, two 5/16" nuts, and two black protective tip covers for the A-260 welding tip ends.

WARNING: Operators wearing any type of heart pacemaker should consult a physician before operating or being in area during operation of this equipment.

Follow disarming procedures recommended by automotive manufacturers for electrical and air bag systems.

HOOK UP: Unplug welder from 208/230V or 480V incoming power source. Unplug existing trigger switch plug from front of welder, remove A-260 cable assembly from transformer leads. Using existing hardware, attach L-950 in the same manner as the previous cables were attached to the transformer leads. NOTE: The A-260 and the L-950 can be attached to the transformer leads using the 2" hardware in the warranty pack. Make sure to place each cable lead on opposite sides of transformer leads. This allows the user to operate either attachment by simply changing the trigger switch plug. Slide black protective covers on A-260 welding tip ends to prevent arcing.

L-950 ADJUSTING/OPERATION



IMPORTANT: The L-950 comes preadjusted for automobile panels, but further adjustments of the unit may be necessary for individual applications. **TOO MUCH PRESSURE WILL CAUSE POOR OR NO WELDS.** Not enough pressure causes arcing and burn through. To set tip pressure, loosen spring pressure using the nut (See Fig. A; No. 30). Open the tips (See Fig. A, No. 31) as far as possible using lever (See Fig. A, No. 23). Adjust the space (See Fig. A, No. 31) between the tips 1/2" to 9/16" by loosening the body screws (See Fig. A, No. 6) and twisting and sliding stationary cable (See Fig. A, No. 4) backward or forward to get the 1/2" to 9/16" space (Fig. A, No. 31). Align the tip points so that they are parallel; tighten the screws in the body (See Fig. A, No. 6) to secure the stationary cable assembly (See Fig. A, No. 4). Avoid overtightening to allow movable electrode to move freely. Adjust nut (See Fig. A, No. 30) to touch the spring to allow no movement; tighten lock nut.

OPERATION: Plug welder into incoming power source, turn the switch to ON position and set timer control between 1 1/2 and 2. Check to ensure both tips are tight and aligned. Remove all paint and rust from contact areas on both sides of each piece of metal to be welded, however, the L-950 will make effective welds using LENCO's Spray-Galv, LSG-16.

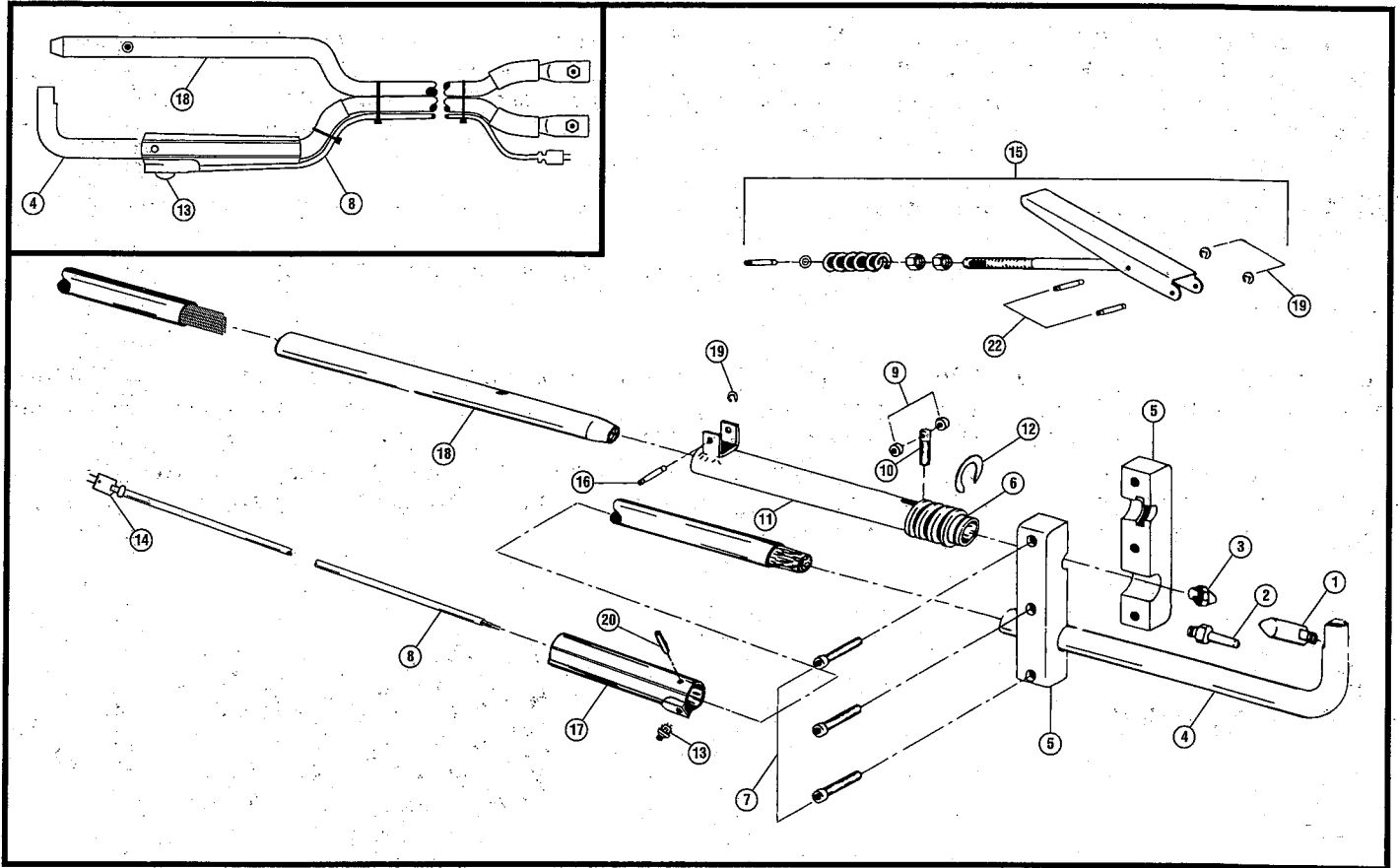
Using lever handle (See Fig. A, No. 23), secure the work pieces to be welded between the two tips, press the switch and hold to the end of timer cycle and the weld is made. Release handle and make next spot weld.

HELPFUL HINTS:

1. Clean Metal.
2. **TOO MUCH TIP PRESSURE WILL CAUSE POOR OR NO WELDS.**
3. Blunt tips cause poor welds (dress tips to 5/16" diameter).
4. Keep connections clean and tight on cables and tips.
5. The lever (See Fig. A, No. 23) can be rotated for more convenience by loosening the three screws located in the body (See Fig. A, No. 6). Rotate to desired position and retighten body screws. To change tips, use a 5/16" wrench. NOTE: Make sure tips are re-aligned for proper weld.



L-950 UNI-SPOT III REPLACEMENT PARTS



ITEMS NO.	PART NO.	ORDERING NO.	DESCRIPTION
1	UL-201	27201	Long Spot Tip
2	UD-203	27203	Drip Rail Spot Tip
3	US-202	27202	Short Spot Tip
4	US-2041	272041	9" Stationary Cable Assembly W/ Nylon Ties
5	U-208	27208	Body Clamp (includes #7)
6	U-2101	272101	Return Spring (external)
7	included with item #5, Body Clamp Screws		
8	QP-443	27443	Cord with Plug and Cable Ties (12)
9	U-214	27214	Bushings (4)
10	U-2111	272111	Linkage Post
11	U-209	27209	Movable Handle (includes #12)
12	included with item #11, Large Retainer		
13	LAS-170	23170	Push Button Switch w/Retaining Nut
14	U-101	29685	Male Plug
15	U-2121	272121	Lever Handle Assembly (includes #19, #22, #9, #10, 16)
16	U-213	27213	Hinge Pin w/Retainer (includes #9, #22)
17	LP-449	29449	Molded Handle (stationary)
18	U-2051	272051	9" Movable Cable Assembly w/Nylon Ties
19	included with item #16, Small retainer		
20	QP-432	27432	Spring Pin
22	included With Item #16, Pins		

NLC, Inc.

319 W. Main Street • Jackson, MO 63755 • Phone: (573) 243-3141 • Fax: (573) 243-7122