

**PRO SPOT**  
QUALITY WELDING SYSTEMS

# QUICK START GUIDE

**PR-220MV-COMplete**



MNL-PR-220MV-COMplete REV B.

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# 1. HARDWARE



1. M8x40 bolts, M8 Lock nuts, M8 flat washers
2. M6x25 Phillips button head screws
3. M6x10 Phillips button head screws
4. M5x10 Phillips button head screws
5. M6x10 Phillips pan head screws, M6 flat washers, M6 lock nuts



## TOOLS FOR ASSEMBLY:

1. Ratchet and 13mm Socket
2. 13mm Wrench
3. 10mm Wrench
4. #2 Phillips Screwdriver
5. Adjustable Wrench
6. Cutting Blade

# 2. UNPACKING



1. Cut straps.
2. Remove top lid.
3. Remove sleeve.
4. Remove all foam and contents from the cart.

5. Remove the welder and set aside.



**Be cautious when lifting the PR-220MV as it weighs close to 50 pounds.**

6. Lift cart out of the shipping box.

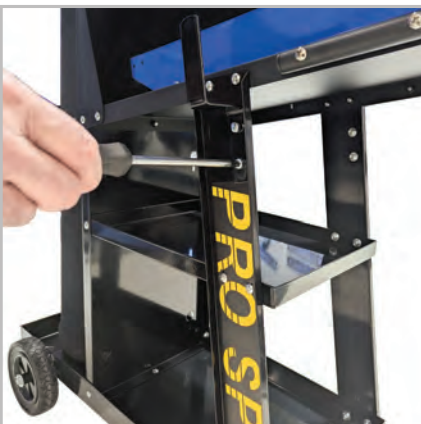
### 3. CART ASSEMBLY



1. Lift and level the middle shelf.
2. Secure middle shelf on both sides with 4 M6x10 Phillips pan head screws, M6 flat washers, M6 lock nuts.



1. Unfold the cart handle.
2. Secure with 2 M6x25 Phillips button head screws.

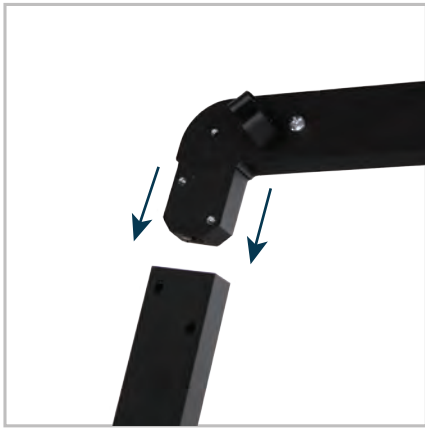


1. Install the ground cable storage hook to the left side of the cart.

### 4. BOOM ASSEMBLY

- |                      |                   |
|----------------------|-------------------|
| 1. Weld Test Station | 3. Horizontal Arm |
| 2. Vertical Boom     | 4. Torch Holster  |





1. Connect horizontal and vertical boom.



2. Secure with two M6x10 Phillips button head screws on both sides.



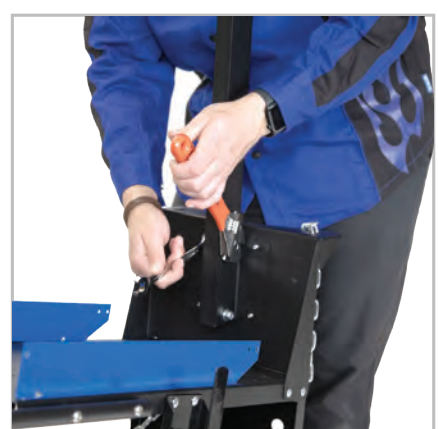
3. Attach torch holster to horizontal arm. Secure with two M5x10 Phillips button head screws.



Assembled Boom.



4. Place the vertical boom into the slot at the back of the cart.



5. Secure using 2 M8x40 bolts, M8 nuts and washers.

Assembled Cart



## 5. WELDER PLACEMENT AND SETUP



1. Remove 4 side screws from PR-220MV before placing it on the cart.



2. Place PR-220MV in welder tray on cart.



3. Attach to cart with 4 screws (2 on each side).

**Note:** The two pointed-end screws and the two flat-end screws must be reinstalled in their original holes.



4. Remove the white cap from the front of the welder and attach the torch.



5. Place the torch on the cradle of the boom and secure cable in the cable clamp.



6. Insert ground clamp to Negative (-) port on the front of the welder.



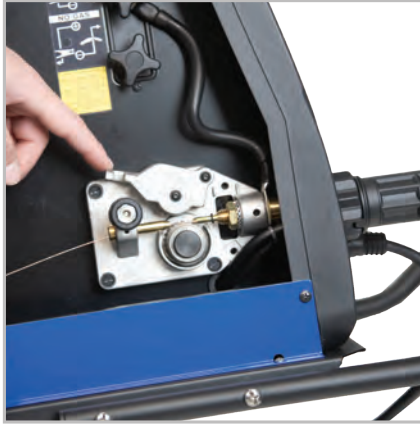
7. Lift the side panel of PR-220MV to access the Quick Start guide.



8. Place the provided spool of ER70S-6 steel MIG welding wire (part #50-7208) onto the spindle.



9. Loosen the lock knob and pull down to release the drive roller tensioner.



10. Feed the wire into the liner.



11. Close and lock the tensioner by replacing and tightening the lock knob.



12. Close the panel of the welder, plug it into a 220V outlet, and turn the power switch on the back panel to the right.



13. Press the torch trigger to feed the wire until it exits the front of the torch. Clip excess wire to approximately 1/4".



14. Attach the gas line to the back panel of the welder, but do not connect the other end to the gas bottle yet.



15. Place the gas bottle on the back of the cart.



16. Secure the bottle with supplied chains.



17. Before attaching the gas regulator, perform a purge of the gas tank. This step requires safety glasses and gloves.

18. Attach gas regulator to the gas bottle



19. Attach the gas line to the gas bottle and turn on the gas valve.

## 6. FINAL SETUP



1. Attach the overhead testing station rod to the holder

2. Insert the weld test station to the front of the boom and adjust to desired height by tightening the silver lock knob. Store in back when not in use.

3. Review **WELDING SAFETY INFORMATION** on the next page.

## 7. WELDING SAFETY

- Wear #9 Shade Welding Lens.
- Use gloves, welding jacket, and proper footwear.
- Protect yourself from UV light and sparks.
- Follow standard GMAW safety practices.
- Prior to performing an overhead weld test, be sure to place the protective cover on the PR-220MV. It's recommended that a weld blanket is also placed on the top of the unit.
- To prevent injuries, be sure to remove the test coupon after testing.
- Always store the weld test platform at the lower position and facing inwards when it's not in use. The weld test station can also be placed at the back of the boom if more convenient, and remember to also store the weld test platform at its lowest position and facing **inwards**.



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Start Guide  
Video, Scan:**



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