



Owner's Manual

EASY ARC WELDER



Please read and save these instructions.

*HAVE QUESTIONS OR NEED SERVICE
DO NOT RETURN TO STORE!*

PLEASE CALL TOLL FREE: 888.896.6881



www.allpoweramerica.com

Plasma Cutter

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Operating Instructions And Parts Manual

Please read and save these instructions. Read through this owner's manual carefully before using product. Protect yourself and others by observing all safety information, warnings, and cautions. Failure to comply with instructions could result in personal injury and/or damage to product or property. Please retain instructions for future reference.

Owner's Manual

Description

APEW018 is an IGBT inverter plasma cutter with the function of thermal protection, TRAFIMET torch and built-in gas regulator. It can make the good and easy cutting performance and also can be used for metal net cutting. It is designed to connect to 1ph, 230v (220-240V), 60HZ power supply. It is an ideal machine to cut the metal thickness up to 0.375 inch.



Specifications and Dimension

DESCRIPTION	SPECIFICATION
Power Supply	1ph-230V-60HZ
No-load Voltage	340V
Output Range	15-40A
Duty Cycle	35%
Air Pressure	4.5 CFM@ 60 PSI
Power Switch	250VAC 30Amps
Dimension (L x W x H)	17.7"x6.7"x9"
Weight	21 lbs

Removing from carton

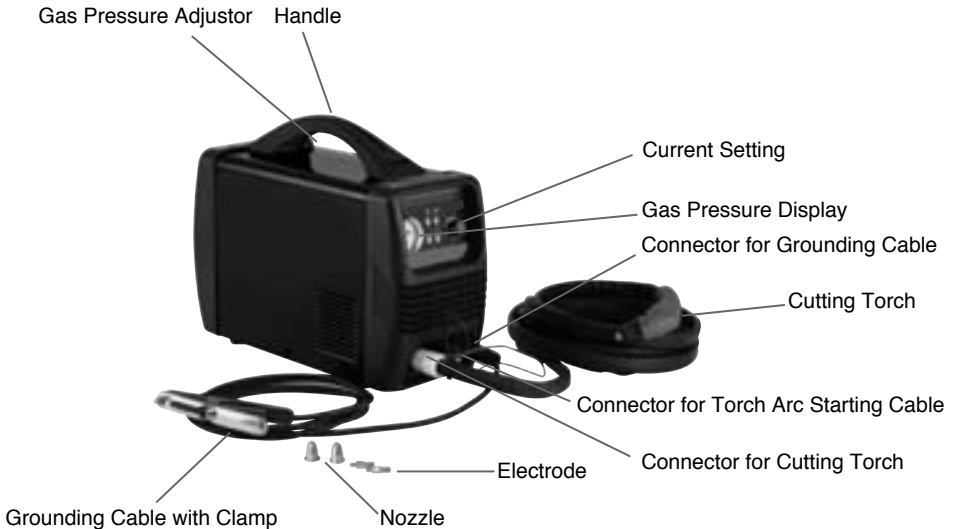
- 1.1 Remove cartons, bags or Styrofoam containing the welder and accessories.
- 1.2 Check the contents with the packing list below.

ITEM	QTY.
Plasma Cutter	1 unit
Grounding Cable	1 pc
TRAFIMET Cutting Torch	1 pc
Electrode	3 pcs
Nozzle	3 pcs
Operator's Manual	1set

- 1.3 After unpacking unit, inspect carefully for any damage that may have occurred during transit. Check for loose, missing, or damaged parts. Shipping damage claim must be filed with carrier.

Plasma Cutter

Know your Welder



Gas Pressure Display

The built-in gas display is used for reading the output gas pressure when cutting.

Gas Pressure Adjustor

It is used for adjusting the gas pressure. The gas pressure can be read from the gas pressure display on the front panel. Normally, the pressure should be adjusted between 55-90psi.

Work Indicator

When cutting, this light is on to show the unit is on working mode.

Cutting Current Adjustor

Variable adjust the output cutting current. The higher output matches the thicker metal. The maximum cutting thickness is up to 0.375" for this unit. Please note that different metal, the maximum cutting thickness is different, see following table for reference;

Material	Maximum Outting Thickness
Carbon Steel	3/8"
Aluminium	1/4"
Stainless Steel	1/4"
Copper	1/8"

Gas Lack Indicator

When lack of gas, the indicator will be on.

"+" Output Connector - the Connector for Grounding Cable

The "+" current output, it is the connector for grounding cable. Plug in the dinse connector to this connector, the earth clamp is connected to the work piece.

Connector for Torch Control Cable

This connector is for the black cable of the torch. It is the control cable of the torch.

Connector for Torch Arc Starting Cable

This connector is for the red cable of the torch. It is used to help the arc starting.

"-" Output Connector for Trafimet Torch

It is the connector for the Trafimet torch main cable.

Protection indicator

When the unit is thermal overload, over/lack voltage, the indicator will be on and the machine stop working. When the unit is cooled down and voltage goes stable, the unit will return to work automatically.

Power indicator

When the plug of power cord on the back panel was connected to the power supply and turn on the power switch on the back panel, the light is on.

Connector for gas hose

It is on the back panel of the unit. It is the 1/4 inch screw connector for the gas hose. Screw in one end of the gas hose. The other end of the gas hose is connected to the air compressor.

Power switch

It is the on/off switch. After the machine is connected to the power supply, turn on this switch and then the power indicator on the front panel is on.

Power cord

There is a 50amp plug of this cable. Plug in this to the 230v, 50amp circuit breaker power supply

Nameplate

The specification table.

Plasma Cutter

General Safety Information

1.1 Your Welding/Cutting Environment

- Keep the environment you will be welding/cutting in free from flammable materials.
- Always keep a fire extinguisher accessible to your welding environment.
- Always have a qualified person install and operate this equipment.
- Make sure the area is clean, dry and ventilated. Do not operate the welder in humid, wet or poorly ventilated areas.
- Always have your welder/cutter maintained by a qualified technician in accordance with local, state and national codes.
- Always be aware of your work environment. Be sure to keep other people, especially children, away from you while welding/cutting.
- Keep harmful arc rays shielded from the view of others.
- Mount the welder/cutter on a secure bench or cart that will keep the welder secure and prevent it from tipping over or falling.

1.2 Your Welder/Cutter's Condition

- Check all cables, power cord and torch gun to be sure the insulation is not damaged. Always replace or repair damaged components before using the welder/cutter.
- Check all components to ensure they are clean and in good operating condition before use.

1.3 Use of Your Welder/Cutter

⚠ CAUTION

Do not operate the welder/cutter if the torch is wet. Do not immerse the plasma torch. Do not stand in water while using this plasma cutter. These components and the welder/cutter must be completely dry before attempting to use it.

- Follow the instructions in this manual.
- Keep welder in the off position when not in use.
- Connect ground lead as close to the area being welded/cut as possible to ensure a good ground.
- Do not allow any body part to come in contact with the welding wire if you are in contact with the material being welded, ground or electrode from another welder.
- Do not weld if you are in an awkward position. Always have a secure stance while welding/cutting to prevent accidents. Wear a safety harness if working above ground.
- Do not drape cables over or around your body.
- Wear eye protection (see ANSI Z49.1 safety standard) while cutting to protect from harmful UV and IR ray's.
- Wear proper gloves and protective clothing to prevent your skin from being exposed to hot metals, UV and IR rays.
- Do not overuse or overheat your welder/cutter. Allow proper cooling time between duty cycles.
- Keep hands and fingers away from moving parts and stay away from the drive rolls.
- Do not point Plasma torch at any body part of yourself or anyone else.
- Always use this welder/cutter in the rated duty cycle to prevent excessive heat and failure.

1.4 Specific Areas of Danger, Caution or Warning,



Electrical Shock

▲ WARNING

Electric arc welders can produce a shock that can cause injury or death. Touching electrically live parts can cause fatal shocks and severe burns. While welding/cutting, all metal components connected to the wire are electrically hot. Poor ground connections are a hazard, so secure the ground lead before welding/cutting.

- Wear dry protective apparel: coat, shirt, gloves and insulated footwear.
- Insulate yourself from the work piece. Avoid contacting the work piece or ground.
- Do not attempt to repair or maintain the welder/cutting while the power is on.
- Inspect all cables and cords for any exposed wire and replace damaged or worn cables immediately.
- Use recommended replacement cables and cords.
- Always attach ground clamp to the work piece or work table as close to the weld/cutting area as possible.
- Do not touch the torch and the ground or grounded work piece at the same time.



Fumes and Gases

▲ WARNING

-Fumes emitted from the welding/cutting process displace clean air and can result in injury or death.

- Do not breathe in fumes emitted by the welding/cutting process. Make sure your breathing air is clean and safe.
- Work only in a well-ventilated area or use a ventilation device to remove welding/cutting fumes from the environment where you will be working.
- Do not weld/cut on coated materials (galvanized, cadmium plated or containing zinc, mercury or barium). They will emit harmful fumes that are dangerous to breathe. If necessary use a ventilator, respirator with air supply or remove the coating from the material in the weld/cutting area.
- The fumes emitted from some metals when heated are extremely toxic. Refer to the material safety data sheet for the manufacturer's instructions.
- Do not weld/cut near materials that will emit toxic fumes when heated. Vapors from cleaners, sprays and degreasers can be highly toxic when heated.



UV and IR Arc Rays

▲ DANGER

The welding/plasma arc produces ultraviolet (UV) and infrared (IR) rays that can cause injury to your eyes and skin. Do not look at the welding/plasma arc without proper eye protection.

- Always use safety glasses/shield or helmet that meet ANSI Z49.1 standards for plasma cutting.
- Cover all bare skin areas exposed to the arc with protective clothing and shoes. Flame-retardant cloth or leather shirts, coats, pants or coveralls are available for protection.
- Cover all bare skin areas exposed to the arc with protective clothing and shoes. Flame-retardant cloth or leather shirts, coats, pants or coveralls are available for protection.
- Use screens or other barriers to protect other people from the arc rays emitted from your welding/cutting.

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-Warn people in your welding/cutting area when you are going to strike an arc so they can protect themselves.



Fire Hazards

▲ WARNING

Do not weld/cut on containers or pipes that contain or have had flammable, gaseous or liquid combustibles in them. Welding/cutting creates sparks and heat that can ignite flammable and explosive materials.

- Do not operate any electric arc welder or plasma cutter in areas where flammable or explosive materials are present.
- Remove all flammable materials within 35 feet of the welding/plasma arc. If removal is not possible, tightly cover them with fireproof covers.
- Take precautions to ensure that flying sparks do not cause fires or explosions in hidden areas, cracks or areas you cannot see.
- Keep a fire extinguisher close in the case of fire.
- Wear garments that are oil-free with no pockets or cuffs that will collect sparks.
- Do not have on your person any items that are combustible, such as lighters or matches.
- Keep work lead connected as close to the weld/cutting area as possible to prevent any unknown, unintended paths of electrical current from causing electrical shock and fire hazards.



Hot Materials

▲ CAUTION

Welded/cut materials are hot and can cause severe burns if handled improperly.

- Do not touch welded/cut materials with bare hands.
- Do not touch torch tip after cutting until it has had time to cool down.



Sparks/Flying Debris

▲ CAUTION

Welding/cutting creates hot sparks that can cause injury. Chipping slag off welds creates flying debris.

- Wear protective apparel at all times: ANSI-approved safety glasses or shield, welder's hat and ear plugs to keep sparks out of ears and hair.



Electromagnetic Field

▲ CAUTION

-Electromagnetic fields can interfere with various electrical and electronic devices such as pacemakers.

- Consult your doctor before using any electric arc welder or cutting device
- Keep people with pacemakers away from your welding/cutting area when welding/cutting.
- Do not wrap cable around your body while welding/cutting.
- Wrap plasma torch cable and ground cable together whenever possible.
- Keep plasma torch and ground cables on the same side of your body.



Shielding Gas Cylinder can explode

▲ WARNING

- High pressure cylinders can explode if damaged, so treat them carefully.
- Never expose cylinders to high heat, sparks, open flames, mechanical shocks or arcs
 - Do not touch cylinder with plasma torch.
 - Do not weld/cut on the cylinder.
 - Always secure cylinder upright to a cart or stationary object cart or stationary object
 - Do not touch cylinder with MIG gun.
 - Do not weld on the cylinder.
 - Always secure cylinder upright to a cart or stationary object.
 - Keep cylinders away from welding/cutting or electrical circuits.
 - Use the proper regulators, gas hose and fittings for the specific application



Proper Care, Repair and Maintenance

▲ WARNING

- Always have power disconnected when working on internal components.
- Do not touch or handle PC board without being grounded with a wrist strap. Put PC board in static proof bag to move or ship.
- Do not put hands or fingers near moving parts such as drive or fan.



Oposition 65 Warnings

▲ WARNING

- Welding and cutting equipment produces fumes or gases which contain chemicals known to the state of California to cause birth defects and, in some cases, cancer. (California Health & Safety code section 25249.5 et seq.)

Installation

1. Power requirement

AC single phase 230 (220-240V) 60HZ fused with a 50amp time delayed fuse or circuit breaker is required. DO NOT OPERATE THIS UNIT if the ACTUAL power source voltage is less than volts 170v ac or greater than 250 volts ac.

▲ WARNING

- High voltage danger from power source!
Consult a qualified

electrician for proper installation of receptacle. This cutter must be Grounded while in use to protect the operator from electrical shock.

- Do not remove grounding prong or alter the plug in any way. Do not use any adapters between the cutter's power cord and the power source receptacle. Make sure the POWER switch is OFF when connecting your cutter's power cord to a properly grounded 230 VAC, 60Hz, 1 phase, 50 amp input power supply.

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INSTALLING THE CUTTING TORCH

1. Prepare all the necessary components.



2. Screw in the electrode to the cutting torch.



3. Slide in the diffuser.



4. Line the electrode and nozzle and slide in.

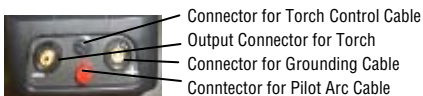
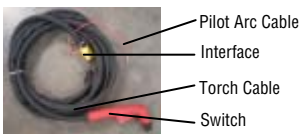


5. Install the outer protector to the torch and screw.



INSTALLING THE CUTTER

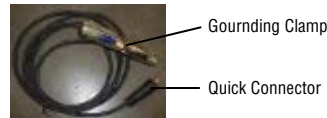
1. Connect the red cable with the red terminal on the front side of the plasma cutter.



2. Connect the torch cable with the black terminal on the front side of the plasma cutter and make sure the concave convex correspond with each other.

3. Connect the interface of the torch cable with the "-" output terminal and tighten.

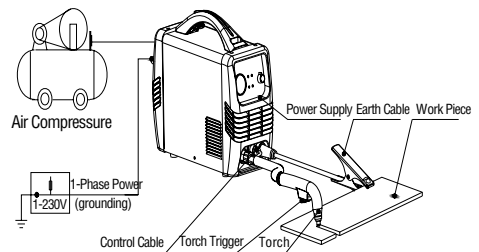
4. Connect the grounding cable with the "+" output terminal and tighten.



5. The right connection



6. Illustration of Complete Assembly



Operation

⚠ WARNING

High voltage danger from power source!
Consult a qualified electrician for proper installation of receptacle at the power

source. This cutter must be grounded while in use to protect the operator from electrical shock. If you are not sure if your outlet is properly grounded, have it checked by a qualified electrician. Do not cut off the grounding prong or alter the plug in any way and do not use any adapters between the cutter's power cord and the power source receptacle. Make sure the POWER switch is OFF then connect your welder's power cord to a properly grounded 230 Vac (220v-240v), 60Hz, single phase, 50 amp power source.

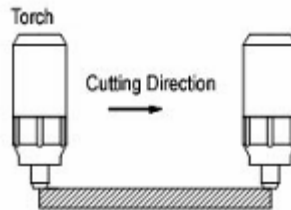
1. Set up

- Check the plasma cutter to see if it has been connected correctly and is in good working condition as described in Section 1 on Safety and that it complies with safe operation requirements.
- When the supply power is on, (Voltage Display) shows the input power supply voltage; Switch on the power supply switch of the cutter to observe if the operation is normal. If it is normal, the fan should start up; the (Power Supply Indication Light) should be on. If there is no compressed air or the air pressure is low the (Low Pressure Indicator Light) will be light.
- Switch the Torch cooling switch to the 'Air Cooling', adjust air supply valve till the air pressure is up to the cutting torch requirement. (Lowest pressure should be no less than 50PSI), the Low Pressure Indicator Light will not be lit up in those conditions.
- Adjust the air flow to be sure it is consistent.
- Turn on the torch switch; the cutting operation begins after the cutting plasma pilot is made.

2. Manual Contact Cutting

2.1. Metal Sheet Cutting

- Put the torch's nozzle at the start of the work piece (with slight touch or lift). Turn on the torch switch to ignite the plasma pilot. After the work piece is cut thorough, then move the torch along the cutting direction uniformly. The cutting speed is determined by watching to see if the cutting goes all the way through. If the speed is too fast, the work piece won't be cut thorough, or if too slow, the cut quality would be affected or the arc could stop.



- When you've completed the cutting process, turn off the torch; the plasma pilot arc will stop.

2.2. Metal Mesh Cutting

- Fix the work piece and connect the earth cable with the work piece.

- Put the cutting nozzle onto the work piece and turn on the switch to cut.

2.3. Notice while cutting

- If unnecessary, please do not ignite the leading pilot in the air, or it will reduce life-span of the torch's electrode and nozzle.
- It is best to start cutting at the edge of the work piece, unless you must do perforation operation on the work piece.
- Keep a space between the nozzle and the work space. If you press the torch onto the work piece to strong the nozzle could

Plasma Cutter

stick to the work piece and reduce the smoothness of the cutting action and resulting cut.

- Keep the torch's nozzle vertical against the work piece, and watch to be sure the arc is moving along the cutting line.
- For thin materials reduce the amperage setting to get the best cutting quality with low waste and longer life of electrode and nozzle.
- Do not rapidly switch the torch trigger back and forth; this will damage the pilot arc system and work piece.
- The cutter's working range is 40-90psi. Notice: the internal pressure switch will shut off when the compressed air pressure falls below 50psi. The switch only works when the pressure rises to 50psi or above.
- Every 4-8 hours, check the air filter and remove excess moisture. Too much moisture in the cutter or torch may lead to operational trouble.

▲ WARNING

- Always unplug the power supply before checking for and removing moisture.

3. Safety Requirements

- Never allow the torch to be aimed at any part of a body.
- Make sure to wear protection glasses and protection gloves while operating.

- Work only in well-ventilated areas. If necessary, use exhaust/ventilation fans to keep fumes or emissions away from the breathing zone.
- Do not touch the work piece while cutting.
- Do not cut a pipe, container, etc. that contains, or has ever contained, flammable or explosive materials.
- Do not work underwater or in wet/moist environments.
- Do not bend the torch cable sharply; this may damage the air hose.
- Nobody other than the operator should be allowed to access the working area.
- Always turn off the power supply prior to repairing or moving the machine.
- Always turn off the power supply prior to repairing or installing any spare parts (e.g., torch, electrode, nozzle, ground clamp, etc.).
- Never allow a person with a cardiac pacemaker close to the working area without the permission of a doctor. The magnetic field produced by plasma cutters during operation can disrupt pacemakers and similar devices.
- Do not allow the ground cable to be pinched or damaged. If damaged, replace immediately.
- Never clean the slag off the torch head by hitting it against a hard object.

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Trouble shooting Chart

Symptom (s)	Possible Causes(s)	Corrective Action(s)
Indication Light is off after turning on the power supply.	<ol style="list-style-type: none"> 1.The light is broken. 2.Fuse is blown. 3.No 230V Input Voltage. 4.Power supply switch is broken. 5.Controlling board or cutter is damaged. 	<ol style="list-style-type: none"> 1.Replace. 2.Replace. 3.Connect the 230V Input cable. 4.Replace. 5.Examine and repair.
Fan doesn't work after turning on the power supply.	<ol style="list-style-type: none"> 1.Fan is damaged. 2.Fan's ground lead is broken. 3.Fan's blade is blocked 4.Transformer is damaged. 	<ol style="list-style-type: none"> 1.Replace. 2.Examine and repair. 3.Clean the block. 4. Replace.
Low Pressure Indicator Light is on	<ol style="list-style-type: none"> 1.No input compressed air 2.Air/gas pressure valve is adjusted to 0 or broken. 3.Air/gas pressure circuit is blocked 4.Air/gas pressure valve is damaged 	<ol style="list-style-type: none"> 1.Examine and repair. 2.Adjust or replace. 3.Clean the block. 4.Replace.
No Air/gas check function.	<ol style="list-style-type: none"> 1.Air/Gas valve is ruined. 2.Air/Gas circuit is blocked. 3.Air/Gas check switch is ruined 4.Ground lead is broken. 	<ol style="list-style-type: none"> 1.Replace. 2.Clean the block. 3.Replace. 4.Examine and repair.
Can't cut or no high frequency output.	<ol style="list-style-type: none"> 1.Discharge gap is too big. 2.High pressure mica capacitance damaged. 3.Pilot transformer is damaged. 4.Main controlling board is damaged. 5.Ground lead is broken 	<ol style="list-style-type: none"> 1.Adjust to suitable gap. 2.Replace. 3.Replace. 4.Examine and repair. 5.Examine and repair.
No response after turning on the torch switch.	<ol style="list-style-type: none"> 1.Switch and ground-lead are broken. 2.Switch board is broken. 3.Main controlling board is damaged. 4.Transformer is damaged. 5.Ground lead is broken. 	<ol style="list-style-type: none"> 1.Examine and repair or replace. 2.Examine and repair or replace. 3.Examine and repair or replace. 4.Replace. 5.Examine and repair.
No response after turning on power supply.	<ol style="list-style-type: none"> 1.Power cord hooked up wrong. 2.Power supply switch is broken. 3.Fuse is damaged. 	<ol style="list-style-type: none"> 1.Examine and repair. 2.Replace. 3.Replace.

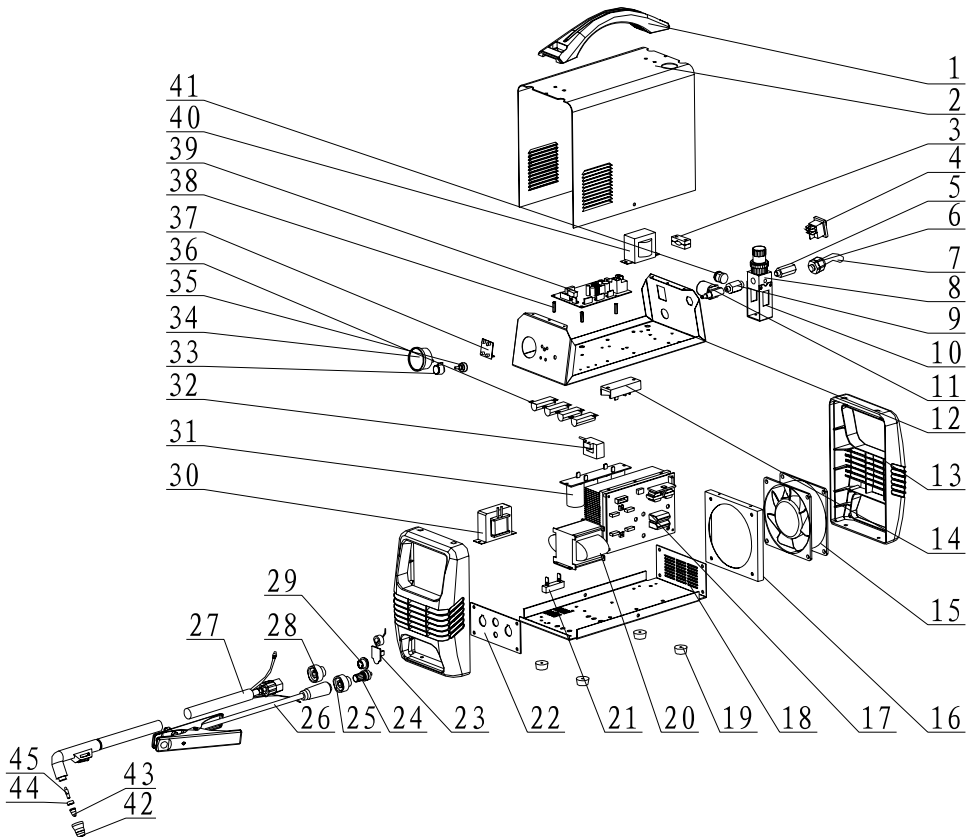
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	<p>4. Transformer is broken.</p> <p>5. Main controlling board is ruined.</p>	<p>4. Replace.</p> <p>5. Examine and repair or replace.</p>
<p>Protection indicator comes on.</p>	<p>1. High/low voltage</p> <p>2. The High/low voltage setting is incorrect.</p> <p>3. Over heating from exceeding the duty cycle.</p> <p>4. The bad or broken connection in the thermal relay.</p> <p>5. Main PCB board is broken.</p>	<p>1. The tolerant voltage range is 170V ~ 250V and the machine will stop working and indicator will come on if there is any over or less input voltage. Please check the voltage with a volt meter.</p> <p>2. Please open the case to adjust the potentiometer VR101 (for high voltage setting) and VR102 (for low voltage setting) on the main control PCB. Note: VR 101 should be adjusted clockwise, the VR 102 should be adjusted counter clockwise.</p> <p>3. Wait till machine cool down.</p> <p>4. Repaired by the qualified people.</p> <p>5. Replace.</p>
<p>Other problem.</p>		<p>Please contact customer service number on the outside of the manual</p>

Please provide the following:

- Model Number
- Serial Number (if any)
- Part description and number as shown on parts list

Plasma Cutter



APA No.	Parts No.	Description
APEW018-01-HG	2.05.08.019	Handle
APEW018-02-HG	1.51.401.01	Enclosure
APEW018-03-HG	2.05.17.020	Power cord holder
APEW018-04-HG	2.07.80.213	Main Switch
APEW018-05-HG	1.51.401.14	Gas valve connector
APEW018-06-HG	2.04.30.102	Power cord holder
APEW018-07-HG	2.03.05.148	Power cord plug
APEW018-08-HG	2.07.55.104	Gas valve
APEW018-09-HG	1.51.030.03-03	Gas connector II
APEW018-10-HG	1.51.042.03-4	Gas valve board
APEW018-11-HG	1.51.030.03-7	Gas valve
APEW018-12-HG	1.51.401.03-1	Middle board

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APA No.	Parts No.	Description
APEW018-13-HG	2.05.05.039	Plastic panel
APEW018-14-HG	2.07.37.501	Rectifier
APEW018-15-HG	2.07.89.400	Fan
APEW018-16-HG	1.51.401.08-7-1	Fan bracket
APEW018-17-HG	1.51.401.08-6	Heat sink
APEW018-18-HG	1.51.401.08-5	Bottom
APEW018-19-HG	2.05.05.016	Feet
APEW018-20-HG	1.51.401.08-4	Main transformer
APEW018-21-HG	1.51.401.08-1	Load wire bunch
APEW018-22-HG	1.51.042.13-1	Front lower panel
APEW018-23-HG	1.51.401.13-3	Arc control PCB
APEW018-24-HG	2.05.03.104	Connection pole
APEW018-25-HG	2.07.57.123	Quick connector
APEW018-26-HG	1.51.030.09	Grounding cable
APEW018-27-HG	2.20.08.258	Cutting torch
APEW018-28-HG	1.51.030.08-1	Output power PCB
APEW018-29-HG	2.07.54.114	Socket
APEW018-30-HG	1.51.409.08-8	Chock
APEW018-31-HG	1.51.401.08-9	Capcitanse board
APEW018-32-HG	1.51.042.03-10	Hall sensor
APEW018-33-HG	2.07.11.017	Potentiometer knob
APEW018-34-HG	2.07.55.105	Regulator
APEW018-35-HG	1.51.401.03-7	Potentiometer
APEW018-36-HG	2.07.02.003	Resistance
APEW018-37-HG	1.51.042.03-5	Power indicating board
APEW018-38-HG	2.06.01.701	Bolt
APEW018-39-HG	1.51.409.03-2	Main PCB
APEW018-40-HG	1.51.401.03-3	Control transformer
APEW018-41-HG	1.51.401.03-10	Pressure switch
APEW018-42-HG	2.20.04.901	Cutting nozzle
APEW018-43-HG	2.20.04.902	Tip nozzle
APEW018-44-HG	2.07.42.010	Whirlpool ring
APEW018-45-HG	2.20.06.301	Cutting tip

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Limited Warranty

All-Power America warrants to the original purchaser who uses the product in a consumer application (personal, residential or household usage) that all products covered under this warranty are free from defects in material and workmanship for one year from the date of purchase. All products covered by this limited warranty which are used in commercial applications (i.e. income-producing) are warranted to be free of defects in material and workmanship for 90 days from the date of original purchase. Products covered under this warranty include air compressors, air tools, service parts, pressure washers, and generators.

All-Power America will repair or replace, at All-Power America's sole option, products or components which have failed within the warranty period. Service will be scheduled according to the normal work flow and business hours at the service center location, and the availability of replacement parts. All decisions of All-Power America with regard to this limited warranty shall be final.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

RESPONSIBILITY OF ORIGINAL PURCHASER (initial User):

- To process a warranty claim on this product, DO NOT return item to the retailer. The product must be evaluated by an Authorized Warranty Service Center. For the location of the nearest Authorized Warranty Service Center contact the retailer or place of purchase.
- Retain original cash register sales receipt as proof of purchase for warranty work.
- Use reasonable care in the operation and maintenance of the product as described in the Owners Manual(s).
- Deliver or ship the product to the nearest Authorized Warranty Service Center. Freight costs, if any, must be paid by the purchaser.
- Air compressors with 60 and 80 gallon tanks will be inspected at the site of installation. Contact the nearest Authorized Warranty Service Center that provides on-site service calls for service call arrangements.
- If the purchaser does not receive satisfactory results from the Authorized Warranty Service Center, the purchaser should contact All-Power America.

Limited Warranty (cont'd)

THIS WARRANTY DOES NOT COVER:

- Merchandise sold as reconditioned, used as rental equipment, or floor or display models.
- Merchandise that has become damaged or inoperative because of ordinary wear, misuse, cold, heat, rain, excessive humidity, freeze damage, use of improper chemicals, negligence, accident, failure to operate the product in accordance with the instructions provided in the Owners Manual(s) supplied with the product, improper maintenance, the use of accessories or attachments not recommended by All-Power America, or unauthorized repair or alterations.
- Repair and transportation costs of merchandise determined not to be defective.
- Costs associated with assembly, required oil, adjustments or other installation and start-up costs.
- Expendable parts or accessories supplied with the product which are expected to become inoperative or unusable after a reasonable period of use.
- Merchandise sold by All-Power America which has been manufactured by and identified as the product of another company, such as gasoline engines. The product manufacturer's warranty, if any, will apply.
- ANY INCIDENTAL, INDIRECT OR CONSEQUENTIAL LOSS, DAMAGE, OR EXPENSE THAT MAY RESULT FROM ANY DEFECTS, FAILURE OR MALFUNCTION OF THE PRODUCT IS NOT COVERED BY THIS WARRANTY.
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ALL-POWER AMERICA
730 S. Epperson Dr.
City Of Industry, CA 91748
www.allpoweramerica.com