



Octagonal Exacto-Pak™ (X-Pak™) Set Up & Tear Down Guide



Octagonal Exacto-Pak (X-Pak)

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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.

Hobart Brothers LLC is not responsible for personal, product, or other property damage resulting from improper storage, transportation, set up, or tear down of the Hobart bulk packaging.

Hobart Brothers products are warranted from defects in material and workmanship for a period of (1) year from the time of shipment in its original undamaged and unopened package. For details on the Hobart Brothers LLC product warranty, please contact our Customer Service department at 1-800-424-1543. For additional questions on the storage and care of Hobart Brothers Tubular Products, please contact the Applications Engineering Dept. at 1-800-532-2618 or at applications.engineering@hobartbrothers.com

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Wire Wizard is a registered trademark of ELCo Enterprises Inc.

Weldmatic is a registered trademark of Weldmatic Inc.



EQUIPMENT REQUIRED

PERSONAL PROTECTIVE EQUIPMENT & TOOLS

Typical personal protective equipment includes: safety glasses with side shields, cut-resistant material handling gloves, and closed-toed footwear having steel/composite toes.

The tools required for drum set up include: a utility knife, a pair of adjustable wrenches, a pair of diagonal cutters (or similar wire-cutting tool)



TWO-POINT LIFTING DEVICE

Two-point lifting devices are manufactured by Weldmatic® and Wire Wizard®. Shown below are relevant Wire Wizard part numbers.

FDL-24-12 (Left): Non-adjustable and designed for 23.5" drums.

FDL-HS (Right): Adjustable for a range of drum diameters



WIRE FEEDING ACCESSORIES

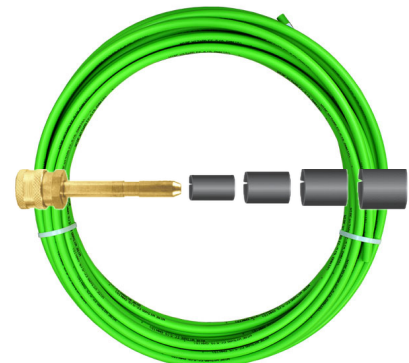
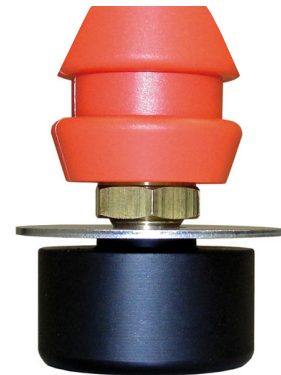
(Optional; 1x) 23.5" Octagonal Drum Cone

(1x) Direct Pull Kit (Wire Wizard® part number WWDP)

(1x) Polymer welding wire conduit suitable for spanning the distance between the drum and wire feeder

(2x) Compression or self-threading male quick-disconnect fittings

(1x) Quick-disconnect wire-feeder inlet guide designed for the wire feeder model being used.



SET UP



STEP ONE




Remove the stretch wrap and inspect the drum for shipping damage.

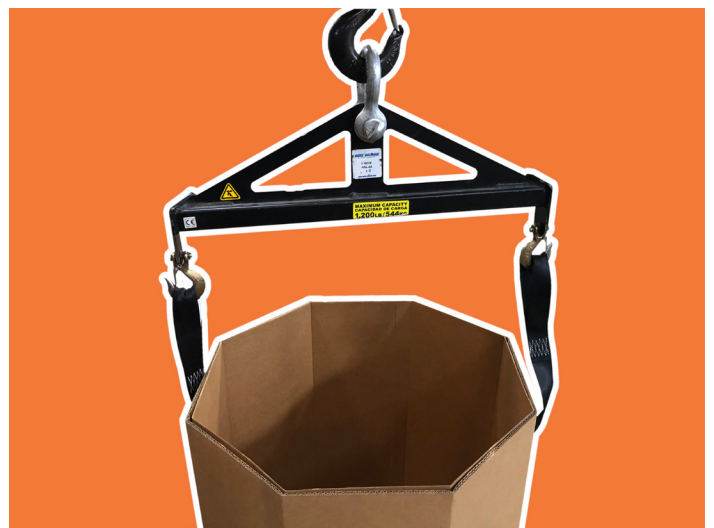
Do not use any drum if the drum is punctured or shows signs of being mishandled (including being tipped).



STEP TWO

Remove a drum from the pallet and transport to the desired location by using a two-point lifting device. Always adhere to the following:

-  Only qualified material handling personnel should perform the lifting/transportation of Hobart bulk packaging.
-  Never lift damaged packaging and/or use damaged equipment or equipment with insufficient capacity.
-  Prior to lifting and transporting, plan a safe route to the destination that minimizes the potential for collisions.



- ⚠ Never drop, tip, or roll the drum during transport or storage.
- ⚠ The drum should never be lifted higher than is immediately necessary to clear obstacles. Never walk under Hobart bulk packaging while it is suspended. Never transport Hobart bulk packaging over the top of personnel in the area.



A: Ensure the lifting device has a locking device, and that the strap is clear of the locking device.
 B: Improper Technique. Ensure the lifting device is centered over the load to prevent the risk of swinging.



C: Improper technique. Do not perform a single-point single-side lift
 D: Improper technique. Do not perform a single-point lift. Damage to the wire and drum will occur.

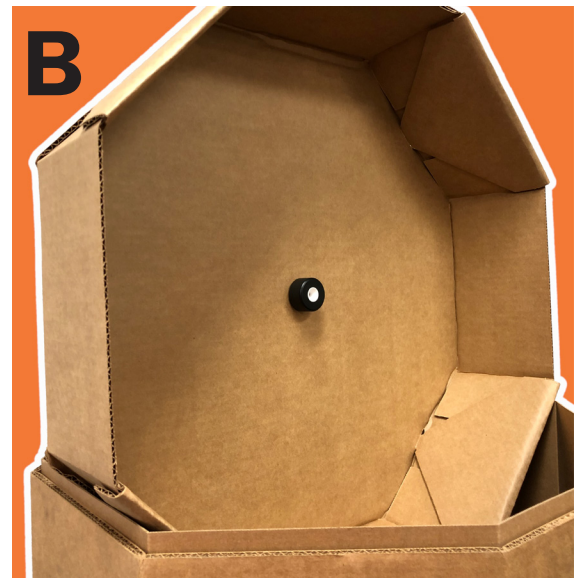
STEP THREE

Remove the lid and install a direct-pull kit into the desired wire protection method: 23.5" octagonal drum hood or the drum lid.

- If a drum hood will be used, the lid may be collapsed and recycled.
- If a drum hood will not be used, remove the "knock-out" in the center of the lid and install a direct-pull kit onto the drum lid. A lid outfitted with a direct-pull kit can be reused on other octagonal drums as a time-saving measure.

A: Direct Pull Kit and wire conduit installed onto an octagonal drum hood (shown below without kit).

B: Direct Pull Kit installed onto a drum lid.



STEP FOUR

Remove and discard the steel tie down bar used to hold the wire and float ring in place during transit. The tie down bar should be discarded outside of the drum to prevent interference with wire payoff.



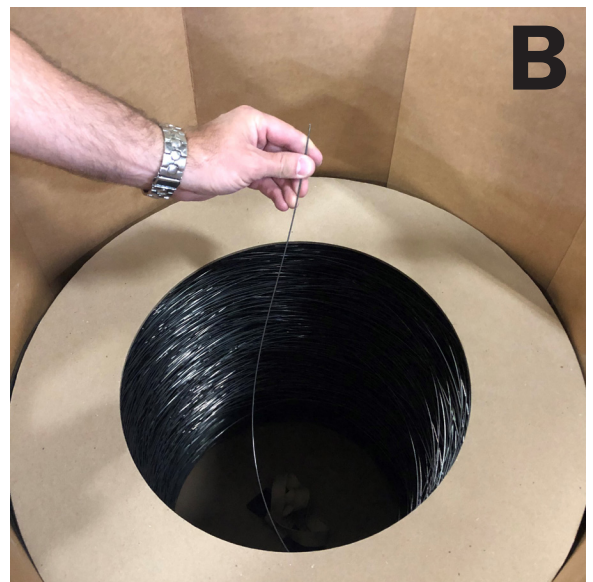
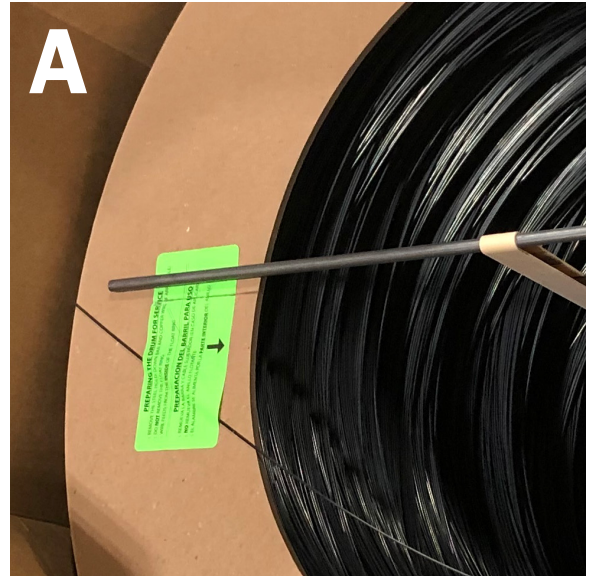
STEP FIVE

Do not remove or damage the cardboard float-ring. It is important that the float-ring is centered within the drum and free to move or “float” with the wire as it is consumed to prevent the wire from tangling.

Find the leading end of the wire and clip any sharp bends. The wire end should be feeding from under the float ring toward the center of the drum, not from under float-ring toward the outer edge of the drum.

A: Wire is retained by a label placed on the float ring.

B: Wire that has been clipped and is ready to feed.



PREPARING THE DRUM FOR SERVICE

- REMOVE THE STEEL HOLD-DOWN BAR AND COPPER WIRE (IF APPLICABLE)
- DO **NOT** REMOVE THE FLOAT RING
- WIRE FEEDS FROM THE **INSIDE** OF THE FLOAT RING

PREPARACION DEL BARRIL PARA USO

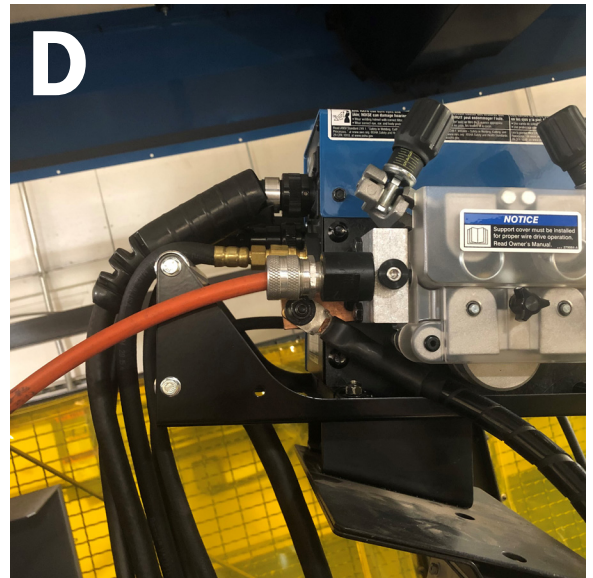
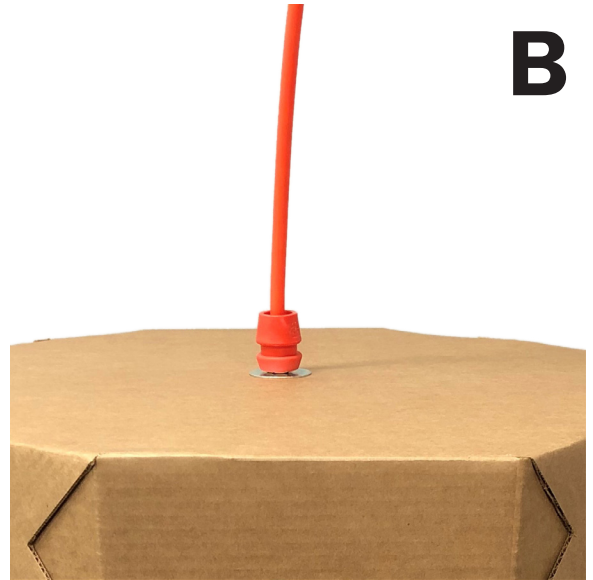
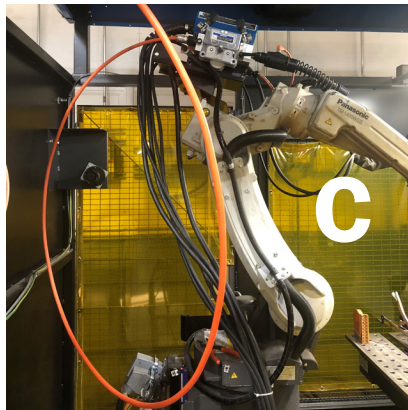
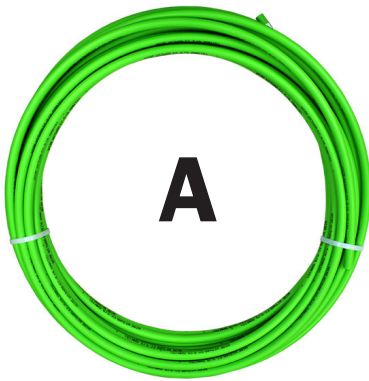
- REMUEVA LA BARRA Y CABLE SUJETADOR (EN CASO DE APLICAR)
- **NO** REMUEVA EL ANILLO FLOTANTE
- EL ALAMBRE SE ALIMENTA POR LA **PARTE INTERIOR** DEL ANILLO



STEP SIX




Ensure that the wire conduit is securely connected to the quick disconnects at both the drum lid/hood and the wire feeder (D)

- Use only conduit designed for welding wire. (A)
- Conduit should be straight for 12” to 18” after leaving the drum. (B)
- Conduit should have no sharp bends and any bend should have a minimum radius of 24” for each 90° with a maximum of 3 bends. (C)
- Conduit should be free of burrs, flash, or similar obstructions at both ends. Chamfer conduit edges using a utility knife or specialized countersink tool



STEP SEVEN

Feed the wire through the direct-pull kit, through the conduit to and through the feed rolls on the wire feeder.

-  **MOVING PARTS** can injure. Keep away from pinch points such as drive rolls.
-  **WELDING WIRE** can injure. Do not point gun toward any part of the body, other people, or any metal when threading welding wire.
-  Welding wire and drive parts are at welding voltage during operation – keep hands and metal objects away

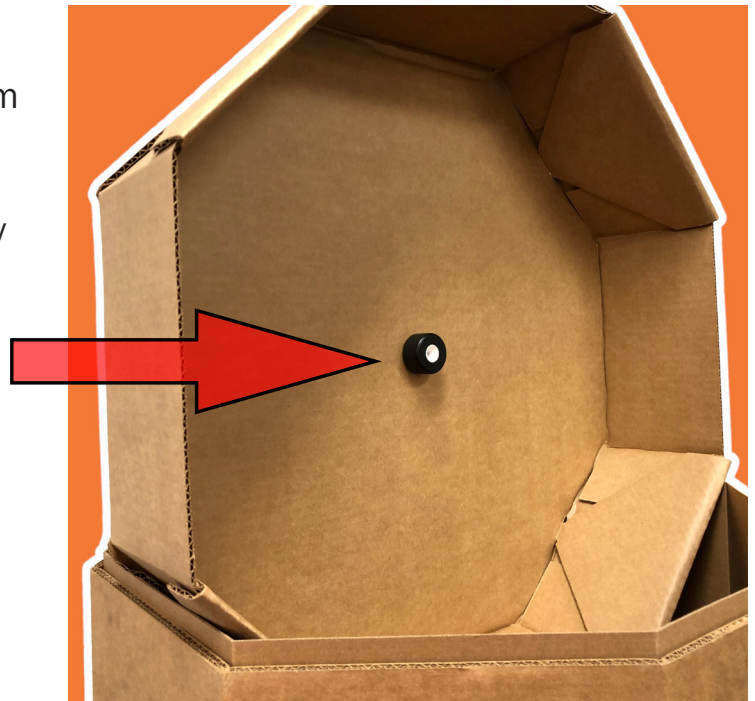


STEP ONE

Disconnect the wire conduit from the quick-disconnect at the drum hood/drum lid. Clip the wire and remove from the feeding system.

STEP TWO

When a direct pull kit is connected to a drum lid, reuse the lid on a new drum if it is in good condition. Break down the lid that is not connected to the direct pull kit. Begin by removing the direct-pull kit.



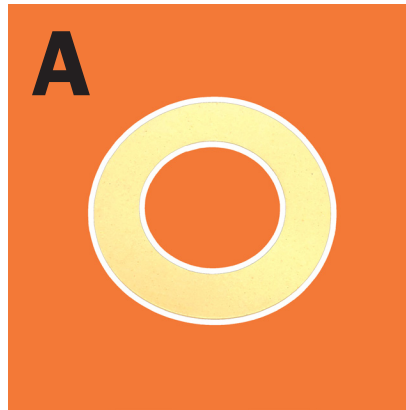
STEP THREE

Pull on the flaps inside of the drum lid to flatten the drum lid.



STEP FOUR

Remove and recycle the cardboard float ring (A). Remove and dispose of any remaining wire in the drum.



STEP FIVE

Remove the inner octagonal drum support. Fold this inner octagonal drum support as flat as possible; it is not necessary to tear the glued vertical seam, although doing so will allow further flattening.



STEP SIX

Pull on one side of the lifting strap to remove it from the drum. This lifting strap can be disposed of with other non-hazardous trash.

STEP SEVEN

Remove and recycle the strap retainer. Dispose of the rubber band used to secure the tie-down bar.



STEP EIGHT

Turn the drum over. Pull on the bottom flaps to dislodge the glue securing them in place.



STEP NINE

Collapse and recycle the main drum body. It is not necessary to tear the glued vertical seam, although doing so will allow further flattening.



STORAGE



Hobart bulk packaging shall be kept vertical during storage. Never drop, tip, or roll Hobart bulk packaging. Dropping, rolling, or tilting Hobart bulk packaging at any time will increase the likelihood of wire tangles while in use.

Hobart bulk packaging should never be stacked higher than indicated on package labeling. Tubular Products should be stored in a dry, enclosed environment and preferably at a constant temperature.

**DO NOT STACK
ON TOP
STORE IN A
DRY PLACE**

The storage temperature should be between 40°F (4°C) and 120°F (49°C) with a maximum of 80% humidity

Hobart bulk packaging should always be stored away from potential sources of damage to the packaging, such as moisture, open flames, or sparks from the welding process. In particular, moisture must NOT be allowed to come in contact with the packages. This includes dripping water, heavy condensation, or storing the product in standing water. Moisture contact may significantly affect the product performance and void the product warranty.

Cold product must be allowed to stabilize thermally (acclimate) within 10°F (6°C) of the temperature in the welding environment. Acclimation is particularly important when the product is stored at temperatures well below the welding environment temperature. If not acclimated, condensation can form directly on the product if opened in a warm environment while still cold.

Hobart bulk packaging is not recommended to be stored in a storage or drying oven at elevated temperatures as these temperatures can cause changes in the electrode performance.