



# How to Set-up Aluminum Drums

## 1000, 4000, and 5000 Series Alloys

### STEP 1



Remove the lid from the drum.

### STEP 2



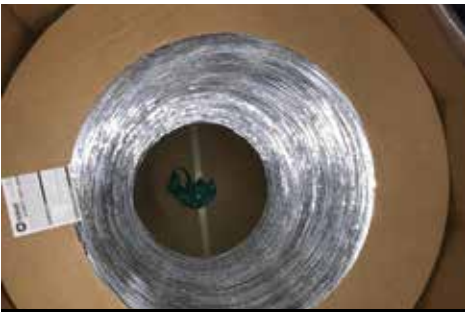
Remove the wire tie on the plastic bag and then pull the bag down over the drum.

### STEP 3



Remove the wood slats and release the rubber bands to the bottom of the drum.

### STEP 4



Center the rubber bands in the bottom of the drum. Any object/waste left in the bottom of the drum may cause tangles.

### STEP 5



Grasp the end of the wire and hold onto it while removing and discarding the cardboard ring. Pressure should be applied to the wire to prevent it from springing out of the drum.

### STEP 6 (1000/4000 SERIES)



1- Clip the loop from the end of the wire and insert the Top Hat Spinner device in the drum.  
2- Thread the wire into the device.

### STEP 6 (5000 SERIES)



Clip the loop from the end of the wire and place the clear plastic ring on top of the wire drum. The edges of the plastic ring must be pointing up and the wire must feed through the center of the ring for proper payout.

### STEP 7



Remove any burrs or flashing in the orange drum tube and connect it to the feeder and the Drum Tube Connect Kit.

### STEP 8



Thread the wire into the Drum Tube Connector Kit/drum tube and the orange conduit. The drum tube (orange tube 418750-005) should protrude 1/4" below the Drum Tube Connect Kit (418750-004).

**STEP 9**

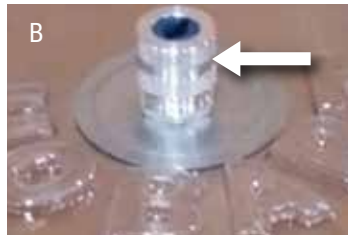


Push wire through the conduit and into feed roll system. Jog the wire through the welding gun and out the contact tube several feet.



For a step by step instructional video, please visit: <https://bit.ly/2MrEFR1>

## Components for Hobart Aluminum Drums



300 & 100 lb MAXALPAC Drum	
1XXX & 4XXX alloys	A, B, C, E
5XXX alloys	A, B, D, E

- A Drum Cone – Part Number 418750-001
- B Drum Tube Connect Kit – Part Number 418750-004)
- C 12" Top Hat Spinner 1XXX/4XXX Series only, 100 lb. and 300 lb. drums only – Part Number 418750-003
- D Drum Ring 5000 Series only – Part Number 418750-002
- E Drum Tube, order by the foot – Part Number 418750-005
- F Drum Roll Straightener – Optional, Part Number 418750-007
- G Feeder Inlet Guide Adaptor – Part Numbers as follows:  
 Miller Alumafeed: 418750-013  
 Miller S70: 418750-009  
 Panasonic: 418750-010  
 Fronius: 418750-011  
 OTC: 418750-012

