

MIGPONY[®]140

WELDING SYSTEM

SAFETY AND OPERATION MANUAL



Congratulations on purchasing the MIGPONY[®]140 Welder!

This manual is designed to help you get the most out of your MIGPONY[®]140. CAREFULLY REVIEW ALL SAFETY INSTRUCTIONS. Adherence to proper safety practices protects you from potential hazards on the worksite. Installation and operation are quick and easy. A Troubleshooting section is included that will help aid you in the event a problem arises with this unit. The parts list will then help you to decide the exact part(s) you may need to fix the problem. Warranty and service information are also provided. Keep this manual in a secure place for future reference. Write your invoice number, purchase date and purchase location below:

Invoice Number: _____ Purchase Date: _____

Purchase Location: _____

www.gaspony.com

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SECTION 1 – SAFETY INFORMATION

WARNING: READ BEFORE USING – AVOID INJURY TO YOURSELF AND OTHERS

WARNING: Only qualified persons should install, operate, maintain, and repair this unit.

WARNING: Keep other people, especially children, away during operation.



ELECTRIC SHOCK CAN KILL - Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit are electrically live whenever the output is on. The input power circuit and machine internal circuits are live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- DO NOT touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground. Use dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Avoid welding in damp locations, while wearing damp clothing, on metal structures or surfaces, in cramped locations where accidental contact with the work piece is likely.
- NEVER WORK ALONE!
- Disconnect input power before installing or servicing this equipment.
- Ensure that welder is properly installed and grounded according to manual specification and national, state, and local codes.
- When attaching inputs, attach ground first.
- Before each use, inspect all cords and cables for damage. Replace immediately if bare wiring is visible.
- When not in use, turn off all equipment.
- DO NOT wrap cables around your body. DO NOT drape cables over your body.
- When earth grounding the work piece, always use a separate cable that directly grounds.
- DO NOT touch electrode if any part of your body is in contact with the ground, work piece or electrode from another machine.
- DO NOT touch two electrode holders attached to different machines. Open-circuit voltage will be present.
- Maintain this equipment according to manual specifications. Repair and/or replace parts immediately as needed.
- Keep all panels and covers securely in place.
- Ensure the work clamp is positioned as closely to weld as practical with good metal to metal contact.
- When not in use, avoid contact of the work clamp with metal objects.
- DO NOT connect more than one electrode or work cable to a single weld output terminal.

 **WARNING**

FUMES AND GASES ARE OFTEN HAZARDOUS – Breathing gases generated from the welding process can be hazardous to your health.

- Avoid breathing fumes by keeping your head clear of fumes.
- Ensure that area is well ventilated. If necessary, force ventilation at the arc to remove welding fumes and gases.
- Wear an approved air-supplied respirator when area is poorly ventilated.
- ALWAYS read the Material Safety Data Sheets (MSDSs) and manufacturer's recommendations for consumables, coatings, degreasers, cleaners and filler metals.
- Extra precaution should be used while welding in confined areas. Ensure that breathing air is safe. Welding fumes and gases displace air and lower the oxygen level causing injury or death. Use an approved air-supplied respirator when needed.
- Avoid welding in locations with potential for high concentrations of chemical vapors. The heat and rays of the welding arc can react with vapors to form highly toxic and irritating gases.
- Remove all coatings from the weld area. Coatings can give off toxic fumes if welded.

 **WARNING**

GAS BUILDUP CAN INJURE OR KILL

- Shut off supply of gas when welder is not in use.
- ALWAYS ensure weld space is properly ventilated or use approved air-supplied respirator.

 **WARNING**

ARC RAYS CAN BURN EYES AND SKIN – The welding process produces visible and invisible (ultraviolet and infrared) rays. These rays can burn eyes and skin. Arc sparks are produced during the welding process which also can burn eyes and skin.

- ALWAYS wear an approved welding helmet with a shaded filter adequate to protect your face, eyes and skin when welding. Refer to ANSI Z49.1 and Z87.1
- ALWAYS wear approved safety glasses under the welding helmet.
- Protect others. Screens and barriers should be used to block sparks, flash and glare. Instruct others not to look at the arc.
- ALWAYS wear protective flame resistant clothing.

 **WARNING**

WELDING CAN CAUSE FIRE AND/OR EXPLOSION – Welding produces intense heat in the work piece and equipment. The welding arc can produce flying sparks. Ensure work area is safe before starting any welding process.

- Avoid buildup of combustible materials in work area. Remove combustible materials a minimum of 40 feet from work area. Use approved flame resistant materials to cover combustible materials that cannot be removed.
- DO NOT weld where flying sparks can come into contact with combustible materials.
- Protect yourself and others from flying sparks and hot metal.
- Be aware that welding on closed containers such as tanks, pipes or drums can result in explosion. Properly prepare closed containers according to AWS F4.1
- Small cracks and openings can allow welding sparks and hot metal to move to adjacent areas.
- Keep a fire extinguisher close to welding area and be alert for fire.
- Reduce the risk of electric shock, sparks and fire hazard from the weld current by connecting the work cable to the work area as close to the weld as practical.
- DO NOT thaw frozen pipes with the welder.
- Cut off welding wire at contact tip when not in use.
- Wear flame resistant protective gear. Ensure protective gear is oil and grease free.
- DO NOT keep matches or butane lighters on your person while welding.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work.

 **WARNING**

HOT METAL CAN CAUSE SEVERE BURNS

- DO NOT touch hot parts without approved safety gloves.
- Allow gun to cool before repair or exchange of consumables.
- Wear heavy, insulated welding gloves and clothing to prevent burns.

 **WARNING**

EYE PROTECTION

- ALWAYS wear an approved welding helmet with a shaded filter adequate to protect your face, eyes and skin when welding. Refer to ANSI Z49.1 and Z87.1
- Welding, chipping, wire brushing and grinding cause sparks and/or flying metal.
- Welding produces slag (molten metal).
- ALWAYS wear approved safety glasses, even under your welding helmet.
- To maximize protection, choose approved safety glasses with side shields.

 **WARNING****EAR PROTECTION**

- Certain processes or equipment produce high levels of noise.
- Wear approved ear protection.

 **WARNING**

ELECTROMAGNETIC FIELDS – The welding process generates electromagnetic fields that can interfere with electrical devices. Research is proceeding to determine the health risk to humans exposed to electric or magnetic fields. To reduce magnetic fields in the workplace adhere to the following:

- A wearer of a pacemaker should keep away during any welding process until they have consulted their physician.
- Keep cables close together by twisting or taping.
- Keep cables away from operator and to a single side.
- DO NOT coil or drape cables around your body.
- Keep power source and cables as far away from operator as practical.
- Keep work clamp connected to work piece as close to the weld as practical.

 **WARNING**

CYLINDERS CAN EXPLODE IF DAMAGED – Shielding gas cylinders contain gas under high pressure. Inspect the cylinder for dents, gouges or other types of damage. A damaged cylinder can explode.

- Protect gas cylinders from excessive heat, mechanical shock, physical damage, slag, open flames, sparks and welding arcs.
- Maintain cylinders in a upright position. Secure cylinders to a stationary support. DO NOT allow cylinder to fall.
- Cylinders must be kept away from the welding process and electrical circuits.
- NEVER drape a welding torch over a gas cylinder.
- NEVER touch a gas cylinder with an electrode.
- NEVER weld on a pressurized cylinder.
- Identify your application and only use correct shielding gas cylinders, regulators, hoses and fittings. Keep all well maintained and replace as needed.
- NEVER face valve outlet when opening.
- ALWAYS keep protective cap over the valve when cylinder is not in use.
- Cylinders are heavy and may require specialized equipment or multiple people to move and position safely.
- Read and comply with instructions from Compressed Gas Association (CGA) publication P-1.



CALIFORNIA PROPOSITION 65 WARNINGS

- Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defect and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)
- Battery posts, terminals and related accessories contain lead and lead compounds, chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Wash hands after handling.

SECTION 2 – SPECIFICATIONS

Rated input	115 VAC, 60 Hz, 20 Amps
Maximum output open-circuit voltage	28 VDC
Rated output	90 Amps @ 18 V, 20% duty cycle***
Wire feed speed	59 to 393 in/min (1.5-10.0 m/min)
Wire Size	Solid Steel: .023" - .030" (0.6-0.8 mm) Flux Cored: .030" - .035" (0.8-0.9 mm)
Wire Spool Size	8" x 2" (200 x 50 mm) 4" x 5/8" (100 x 16 mm)
Weight	45 lb (20.6 kg)
Dimensions (Length x Width x Height)	16" x 9.6" x 14.5" (408 x 244 x 367 mm)

***NOTE: Duty Cycle is defined as “The amount of time in a ten-minute period that an electrical device can perform work without overheating.” This machine can run for 2 minutes and must rest for 8 minutes within any consecutive 10 minute period to prevent overheating.

SECTION 3 – CONTENTS

Carefully unpack machine and components. Ensure that the package contains the following:

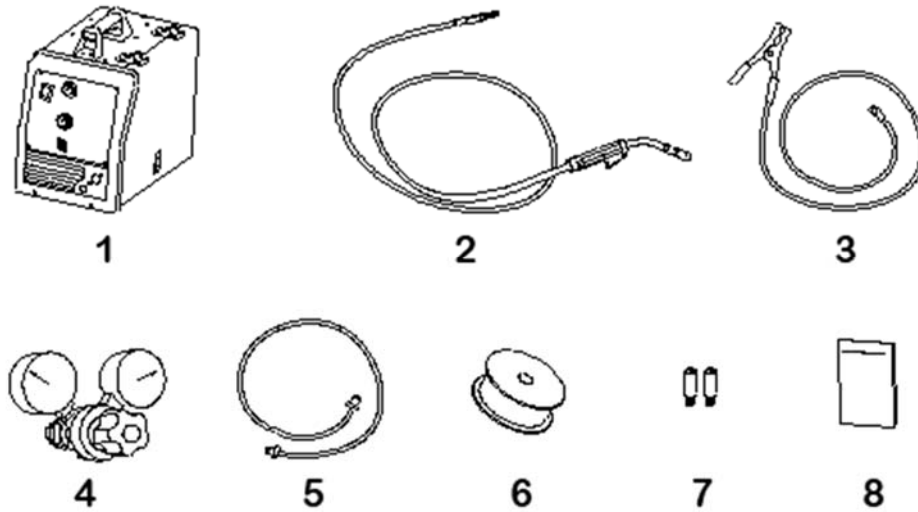


Figure 1

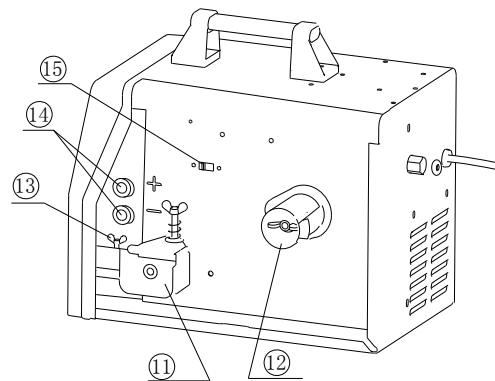
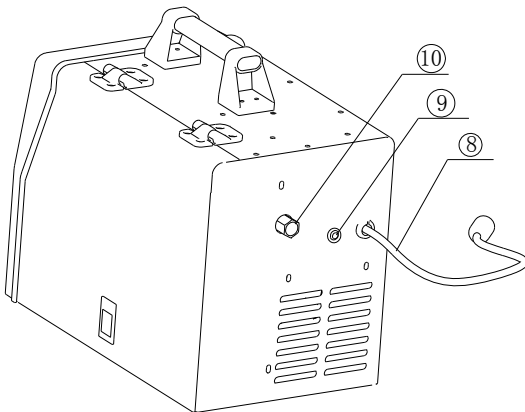
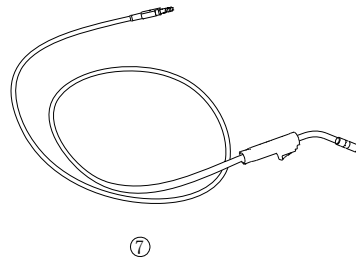
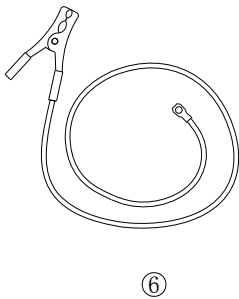
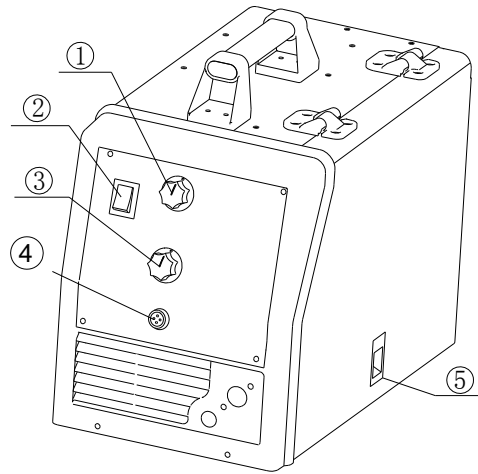
Parts List:

1. Power Supply
2. Welding Gun
3. Work Clamp
4. Regulator/Flow Gauge
5. Gas Hose
6. 2 lb Spool .023" Solid MIG Wire
7. .030" & .035" Contact Tips (pre-installed .023" contact tip not shown)
8. Safety and Operation Manual

Optional Spool Gun (not included) - Contact your local Thoroughbred Industrial Cylinder Exchange dealer or visit www.gaspony.com Part #: TB-SG

SECTION 4 – COMPONENTS AND CONTROLS

1. Output voltage adjust knob
2. Power switch
3. Wire feed rate adjust knob
4. Gun trigger lead connectors
5. Latch
6. Ground (work) clamp and cable
7. Welding gun and cable assembly
8. Power cord
9. Reset overload protective device - the protector will cut off the circuit if the welding machine is in excess of the maximum load, after which the switch must be manually reset.
10. Shielding gas inlet fitting 5/8"-18UNF
11. Wire feed gearbox
12. Wire spool spindle/shaft
13. Wing screw to fasten welding gun
14. Positive (+) and Negative (-) output terminals
15. Change switch(for optional spool gun)



SECTION 5 – INSTALLATION

5.1 Installing the Work Clamp

(See Figure 2, Figure 3, Figure 4)

1. Power off the welding machine.
2. Open the right-side panel of the welding machine
3. Insert the lug end of the ground clamp through access hole ②
4. Route the cable of the work clamp around the wire feed gearbox and connect it to the negative (-) output for GMAW (Figure 3) or the positive (+) output for FCAW (Figure 4)
5. Tighten the lug plate attached to the end of the wire with wing screw ④.

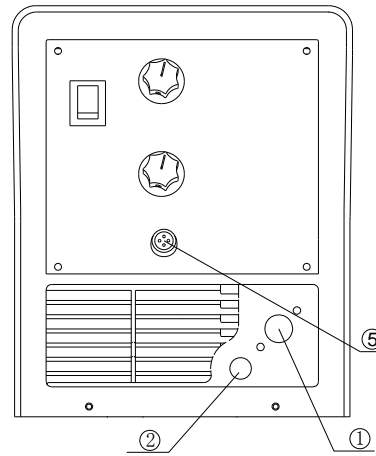


Figure 2

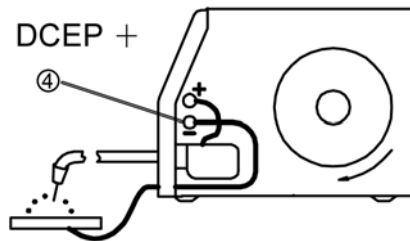


Figure 3 (GMAW)

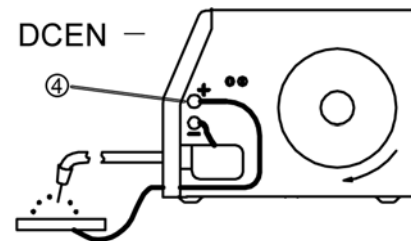


Figure 4 (FCAW)

NOTE: The short power cable must be connected to the opposite terminal as the Work Clamp: Positive (+) for GMAW and negative (-) for FCAW.

5.2 Installing the Welding Gun

(See Figure 2, Figure 5, Figure 6)

1. Power off the welding machine.
2. Insert the welding gun end into access hole ① (Figure 2). Tighten the wing screw ③ to secure the gun (Figure 5).
3. Plug the gun trigger connector into trigger terminal ⑤ (Figure 2).
4. The gun changing switch ⑦ should be in the MIG position for standard welding.
5. When using .030-.035" (0.8-0.9mm) wire, install the correct size contact tip in the welding gun ⑥ (Figure 6). Unscrew welding nozzle, remove and replace contact tip and replace nozzle.

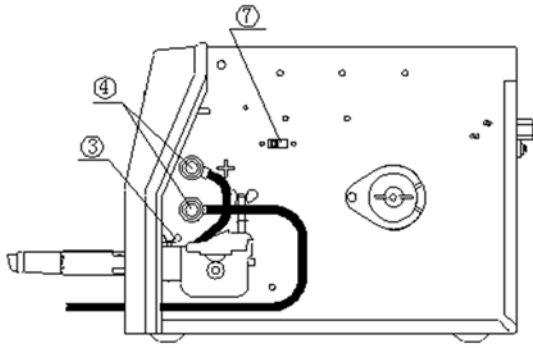


Figure 5

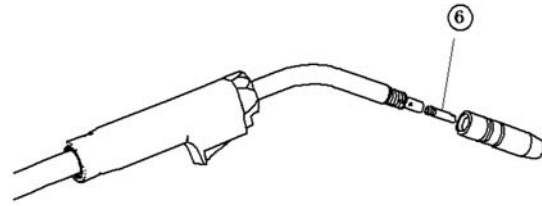


Figure 6

5.3 Installing the Drive Roll

(See Figure 7)

The MIGPONY®140 is equipped with a reversible dual groove wire drive roll. The smaller groove is for .023" (0.6mm) solid wire only. The larger groove is for .030-.035" (0.8-0.9mm) solid or flux-cored welding wire. The default installation is .023" (0.6mm). When using .030-.035" (0.8-0.9mm) welding wires, the drive roll must be changed.

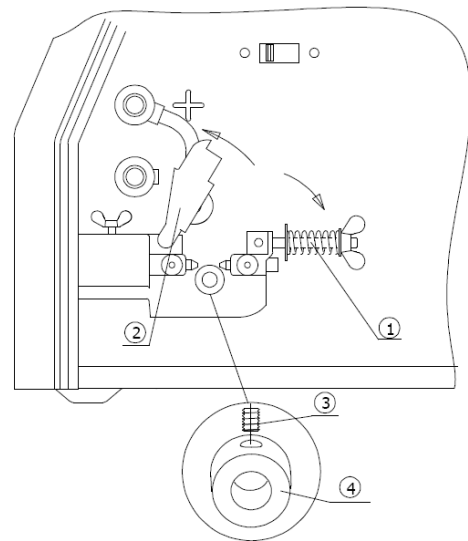


Figure 7

1. Power off the welding machine.
2. Unlatch the spring loaded pressure arm ① and lift up the idle roll arm ②.
3. Loosen the hex bolt ③ that attaches the wire drive roll.
4. Remove the wire drive roll ④ and flip the wire drive roll over so that the .030" (0.8mm) mark faces the user.
5. Reinsert the wire drive roll and tighten the hex bolt.

5.4 Installing the Welding Wire

(See Figure 8, Figure 9, Figure 10)

The MIGPONY®140 can use wire spools up to 8" (200mm) diameter with a maximum width of 2" (50mm). A spindle adapter is pre-installed for an 8" (200mm) diameter wire spool. The following wire installation should be performed only when the machine is powered off.

Installing an 8" (200mm) diameter wire spool.
(See Figure 8)

1. Insert the wire spool ① on the wire spindle ②. Ensure that the wire spool spindle tab ③ engages the hole in the wire spool.

(Note: The wire spool will rotate clockwise when the wire is de-reeled.)

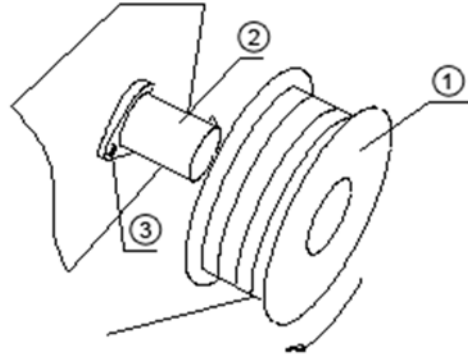


Figure 8

Installing a 4" (100mm) diameter wire spool.
(See Figure 8, Figure 9)

1. Remove the 2" (50mm) diameter spindle adapter ② (See Figure 8) by first removing the wing nut ⑤.
2. Remove the plastic spacer ⑥.
3. Mount 4" (100mm) diameter wire spool directly onto 5/8" (16mm) shaft ⑦.
4. Reinstall the plastic spacer ⑥ and wing nut ⑤.

(Note: The wire spool will rotate clockwise when the wire is de-reeled.)

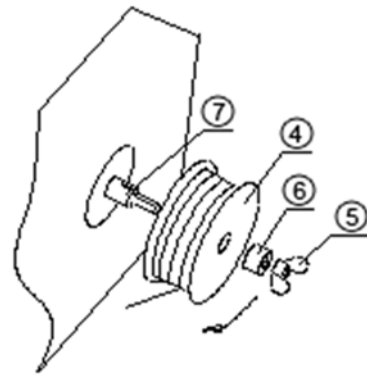


Figure 9

Thread the Welding Wire
(See Figure 10)

1. Power off the welding machine.
2. Release the spring loaded pressure arm ① and lift up the idle roll arm ②. Ensure the groove size matches the wire size. (See section 5.3 for wire drive roll installation)
3. Carefully pull out the welding wire ③ from wire spool. Maintain tension on the wire to prevent unwinding.
4. Cut starting end of the welding wire and straighten the lead section. You will need approximately a 4" (100mm) section of straightened wire.
5. Thread the straightened wire through the inlet guide tube ④ to the drive roll groove ⑤, and then guide the wire into the tube liner ⑥, continue to push the wire into the tail piece of the gun for approximately 6" (150mm).

- Return the idle roll arm ② back into the welding position and reset the spring loaded pressure arm ①.

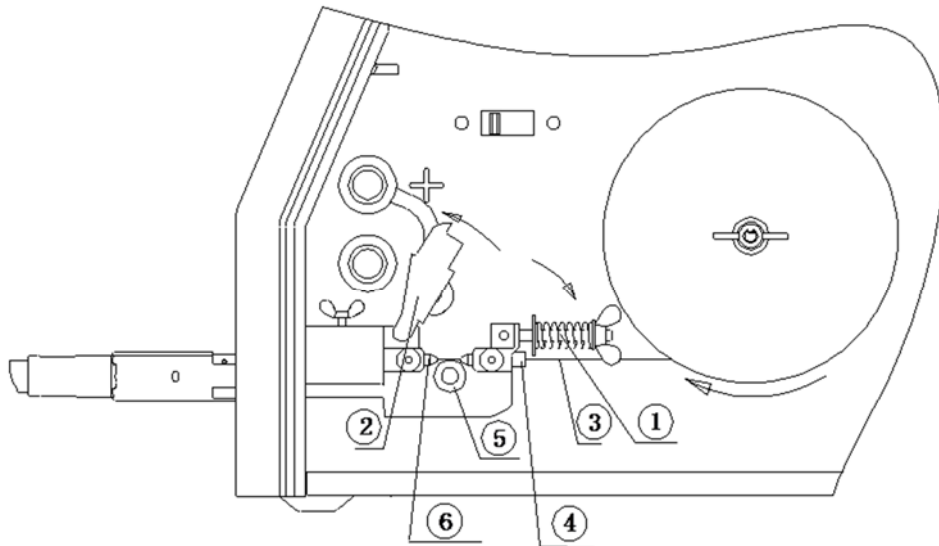


Figure 10

- Remove nozzle and contact tip from welding gun.
- Power on the welding machine.
- Straighten welding gun.
- Depress trigger switch on welding gun to feed welding wire. When welding wire is exposed at the outlet side of the welding gun, release the trigger switch.
- Power off the welding machine.
- Reinstall the contact tip and nozzle.
- Cut welding wire leaving approximately 1/4-1/2" (6-10mm) protruding from tip end of the gun.

5.5 Installing the Shielding Gas

(See Figure 11)

There are many different types of shielding gases that have been developed over the years, A general chart for common shielding gases and where they are used is below.

Gas	Application			
	Spray Arc Steel	Short Circuiting Steel	Short Circuiting Stainless Steel	Short Circuiting Aluminum
Argon				All positions
75% Argon + 25% CO2	Flat & Horizontal* Fillet	All Positions	All Positions**	
CO2	Flat & Horizontal* Fillet	All Positions		
Tri-Mix***			All Positions	

*Globular Transfer

**Single Pass Welding Only

***90% HE + 7-1/2% AR + 2-1/2% CO2

The flow regulator supplied in this package is suitable for 75% Argon + 25% CO2 mixed shielding gas which is used in the GMAW process. Obtain a compressed gas cylinder from your local welding supplier or from an authorized Thoroughbred Industrial Cylinder Exchange cage. For cage locations near you, visit www.gaspony.com

1. Power off the welding machine.
2. Secure the compressed cylinder to a wall, cylinder cart or other approved device with a chain or bracket system designed to prevent the cylinder from falling.
3. Once secured, remove cylinder cap.
4. Install flow regulator (CGA-580) to the supply valve on the cylinder and tighten with wrench.
5. Install one end of the gas supply hose to the outlet of the flow regulator and tighten. Connect the other end of the hose to the gas inlet located in the rear of the MIGPONY®140 machine. (The connector nipple 5/8-18 adapts to CGA-032) Ensure that the hose has no twisting or knotting.
6. Slowly twist the gas cylinder valve to start gas flow. Listen for leaking gas. If gas leakage is present, close valve disconnect flow regulator and hose and repeat steps 4 through 6.
7. Power on the welding machine.
8. Depress gun trigger switch and adjust the flow regulator to 25-30 cubic feet per hour (CFH), (12-14 In/min).
9. When welding process is complete, close valve on gas cylinder. Depress gun trigger to release excess gas. Power off the welding machine.

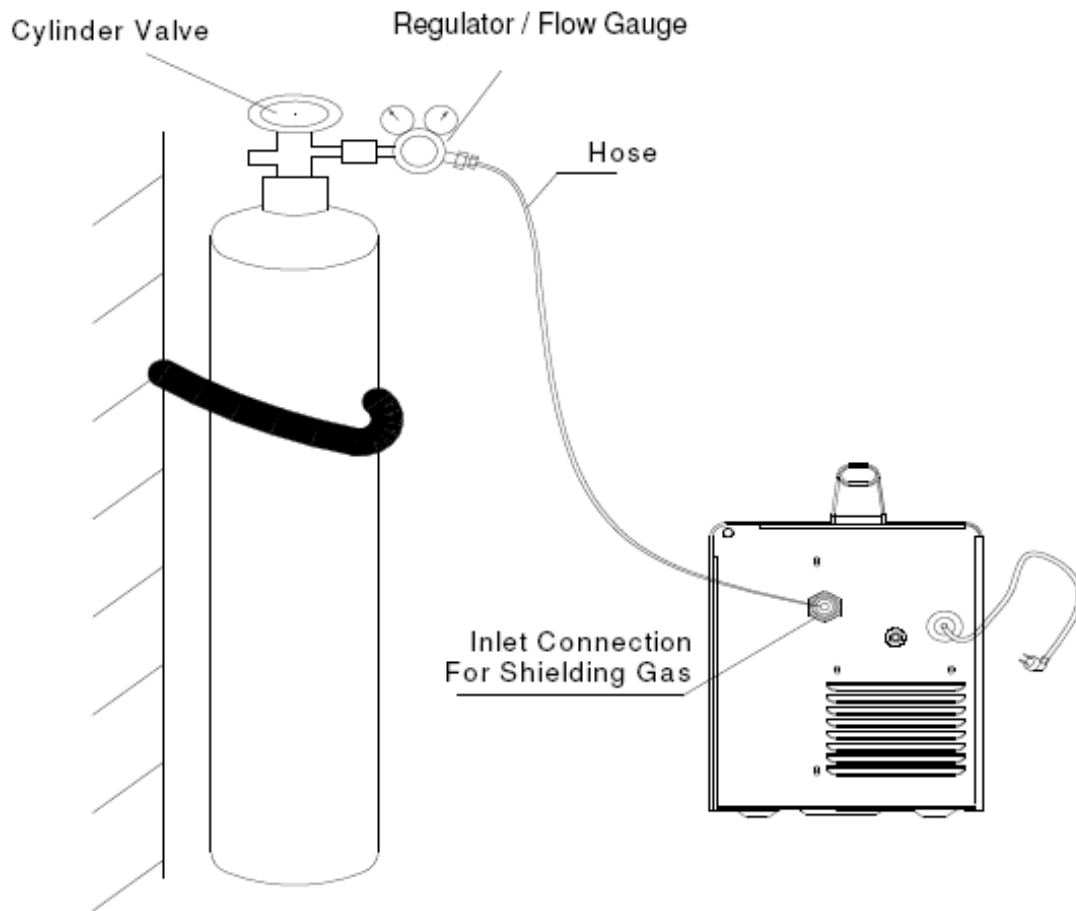
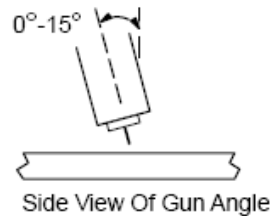
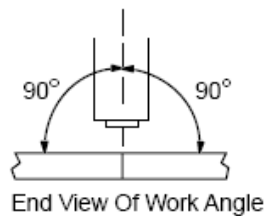
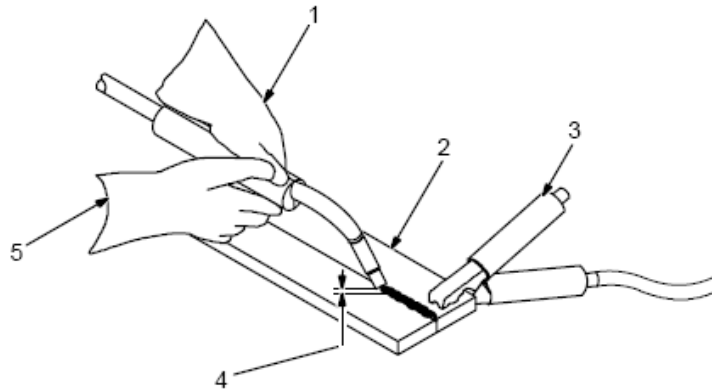


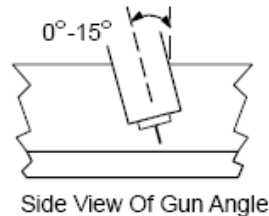
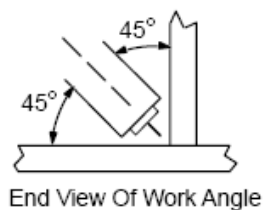
Figure 11

SECTION 6 – WELDING PROCESS

1. Refer to the “Welding Control Guide” located on the inside right panel of the welding machine and in this manual (page 18).
2. Set output voltage, wire feed speeds and polarity on the welder according to the welding wire type in use.
3. When not using flux-cored wires, use proper shielding gas mixture. (See Section 5.5)
4. Connect work clamp to work piece(s) as close to the weld as practical. Ensure good metal to metal contact.
5. The welding gun should have free movement in the area of the piece(s) to be welded.
6. Power on the welding machine.
7. Make sure wire is no more than 1/2” (13mm) past end of nozzle and tip of wire is positioned correctly on seam. (See Figure 12)



GROOVE WELDS



FILLET WELDS

Figure 12

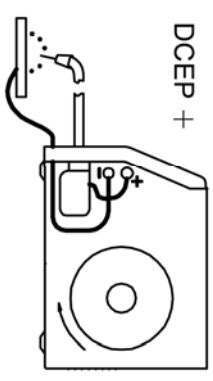
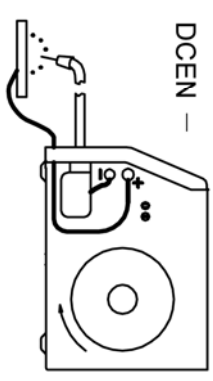
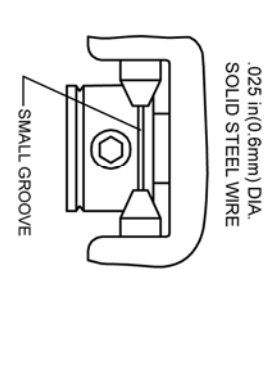
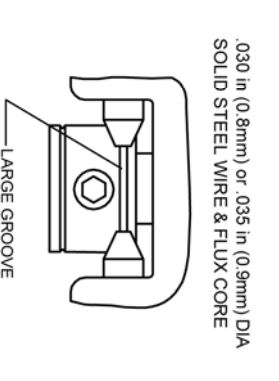
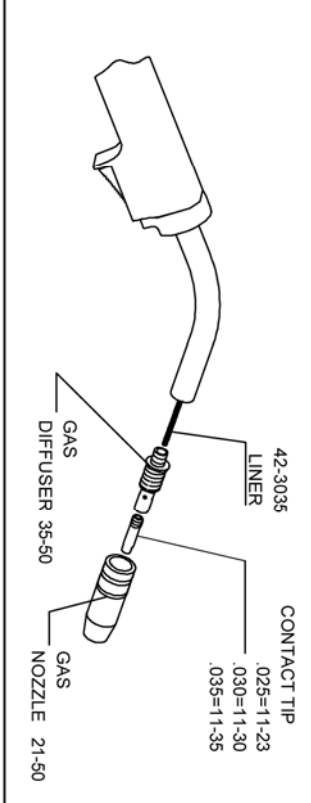
8. Always wear fire resistant protective safety clothing. Cover eyes with approved welding helmet.
9. Keep contact tip of the welding gun approximately 3/8 – 1/2” (10-13mm) away from weld seam.
10. Depress trigger switch on welding gun and begin to weld.
11. Release trigger switch to end welding pass.
12. When welding is complete, close valve on shielding gas cylinder. Depress trigger switch on welding gun to vent excess gas.
13. Power off the welding machine.

WELDING CONTROL GUIDE

MIGPONY140

Recommended voltage, wire speed and polarity settings						
STEEL	WIRE SIZE	WIRE TYPE	POLARITY DCEP= + DCEN= -	GAS C25 = 25% CO ₂ 75% Argon	VOLTAGE	WIRE SPEED
24 ga .024 in 0.60mm	.025	ER70S-6	+	C25	3	25
20 ga .036 in 1.0mm	.025 .030	ER70S-6 ER70S-6	+	C25 C25	4 5	40 35
18 ga .048 in 1.2mm	.025 .030 .030	ER70S-6 ER70S-6 E71T-11	+	C25 C25 NONE	6 5 2	55 40 30
16 ga .060 in 1.6mm	.025 .030 .030 .035	ER70S-6 ER70S-6 E71T-11 E71T-11	+	C25 C25 NONE NONE	7 6 3 3	65 45 30 25
12 ga .105 in 2.5mm	.025 .030 .030 .035	ER70S-6 ER70S-6 E71T-11 E71T-11	+	C25 C25 NONE NONE	10 8 4 4	80 60 40 35
1/8 IN 3.2mm	.030 .035	E71T-11 E71T-11	-	NONE NONE	4 4	40 35
3/16 in 4.8mm	.030 .035	E71T-11 E71T-11	-	NONE NONE	5 5	45 35

Wire speed and voltage settings are for basic starting reference only. The settings can be adjusted while welding, adjust as required.

CHANGING POLARITY SETTINGS	
<p>DCEP +</p> 	<p>DCEN -</p> 
<p>DRIVE ROLL SETTING---MATCH GROOVE TO DIAMETER OF WIRE</p>	
 <p>.025 in (0.6mm) DIA. SOLID STEEL WIRE</p> <p>SMALL GROOVE</p>	 <p>.030 in (0.8mm) or .035 in (0.9mm) DIA SOLID STEEL WIRE & FLUX CORE</p> <p>LARGE GROOVE</p>
	

SECTION 7 – TROUBLE SHOOTING

Problem	Solution
No weld output, wire does not feed, fan does not run	<ol style="list-style-type: none"> 1. Check that power cord is undamaged and plug is secure in receptacle. 2. Check fuse box and reset circuit breaker if open. 3. Check that power switch is turned to “on” position on welder.
No weld output, wire does not feed, fan motor continues to run	<ol style="list-style-type: none"> 1. Unit could be overheating. Allow fan to run for unit to cool down. Refer to Section 2 for duty cycle information 2. Check that gun is properly attached to welder. 3. Release gun trigger switch and cycle machine power off and back on.
No weld output, wire feeds	<ol style="list-style-type: none"> 1. Check that work clamp is secured to work piece with good metal to metal connection. 2. Check that polarity is set correctly. 3. Check that gun is properly connected to welder. 4. Replace contact tip.
Low weld output	<ol style="list-style-type: none"> 1. Check that input voltage is correct or check for low line voltage. 2. Check that power switch is in “on” position on welder.
Wire feeding stops during welding	<ol style="list-style-type: none"> 1. Straighten gun cable and replace damaged parts. 2. Check and adjust drive roll. Make sure correct groove is used. 3. Adjust tension on wire. 4. Replace contact tip if blocked. 5. Clean wire inlet guide or gun liner if dirty. 6. Check for obstructions at drive assembly.

Find your nearest Thoroughbred Authorized Service / Repair Center by visiting www.gaspony.com

SECTION 7 – WARRANTY INFORMATION

LIMITED WARRANTY - MIGPONY®140 WELDER - LIMITED 1 YEAR / 90 DAY WARRANTY

STATEMENT OF LIMITED WARRANTY. THOROUGHbred INDUSTRIAL CYLINDER EXCHANGE MAKES EVERY EFFORT TO ENSURE THAT ITS PRODUCTS MEET HIGH QUALITY STANDARDS AND WARRANTS THE FOLLOWING TO THE ORIGINAL END USER (PURCHASER): NINETY (90) DAYS, FROM THE DATE OF PURCHASE, THAT THE GUN, LINER, WIRE FEED MECHANISM, WELDING CLAMPS, ELECTRODE HOLDER, CABLES AND ACCESSORIES PACKAGED WITH THE WELDER ARE FREE OF DEFECTS IN MATERIAL AND WORKMANSHIP. THIS DOES NOT APPLY TO CONSUMABLE PARTS, TIPS, NOZZLES AND WELDING WIRE. ONE (1) YEAR, FROM THE DATE OF PURCHASE, THAT THE TRANSFORMER AND RECTIFIERS ARE FREE OF DEFECTS IN MATERIAL AND WORKMANSHIP.

THIS WARRANTY IS VOID IF THOROUGHbred INDUSTRIAL CYLINDER EXCHANGE OR ITS AUTHORIZED SERVICE CENTERS FINDS THAT THE EQUIPMENT HAS BEEN SUBJECTED TO IMPROPER INSTALLATION, CARE, UNAUTHORIZED MODIFICATION, TAMPERING, INADEQUATE MAINTENANCE, IMPROPER STORAGE OR ABNORMAL USE. THIS LIMITED WARRANTY IS NOT TRANSFERABLE FROM THE ORIGINAL PURCHASER TO A SECOND OWNER. IN NO EVENT IS THOROUGHbred INDUSTRIAL CYLINDER EXCHANGE LIABLE OR RESPONSIBLE FOR ANY INJURY, DAMAGE, OR LOSS RESULTING EITHER DIRECTLY OR INDIRECTLY FROM THE USE OR MISUSE OF THIS PRODUCT. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

To take advantage of this warranty, the product or part must be returned to Thoroughbred Industrial Cylinder Exchange or its authorized service centers with transportation charges prepaid. Proof and date of purchase, with an explanation of the complaint, must accompany the merchandise. If our inspection verifies a defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily or quickly provide purchaser with a replacement. Thoroughbred Industrial Cylinder Exchange will return repaired products at our expense, but if Thoroughbred Industrial Cylinder Exchange determines there is no defect, or that the defect resulted from causes not within the scope of our warranty, then the purchaser must pay the cost for the return of the product.

This warranty gives the purchaser specific legal rights and they may also have other rights, which vary from state to state. www.gaspony.com

