CIGWELD

AN ESAB BRAND

100+ YEARS OF WELDING INNOVATION

DURAGUIDE



P/N: 208595
P/N: 208596
P/N: 208615

OPERATING MANUAL

CIGWELD
AN ESAB BRAND

WE APPRECIATE YOUR BUSINESS!

Congratulations on your new CIGWELD product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and world-wide service network.

This Operating Manual has been designed to instruct you on the correct use and operation of your CIGWELD product. Your satisfaction with this product and its safe operation is our ultimate concern. Therefore please take the time to read the entire manual, especially the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product.

We have made every effort to provide you with accurate instructions, drawings, and photographs of the product(s) while writing this manual. However errors do occur and we apologize if there are any contained in this manual.

Due to our constant effort to bring you the best products, we may make an improvement that does not get reflected in the manual. If you are ever in doubt about what you see or read in this manual with the product you received, then check for a newer version of the manual on our website or contact our customer support for assistance.

YOU ARE IN GOOD COMPANY!

The Brand of Choice for Contractors and Fabricators Worldwide.

CIGWELD is a Market Leading Brand of Arc Welding Products for ESAB. We are a mainline supplier to major welding industry sectors in the Asia Pacific and emerging global markets including; Manufacturing, Construction, Mining, Automotive, Engineering, Rural and DIY.

We distinguish ourselves from our competition through market-leading, dependable products that have stood the test of time. We pride ourselves on technical innovation, competitive prices, excellent delivery, superior customer service and technical support, together with excellence in sales and marketing expertise.

Above all, we are committed to develop technologically advanced products to achieve a safer working environment for industry operators.

100+ YEARS OF WELDING INNOVATION

WARNING

Read and understand this entire Manual and your employer's safety practices before installing, operating, or servicing this product. While the information contained in this Manual represents the Manufacturer's best judgement, the Manufacturer assumes no liability for its use.

CIGWELD DURAGUIDE KIT OPERATING MANUAL FOR:

P/N 208595
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RECORD THE FOLLOWING INFORMATION FOR WARRANTY PURPOSES:

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Equipment Serial #:

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SECTION 1: INTRODUCTION

1.01 DESCRIPTION

The CIGWELD DuraGuide range is designed to make straight-line, circle and bevel cutting easier, smoother and more precise. Featuring a non-jamming hub, consistent tip-height control, adjustable pivot lengths and magnetic or suction pivot options, DuraGuide helps improve cutting stability, accuracy and overall cut quality. The range provides a reliable and versatile solution for a wide variety of cutting torches and demanding workshop and industrial applications.

The DuraGuide Guide Kit brings together the essential guide components in one complete accessory kit, making it a convenient go-to solution for a wide range of gas and plasma cutting applications. Packed in a durable hard case for easy storage, protection and transport, the kit provides users with a practical and versatile setup for straight-line, circle and bevel cutting.

1.02 IDENTIFYING THE GUIDE KIT COMPONENTS



SECTION 2:
GETTING THE MOST FROM YOUR DURAGUIDE KIT

2.01 ROLLER GUIDE SETUP OPTIONS

ROLLER GUIDE SETUP 1

Straight-Line Cutting

Position the roller guide against a suitable straight edge to guide the torch along the required cutting path. Set the guide to achieve the correct tip-to-work distance before commencing the cut. Keep the guide in contact with the straight edge throughout the cut to maintain smooth movement and consistent cutting results.

This setup can also be used to cut marked out shapes.



ROLLER GUIDE SETUP 2

Straight-Bevel Cutting

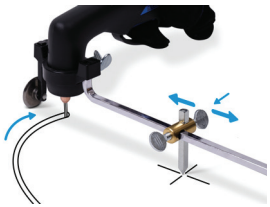
Adjust the height of the roller guide wheels to achieve the required torch angle for straight-bevel cutting. Check the torch position and tip-to-work distance before commencing the cut to ensure smooth movement and consistent cutting results.



ROLLER GUIDE SETUP 3

Circle Cutting

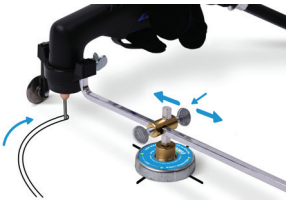
Fit the radius bar to the roller guide assembly and position the straight pivot pin at the centre of the required circle. Adjust the cutting radius by sliding the radius bar to the desired position, then secure it using the fasteners. Check the torch and pivot alignment before cutting to achieve a smooth and accurate circular cut.



ROLLER GUIDE SETUP 4

Circle Cutting with Magnetic Pivot

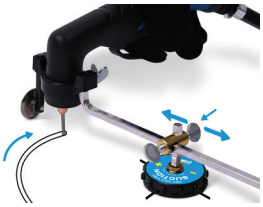
For cutting on steel plate, attach the magnetic pivot to the straight pivot pin as shown to provide a secure and stable centre point. Position the magnetic pivot so the alignment grooves in the base are aligned with the centre of the required cutting circle, then secure the setup before commencing the cut.



ROLLER GUIDE SETUP 5

Circle Cutting with Suction Pivot

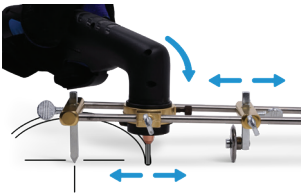
For cutting on non-steel or non-magnetic surfaces, attach the suction pivot to the straight pivot pin as shown to provide a secure and stable centre point. Position the suction pivot so the straight pivot pin is aligned with the centre of the required cutting circle, then secure the setup before commencing the cut.



2.02 CIRCLE GUIDE SETUP OPTIONS

CIRCLE GUIDE SETUP 1

Circle Cutting with Magnetic Pivot

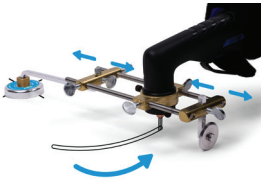


For small diameter circles, fit the pivot pin to the fixed end of the circle guide rail and the guide wheel to the adjustable end. Position the pivot pin on the marked centre point, then slide both the torch body attachment and the adjustable guide wheel end along the circle guide rail to set the required cutting radius. Begin the cut and rotate the guide rail smoothly in one continuous motion, keeping the torch and guide assembly aligned until the circle is complete.

For added stability and improved cutting accuracy, the magnetic pivot or suction pivot can be attached to the pivot pin, depending on the work surface, to help maintain a secure centre point throughout the cut.

CIRCLE GUIDE SETUP 2

Circle Cutting with Suction Pivot

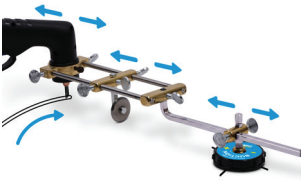


For large diameter circles, fit the guide wheel to the fixed end of the circle guide rail and the pivot pin/radius bar/ radius arm to the adjustable end. Position the pivot point on the marked centre of the circle, then slide both the torch body attachment and the adjustable pivot end along the circle guide rail to set the required cutting radius. Begin the cut and rotate the guide rail smoothly in one continuous motion, keeping the torch and guide assembly aligned until the circle is complete.

For added stability and improved cutting accuracy, the magnetic pivot or suction pivot can be attached to the pivot pin, depending on the work surface, to help maintain a secure centre point throughout the cut.

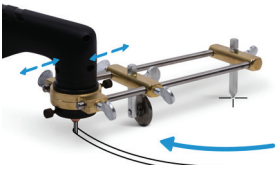
CIRCLE GUIDE SETUP 3

Circle Cutting at an Edge



For cutting large diameter circles or curves near the edge of a metal workpiece, configure the circle guide rail with the fixed end connected to the radius arm/radius bar. Fit the guide wheel to the adjustable end and position the torch body attachment towards the outer end of circle guide rail.

Slide the torch body attachment and adjustable guide wheel end along the circle guide rail to set the required cutting radius. Ensure the pivot point is correctly positioned, and all adjustments are secure before commencing the cut.

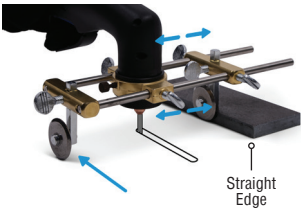


For smaller diameter circles or curves, replace the radius arm or radius bar with the straight pivot pin fitted directly to the fixed end of the circle guide rail.

For added stability and improved cutting accuracy, the magnetic pivot or suction pivot can be attached to the pivot pin/radius bar/ radius arm, depending on the work surface, to help maintain a secure centre point throughout the cut.

CIRCLE GUIDE SETUP 4

Straight-Line Cutting

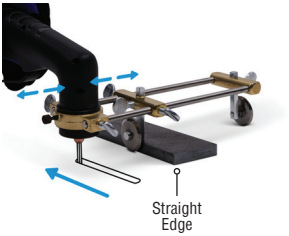


For improved stability during straight-line cutting, the circle guide rail can be configured with guide wheels fitted to both the fixed and adjustable ends, with the torch body attachment positioned between them. Position the guide wheel at the adjustable end against a suitable straight edge to maintain a consistent cutting path. Slide the torch body attachment and adjustable guide-wheel end along the circle guide rail as required to align the torch with the intended cut line.

Ensure all adjustments are secure and the guide wheels move freely before commencing the cut.

CIRCLE GUIDE SETUP 5

Offset Straight-Line Cutting



For straight-line cutting close to an edge or along an offset cutting path, configure the circle guide rail to position the torch away from the straight edge. Fit the guide wheels to the fixed and adjustable ends of the circle guide rail and position them against a suitable straight edge.

Position the torch body attachment towards the outer end of the rail, then adjust both the torch body attachment and the adjustable guide-wheel end to align the torch with the required cutting path.

Ensure all adjustments are secure and the guide wheels move freely along the straight edge before commencing the cut.

CAUTION

The setups shown above are examples of common DuraGuide configurations.
Components may be rearranged to suit different cutting applications and achieve the required result.

Always ensure the selected configuration is stable, secure and allows the torch and guide to move freely. Some configurations may not be suitable or safe for certain applications.

Before commencing any cut, test the complete setup with the torch switched off by moving the guide through the intended cutting path on the workpiece. Check for stability, clearance, alignment and unrestricted movement. If the setup does not operate safely and smoothly, reposition the components and retest before cutting.

Always follow the operating and safety instructions provided with the cutting torch and associated equipment.

SECTION 3: OPERATION AND MAINTENANCE

3.01 PERSONAL SAFETY

Always follow the safety instructions provided with the cutting torch and associated cutting equipment when using the DuraGuide attachments. Stay alert and do not operate cutting equipment when tired or under the influence of alcohol, drugs or medication that may affect your ability to work safely. Always wear appropriate personal protective equipment (PPE), including suitable eye and face protection, protective gloves, flame-resistant clothing and safety footwear. Ensure the work area is clear of flammable materials and that adequate ventilation is provided before commencing cutting. Maintain a stable working position and keep hands, clothing and other objects clear of the cutting tip, flame, arc and hot workpiece. Before making any adjustments to the DuraGuide, stop the cutting operation and allow hot components to cool where required. Ensure all fasteners, guide components and attachments are correctly positioned and securely fitted before use. Never touch recently cut material with bare hands, as the workpiece and DuraGuide components may remain hot after cutting.

3.02 GENERAL USE & MAINTENANCE

Correct setup, regular inspection and maintenance of the DuraGuide components are important to ensure smooth operation, cutting accuracy and long service life. Before use, inspect all DuraGuide components for signs of wear, damage or looseness. Replace any damaged or excessively worn parts before operation. Ensure all adjustment screws and fasteners are securely fitted and hand-tightened only. Do not use tools or apply excessive force. Keep all moving and adjustment components clean and free from metal particles, cutting debris and other contamination.

Ensure components move freely without binding or excessive play. Check that the DuraGuide is correctly positioned and securely adjusted before commencing any cut. Do not force the guide during operation. Maintain a smooth, controlled cutting motion. After use, clean the components as required and store the DuraGuide and accessories in the supplied hard case in a clean, dry location.

3.03 TROUBLESHOOTING

FAULT	POSSIBLE CAUSE	ACTION
1. Guide does not move smoothly	Guide wheels or rotating components are obstructed, contaminated or incorrectly adjusted.	• Check the guide wheels and rotating bush for debris or contamination. • Confirm that the wheels rotate freely. • Check that fasteners have not been overtightened. • Inspect components for damage or excessive wear.
2. Inconsistent cut or tip height	Roller/ circle guide height is incorrectly set or guide components are loose.	• Check and adjust the tip-to-work distance. • Ensure both guide supports are correctly positioned. • Confirm all adjustment screws and fasteners are securely fitted. • Check that the guide remains stable throughout the cut.
3. Circle is not cutting accurately	Pivot pin or cutting radius is incorrectly positioned or radius bar has moved.	• Confirm the pivot pin is aligned with the centre of the required circle. • Recheck the required cutting radius. • Ensure the radius bar adjustment is securely tightened. • Maintain a smooth and consistent movement throughout the cut.
4. Magnetic/suction pivot moves during cutting	Surface is rough, dirty, uneven or unsuitable	• Clean the contact surface before fitting the magnetic/suction pivot. • Ensure the surface is sufficiently smooth and flat. • Reposition and firmly secure the magnetic/suction pivot. • Do not use the magnetic/suction pivot if a secure attachment cannot be achieved.
5. Guide components become loose during operation	Adjustment screws, fasteners or snap rings are not correctly fitted.	• Stop cutting and allow components to cool if required. • Check all fasteners, screws and snap rings. • Refit or tighten components as required. • Replace damaged or worn retaining components before further use.

SECTION 4: WARRANTY

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LIMITED WARRANTY TERMS

LIMITED WARRANTY: CIGWELD Pty Ltd, An ESAB Brand, hereafter, “CIGWELD” warrants to customers of its authorized distributors hereafter “Purchaser” that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the CIGWELD products as stated below, CIGWELD shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with CIGWELD’s specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at CIGWELD’s sole option, of any components or parts of the product determined by CIGWELD to be defective.

CIGWELD MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHERS, INCLUDING, BUT NOT LIMITED TO ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE.

LIMITATION OF LIABILITY: CIGWELD SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE FOR SPECIAL, INDIRECT OR CONSEQUENTIAL DAMAGES, SUCH AS, BUT NOT LIMITED TO, LOST PROFITS AND BUSINESS INTERRUPTION.

The remedies of the Purchaser set forth herein are exclusive and the liability of CIGWELD with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by CIGWELD whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based. No employee, agent, or representative of CIGWELD is authorized to change this warranty in any way or grant any other warranty.

PURCHASER’S RIGHTS UNDER THIS WARRANTY ARE VOID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH IN CIGWELD’S SOLE JUDGEMENT MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY CIGWELD PRODUCT. PURCHASER’S RIGHTS UNDER THIS WARRANTY ARE VOID IF THE PRODUCT IS SOLD TO PURCHASER BY NON-AUTHORIZED PERSONS.

The warranty is effective for the time stated below beginning on the date that the authorized distributor delivers the products to the Purchaser. Notwithstanding the foregoing, in no event shall the warranty period extend more than the time stated plus one year from the date CIGWELD delivered the product to the authorized distributor.

Any claim under this warranty must be made within the warranty period which commences on the date of purchase of the product. To make a claim under the warranty, take the product (with proof of purchase from a CIGWELD Accredited Seller) to the store where you purchased the product or contact CIGWELD Customer Care 1300 654 674 for advice on your nearest Service Provider. CIGWELD reserves the right to request documented evidence of date of purchase. CIGWELD or our Accredited Distributor must be notified in writing of its claim within seven (7) days of becoming aware of the basis thereof, and at its own expense returning the goods which are the subject of the claim to CIGWELD or nominated Accredited Distributor/Accredited Service Provider

This warranty is given.
CIGWELD Pty Ltd A.B.N. 56007226815
71 Gower Street, Preston Victoria, Australia, 3072
Phone: 1300 654 674
Email: support@cigweld.com.au
Website: www.cigweld.com.au

This warranty is provided in addition to other rights and remedies you have under law: Our goods come with guarantees which cannot be excluded under the Australian Consumer Law. You are entitled to replacement or refund for a major failure and to compensation for other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

Note: In the interest of continuous improvement, CIGWELD Pty Ltd reserves the right to change the specifications or designs of any of its products without prior notice.

WARRANTY SCHEDULE - DURAGUIDE

WARRANTY	WARRANTY PERIOD
DuraGuide Range	1 Year

CIGWELD LIMITED WARRANTY DOES NOT APPLY TO;

- Obsolete goods sold at auction, second- hand goods and prototype goods.
- Consumable parts such as fasteners and snap rings.

Notes:

* No employee, agent, or representative of CIGWELD is Authorised to change this warranty in any way or grant any other warranty, and CIGWELD shall not be bound by any such attempt. Correction of non-conformities, in the manner and time provided herein, constitutes fulfilment of CIGWELD's obligations to purchaser with respect to the product.
* This warranty is void, and seller bears no liability hereunder, if purchaser used replacement parts or accessories which, in CIGWELD's sole judgment, impaired the safety or performance of any CIGWELD product and if the unit is altered or serviced by an unauthorised CIGWELD Service Provider. Purchaser's rights under this warranty are void if the product is sold to purchaser by unAuthorised persons.

DURAGUIDE PLASMA CUTTING RANGE SPARES

PART NUMBER	DESCRIPTION
208588	DURAGUIDE CIRCLE GUIDE TO SUIT: BLUEVENOM 60A TORCH
208590	DURAGUIDE CIRCLE GUIDE TO SUIT: THERMAL DYNAMICS1TORCH SL60/SL100
208591	DURAGUIDE MAGNETIC PIVOT
208592	DURAGUIDE RADIUS BAR KIT
208593	DURAGUIDE ADAPTER BUSH TO SUIT: THERMAL DYNAMICS 1TORCH SL60/SL100
208594	DURAGUIDE ADAPTER BUSH TO SUIT: BLUEVENOM 60A TORCH
208597	DURAGUIDE ROLLER GUIDE TO SUIT: THERMAL DYNAMICS 1TORCH SL60/SL100
208598	DURAGUIDE ROLLER GUIDE TO SUIT: BLUEVENOM 60A TORCH
208610	DURAGUIDE SUCTION PIVOT
208612	DURAGUIDE ADAPTER BUSH TO SUIT: BLUEVENOM PCX 85A/125A TORCHES
208613	DURAGUIDE CIRCLE GUIDE TO SUIT: BLUEVENOM PCX 85A/125A TORCHES
208614	DURAGUIDE ROLLER GUIDE TO SUIT: BLUEVENOM PCX 85A/125A TORCHES

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