

Everlast Guide for Servicing a Solenoid

Locate the Solenoid:

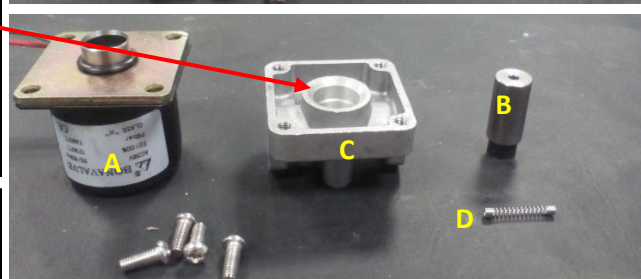
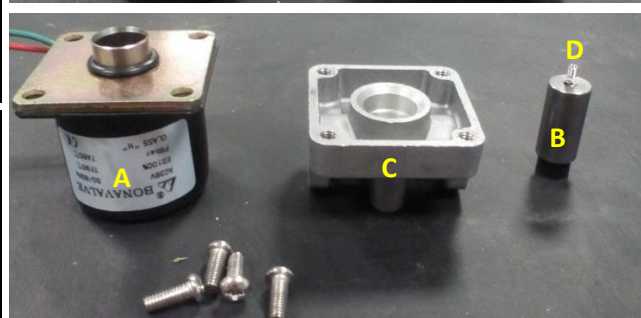
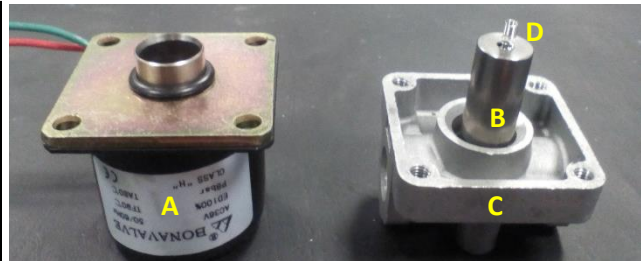
- 1) Turn off and unplug the welder. Use a Phillips-head screwdriver to remove the screws from the green case and from the back plastic bezel (if present). An Allen key (5.5mm) is required to remove the handle for a MIG welder.
- 2) Locate the gas inlet on the back of the welder. Follow the hose line from the inlet until you find the solenoid. It will often be located directly after the inlet.
- 3) Loosen and remove the fitting on the back of the machine and the solenoid can be pulled out to an area where it can be serviced, if you still find that is not enough room to work you can remove the rear fan to provide more space.
- 4) For most MIG units, you will need to move aside the large side board to properly access the solenoid. You can do this by removing the screws holding it in place (there are four on the bottom) and getting some slack on some wires. That will allow you to move it aside without removing it completely.
- 5) For machines that have multiple solenoids, ensure that you track down the correct one. This is important for multi-process units in particular.
- 6) The solenoid should resemble Figure 1. The displayed information will vary from model to model and may be facing down, depending on where the solenoid is located.



Figure 1

Disassemble the Solenoid

- 1) Remove the four Phillips-head screws holding the top of the solenoid in place.
- 2) Lift the top (A) off of the solenoid. You can leave the wires in place and set the top aside.
- 3) Lift the plunger (B) out of the bottom (C) of the solenoid.
- 4) Lift the spring (D) out of the plunger.



Clean the Solenoid

- 1) Use an air compressor to clean out the bottom of the solenoid.
- 2) Use an emery cloth/SOS pad to clean the sides of the plunger and around the edge of its seat in the bottom of the solenoid.
- 3) Stretch the spring out a bit. Less than 1/8" more. Do not over-stretch.
- 4) Put the solenoid back together.

Do not Disassemble the Top of the Solenoid

If it comes apart, the image below is the order in which it should be put back together. (Left to right)



Direction of Solenoid:

Look through the gas inlet fitting on the back of the machine. You should see a screen through it. If you can't, then the solenoid may be backwards.