

Thank you for purchasing a Sealey product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.

MODEL NO: **BTR4**



IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS, AND CAUTIONS. USE THIS PRODUCT CORRECTLY, AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY.

1. SAFETY INSTRUCTIONS

- x Do not put more than one bottle on the trolley.
- ✓ Always seat the bottle in the upright position.
- ✓ Always secure the bottle tightly to the trolley with the chains provided.
- ✓ Only use the trolley on firm, level, unobstructed surfaces which are capable of supporting the trolley and its load.
- x Do not use the trolley on sloping surfaces.
- x Do not allow others to ride on the trolley.
- x Do not attempt to move the trolley by pulling on the earth or torch cable.
- x Do not attach the welder's earth clamp to the metal frame of the trolley as this may result in accidental arcing from the torch.
- ✓ Replace or repair damaged parts. *Use only recommended parts. Unauthorised parts may be dangerous and will invalidate the warranty.*
- ✓ Store gas cylinders in a vertical position only and ensure the storage area is correctly secured.
- x DO NOT store gas cylinders in areas where temperature exceeds 50°C. DO NOT use direct heat on a cylinder. Always keep gas cylinders cool.
- x DO NOT attempt to repair or modify any part of a gas cylinder or valve, and DO NOT puncture or damage a cylinder.
- x DO NOT obscure or remove any official labels from a cylinder. Always check the gas identity before use.
- x Avoid getting gas cylinders oily or greasy.
- x DO NOT try to lift or handle cylinder by its cap, guard or valve. Always keep caps and guards in place and close valve when not in use.
- Gas cylinders are heavy, use mechanical lifting equipment.
- ☐ **Warning!** Failure to comply with these instructions may result in loss of load, damage to trolley or other property and/or personal injury.

2. INTRODUCTION

This trolley is intended to carry a portable MIG welder and a single gas bottle of medium size, making relocation of welding equipment quick and easy. Fitted with two fixed wheels and two castors for excellent manoeuvrability and supplied with bottle retaining chains and cable stowage hooks. Upper tray for MIG welder and two lower trays for associated items. Suitable for portable MIG welders up to 265mm wide and 440mm long. Suitable for Sealey Welders: EM130XT and PMG110. Also PM140XT, PM150XT, PMG135XT, PMG155XT with wheels and axle removed.

3. ASSEMBLY

3.1 REAR WHEELS (2)

- 3.1.1 Slide axle (9) through support tube on bottom of lower shelf (1).
- 3.1.2 Slip washers (11) over both ends of axle.
- 3.1.3 Fit wheels (2) onto axle.
- 3.1.4 Insert cotter pins (11) into holes at either end of axle and bend the ends around the axle with a pair of thin nosed pliers.
- 3.1.5 Push red plastic caps (12) firmly into place on each end of each axle.

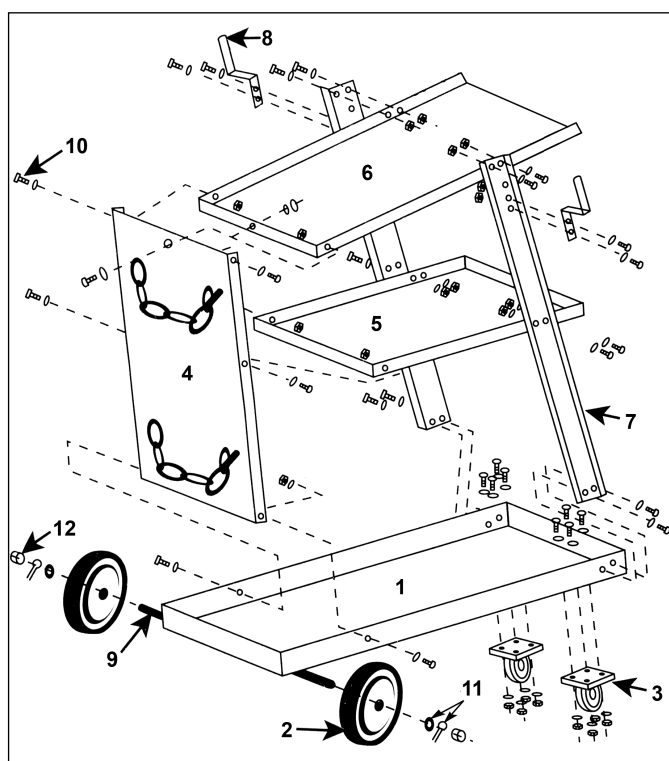
3.2 FRONT CASTORS (3)

- 3.2.1 Align castor (3) with 4 holes at left front of bottom shelf.
- 3.2.2 From top of shelf, insert a bolt with flat washer through each hole.
- 3.2.3 Slide one lock washer onto each bolt.
- 3.2.4 Firmly tighten a nut onto each bolt with 10mm wrench.
- 3.2.5 Repeat steps 1-4 for right side castor.

3.3 VERTICAL SUPPORT (4)

- 3.3.1 Align the bottom holes in the sides of the vertical support (4) with the holes in the sides of bottom shelf (1). Note: Lips on vertical support should be facing the front of the trolley.)
- 3.3.2 From top face of bottom shelf, insert a bolt with flat washer through centre hole of vertical support and bottom shelf.
- 3.3.3 Lay the assembly on its side and slide one lock washer onto bolt.

- 3.3.4 Screw a nut onto the bolt and tighten with 10mm wrench.
- 3.3.5 From outside face of shelf (1), insert a bolt with flat washer through each side hole of vertical support and bottom shelf.
- 3.3.6 Slide one lock washer onto each bolt.
- 3.3.7 Screw a nut onto bolts and tighten with 10mm wrench.
- 3.4 **SUPPORT RAILS (7)** (Note: Support rails are handed.)
- 3.4.1 Align left bottom support rail holes with holes on front left side of bottom shelf. (Bottom of support rails have only 2 holes. Top of support rails have 5 holes.)
- 3.4.2 From outside of support rail, insert a bolt with flat washer through each hole.
- 3.4.3 Slide one lock washer onto each bolt.
- 3.4.4 Firmly tighten nut onto each bolt with a 10mm wrench.
- 3.4.5 Repeat steps 1-4 for right side support rail.
- 3.5 **CENTRE SHELF (5)**
- 3.5.1 Align four front holes (two on either side) of centre shelf (5) with four centre holes (two on either side) of support rails (7). (Note: Centre shelf has four lipped sides. Lips should be facing upwards when installing.)
- 3.5.2 From outside of support rail (7) insert a bolt with flat washer through each hole and retain them with a lock washer and nut.
- 3.5.3 Align holes at rear of side lips of centre shelf (5) with centre holes (one on either side) of vertical support (4).
- 3.5.4 Insert a bolt with flat washer from either side and retain them with a lock washer and nut.
- 3.5.5 Firmly tighten all 6 nuts with a 10mm wrench.
- 3.6 **TOP SHELF (6)**
- 3.6.1 Align four front holes (two on either side) of top shelf (6) with four centre holes (two on either side) of support rails (7). (Note: top shelf has four lipped sides. The back lip and side lips should be facing upwards when installing.)
- 3.6.2 From outside of support rails (7) insert a bolt with flat washer through each hole and retain them with a lock washer and nut.
- 3.6.3 Align two rear holes (one on either side) of top shelf (6) with upper holes (one on either side) of vertical support (4).



- 3.6.4 From outside of vertical support (4), insert a bolt with flat washer through each hole and retain them with a lock washer and nut.
- 3.6.5 Align hole in rear lip of top shelf (6) with top centre hole in vertical support (4).
- 3.6.6 From outside of vertical support, insert a bolt with flat washer through hole and retain it with a lock washer and nut.
- 3.6.7 Firmly tighten all 7 nuts with a 10mm wrench.
- 3.7 CABLE BRACKETS (8)**
- 3.7.1 Align holes on cable bracket with vertically aligned holes on support rails.
- 3.7.2 From outside of cable bracket insert a bolt with flat washer through each hole and retain it with a lock washer and nut.
- 3.7.3 Firmly tighten all 4 nuts with a 10mm wrench.

4. USING THE TROLLEY

- 4.1 LOADING A GAS BOTTLE**
- 4.1.1 The trolley can be loaded with a suitable gas bottle up to a size of 93cm in height and approximately 20cm in diameter. Taller bottles should not be loaded onto the trolley as it may become unstable in transit. The maximum weight of bottle should not exceed 40kg. The trolley is designed to accommodate one bottle only.
- 4.1.2 Position the trolley as near as possible to the welding bottle. The maximum size bottle will require two people to load it. When the bottle is in place it should be held steady by one person whilst the other secures the chains around the bottle. The chains must be as tight as possible to ensure stability of the trolley. Make sure that the ends of the chains are fully engaged in the slots in the back of the vertical support member.
- 4.2 LOADING A WELDER**
- 4.2.1 The trolley is primarily intended for MIG welders that use gas but could equally accommodate an arc welder as long as it does not exceed the maximum footprint dimensions of 265mm wide and 440mm long.
- 4.2.2 Place the welder onto the top shelf and ensure that it is retained by the lipped sides. Any tall feet or wheels on the welder that prevent it sitting down properly into the tray should be removed.
- 4.3 MOVING A FULLY LOADED TROLLEY**
- 4.3.1 For transit purposes the welding cables can either be coiled and placed in the lower trays or hung on the cable brackets on either side of the support rails.
- 4.3.2 Before moving the trolley ensure that the bottle retaining chains are tightly fastened and that there are no dangling cables that could become caught in the wheels.
- 4.3.3 Move the trolley by taking hold of the down turned lip at the front of the top shelf. Do not try to move the trolley by pushing or pulling on the welder or gas bottle.
- 4.3.4 The trolley should only be moved over smooth and level surfaces.
- 4.4 WELDING WITH THE TROLLEY**
- 4.4.1 At the welding site ensure that the trolley is conveniently placed within reach of both the power socket and the item to be welded without any cables being over-stretched.
- 4.4.2 Do not switch the welder on whilst the cables are still stowed on the trolley.
- 4.4.3 **Warning!** Never attach the welder's earth clamp directly to the trolley frame as this will damage the paint finish and could result in accidental arcing from the torch.
- 4.4.4 Do not attempt to move the trolley by pulling on the earth or torch cable.



TROLLEY FULLY ASSEMBLED



TROLLEY FULLY LOADED

5. PARTS LIST

ITEM	PART NO	DESCRIPTION
1	8103087-01	BOTTOM SHELF
2	8103087-02	WHEEL
3	8103087-03	CASTOR
4	8103087-04	VERTICAL SUPPORT
5	8103087-05	MIDDLE SHELF
6	8103087-06	TOP SHELF

ITEM	PART NO	DESCRIPTION
7	8103087-07	SUPPORT RAIL
8	8103087-08	CABLE BRACKET
9	8103087-09	AXLE
10	8103087-10	COMPLETE FIXING KIT
11	8103087-11	WHEEL FIXING KIT
12	8103087-12	PLASTIC CAP

NOTE: It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.
IMPORTANT: No liability is accepted for incorrect use of this product.
WARRANTY: Guarantee is 12 months from purchase date, proof of which will be required for any claim.
INFORMATION: For a copy of our catalogue and latest promotions call us on 01284 757525 and leave your full name, address and postcode.

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