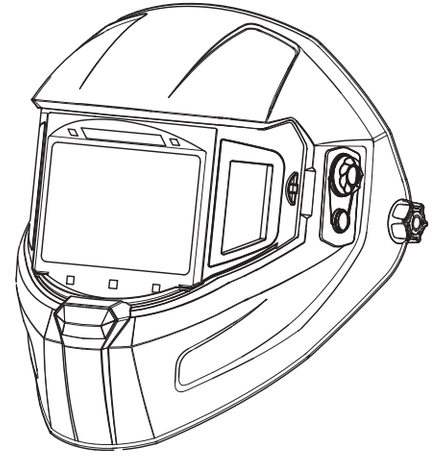
USER MANUAL

AUTO DARKENING WELDING HELMET



After-Sales Center
USA: LIPOINCD-100, 12 Hughes Irvine, CA 92618
Hong Kong: Workshop60,3/F, Block A, East Sun, Industrial Centre,
No.16 Shing Yip Street, Kwun Tong, Hong Kong
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www.andelitools.com

USER MANUAL

ANDELI

ANDELI

TABLE OF CONTENTS

SECTION1-SAFETY

THANKYOU FOR SELECTING A QUALITY PRODUCT

PLEASE EXAMINE CARTON AND EQUIPMENT FOR DAMAGE IMMEDIATELY

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

SAFETY DEPENDS ON YOU

ANDELI arc welding and cutting equipment is designed and built with safety in mind. However, your overall safety can be increased by proper installation ... and thoughtful operation on your part.

DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT READING THIS MANUAL AND THE SAFETY

PRECAUTIONS CONTAINED THROUGHOUT. And, most importantly, think before you act and be careful.

⚠ WARNING

This statement appears where the information must be followed exactly to avoid serious personal injury or loss of life.

⚠ CAUTION

This statement appears where the information must be followed to avoid minor personal injury or damage to this equipment.

KEEP YOUR HEAD OUT OF THE FUMES.DON'T

get too close to the arc. Use corrective lenses if necessary to stay a reasonable distance away from the arc. READ and obey the Safety Data Sheet (SDS) and the warning label that appears on all containers of welding materials.

READ and obey the Safety Data Sheet (SDS) and the warning label that appears on all containers of welding materials.

USE ENOUGH VENTILATION or exhaust at the arc, or both, to keep the fumes and gases from your breathing zone and the general area.

IN A LARGE ROOM OR OUTDOORS, natural ventilation may be adequate if you keep your head out of the fumes (See below).

USE NATURAL DRAFTS or fans to keep the fumes away from your face. If you develop unusual symptoms, see your supervisor. Perhaps the welding atmosphere and ventilation system should be checked.

WEAR CORRECT EYE, EAR & BODY PROTECTION

PROTECT your eyes and face with welding helmet properly fitted and with proper grade of filter plate (See ANSI Z49.1).

PROTECT your body from welding spatter and arc flash with protective clothing including woolen clothing, flame-proof apron and gloves, leather leggings, and high boots.

PROTECT others from splatter, flash, and glare with protective screens or barriers.

IN SOME AREAS, protection from noise may be appropriate.

BE SURE protective equipment is in good condition. Also, wear safety glasses in work area **AT ALL TIMES.**

SPECIAL SITUATIONS

DO NOT WELD OR CUT containers or materials which previously had been in contact with hazardous substances unless they are properly cleaned. This is extremely dangerous.

DO NOT WELD OR CUT painted or plated parts unless special precautions with ventilation have been taken. They can release highly toxic fumes or gases.

Additional precautionary measures

PROTECT compressed gas cylinders from excessive heat, mechanical shocks, and arcs; fasten cylinders so they cannot fall.

BE SURE cylinders are never grounded or part of an electrical circuit.

REMOVE all potential fire hazards from welding area.

ALWAYS HAVE FIRE FIGHTING EQUIPMENT READY FOR IMMEDIATE USE AND KNOW HOW TO USE IT.

⚠ SECTION A: WARNINGS ⚠

CALIFORNIA PROPOSITION 65 WARNINGS

⚠ **WARNING:** Breathing diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects, or other reproductive harm.

- Always start and operate the engine in a well-ventilated area.
- If in an exposed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system.
- Do not idle the engine except as necessary.

For more information goto www . P65 warnings.ca.gov/diesel

WARNING: This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code § 25249.5 et seq.)

⚠ **WARNING: Cancer and Reproductive Harm www.P65warnings.ca.gov**

ARC WELDING CAN BE HAZARDOUS. PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS SHOULD CONSULT WITH THEIR DOCTOR BEFORE OPERATING.

Read and understand the following safety highlights. For additional safety information, it is strongly recommended that you purchase a copy of"Safety in Welding & Cutting - ANSI Standard Z49.1"from the American Welding Society, P.O. Box 351040, Miami, Florida 33135 or CSA Standard W117.2.

BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.

FOR ENGINE POWERED EQUIPMENT.

1.a. Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.

1.b. Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.

1.c. Do not add the fuel near an open flame welding arc or when the engine is running. Stop the engine and allow it to cool before refueling to prevent spilled fuel from vaporizing on contact with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.

1.d. Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.

1.e. In some cases it may be necessary to remove safety guards to perform required maintenance. Remove guards only when necessary and replace them when the maintenance requiring their removal is complete. Always use the greatest care when working near moving parts.

1.f. Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.

1.g. To prevent accidentally starting gasoline engines while turning the engine or welding generator during maintenance work, disconnect the spark plug wires, distributor cap or magneto wire as appropriate.

1.h. To avoid scalding, do not remove the radiator pressure cap when the engine is hot.

1.i. Using a generator indoors CAN KILL YOU IN MINUTES.

1.j. Generator exhaust contains carbon monoxide. This is a poison you cannot see or smell.

1.k. NEVER use inside a home or garage, EVEN IF doors and windows are open.

1.l. Only use OUTSIDE and far away from windows, doors and vents.

1.m. Avoid other generator hazards. READ MANUAL BEFORE USE.

ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS

2.a. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines

2.b. EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.

2.c. Exposure to EMF fields in welding may have other health effects which are now not known.

2.d. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

2.d.1. Route the electrode and work cables together - Secure them with tape when possible.

2.d.2. Never coil the electrode lead around your body.

2.d.3. Do not place your body between the electrode and work cables. If the electrode cable is on your right side, the work cable should also be on your right side.

2.d.4. Connect the work cable to the work piece as close as possible to the area being welded.

2.d.5. Do not work next to welding power source.

SECTION1-SAFETY

ARC RAYS CAN BURN.

3.a. The electrode and work (or ground) circuits are electrically“hot”when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.

3.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground. In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying, if there is a high risk of unavoidable or accidental contact with the work piece or ground) use the following equipment:

• Semiautomatic DC Constant Voltage (Wire) Welder.

• DC Manual (Stick) Welder.

• AC Welder with Reduced Voltage Control.

3.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically“hot”.

3.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.

3.e. Ground the work or metal to be welded to a good electrical (earth) ground.

3.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.

3.g. Never dip the electrode in water for cooling.

3.h. Never simultaneously touch electrically“hot”parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.

3.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.

3.j. Also see Items 6.c. and 8.

ELECTRIC SHOCK CAN KILL.

4.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Head shield and filter lens should conform to ANSI Z87. I standards.

4.b. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.

4.c. Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.

FUMES AND GASES CAN BE DANGEROUS.

5.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone.

When welding Hard facing (see instructions on container or SDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and With inapplicable OSHA PEL and ACGIH TLV limits using local exhaust or mechanical ventilation unless exposure assessments indicate otherwise. In confined spaces or in some circumstances, outdoors, a respirator may also be required. Additional precautions are also required when welding on galvanized steel.

5.b. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is with inapplicable OSHA PEL and ACGIHTLV limits.

5.c. Do not weld in locations near chlorinated hydrocarbon vapors coming from degrease cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.

5.d. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.

5.e. Read and understand the manufacturer's instructions for this equipment and the consumables to be used, including the Safety Data Sheet (SDS) and follow your employer's safety practices. SDS forms are available from your welding distributor or from the manufacturer.

WELDING AND CUTTING SPARKS CAN CAUSE FIRE OR EXPLOSION.

6.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.

6.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to"Safety in Welding and Cutting"(ANSI Standard Z49.1) and the operating information for the equipment being used.

6.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.

6.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase"Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).

6.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.

6.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.

6.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail. 6.h. Also see item 1.c.
6.I. Read and follow NFPA 51B“Standard for Fire Prevention During Welding, Cutting and Other Hot Work”, available from NFPA, 1 Battery march Park, PO box 9101, Quincy, MA 022690-9101. 6.j. Do not use a welding power source for pipe thawing.

CYLINDER MAY EXPLODE IF DAMAGED.

7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.
7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
7.c. Cylinders should be located:
- Away from areas where they may be struck or subjected to physical damage.
- A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.

7.d. Never allow the electrode, electrode holder or any other electrically“hot”parts to touch a cylinder.
7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-l,“Precautions for Safe Handling of Compressed Gases in Cylinders,”available from the Compressed Gas Association, 14501 George Carter Way Chantilly, VA 20151.

FOR ELECTRICALLY POWERED EQUIPMENT.

8.a. Turn off input power using the disconnect switch at the fuse box before working on the equipment.
8.b. Install equipment in accordance with the U.S. National Electrical Code, all local codes and the manufacturers recommendations.
8.c. Ground the equipment in accordance with the U.S. National Electrical Code and the manufacturers recommendations.

REGULATORY STATEMENTS

SAFETY WARNINGS – READ BEFORE USING

⚠ WARNING

ARC Rays can injure eyes and burn skin

- Before welding, always inspect helmet and filter lens to be sure they are fitted properly, in good condition and not damaged.
- Check to see that the clear lens is clean and securely attached to the helmet.
- Always wear safety glasses or goggles under the welding helmet and protective clothing to protect your skin from radiation, burns and spatter.
- Ensure that optical radiation from other welder's arcs in the immediate area does not enter in from behind the helmet and auto-darkening filter.

Note: Auto-darkening filters in andeli helmets are designed to protect the user against harmful ultra-violet and infrared rays both in the dark and light states. No matter what shade the filter is set to, the UV/IR protection is always present.

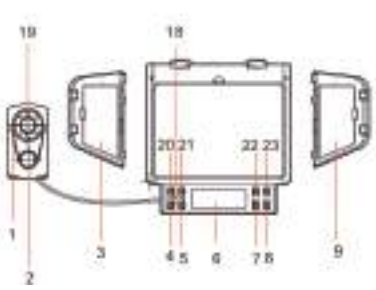
FUMES AND GASES can be dangerous to your health.

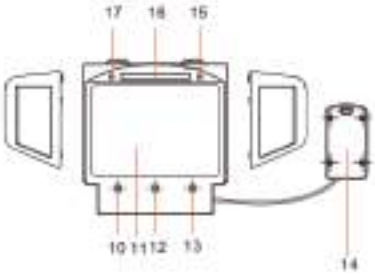
- Keep your head out of fumes.
- Use enough ventilation or exhaust at the arc or both to keep fumes and gases from your breathing zone and general area.
- When welding with electrodes which require special ventilation such as stainless or hard facing (see instructions on container or MSDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and within applicable OSHA PELand ACGIHTLV limits using local exhaust or mechanical ventilation. In confined spaces or in some circumstances, outdoors, a respirator may be required. Additional precautions are also required when welding on galvanized steel.

SECTION2-SPECIFICATIONS

Model	RL-600LA	RL-600LB
Optical Class	1/1/1/1	1/1/1/2
LCD Viewing Area	115 × 82 mm (4.53" × 3.23")	115 × 82 mm (4.53" × 3.23")
Cartridge Size	131 × 135 mm (5.31" × 5.15" × 0.39")	131 × 135 mm (5.31" × 5.15" × 0.39")
UV/IR Protection	DIN 16	DIN 16
Arc Sensors	5	4
Variable Welding Shades	WELD Mode: Dark State: DIN 9-13 Light State: DIN 3 CUT Mode: Dark State: DIN 5-9 Light State: DIN 3 GRIND Mode: Light State: DIN 3 LOCK Mode: Dark State: DIN 5-13	WELD Mode: Dark State: DIN 9-13 Light State: DIN 3 CUT Mode: Dark State: DIN 5-9 Light State: DIN 3 GRIND Mode: Light State: DIN 3 LOCK Mode: Dark State: DIN 5-13
Shade Control	Digital Adjust	Digital Adjust
Sensitivity Control	Digital Adjust	Digital Adjust
Power Supply	Solar Cells + Polymer Battery	Solar Cells + Polymer Battery
Battery Capacity	500mAh	500mAh
Charging Type	Type-C	Type-C
Low Battery Indicator	Yes	Yes
Light to Dark Switching Time	0.07 ms	0.08 ms
Dark to Light Switching Time	0.1 – 2.0 s	0.1 – 1.0 s
TIG Rating	DC 5 A / AC 5 A	DC 5 A / AC 5 A
Operating Temperature	23°F to 131°F (-5°C to 55°C)	23°F to 131°F (-5°C to 55°C)
Storage Temperature	- 4°F to 158°F (-20°C to 70°C)	-4°F to 158°F (-20°C to 70°C)
Total Weight	590 g	560 g

3.1 Helmet Controls





1.Knob
2.Power On/Off Button
3.LCD Display
4.Shade Number / Intelligent Mode Button
5.Delay / Intelligent Mode Button
6.Display Screen
7.Decrease Button
8.Gradient Button

9.LCD Display
10.Arc Sensor
11.LCD Display
12.Ambient Light Sensor / Electric Tube
13.Arc Sensor
14.Polymer Battery
15.Arc Sensor
16.Solar Panel

17.Arc Sensor
18.Grinding Indicator Light
19.Delay / Sensitivity / Shade Button
20.Mode Button
21.Sensitivity Button
22.Increase Button
23.Memory Button

3.2 RL-600LB Lens Button Control

RL-600LB

①MODE BUTTON:

Press Mode Button to select the mode appropriate for your work activity:
Weld Mode: Used for most welding applications. In this mode the lens turns on when it optically senses a welding arc. Adjust shade, sensitivity, and delay settings as needed.
Cut Mode: Used for cutting applications. In this mode the lens turns on when it optically senses a cutting arc. Adjust shade, sensitivity, and delay settings as needed.
Grind Mode: Used for metal grinding applications. In this mode the shade is fixed shade No. 3. No lens adjustments are possible.
Lock Mode: Used for temporarily locking the current darkening settings during welding. Ideal for repetitive tasks.

① MODE KEY

③ SENSI KEY

④ DELAY KEY

② SELF-CHECK

⑤ –

⑥ +

③SENSITIVITY BUTTON

Press the Sensitivity Button to adjust the detection threshold of the arc sensors. It controls how easily the helmet's sensors are triggered to darken the lens. There are 5 different levels for sensitivity adjustment.

Recommended Settings	
Low-Current TIG Welding	High Sensitivity
High-Current MIG/Stick Welding	Medium to Low Sensitivity
Outdoor Welding	Lower Sensitivity
Factory/Group Welding	Lower Sensitivity

②TEST BUTTON

Press the Test Button to test whether the helmet's auto-darkening function is working correctly before you begin welding.

⑤- BUTTON

⑥+ BUTTON

Press the ± Button to adjust the lens shade in darkened state.
Weld: No.9-No.13
Cut: No.5-No.9
Grind: No.3

④DELAY BUTTON

Press the Delay Button to control the time delay between the end of the welding arc and the lens returning to its light state. It protects the welder's eyes from the bright afterglow of the molten weld pool and cooling slag after the arc stops. It keeps the lens dark for an adjustable period post-arc.

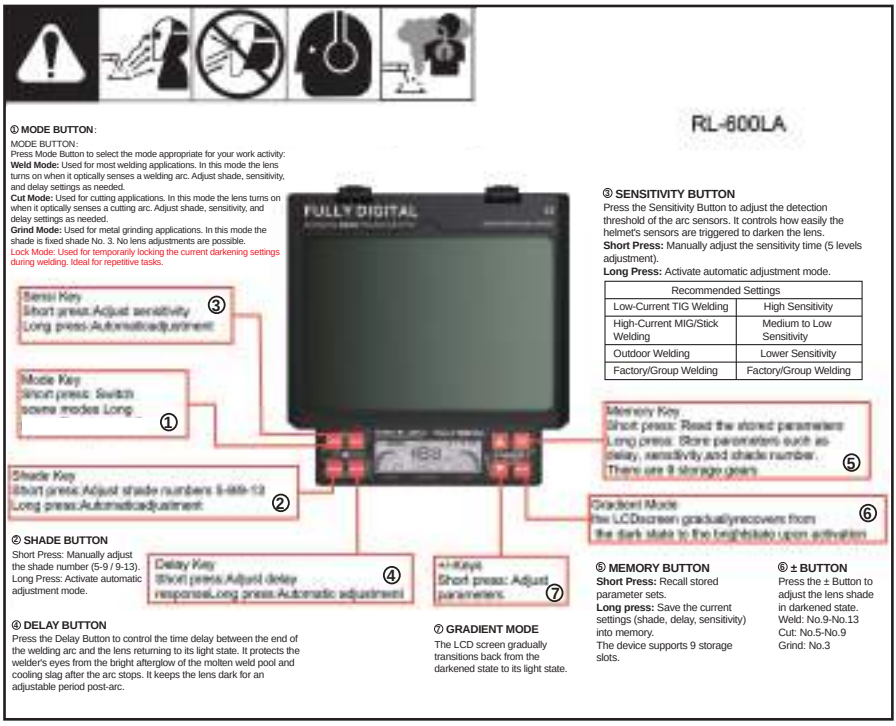
3.3 External button control

Quick-Access Button
Instantly switches between Sensitivity and Delay adjustment modes.

Multi-Function Knob
Quickly adjusts Shade Number, Sensitivity, and Delay values.

Grind Mode Button: Shortly press to activate Grind mode instantly.
Power Button: Press and hold for Power on/off

3.4 RL-600LA Lens Button Control



① MODE BUTTON:
MODE BUTTON:
Press Mode Button to select the mode appropriate for your work activity:
Weld Mode: Used for most welding applications. In this mode the lens turns on when it optically senses a welding arc. Adjust shade, sensitivity, and delay settings as needed.
Cut Mode: Used for cutting applications. In this mode the lens turns on when it optically senses a cutting arc. Adjust shade, sensitivity, and delay settings as needed.
Grind Mode: Used for metal grinding applications. In this mode the shade is fixed shade No. 3. No lens adjustments are possible.
Lock Mode: Used for temporarily locking the current darkening settings during welding. Ideal for repetitive tasks.

② SHADE BUTTON
Short Press: Manually adjust the shade number (5-9 / 9-13).
Long Press: Activate automatic adjustment mode.

④ DELAY BUTTON
Press the Delay Button to control the time delay between the end of the welding arc and the lens returning to its light state. It protects the welder's eyes from the bright afterglow of the molten weld pool and cooling slag after the arc stops. It keeps the lens dark for an adjustable period post-arc.

⑦ GRADIENT MODE
The LCD screen gradually transitions back from the darkened state to its light state.

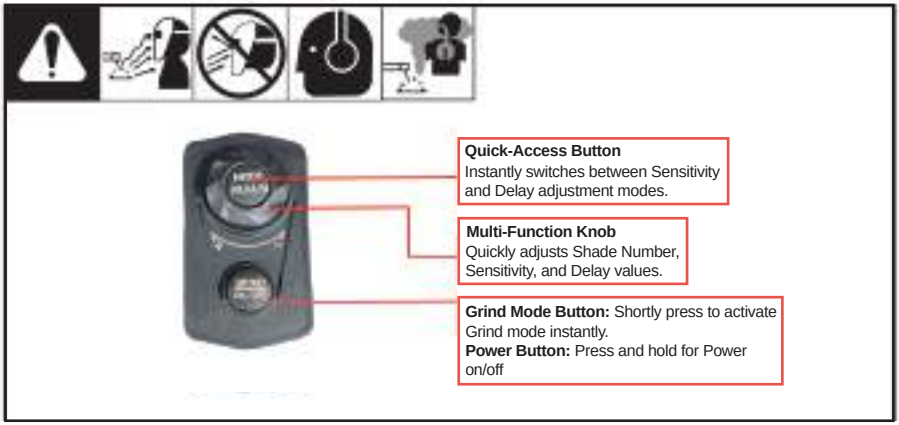
③ SENSITIVITY BUTTON
Press the Sensitivity Button to adjust the detection threshold of the arc sensors. It controls how easily the helmet's sensors are triggered to darken the lens.
Short Press: Manually adjust the sensitivity time (5 levels adjustment).
Long Press: Activate automatic adjustment mode.

Recommended Settings	
Low-Current TIG Welding	High Sensitivity
High-Current MIG/Stick Welding	Medium to Low Sensitivity
Outdoor Welding	Lower Sensitivity
Factory/Group Welding	Factory/Group Welding

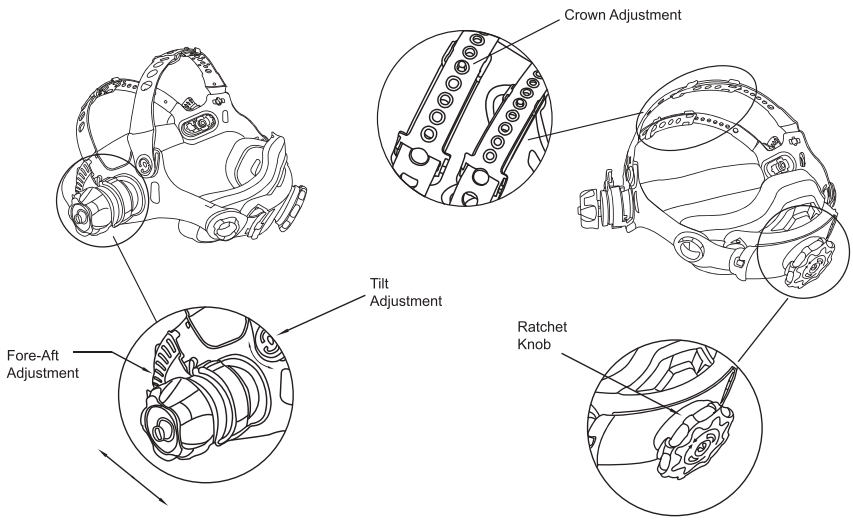
⑤ MEMORY BUTTON
Short Press: Recall stored parameter sets.
Long press: Save the current settings (shade, delay, sensitivity) into memory.
The device supports 9 storage slots.

⑥ ± BUTTON
Press the ± Button to adjust the lens shade in darkened state.
Weld: No.9-No.13
Cut: No.5-No.9
Grind: No.3

3.5 External button control



SECTION 4 – ADJUSTING HEADGEAR

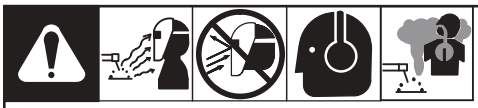


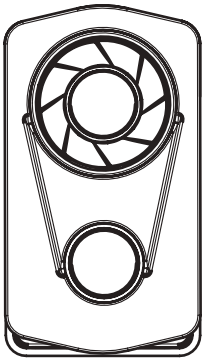
HEAD SIZE ADJUSTMENT: HEADGEAR TIGHTNESS is adjusted by turning the Ratchet Knob to the right or left to adjust for the desired head size.This knob is located at the back of the helmet.

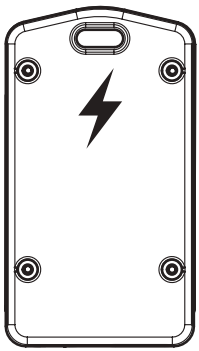
1.CROWN ADJUSTMENT is made by adjusting the comfort then placing the strap under the guide and snapping the pins into the holes to lock securely in place.
2.TILT ADJUSTMENT Tilt adjustment is located on the right side of the helmet. Loosen the right headgear tension knob and push the top end of the adjustment lever outward until the lever's Stop Tab clears the notches. Then rotate the lever forward or back to the desired tilt position. The Stop will automatically engage again when released locking the helmet into position.

FORE / AFT ADJUSTMENT: Adjusts the distance between the user's face and lens. To adjust, slide and hold the spring loaded caps upward while moving the headgear into one of four slotted locations. Once the desired distance has been achieved let go of the cap and it will return to its resting position once the adapter is secured in one of the four slots.

NOTE: Make sure both sides are equally positioned for proper orientation.



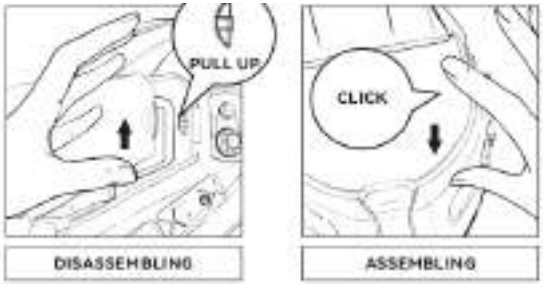




Battery & Charging

The device is equipped with a polymer battery and supports charging via the TYPE-C port (rated input: DC 5V/1A).
A 50cm TYPE-C cable is included. Please recharge promptly using the provided cable when the battery level is low.
The battery level is displayed in the top-right corner of the screen.

6.1 Replacing the Outer Cover Lens



Removal: Press down on one side of the buckle with your hand to release and remove the shell.
Installation: To install a new shell, first align and clip it into the middle groove. Then, press firmly on both sides until it locks into place.

6.2 Replacing Inner Cover Lens

Never use the auto-darkening lens without the inside and outside lens covers properly installed. Welding spatter will damage the auto-darkening lens and void the warranty.

– Remove the lens cover holder and take out the lens assembly.
– To remove the inner lens cover, gently pry it upward using the thumbnail openings located on both sides.
– Slide the cover out from either side of the frame.
– Insert the new lens cover and reassemble the unit by reversing the above steps.

SECTION 7-BASIC TROUBLESHOOTING

FAULT DESCRIPTION	POSSIBLE CAUSE	SOLUTION
1. Irregular darkening or uneven dimming	A. Improperly adjusted headband causing uneven distance between eyes and filter lens.	A. Readjust the headband to ensure equal distance to the filter on both sides.
2. Filter does not darken or flickers during use	A. Dirty or damaged outer protective lens. B. Blocked or dirty arc sensors. C. Welding current below activation threshold. D. Low battery or poor contact. E. Device not switched to appropriate operating mode.	A. Clean outer lens with a soft cloth; replace if damaged. B. Gently clean sensor surfaces. C. Increase sensitivity setting or welding current. D. Check battery level, condition, and contacts; recharge or clean as needed. E. Ensure device is powered on and set to correct welding mode via control panel.
3. Slow response when darkening	A. Operation in low-temperature conditions.	A. Do not use below -10°C; allow helmet to warm to operating temperature.
4. Poor visibility through lens	A. Dirty outer/inner cover lenses or filter. B. Insufficient ambient light in work area. C. Incorrect shade number setting.	A. Replace soiled or scratched lenses. B. Ensure adequate workspace lighting. C. Adjust shade number to suitable level for the process.
5. Helmet slips during use	A. Loose or improperly fitted headband.	A. Adjust headband size and tension for secure and comfortable fit.

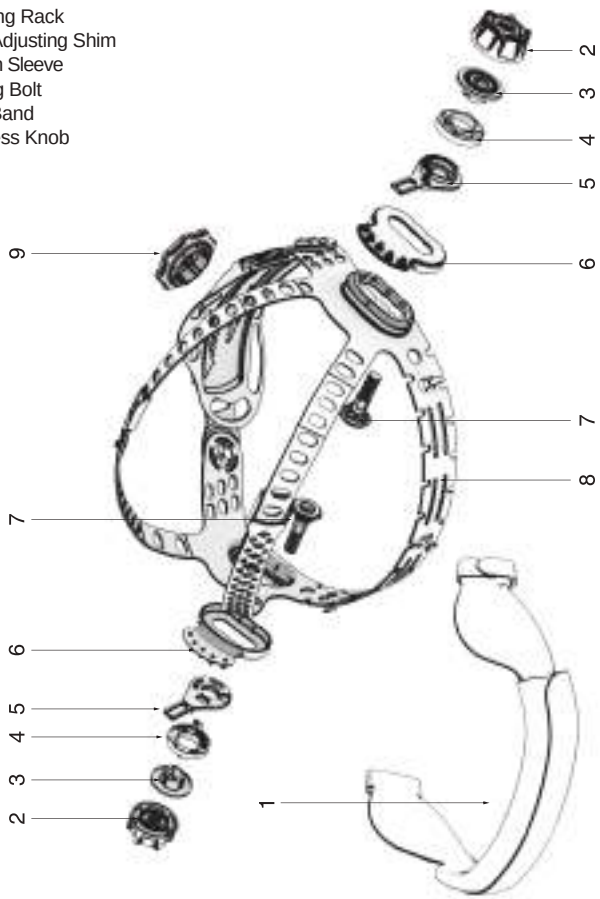
⚠ WARNING

If these troubleshooting steps do not resolve the issue, **discontinue use immediately** and contact ANDELI support for assistance. Do not use a malfunctioning auto-darkening helmet.

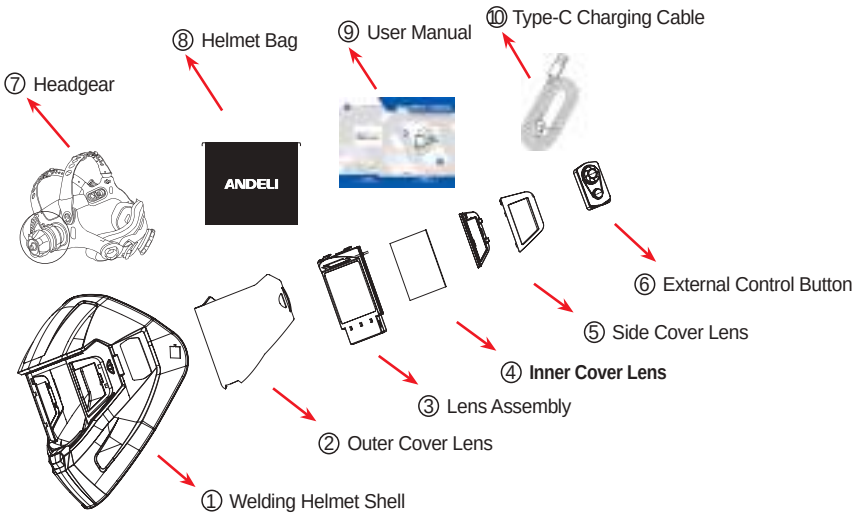
Description of Headband Installation

Take out the headband, and disassemble it according to the exploded view below:

1. Sweat Band
2. Plastic Nut
3. Fix Set
4. Adjusting Rack
5. Angle Adjusting Shim
6. Position Sleeve
7. Locking Bolt
8. Head Band
9. Tightness Knob



SECTION 9-HEADGEAR SPARE PARTS



PART NO.	DESCRIPTION	QUANTITY
ADL-RL-010001	Welding Helmet Shell	1
ADL-RL-010002	Outer Cover Lens	1
ADL-RL-010003	Lens Assembly	1
ADL-RL-010004	**Inner Cover Lens**	1
ADL-RL-010005	Side Cover Lens	1
ADL-RL-010006	External Control Button	1
ADL-RL-010007	Headgear	1
ADL-RL-010008	Helmet Bag	1
ADL-RL-010009	User Manual	1
ADL-RL-0100010	Type-C Charging Cable	1