



WELD THE WORLD

WF-205p



Instruction manual

ENGLISH

Translation of original instructions

ENGLISH

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ENGLISH

1 INTRODUCTION

| | | |
|---|--|-------------------|
| | | IMPORTANT! |
| <p><i>This handbook must be handed over to the user prior to installation and commissioning of the unit. Read the "General prescriptions for use" handbook supplied separately from this manual before installing and commissioning the unit.</i></p> | | |
| <p><i>The meaning of the symbols in this manual and the associated precautionary information are given in the "General prescriptions for use".</i></p> | | |
| <p><i>If the "General prescriptions for use" are not present, it is mandatory to request a replacement copy from the manufacturer or from your dealer.</i></p> | | |
| <p><i>Retain these documents for future consultation.</i></p> | | |

KEY

| | |
|---|---------------------|
| | DANGER! |
| <p><i>This pictogram warns of danger of death or serious injury.</i></p> | |
| | WARNING! |
| <p><i>This pictogram warns of a risk of injury or damage to property.</i></p> | |
| | CAUTION! |
| <p><i>This pictogram warns of a potentially hazardous situation.</i></p> | |
| | INFORMATION! |
| <p><i>This pictogram gives important information concerning the execution of the relevant operations.</i></p> | |

NOTE

The figures in this manual are simply provided to depict the operations and may contain differences with respect to the actual equipment to which they refer.

1.1 PRESENTATION

The WF-205p has been designed to provide welders with a light welder (weighing only 11.5 Kg) which, thanks to its reduced footprint, can be easily moved anywhere, including hard-to-reach places. Moving the welder is also made easier by its ergonomic top handle, which ensures a balanced grip.

The cables are safely and securely fastened in order to protect the signal cable and the power cable, thus prolonging the live of the extension cable. The welder can communicate with the generator up to a distance of 50 metres.

The welding shield protects the user from welding spatter and prevents the grinding sparks from damaging the front panel. The LED lights in the wire feeder compartment make it easier to insert and change the rollers even in poorly lit locations.

The spool storage compartment is fitted with an inspection window to enable the welder to monitor the amount of wire left in the spool.

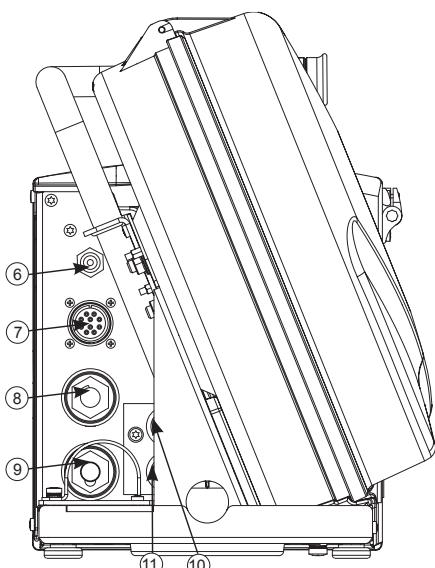
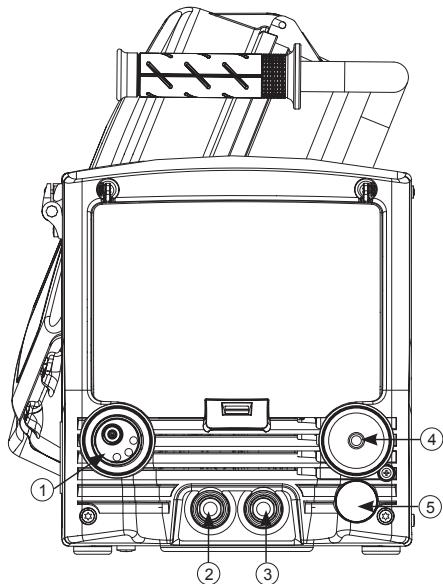
The 4 drive roller system (optional) ensures a smooth wire unwinding operation, particularly with special wires (Aluminium, Stainless Steel, CuSi, ...). The four roller, wire feeder motor with optical Encoder ensures a more effective and accurate wire feeding operation.

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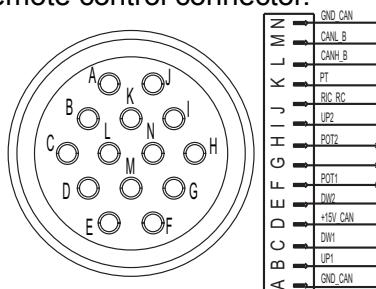
2 INSTALLATION AND ASSEMBLY

2.1 CONNECTIONS AND SOCKETS

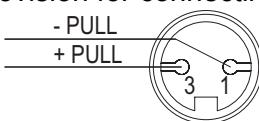
WF-205p



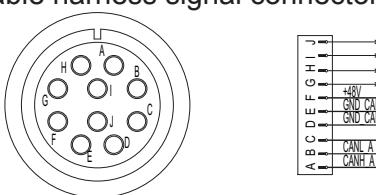
1. Torch socket with EURO connector.
2. Connector for torch coolant return hose (red).
3. Connector for torch coolant delivery hose (blue).
4. Remote control connector.



5. Provision for connecting the push pull torch (by purchasing and installing the relevant kit).



6. Gas rear connector. Provided to connect the gas pipe coming from the cable harness.
7. Cable harness signal connector.



8. Socket provided to connect the power cable coming from the cable harness.
9. MMA socket for welding with coated electrode directly from the wire feeder.
10. Connector to connect the coolant delivery hose from the cooling unit (blue).
11. Connector to connect the coolant return hose from the cooling unit (red).

2.2 MIG/MAG INSTALLATION



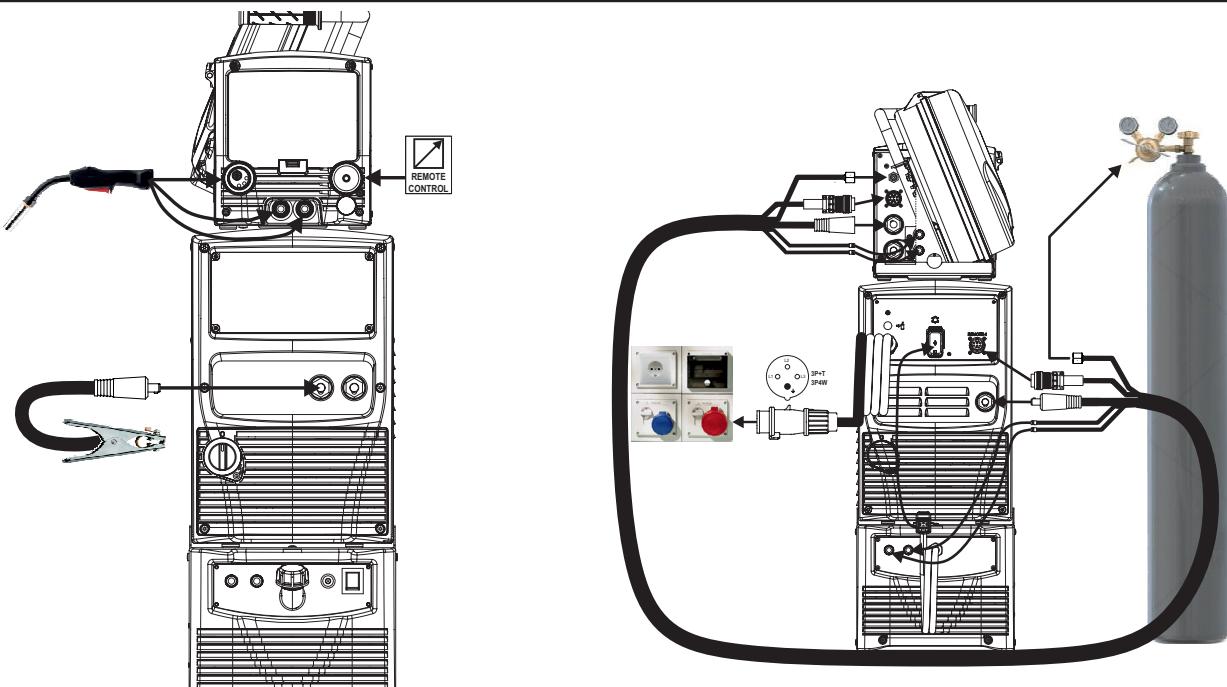
DANGER! Electric shock hazard!

Read the warnings highlighted by the following symbols in the "General prescriptions for use".



DANGER! Lifting and positioning

Read the warnings highlighted by the following symbols in the "General prescriptions for use".



1. Assemble the various units as described in the instruction manual of the power source trolley.
2. Set the welding power source ON/OFF switch to "O" (unit switched off).
3. Connect the power source mains supply cable to the mains socket outlet.
4. Secure the cable harness connectors to the wire feeder.
5. Secure the cable harness connectors to the generator.
6. Connect the power supply cable for the cooling unit to the auxiliary power socket on the power generator.
7. Connect the MIG/MAG torch coolant delivery and return hoses to the coolant fittings located in the wire feeder.
8. Connect the MIG/MAG torch coolant delivery and return hoses of the cable harness to the fittings on the cooling unit and on the wire feeder.

ENGLISH

9. Secure the cable harness by fastening the locking device.
10. Connect the earth clamp plug to the power generator earth socket.
11. Connect the earth clamp to the workpiece being processed.
12. Connect the MIG/MAG torch plug to the EURO TORCH welding socket.

2.3 POSITIONING THE SPOOL AND THE WIRE IN THE WIRE FEEDER

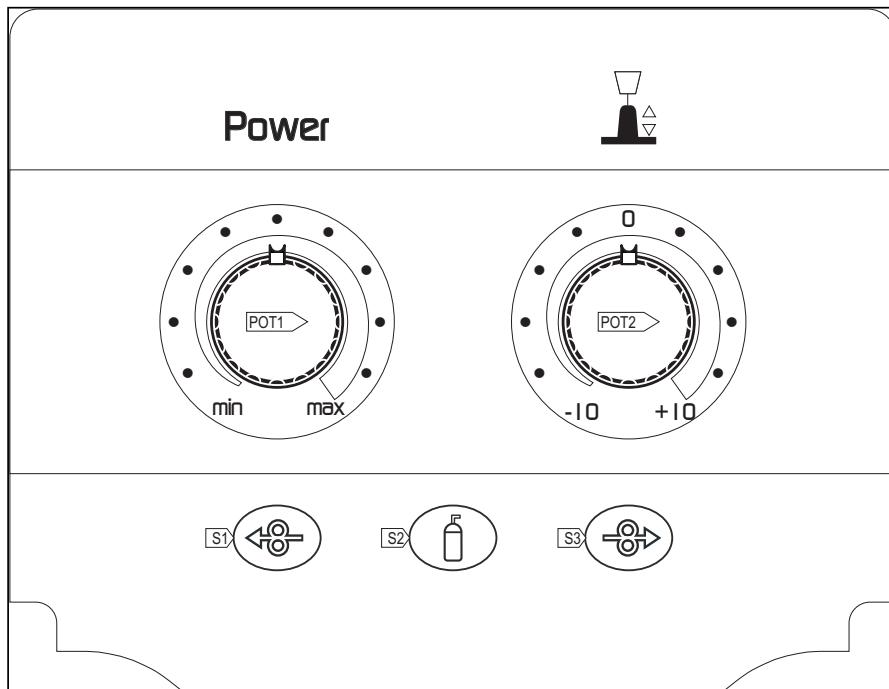


| <ol style="list-style-type: none">1. Fit the spool in the spool holder, ensuring it is located correctly.2. Secure the spool with the ferrule.3. Adjust the spool holder braking system by tightening/loosening the screw in such a way that the wire feed force is not excessive and when the spool stops rotating no excess wire is released. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|--|---|--|---|--------|---------|---------------|---------------|---------------|---------------|---------------|---|---------------|---------------|--|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------|---------------|---------|---------------|---------|---------------|---|---------------|---|-----------------|--|---|------|---|----|---------|---------------|---------------|---------|---------------|---------------|---------|---------------|--|--|--|--|---|------|---|--------|---------|---------------|---------------|---------|---------------|---------------|---|--|--|--|--|
| <ol style="list-style-type: none">4. Check that the feed rolls are suitable for the wire gauge.<ul style="list-style-type: none">o The diameter of the roll groove must be compatible with the diameter of the welding wire.o The roll must be of suitable shape in relation to the composition of the wire material.5. Feed the wire between the wire feeder rolls and insert it into the MIG/MAG TORCH connector plug.6. Make sure the wire is located correctly in the roll grooves. | <table border="1"><tbody><tr><td>Configuration 2</td><td></td><td><table border="1"><thead><tr><th>Ø mm</th><th>U</th><th>V</th><th>VK</th></tr></thead><tbody><tr><td>0,6-0,8</td><td>002.0000.0140</td><td>002.0000.0141</td><td></td></tr><tr><td>0,8-1,0</td><td>002.0000.0145</td><td>002.0000.0142</td><td>002.0000.0149</td></tr><tr><td>1,0-1,2</td><td>002.0000.0145</td><td>002.0000.0142</td><td>002.0000.0149</td></tr><tr><td>1,2-1,6</td><td>002.0000.0146</td><td>002.0000.0143</td><td>002.0000.0150</td></tr><tr><td>1,6-2,0</td><td>002.0000.0147</td><td></td><td></td></tr><tr><td>2,4-3,2</td><td>002.0000.0148</td><td></td><td>002.0000.0151</td></tr></tbody></table></td><td><p>SMOOTH ROLL Code 002.0000.0303</p></td></tr><tr><td>Configuration 3</td><td></td><td><table border="1"><thead><tr><th>Ø mm</th><th>U</th><th>VK</th></tr></thead><tbody><tr><td>1,0-1,2</td><td>002.0000.0145</td><td>002.0000.0149</td></tr><tr><td>1,2-1,6</td><td>002.0000.0145</td><td>002.0000.0150</td></tr><tr><td>2,4-3,2</td><td>002.0000.0152</td><td></td></tr></tbody></table></td><td><p>SMOOTH DOUBLE DRIVING ROLL Code 002.0000.0152</p></td></tr><tr><td></td><td></td><td><table border="1"><thead><tr><th>Ø mm</th><th>U</th><th>TEFLON</th></tr></thead><tbody><tr><td>1,0-1,2</td><td>002.0000.0168</td><td>002.0000.0171</td></tr><tr><td>1,2-1,6</td><td>002.0000.0169</td><td>002.0000.0172</td></tr></tbody></table></td><td><p>KNURLED DOUBLE DRIVING ROLL Code 002.0000.0153</p></td></tr><tr><td></td><td></td><td><p>U= [A] V= Fe/SS VK= Cu/NiCu</p></td><td><p>GEAR ADAPTOR FEED ROLL (BRONZE RUSHING)</p></td></tr></tbody></table> | Configuration 2 | | <table border="1"><thead><tr><th>Ø mm</th><th>U</th><th>V</th><th>VK</th></tr></thead><tbody><tr><td>0,6-0,8</td><td>002.0000.0140</td><td>002.0000.0141</td><td></td></tr><tr><td>0,8-1,0</td><td>002.0000.0145</td><td>002.0000.0142</td><td>002.0000.0149</td></tr><tr><td>1,0-1,2</td><td>002.0000.0145</td><td>002.0000.0142</td><td>002.0000.0149</td></tr><tr><td>1,2-1,6</td><td>002.0000.0146</td><td>002.0000.0143</td><td>002.0000.0150</td></tr><tr><td>1,6-2,0</td><td>002.0000.0147</td><td></td><td></td></tr><tr><td>2,4-3,2</td><td>002.0000.0148</td><td></td><td>002.0000.0151</td></tr></tbody></table> | Ø mm | U | V | VK | 0,6-0,8 | 002.0000.0140 | 002.0000.0141 | | 0,8-1,0 | 002.0000.0145 | 002.0000.0142 | 002.0000.0149 | 1,0-1,2 | 002.0000.0145 | 002.0000.0142 | 002.0000.0149 | 1,2-1,6 | 002.0000.0146 | 002.0000.0143 | 002.0000.0150 | 1,6-2,0 | 002.0000.0147 | | | 2,4-3,2 | 002.0000.0148 | | 002.0000.0151 | <p>SMOOTH ROLL Code 002.0000.0303</p> | Configuration 3 | | <table border="1"><thead><tr><th>Ø mm</th><th>U</th><th>VK</th></tr></thead><tbody><tr><td>1,0-1,2</td><td>002.0000.0145</td><td>002.0000.0149</td></tr><tr><td>1,2-1,6</td><td>002.0000.0145</td><td>002.0000.0150</td></tr><tr><td>2,4-3,2</td><td>002.0000.0152</td><td></td></tr></tbody></table> | Ø mm | U | VK | 1,0-1,2 | 002.0000.0145 | 002.0000.0149 | 1,2-1,6 | 002.0000.0145 | 002.0000.0150 | 2,4-3,2 | 002.0000.0152 | | <p>SMOOTH DOUBLE DRIVING ROLL Code 002.0000.0152</p> | | | <table border="1"><thead><tr><th>Ø mm</th><th>U</th><th>TEFLON</th></tr></thead><tbody><tr><td>1,0-1,2</td><td>002.0000.0168</td><td>002.0000.0171</td></tr><tr><td>1,2-1,6</td><td>002.0000.0169</td><td>002.0000.0172</td></tr></tbody></table> | Ø mm | U | TEFLON | 1,0-1,2 | 002.0000.0168 | 002.0000.0171 | 1,2-1,6 | 002.0000.0169 | 002.0000.0172 | <p>KNURLED DOUBLE DRIVING ROLL Code 002.0000.0153</p> | | | <p>U= [A] V= Fe/SS VK= Cu/NiCu</p> | <p>GEAR ADAPTOR FEED ROLL (BRONZE RUSHING)</p> |
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| 0,8-1,0 | 002.0000.0145 | 002.0000.0142 | 002.0000.0149 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1,0-1,2 | 002.0000.0145 | 002.0000.0142 | 002.0000.0149 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1,2-1,6 | 002.0000.0146 | 002.0000.0143 | 002.0000.0150 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1,6-2,0 | 002.0000.0147 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| 1,0-1,2 | 002.0000.0145 | 002.0000.0149 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1,2-1,6 | 002.0000.0145 | 002.0000.0150 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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8. Press the  key to feed the wire until it protrudes from the torch tip.



3 USER INTERFACE

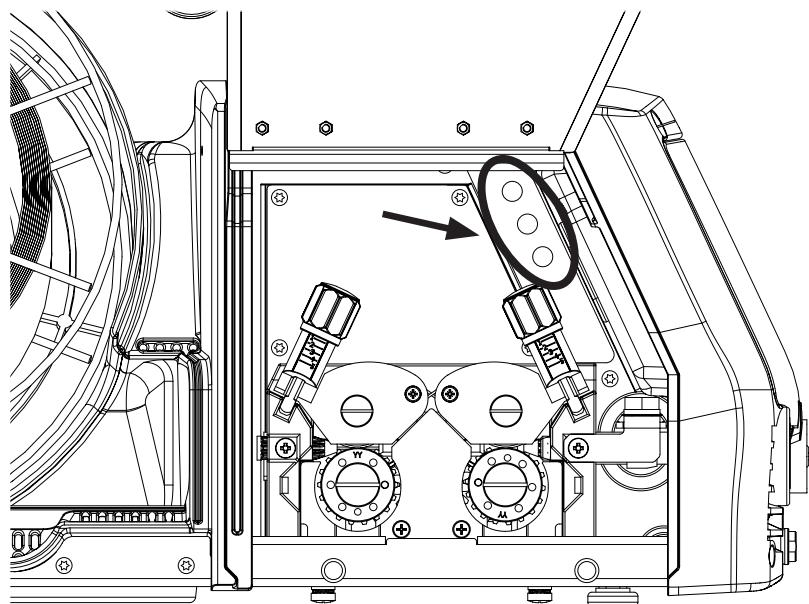


| CODE | SYMBOL | DESCRIPTION |
|------|--------|---|
| POT1 | | Power Sets synergic curve parameters (wire speed/ampere/tension/material thickness) |
| POT2 | | Arc length correction Sets up the welding arc length correction in relation to the preset value from the synergic curve. |
| S1 | | This key allows the MIG/MAG torch wire to be retracted. |

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| CODE | SYMBOL | DESCRIPTION |
|------|--------|--|
| S2 | | This button opens the gas solenoid valve to fill the circuit and calibrate the flow pressure with the regulator located on the gas cylinder. |
| S3 | | This button activates the wire feed to insert it through the MIG/MAG torch. |

KEYS PROVIDED INSIDE THE WIRE FEEDER

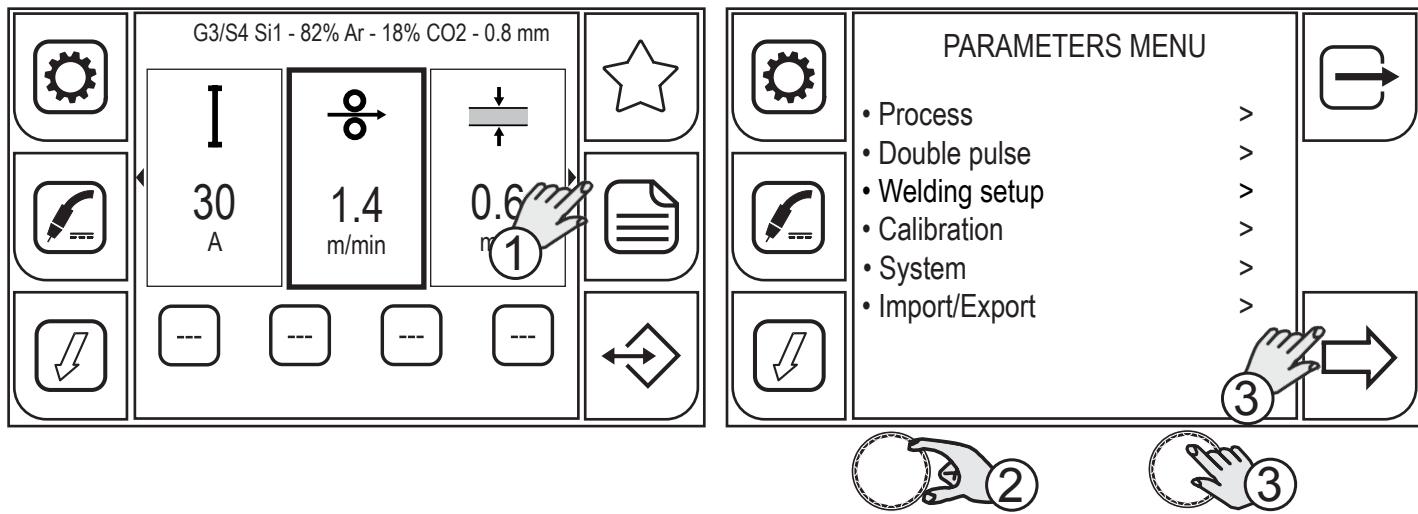


3.1 WIRE FEEDER SETUP

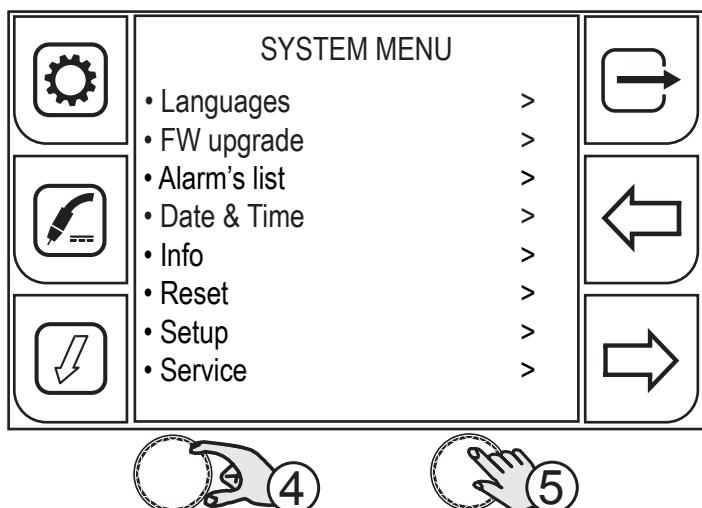


Enable when a WF-205p wire feeder is installed on a 405dms-505dms generator.
WIRE FEEDER SET UP enables the reception of commands from potentiometers of an external wire feeder unit.

USER INTERFACE OF POWER GENERATOR 405dms/505dms

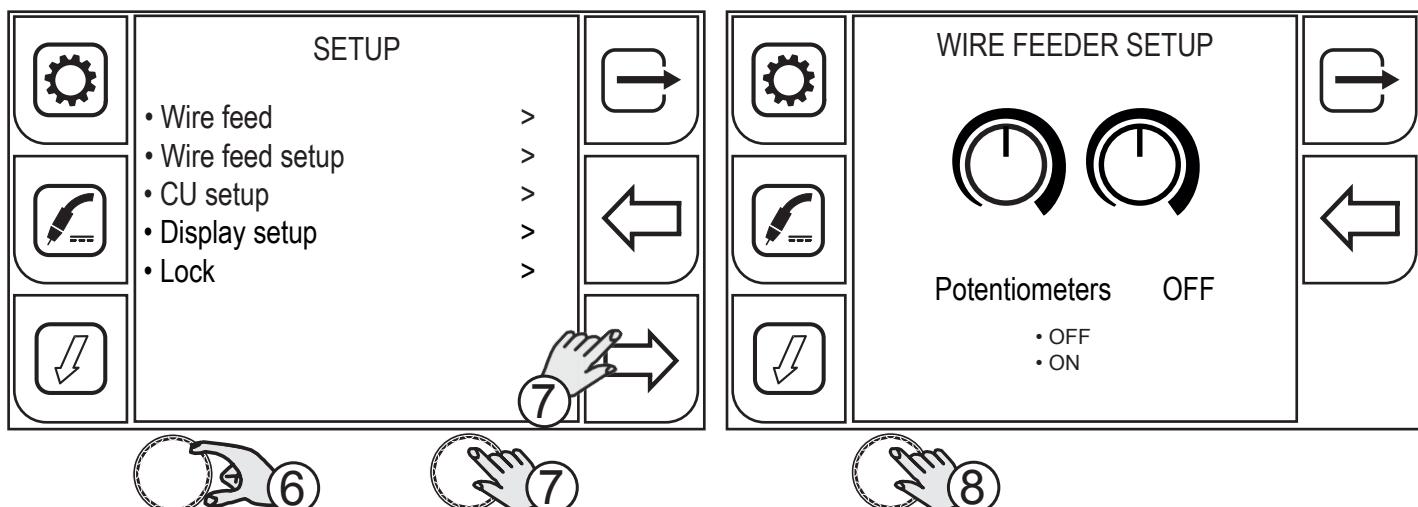


1. Press the (MENU) key.
2. Turn the encoder to select the desired setting. Select the following path: System>
3. Press the (ENCODER) key or the (NEXT) key to confirm.

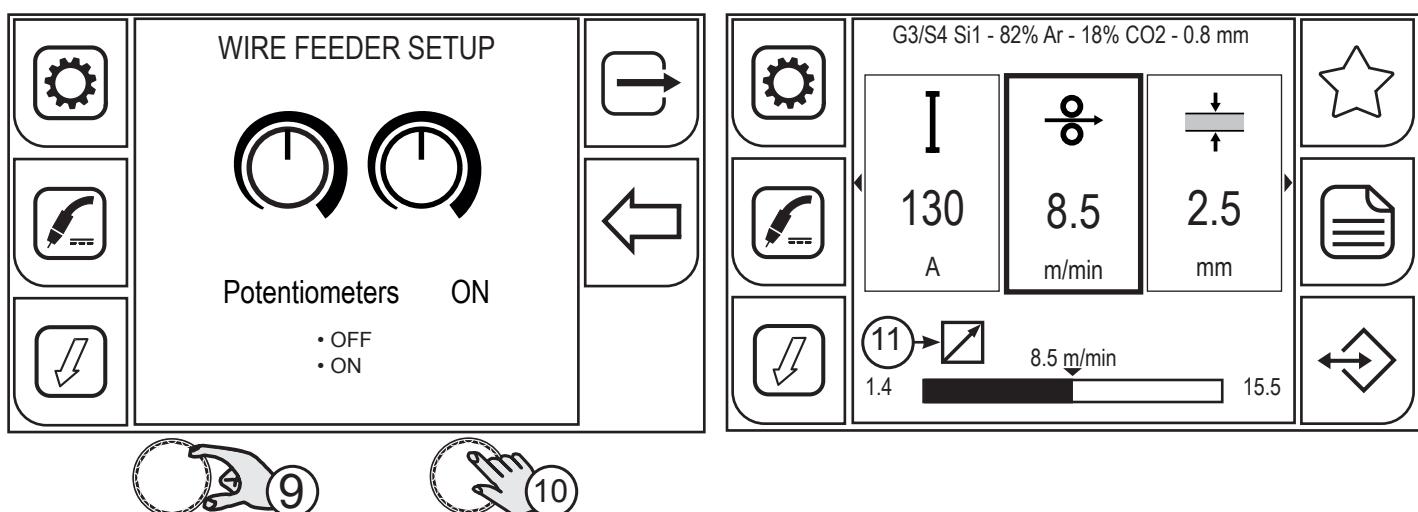


4. Turn the encoder to select the desired setting. Select the following path: Setup>
5. Press the (ENCODER) key or the (NEXT) key to confirm.

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6. Turn the encoder to select the desired setting. Select the following path: Wire Feeder setup>
7. Press the (ENCODER) key or the (NEXT) key to confirm.
8. Press the (ENCODER) key to apply the parameter change.



9. Turn the encoder to set the desired value.
10. Press the (ENCODER) key or the (NEXT) key to confirm.

To exit the screen, press the key.

11. The symbol (REMOTE) appears on the main screen when parameters which can be set by the wire feeder potentiometers are selected.

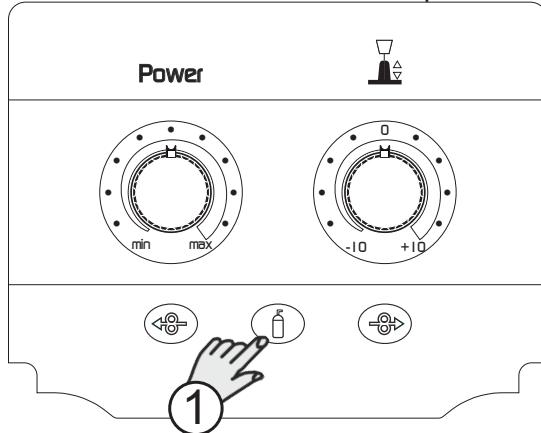
POT1 regulates the adjustment of parameters (wire speed/ampere/tension/material thickness) with respect to values preset from the synergic curve.

POT2 regulates the welding arc length correction in relation to the preset value from the synergic curve.

3.2 GAS FLOW REGULATION

When the unit is powered on, the solenoid valve is enabled for 1 second. This fills the gas circuit.

WIREFEEDER WF-205p

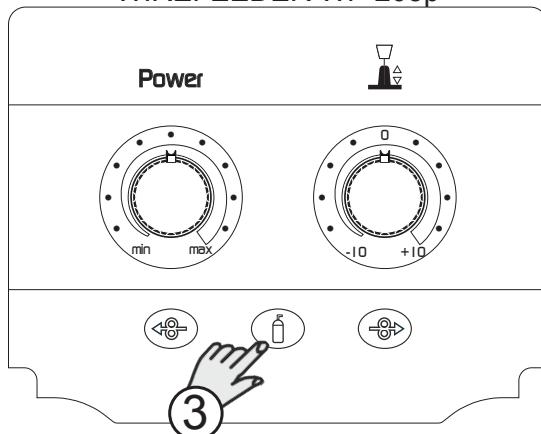


1. Open the gas solenoid valve by pressing and releasing the  (GAS) key.



2. Regulate the pressure of the gas flowing from the torch by means of the flow meter connected to the gas cylinder.

WIREFEEDER WF-205p



3. Close the gas solenoid valve by pressing and releasing the  (GAS) key. The solenoid valve is automatically closed after 30 seconds.

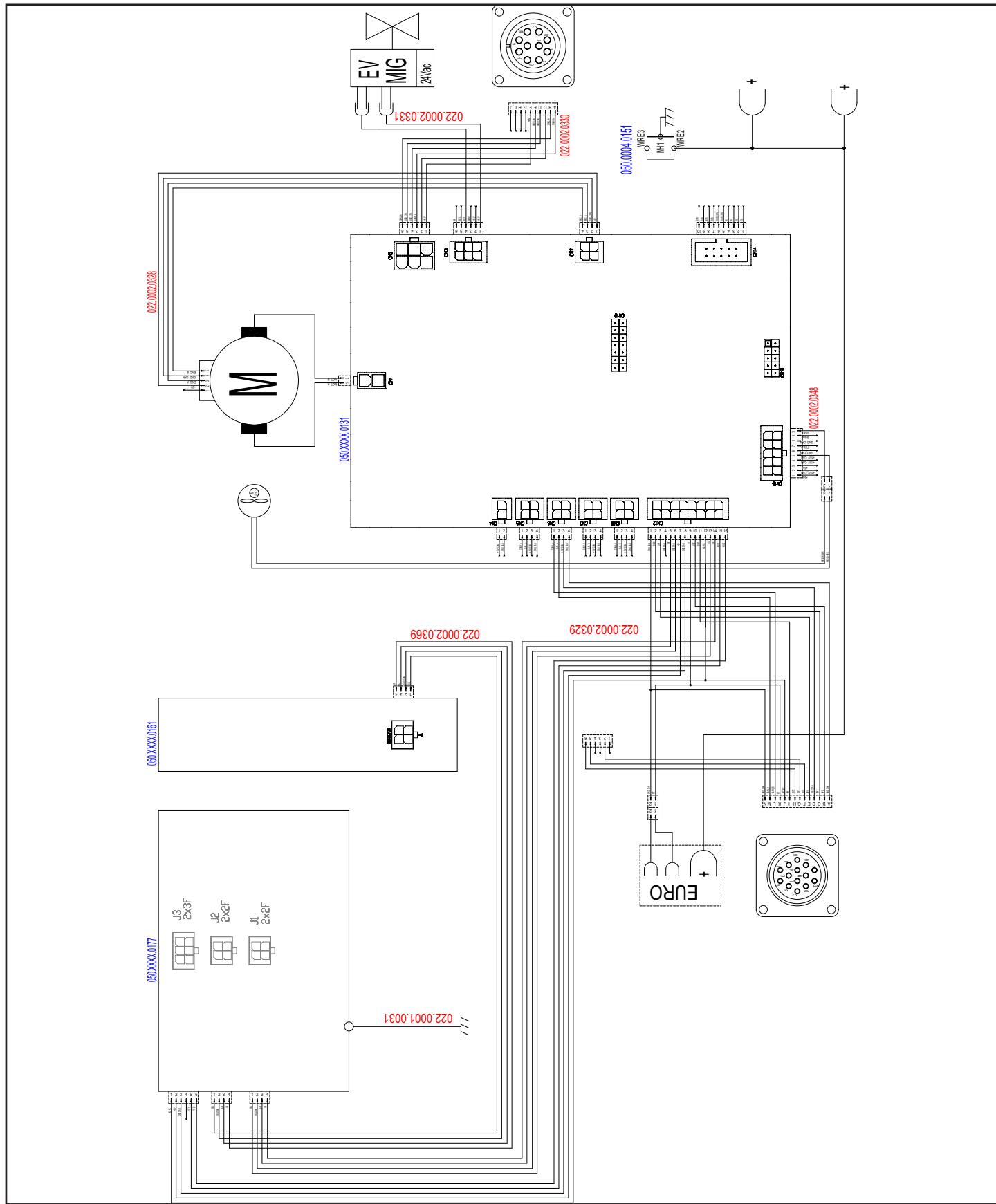
ENGLISH

4 TECHNICAL DATA

| | |
|------------------------|--|
| Directives applied | Waste electrical and electronic equipment (WEEE) |
| | Electromagnetic compatibility (EMC) |
| | Low voltage (LVD) |
| | Restriction of the use of certain hazardous substances (RoHS) |
| Conformity markings |  Equipment compliant with European directives in force |
| |  Suitable in an environment with increased hazard of electric shock |
| |  Compliant with WEEE directive |
| |  Equipment compliant with RoHS directive |
| Construction standards | EN 60974-5 EN 60974-10 Class A |

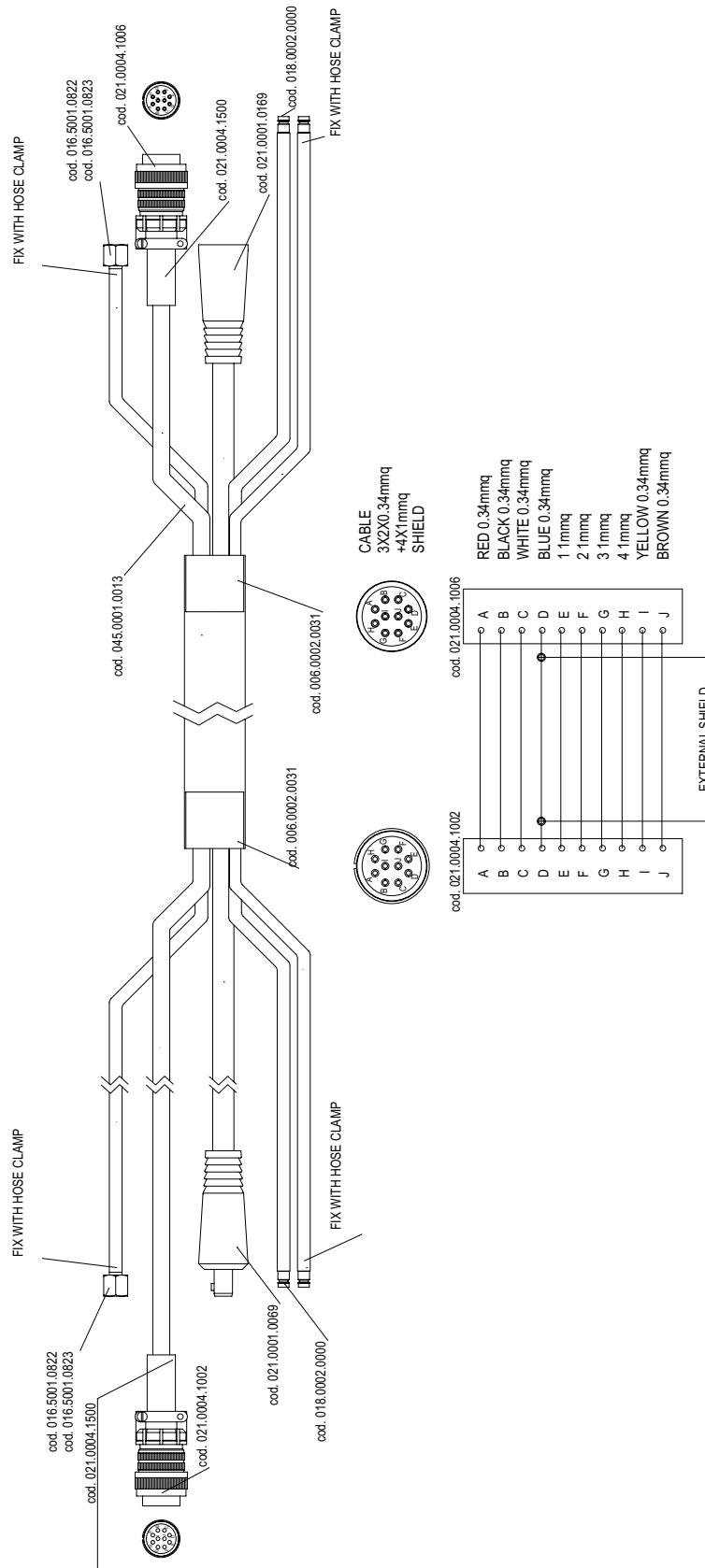
4.1 WF-205p

| | | |
|---------------------------------|---|--------|
| Supply voltage | 48 V a.c. | |
| Dimensions (L x D x H) | 265 x 665 x 360 mm | |
| Weight | 11.5 kg | |
| Protection rating | IP23 | |
| Maximum gas pressure | 0,5 MPa (5 bar) | |
| MIG/MAG welding voltage | 14.5 V - 39.0 V | |
| Motor speed | 1,0-25,0 m/min | |
| Wire spool: (dimensions/weight) | 200 mm / 5 kg – 300 mm / 15 kg | |
| Ambient temperature | 40°C | |
| Welding mode | MIG/MAG | |
| Static characteristic |  | |
| Work cycle | 60 % | 100 % |
| Welding current | 450 A | 400 A |
| Working voltage | 36.5 V | 34.0 V |

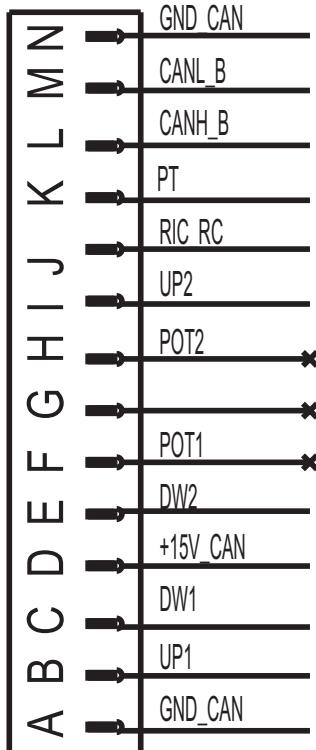
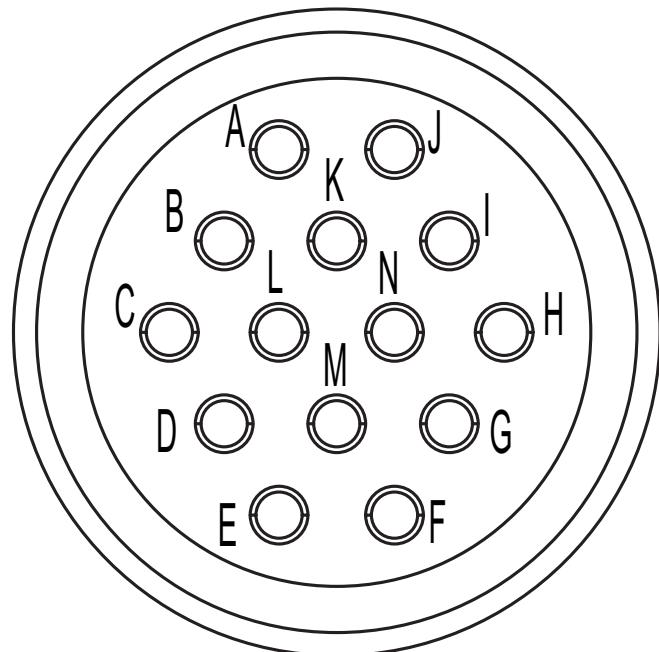
5 WIRING DIAGRAM**5.1 WF-205p**

ENGLISH

5.2 CABLE HARNESS: GENERATOR - WIRE FEEDER



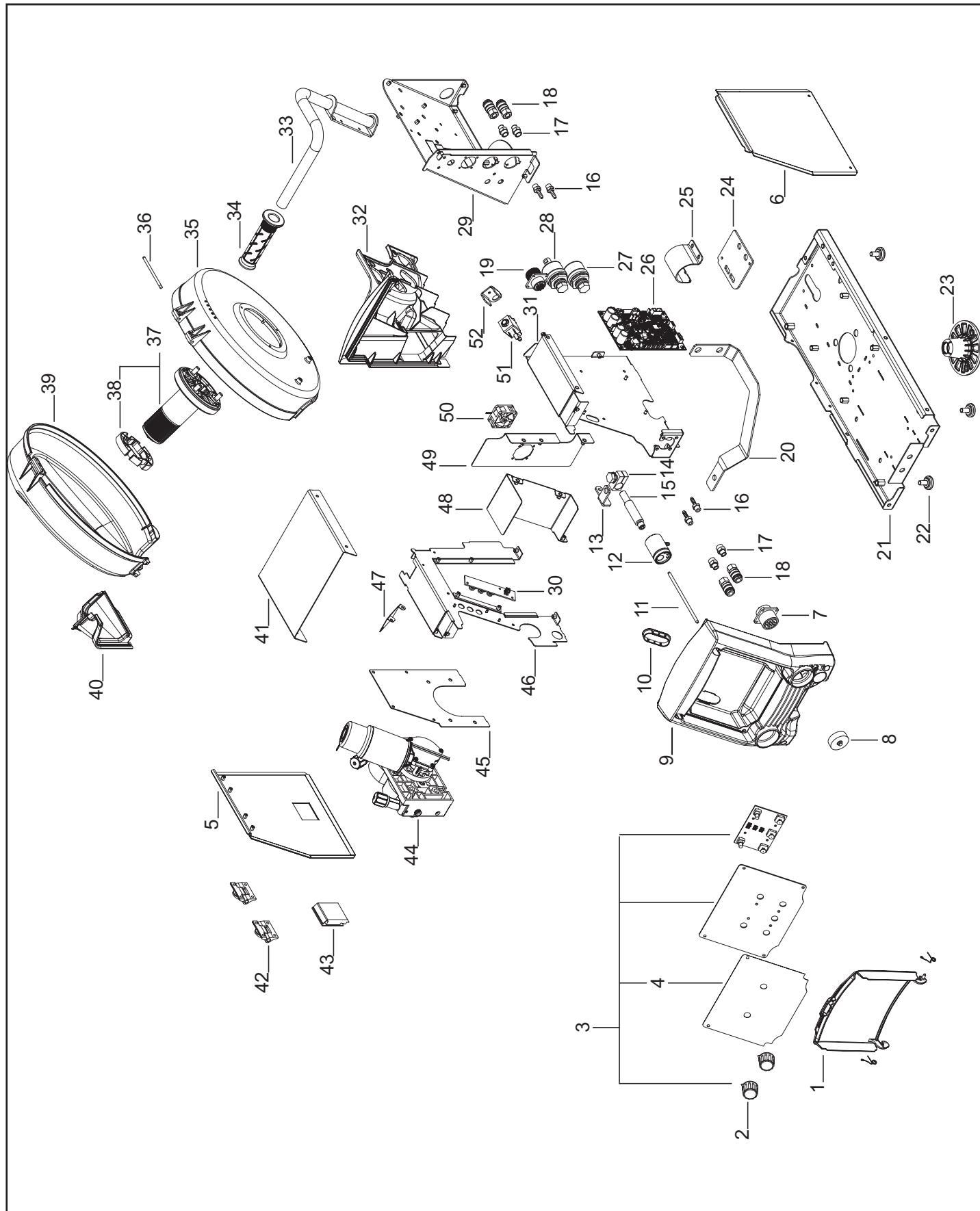
5.3 REMOTE CONTROL CONNECTOR



| PIN | NAME | DESCRIPTION SIGNAL |
|-----|----------|--|
| A | GND_CAN | COMMON FOR POT/UP-DW/PT/CAN... |
| B | UP2 | UP SIGNAL (Volt) |
| C | DW2 | DOWN SIGNAL (Volt) |
| D | +15V_CAN | COMMON TO POWER DIGIM TORCH. or RC08 |
| E | UP1 | UP SIGNAL (m/min) |
| F | POT1 | SIGNAL FOR POTENTIOMETER (Volt) |
| G | +5V | COMMON FOR POT 1 AND 2 |
| H | POT2 | SIGNAL FOR POTENTIOMETER (Volt) |
| I | DW1 | DOWN SIGNAL (m/min) |
| J | RIC_RC | REMOTE ACKNOWLEDGMENT (in bridge with GND_CAN) |
| K | PT | TORCH BUTTON (shared with GND_CAN) |
| L | CANH_B | WECO OPTIONS |
| M | CANL_B | WECO OPTIONS |
| N | GND_CAN | COMMON (SAME AS PIN A) |

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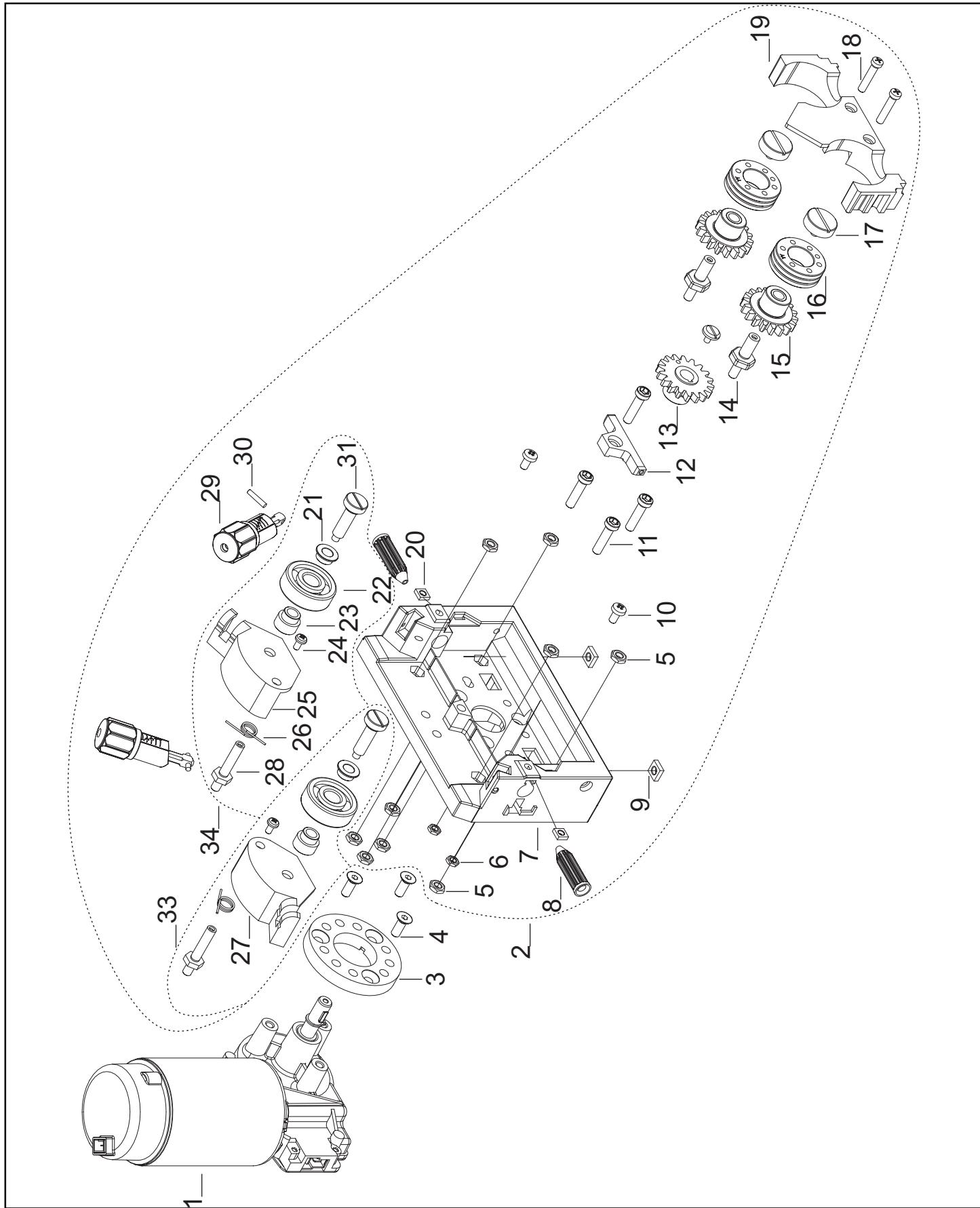
6 SPARES



| No. | CODE | DESCRIPTION |
|-----|---------------|--|
| 1 | 012.0012.0010 | PLEXIGLASS PROTECTION |
| 2 | 014.0002.0026 | KNOB WITH CAP |
| 3 | 050.5332.0000 | COMPLETE LOGIC FRONT PANEL |
| 4 | 013.0020.1201 | FRONT PANEL LABEL |
| 5 | 011.0001.1091 | DOOR |
| 6 | 011.0001.1081 | LATERAL COVER |
| 7 | 022.0002.0329 | LOGIC-MOTOR ENCODER CONNECTOR CABLE |
| 8 | 021.0004.2994 | MS-20 CONNECTOR CAP |
| 9 | 012.0011.0010 | FRONT PLASTIC PANEL |
| 10 | 016.0011.0015 | OVAL CAP |
| 11 | 021.0001.2025 | CAPILLARY TUBE |
| 12 | 021.0001.2001 | COUPLING EURO |
| 13 | 011.0002.0039 | WIRE FEED MOTOR-STING BLOCK BRACKET |
| 14 | 021.0001.2010 | CURRENT CLAMP FOR BRASS GUIDE FOR EURO CONNECTOR |
| 15 | 021.0001.2018 | EURO CONNECTOR STING |
| 16 | 016.5001.3040 | SLEEVE HOSE ADAPTER FOR RUBBER HOSE=6mm F=1/8 F |
| 17 | 017.0003.0055 | NIPPLE CONNECTOR |
| 18 | 018.0002.0004 | QUICK CLUTCH |
| 19 | 022.0002.0330 | REMOTE CONNECTOR CABLE |
| 20 | 045.0006.0103 | COPPER BRACKET |
| 21 | 011.0014.0151 | LOWER COVER |
| 22 | 016.0009.0003 | RUBBER FOOT |
| 23 | 012.0009.0010 | PLASTIC SUPPORT |
| 24 | 011.0014.0157 | FIXING CABLE BUNDLE PLATE |
| 25 | 011.0014.0026 | SUPPORT CABLE BUNDLE PLATE |
| 26 | 050.0002.0131 | 4Q WIREFEEDER BOARD |
| 27 | 021.0001.0279 | FIX SOCKET 500A 95mmq |
| 28 | 021.0001.0379 | FIX PLUG 500A 95mmq |
| 29 | 011.0014.0152 | SPOOL SUPPORT PLATE |
| 30 | 050.0001.0161 | BUTTON BOARD |
| 31 | 011.0014.0153 | INTERNAL PLATE |
| 32 | 012.0010.0010 | REAR NYLON |
| 33 | 011.0014.0158 | HANDLE TUBE |
| 34 | 011.0006.0032 | RUBBER HANDLE |
| 35 | 012.0000.0003 | LOWER SPOOL COVER |
| 36 | 016.0008.0003 | CYLINDRICAL PLUG |
| 37 | 011.0006.0062 | COMPLETE SPOOL SUPPORT |
| 38 | 002.0000.0287 | CAP FOR SPOOL HOLDER |
| 39 | 012.0000.0004 | UPPER SPOOL COVER |
| 40 | 012.0013.0010 | WATER PROTECTION PLASTIC |
| 41 | 011.0001.1071 | UPPER COVER |
| 42 | 011.0006.0007 | PLASTIC HINGE |
| 43 | 011.0006.0003 | SLIDE CLOSURE |
| 44 | 002.0000.0023 | WIRE FEED MOTOR |
| 45 | 011.0014.0156 | MOTOR PLATE |
| 46 | 011.0014.0150 | LEFT INTERNAL PLATE |
| 47 | 011.0014.0161 | MOTORE COMPARTMENT PLATE |
| 48 | 011.0014.0160 | INTERNAL PLATE |
| 49 | 011.0014.0163 | FAN SUPPORT PLATE |
| 50 | 003.0002.0021 | FAN |
| 51 | 017.0001.5543 | SOLENOID VALVE |
| 52 | 011.0002.0018 | SOLENOID VALVE PLATE |

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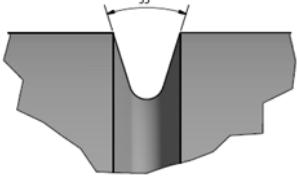
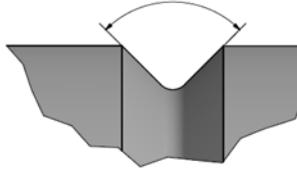
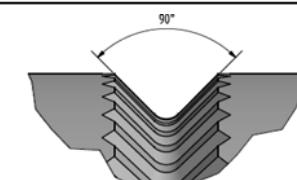
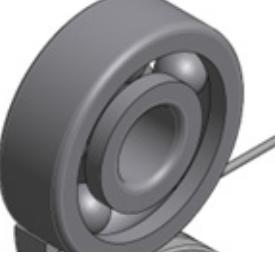
6.1 WIRE FEEDER MOTOR



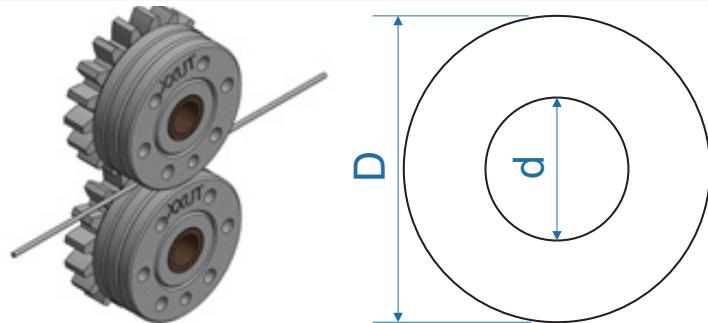
| No. | CODE | DESCRIPTION |
|-----|---------------|---|
| 1 | 002.0000.0392 | MOTOR COIL |
| 2 | 002.0000.0062 | WIRE FEEDER BODY COMPLETE |
| 3 | 002.0000.0390 | DISTANCE RING |
| 4 | 016.0300.0411 | COUNTERSUNK SCREW M6x12 |
| 5 | 002.0000.0349 | HEXAGONAL NUT M6 |
| 6 | 002.0000.0384 | HEXAGONAL NUT M5 |
| 7 | 002.0000.0373 | WIRE FEEDER SUPPORT |
| 8 | 002.0000.0297 | INLET GUIDE |
| 9 | 002.0000.0385 | SQUARE NUT M6 |
| 10 | 002.0000.0324 | SCREW M5x10 |
| 11 | 002.0000.0387 | SCREW M6x25 |
| 12 | 002.0000.0294 | INTERMEDIATE GUIDE |
| 13 | 002.0000.0300 | MAIN GEAR DRIVE |
| 14 | 002.0000.0374 | SHAFT |
| 15 | 002.0000.0299 | GEAR ADAPTOR FEED ROLL (BRONZE BUSHING) |
| 15 | 002.0000.0309 | GEAR ADAPTOR FEED ROLL (BALL BEARING) |
| 16 | 002.0000.0142 | FEED ROLL |
| 17 | 002.0000.0383 | RETAINING SCREW M4 |
| 18 | 002.0000.0382 | SCREW M5x30 |
| 19 | 002.0000.0388 | INTERNAL GUARD |
| 20 | 002.0000.0386 | SQUARE NUT M5 |
| 21 | 002.0000.0315 | DISTANCE RING 1 |
| 22 | 002.0000.0303 | KNURLED DRIVE ROLL |
| 23 | 002.0000.0314 | DISTANCE RING 2 |
| 24 | 002.0000.0318 | SCREW M4x8 |
| 25 | 002.0000.0379 | RIGHT PRESSURE ARM |
| 26 | 002.0000.0317 | SPRING |
| 27 | 002.0000.0378 | COMPLETE LEFT PRESSURE ARM |
| 28 | 002.0000.0375 | JOINT AXLE |
| 29 | 002.0000.0381 | COMPLETE PRESSURE DEVICE |
| 30 | 002.0000.0319 | PIN |
| 31 | 002.0000.0380 | PRESSURE ROLL AXLE |
| 32 | 002.0000.0304 | SCREW M4x10 |
| 33 | 002.0000.0376 | COMPLETE LEFT PRESSURE ARM |
| 34 | 002.0000.0377 | COMPLETE RIGHT PRESSURE ARM |

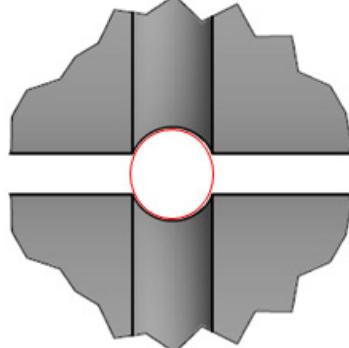
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6.2 WIRE FEED ROLLERS

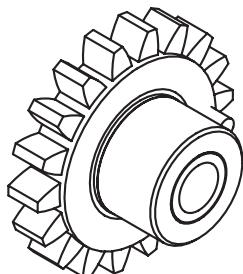
| Standard | | | | | | | | |
|---|---------------------------------|--|-----------------|---------|--|--|--|--|
| Code | Ø wire | Type | Ø roll | Grooves | | | | |
| 002.0000.0140 | 0.6-0.8 | V groove Solid wires (steel - stainless steel) | D=37x12/d=19 V | 35° V |   | | | |
| 002.0000.0141 | 0.8-1.0 | | | | | | | |
| 002.0000.0142 | 1.0-1.2 | | | | | | | |
| 002.0000.0143 | 1.2-1.6 | | | | | | | |
| 002.0000.0144 | 0.8-1.0 | U shape Aluminium wires | D=37x12/d=19 U | 90° V |   | | | |
| 002.0000.0145 | 1.0-1.2 | | | | | | | |
| 002.0000.0146 | 1.2-1.6 | | | | | | | |
| 002.0000.0147 | 1.6-2.0 | | | | | | | |
| 002.0000.0148 | 2.4-3.2 | | | | | | | |
| 002.0000.0149 | 1.0-1.2 | VK shape Tubular wires | D=37x12/d=19 VK | 90° V |   | | | |
| 002.0000.0150 | 1.2-1.6 | | | | | | | |
| 002.0000.0151 | 2.4-3.2 | | | | | | | |
| Arm with standard roll | | | | | | | | |
| Smooth | | | | | | | | |
| Code | Ø roll | | | | | | | |
| 002.0000.0303 | D=37x12/d=12 Standard SMOOTH | | | | | | | |
|  | | | | | | | | |

Double driving roll (4 rolls with grooves) - RECOMMENDED SETUP



| Code | Ø wire | Ø roll | |
|---------------|---------|--------------------------|---|
| 002.0000.0168 | 1.0-1.2 | D=37x12/d=19 U DOUBLE D. |   |
| 002.0000.0169 | 1.2-1.6 | D=37x12/d=19 U DOUBLE D. | |
| 002.0000.0171 | 1.0-1.2 | D=37x12/d=19 UT TEFLON. | |
| 002.0000.0172 | 1.2-1.6 | D=37x12/d=19 UT TEFLON | |

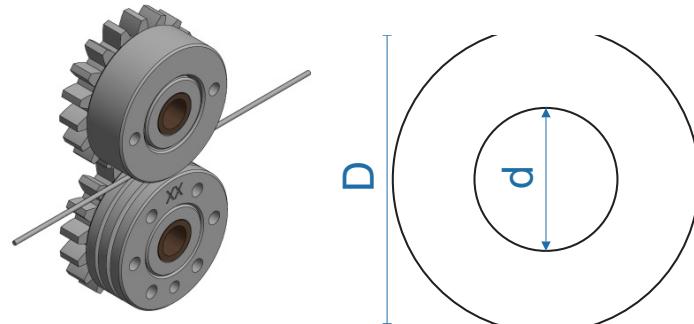
Toothed wheels for dual drive roller



| | |
|---------------|---|
| 002.0000.0299 | Gear adaptor feed roller (with bronze bushings) |
| 002.0000.0309 | Gear adaptor feed roller (with ball bearings) |

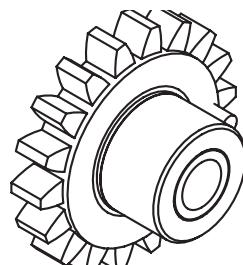
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Dual drive roller (2 rollers with grooves, 2 flat rollers)



| Code | Ø wire | Ø roll | |
|---------------|---------|-----------------|--|
| 002.0000.0145 | 1.0-1.2 | D=37x12/d=19 U | |
| 002.0000.0146 | 1.2-1.6 | D=37x12/d=19 U | |
| 002.0000.0149 | 1.0-1.2 | D=37x12/d=19 VK | |
| 002.0000.0150 | 1.2-1.6 | D=37x12/d=19 VK | |
| 002.0000.0151 | 2.4-3.2 | D=37x12/d=19 VK | |

Toothed wheels for dual drive roller



| | |
|---------------|---|
| 002.0000.0299 | Gear adaptor feed roll (with bronze bushings) |
| 002.0000.0309 | Gear adaptor feed roll (with ball bearings) |

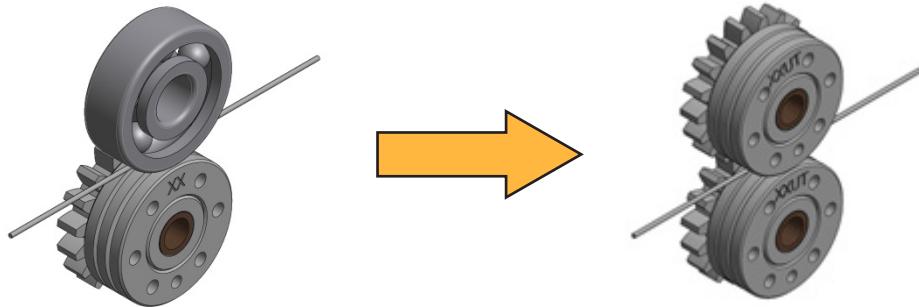
Support with dual drive roller

| Smooth | | Knurled | |
|---------------|--|---------------|---|
| Code | Ø roller | Code | Ø roller |
| 002.0000.0152 | D=37x12/d=19 SMOOTH for dual drive roller | 002.0000.0153 | D=37x12/d=19 KNURLED for dual drive roller |
| | | | |

Kit provided to switch from "STANDARD" wire feeder to wire feeder with "Dual driver roller".

Standard

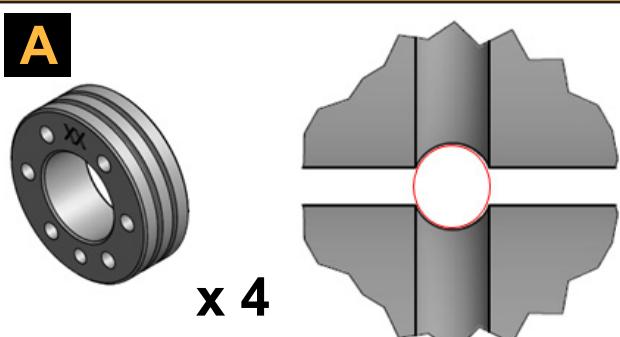
Double driving roll



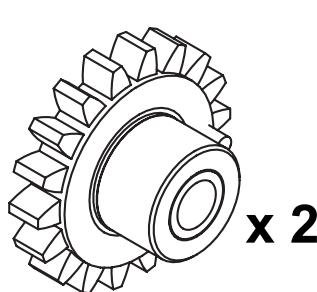
If you wish to switch from the setup with "STANDARD" wire feed rollers to the setup with "DUAL DRIVE ROLLER", the following components must be ordered:

N° 4 Special "U DOUBLE D" rolls (refer to Item A)

N° 2 Gear adaptor feed rolls (refer to Item B) [it is recommended with bronze bushings]

| Code | Ø wire | Ø roller | |
|---------------|---------|--------------------------|--|
| 002.0000.0168 | 1.0-1.2 | D=37x12/d=19 U DOUBLE D. |  A x 4 |
| 002.0000.0169 | 1.2-1.6 | D=37x12/d=19 U DOUBLE D. | |

Gears for double driving roll

| | | |
|---------------|---|---|
| 002.0000.0299 | Gear adaptor feed roll (with bronze bushings) |  B x 2 |
| 002.0000.0309 | Gear adaptor feed roll (with ball bearings) | |

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