



MODEL

**NOVAMIG 506 XP
FEEDER WP6 - 4R
G.R.6**

INSTRUCTION MANUAL

for installation,
use and maintenance
of welding
machines.

Original instructions in Italian.
Please keep for future use.

1.995.249 EN - Rev. 1.1



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1. PREFACE

1.1. PURPOSE OF THE INSTRUCTION MANUAL FOR USE AND MAINTENANCE

This manual has been designed to provide the user with general knowledge of the machine and to allow it to be used safely.

This instruction manual is an integral part of the machine and has the purpose of providing all the information necessary to ensure:

1. safe handling of the machine, either packaged and unpackaged;
2. correct machine installation;
3. knowledge of the technical specifications of the machine;
4. thorough understanding of machine operations and limitations;
5. indication of the qualifications and specific training required of those operating and carrying out maintenance work on the machine
6. in-depth knowledge of its intended, unforeseen and prohibited uses;
7. its proper and safe use;
8. how to carry out correct and safe maintenance and repair operations;
9. technical assistance and management of spare parts;
10. disposal of waste produced by the machine;
11. the safe dismantling of the machine in accordance with applicable regulations to protect workers' health and the environment.

This document assumes that the applicable occupational health & safety and hygiene regulations are complied with at the site where the machine will be used.

IMPORTANT: Those in charge have the responsibility, in accordance with current legislation, to carefully read the contents of this Instruction Manual and ensure that operators and maintenance personnel read the parts relevant to them.

The customer has the responsibility to make sure that, if this document is modified by the Manufacturer, only the updated versions of the manual are actually present at the workplace.

The instructions, documentation and drawings found in this Manual are of a confidential technical nature and strictly the property of the Manufacturer, therefore, aside from the purpose for which it was produced, any reproduction in whole or in part of the contents and/or format must have the prior consent of the Manufacturer.

THE OFFICIAL LANGUAGE CHOSEN BY THE MANUFACTURER IS ITALIAN. The manufacturer cannot be held liable for translations in other languages that do not conform to the original meaning (ORIGINAL INSTRUCTIONS).

1.2. RECIPIENTS

This Instruction Manual is intended for the installer, the operator/user, the system manager, the system safety manager and the qualified or qualified and authorised technician authorised to maintain the machine.

INSTALLER: Technician authorised by the manufacturer and expert in handling, installation, connection and adjustment of the machine.

OPERATOR/USER: This is the person in charge of using the machine and cleaning it.

PLANT MANAGER: The individual who makes the adjustments and the programming.

PLANT SAFETY MANAGER: Person responsible for verifying that all applicable safety regulations and the provisions set out in this manual are observed.

QUALIFIED TECHNICIAN: Qualified person who, by virtue of an accurate technical knowledge of the machine and all the safety procedures, performs ordinary maintenance and minor repairs.

QUALIFIED AND AUTHORISED TECHNICIAN: Highly qualified person, trained and authorised by the manufacturer to make significant adjustments and extraordinary maintenance or repairs during the warranty period.

EXPOSED PERSON: Any person who is wholly or partly in a dangerous area (near the machine and exposed to risk due to his or her safety).

The machine is intended for industrial use, so its use is strictly for qualified, skilled technical personnel, in particular those:

- over 18 years of age;
- physically and psychologically capable of performing particularly difficult technical work;
- sufficiently trained to use the machine and carry out maintenance work on it;
- deemed suitable for carrying out the task entrusted to them by their employer;

- capable of comprehending and interpreting the operator manual and the safety instructions;
- familiar with the emergency procedures and how to implement them;
- have understood the operational procedures established by the machine's Manufacturer.

1.3. STORAGE OF THE INSTRUCTION MANUAL

The Instruction Manual must be carefully stored and must accompany the machine each time it changes hands throughout its life cycle.

It should be kept in good condition by handling it with care, with clean hands, and not placing it on dirty surfaces.

Parts of the manual must not be removed, torn or changed.

The Manual should be kept close to the machine to which it refers in an environment free from humidity and heat.

1.4. UPDATING THE INSTRUCTION MANUAL

The Manufacturer is only liable for the Instructions issued and validated by itself (Original Instructions); any translations **MUST** always be accompanied by the Original Instructions to verify the correctness of the translation. In any case, the Manufacturer is not liable for translations that have not been approved by the Manufacturer himself, thus if an inconsistency is detected, attention must be paid to the original language and, if necessary, the manufacturer's sales office should be contacted, which will make the changes deemed appropriate.

The Manufacturer reserves the right to make changes to the project, changes/improvements to the machine and updates to the Instruction Manual without previously informing Customers. However, should changes be made to the machine installed at the Customer's site, in agreement with the Manufacturer and involving the adaptation of one or more chapters of the Instruction Manual, the Manufacturer shall provide the Customer with the parts of the Instruction Manual that concern the change, with the new global revision model. The Customer shall be responsible, following the instructions that accompany the updated documentation, for replacing any parts that are no longer valid with the new ones.

1.5. HOW TO READ THE INSTRUCTION MANUAL

The Manual is split into chapters, each one dedicated to a specific category of information addressed to the personnel for whom the relevant qualifications have been defined.

To facilitate immediate comprehension of the text, terms, abbreviations and pictograms are used, the meanings of which can be found in Paragraph 1.6.

1.6. TERMS, SYMBOLS AND PICTOGRAMS

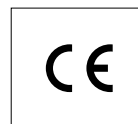
To highlight parts of text of significant importance the following symbols were adopted:

ATTENTION: Indicates the need to adopt appropriate behaviours so as not to put people's health and safety at risk and not to cause damage to the machine or the environment.

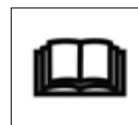
HAZARD: Indicates situations of serious danger that can seriously endanger the health and safety of people.

IMPORTANT: Indicates technical information of particular importance which should not be neglected.

The following pictogram stickers are affixed to the machine, depending on the version:



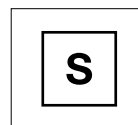
The product complies with the safety requirements provided by the applicable EU directives or regulations.



Carefully read the instructions listed in the manual.



Machine subjected to general danger (see instruction manual).



Machine used in environments with a high risk of electric shock.



WARNING!
Moving mechanical parts.
(For MIG machines only)

2. GENERAL INFORMATION

2.1. MANUFACTURER IDENTIFICATION DATA

MANUFACTURER: SINCOSALD S.r.l

HEADQUARTERS - OFFICES

via della Fisica, 26/28

20864 Agrate Brianza (MB) Italy

Tel: +39 039 641171

Fax: +39 039 6057122

CONTACTS:

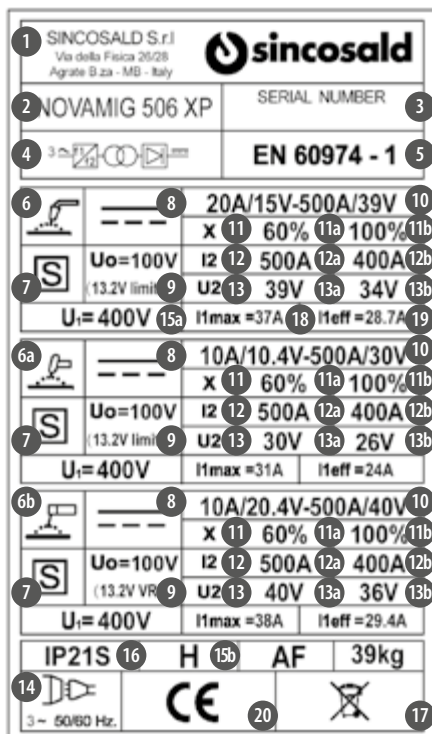
export@sincosald.it www.sincosald.it

2.2. MACHINE IDENTIFICATION DATA AND PLATES

Each machine is identified by a CE plate on which its reference data is indelibly marked. For any communication with the manufacturer or service centre always quote these references.

IMPORTANT: The plate must not be removed for any reason, under penalty of forfeiture of the guarantee and the unavailability of spare parts due to failure to be identified. The position of the nameplate on the Machine can vary from machine to machine.



NOVAMIG 506 XP plate



Explanation of the NOVAMIG 506 XP plate

- Pos. 1** Name and address of the manufacturer and trademark
- Pos. 2** Identification of the welding machine model
- Pos. 3** Welding machine serial number
- Pos. 4** Welding machine type symbol: Transformer - Rectifier for arc welding
- Pos. 5** Reference to the legislation followed for welding machine construction: EN 60974-1
- Pos. 6** Welding with MIG/MAG procedure
- Pos. 6a** Welding with TIG procedure
- Pos. 6b** Welding with MMA procedure
- Pos. 7** Symbol indicating that the welding machine can be used in environments with an increased risk of electric shock
- Pos. 8** Welding current symbol: Direct Current / Alternating Current
- Pos. 9** Rated no-load voltage U₀ in V
- Pos. 10** Electric adjustment range of the welding machine: minimum and maximum rated welding current, with the relevant charged voltages
- Pos. 11** Welding machine service factor (X): this figure indicates the welding machine service factor as a percentage of a 10-minute work cycle. Example X = 60% - I₂ 350 A, these data indicate that the welding machine on a work cycle can weld with a current I₂ = 350 A for a time of 6 minutes out of 10, that is 60%.
- Pos. 11a** Service factor: 60 %
- Pos. 11b** Service factor: 100 %
- Pos. 12** Rated welding current (I₂)
- Pos. 12a** Value of the rated welding current at 60%
- Pos. 12b** Value of rated welding current at 100%
- Pos. 13** Conventional load voltage (U₂)
- Pos. 13a** Voltage at 60 % load
- Pos. 13b** Voltage at 100 % load
- Pos. 14** Symbol for the welding machine power supply and number of phases followed by the direct/alternating current symbol
- Pos. 15a** Rated power voltage
- Pos. 15b** Insulation class
- Pos. 16** Indicates the degree of welding machine protection: IP 23
- Pos. 17** See chapter 9.
- Pos. 18** ADDITIONAL INSTRUCTIONS
- Pos. 18** Maximum current in MIG welding
- Pos. 19** Actual current in MIG welding
- Pos. 20** Product complies with the safety requirements established by the applicable EU directives or regulations



FEEDER WP6 - 4R plate

SINCOSALD S.r.l. Via della Fisica 26/28 Agrate B.za - MB - Italy			
FEEDER WP6 4R		SERIAL NUMBER	
		IEC 974 - 5	
Ø FILO 0.6 - 1.6			
11 = 3.5 A	X	60 %	100 %
U1=24 Vdc	I2	500 A	390 A
CE	IP 23S		

Explanation of the FEEDER WP6 - 4R plate

- Pos. 1** Name and address of the manufacturer and trademark
- Pos. 2** Feeder model identification
- Pos. 3** Feeder serial number
- Pos. 4** Reference to the regulation followed for feeder construction. IEC 974-5
- Pos. 5** Weldable wire diameter
- Pos. 6** Power voltage symbol: single phase
- Pos. 7** Absorbed current
- Pos. 8** Applied voltage
- Pos. 9** Feeder service factor (X): this data indicates the feeder service factor as a percentage of a 10-minute work cycle. Example X = 60% - I2 350 A, these data indicate that the feeder on a work cycle can weld with a current I2 = 350 A for a time of 6 minutes out of 10, that is 60%.
 - Pos. 9a** Service factor: 60 %
 - Pos. 9b** Service factor: 100 %
- Pos. 10** Rated welding current (I2)
- Pos. 10a** Value of the rated welding current at 60%
- Pos. 10b** Rated welding current at 100%
- Pos. 11** Feeder protection grade: IP 23
- Pos. 12** See chapter 9.
ADDITIONAL INSTRUCTIONS

G.R.6 plate

SINCOSALD s.r.l. 20864 AGRATE BRIANZA (MB) ITALY Via della Fisica, 26 / 28			
G.R.6		IEC 60974-2	
U1 = 400V - 1 - 50/60 Hz		I1max = 0.8 A	
IP 23			
MAX FLOW = 10 LT/min		INPUT Capacity = 220 W	

Explanation of the G.R.6 plate

- Pos. 1** Name and address of the manufacturer and trademark
- Pos. 2** Cooling unit model identification
- Pos. 3** Reference to the regulation followed for cooling unit construction: IEC 60974-2
- Pos. 4** Cooling unit power voltage
- Pos. 5** Maximum current
- Pos. 6** Cooling unit protection grade: IP 23
- Pos. 7** See chapter 9.
ADDITIONAL INSTRUCTIONS
- Pos. 8** Maximum flow (LT/min)
- Pos. 9** Absorbed power

2.3. DECLARATIONS OF CONFORMITY

The machine is constructed in compliance with the relevant EU Directives, applicable at the time of its entering onto the market.

2.4. SAFETY STANDARDS

The machine was built in accordance with the following standards and directives:

Harmonised standards
IEC 60974-1 - IEC 60974-5 - IEC 60974-10
Directives
EN 60204-1 - 2014-35-EV - 9231 EEC - 9368 EEC
Standards
EN/IEC 61000-3-12 - EN/IEC 61000-3-11 - EN/IEC 61000-3-3

2.5. INFORMATION ON TECHNICAL ASSISTANCE

The machines are covered by a warranty, as provided for in the general conditions of sale.

If during the warranty period you experience a malfunction or failure of the machine parts, which fall under the cases covered by the warranty, the manufacturer, after the necessary machine checks, will repair or replace defective parts.

The goods travel at the customer's risk; product damage caused by transportation or unloading is not covered by the warranty. All equipment and consumables supplied with the product are also excluded from the warranty.

It is reminded that any modifications carried out by the user, without the express written consent of the manufacturer, will void the warranty and free the manufacturer from any liability for damage caused by a defective product.

This applies in particular to alterations made to safety devices that reduce their effectiveness.

The same considerations apply when using non-original spare parts or those different to the ones explicitly specified by the manufacturer.

For these reasons, we recommend our customers to always contact our Customer Service.

2.6. PREPARATION BY THE CUSTOMER

Unless otherwise agreed in the contract, the following are normally the Customer's responsibility:

- Room preparations, including any building work and/or ducting systems required;
- Electrical supply of the equipment, in compliance with the standards in force in the country of use. Particular care must be given to the protective conductor commonly known as "earthing" and to the efficiency of the circuit breaker installed to protect the power outlet. It is the purchaser's responsibility to keep the above system adequately efficient, in compliance with current accident prevention regulations.
- Consumables or material normally subject to wear;
- Equipment unloading at delivery and the consequent liabilities.

3. SAFETY

3.1. GENERAL SAFETY WARNINGS

WARNING: your safety depends on you!!!

- *Follow all safety rules carefully.*
- *It is your duty to protect yourself and others from the risks of welding operations.*
- *The operator is responsible for his own safety and that of those in the work area. He must therefore know all the safety rules and observe them.*

Nothing can replace common sense!!!

IMPORTANT: Before operating the machine, carefully read the instructions contained in this manual and follow them thoroughly.

The manufacturer has made every effort to design this machine and to make it as **INTRINSICALLY SAFE** as possible.

The manufacturer has also equipped the machine with all the protective and safety devices considered necessary. Finally, it has provided enough information for it to be used safely and correctly.

IMPORTANT: This information must be scrupulously followed.

The user may choose to appropriately add to the information provided by the manufacturer with additional processing instructions, which, obviously, do not contradict that contained in this Instruction Manual, in order to contribute to safe machine use.

For example, you must pay close attention to the clothing that anyone working on the machine is wearing:

- Avoid using clothes with hooks that can remain attached to parts of the machine;
- Avoid using ties or other fluttering clothing parts;
- Avoid wearing bulky rings or bracelets that may get caught in parts of the machine.

Whenever necessary, further recommendations for use will be provided in the Manual for the user related to preventive measures, personal protective equipment, information to prevent human error and any reasonably foreseeable prohibited behaviour.

It is, however, essential to diligently follow the following indications:

- It is absolutely forbidden to operate the machine automatically with the fixed and/or mobile guards removed;
- It is strictly prohibited to disable the safety mechanisms installed on the machine;
- Operations at reduced safety levels must be carried out in strict accordance with the instructions given in the relevant descriptions;
- After any operation with reduced safety levels, guards/safety devices should be replaced on the machine as soon as possible;
- Any cleaning must be carried out with the electrical and pneumatic separation devices sectioned.
- Do not alter parts of the machine for any reason; in the event of malfunction, due to non-compliance with the above, the manufacturer cannot be held liable for the consequences. We recommend that you request any changes to be made directly to the manufacturer;
- Clean the casing of the machines, the panels and the controls with soft cloths that are dry or have been lightly soaked in a mild detergent solution; do not use any type of solvent, such as alcohol or petrol, as the surfaces may be damaged;
- Position the machines as determined at the time of order according to the diagrams provided by the manufacturer, otherwise it cannot be held liable for any problems.

ATTENTION:

The Manufacturer cannot be held liable for damage caused by the machine to persons, animals or property in the event of:

- **use of the machine by personnel who are not adequately trained;**
- **improper use of the machine;**
- **electrical, hydraulic or pneumatic power supply faults;**
- **incorrect installation;**
- **failure to perform scheduled maintenance;**
- **unauthorised modifications or operations;**
- **the use of spare parts that are not original or not specific to the model;**
- **total or partial failure to follow the instructions;**
- **use contrary to the specific national regulations;**
- **calamities and exceptional events.**

General requirements

The moving parts must always be used according to the manufacturer's instructions, as indicated in this manual, which must always be available at the workplace.

All safety features placed on moving parts to prevent accidents and safeguard safety can not be modified or removed, but must be adequately safeguarded.

The user must promptly inform the employer or his direct superior of any defects or anomalies presented on the mobile parts.

A) Electric shock

ELECTRIC SHOCK CAN BE FATAL!!!

- All electric shocks are potentially fatal.
- Do not touch live parts.
- Insulate yourself from the piece to be welded and from the earth, wearing insulating gloves and clothes.
- Keep clothing (gloves, shoes, headgear, clothes) and body dry.
- Do not work in damp or wet environments. Do not lean on the piece to be welded.
- If you have to work near or in an area at risk, use all possible precautions.
- If you also feel a little electric shock, stop welding immediately; do not use the device until the problem is identified and resolved.
- Provide an automatic wall switch, of adequate capacity and possibly in the vicinity of the machine, to immediately cut off the device in the event of an emergency situation.
- Frequently inspect the power cord.
- Disconnect the power cord from the mains before working on the cables or before opening the machine.
- Do not use the machine without the protective bulkheads.
- Always replace any damaged parts of the machine with original materials.
- Never bypass machine safety devices.
- Make sure that the power supply line is equipped with an efficient earth socket.
- Make sure that the work bench and the work piece are connected to an efficient earth socket.
- Never electrically and simultaneously touch "hot" parts of pliers connected to two welders because the voltage between the two can be the total of the no-load voltage of both welding machines.
- Any maintenance must be performed only by expert personnel, aware of the risks due to the voltages necessary for the operation of the equipment.

B) Radiation

Ultraviolet radiation, emitted from the electric arc, can damage the eyes and burn the skin.

Follow the instructions below:

- Wear appropriate clothing and protective masks.
- **DO NOT use CONTACT LENSES!!!** The intense heat emanating from the electric arc could stick them

to the cornea.

- Use masks with lenses, with a minimum DIN 10 or DIN 11 protection grade.
- Protect people near the welding area.
- **REMEMBER:** The arc can blind or damage your eyes. The arc is dangerous up to a distance of 15 metres. Never look at the arc with the naked eye!
- Prepare the welding area so as to reduce reflection and transmission of ultraviolet radiation: paint walls and exposed surfaces black to reduce reflection, installing protective screens or curtains, to reduce ultraviolet transmissions.
- Replace the mask lenses when they are damaged or broken.

C) Welding wire

Attention: the welding wire can cause perforated wounds.

- Do not press the button on the welding torch before carefully reading the instructions for use.
- Do not point the torch towards parts of the body, other people or metals, when mounting the welding wire on the welding machine.

D) Explosions

- Do not weld above or near pressurised containers.
- Do not weld in an atmosphere containing explosive powders, gases or vapours.

This welder uses inert gases such as CO₂, ARGON, or ARGON + CO₂ mixtures to protect the arc, therefore it is necessary to pay the utmost attention to:

1) Cylinders:

- Handle or use pressurised cylinders in accordance with the regulations in force.
- Do not connect the cylinder directly to the machine's gas pipe, without using a pressure regulator.
- Do not use cylinders that leak or are physically damaged.
- Do not use cylinders that are not well secured to the welding machine or to suitable supports.
- Do not transport cylinders without the valve protection fitted.
- Do not use cylinders whose contents have not been clearly identified.
- Do not put the cylinder in electrical contact with the arc.
- Do not expose cylinders to excessive heat, sparks, molten slag or flames.
- Do not tamper with the cylinder valves.
- Do not attempt to unlock blocked valves with hammers, keys, tools or other systems.
- Never delete or alter the name, number or other markings on the cylinders. It is illegal and dangerous.

- Do not lift the cylinders from the ground by holding them by the valve or by the cap, or by using chains, slings or magnets.
- Do not attempt to mix any gas inside the cylinders.
- Never refill the cylinders, but have them refilled by specialised companies.
- Do not modify or exchange the cylinder fittings.

2) Pressure regulators:

- Keep pressure regulators in good condition. Damaged regulators can cause damage or serious accidents; they must be repaired only by qualified personnel.
- Do not use regulators for gases other than those for which they were manufactured.
- Never use a regulator that leaks or appears physically damaged.
- Never lubricate a regulator with oil or grease.

3) Hoses:

- Replace hoses that appear damaged.
- Keep hoses taut to avoid accidental creases.
- Keep the excess hose collected and keep it out of the work area to prevent damage.

E) Fire

- Avoid igniting fire due to sparks and hot slag or incandescent parts.
- Ensure that appropriate fire protection devices are available near the work area.
- Remove flammable and combustible materials from the work area and the surrounding area (minimum 10 metres).
- Do not weld/cut fuel and lubricant containers, even if empty; these must be carefully cleaned before being processed.
- Allow the piece to cool before touching it or putting it in contact with combustible or flammable materials.
- Do not work on parts with cavities containing flammable materials.
- Do not operate in atmospheres with high concentrations of combustible vapours, flammable gases or dust.
- Always check the work area thirty minutes after the end of work to ensure that there are no fires.
- Do not keep combustible materials such as lighters or matches in your pocket.

F) Burns

Protect the skin against burns caused by ultraviolet radiation emitted by the electric arc, by sparks and slag from molten metal, using fireproof clothing, which covers all exposed surfaces of the body.

Wear protective clothing and welder gloves, headgear and high shoes with safety tip. Button the shirt collars and pocket flaps and wear trousers without cuff to avoid the entry of sparks and slag.

Wear a mask with protective glass on the outside and adiactinic glass filter inside. This is MANDATORY for welding/cutting operations, in order to protect the eyes from radiant energy and volatile metals. Replace the protective glass if it is broken, pitted or spotted. Avoid oily or greasy clothes; a spark could ignite them. Incandescent metal parts, such as work pieces, should always be handled with gloves.

First aid equipment and a qualified person should be available for each shift, unless there are health facilities nearby for immediate treatment of eye and skin burns.

G) Fumes

Welding/cutting operations produce harmful fumes and metal dust, which can damage health:

- Do not work in spaces without adequate ventilation. Keep your head out of the fumes.
- In closed environments, use suitable exhaust fans. If ventilation is not adequate, use suitable respirators.
- Clean the material to be welded/cut if there are solvents or halogen degreasers, which give rise to toxic gases. During work, some chlorinated solvents can decompose in the presence of radiation emitted by the electric arc and produce phosgene gas.
- Do not weld/cut coated metals or those containing lead, graphite, cadmium, zinc, chromium, mercury or beryllium, unless a suitable respirator is available.

The electric arc generates ozone. Prolonged exposure, in environments with high concentrations of ozone, can cause headaches, irritation of the nose, throat and eyes and severe congestion and chest pain.

IMPORTANT: DO NOT USE OXYGEN FOR VENTILATION!!!

Gas leaks must be avoided in small spaces. Large gas leaks can dangerously change the oxygen concentration.

Do not place cylinders in small spaces.

DO NOT WELD or CUT where solvent vapours can be drawn into the welding atmosphere or if radiant energy can penetrate into atmospheres containing even tiny amounts of trichloroethylene and perchlorethylene.

H) Moving parts can cause damage

Moving parts, such as the fan, can cut fingers and

hands and catch clothes.

Keep all doors, covers and guards closed and securely in place.

Protections and coverings can be removed, for possible maintenance and checks, only by qualified personnel.

Keep hands, hair, loose clothing and tools away from moving parts.

Refit the covers and guards and close the doors when the operation is completed and before restarting the machine.

I) Noise

These welders do not in themselves produce any noise exceeding 70 dB. Arc welding processes can produce noise levels above this limit. Therefore, users must implement the precautions required by law.

Ear plugs should be used when working overhead or in a small space.

A rigid helmet should be used when others work in the area above.

Welders should not use flammable hair products.

WARNINGS ABOUT ELECTROMAGNETIC COMPATIBILITY

Although these welding machines have been built according to the regulations, they can generate electromagnetic disturbances, that is disturbances to the telecommunication systems (telephone, radio, television) or to the control and safety systems. Read the instructions carefully to eliminate or minimise interference.

ATTENTION: the welding machine has been designed to work in an industrial environment, therefore, to operate in domestic environments it may be necessary to observe special precautions in order to avoid possible electromagnetic interference.

You must install and use the welding machine according to the manufacturer's instructions. If electromagnetic interference is detected, countermeasures must be taken to eliminate the problem, possibly using the manufacturer's technical assistance. In any case, do not modify the welding machine without the manufacturer's approval.

Work area control to prevent E.M. interference

Before installing the welding machine it is necessary to check the work area to detect the existence of services that could malfunction in the event of electromagnetic disturbances.

Below is a list of services to consider:

- a) Power cables, control cables, transmission system and telephone cables that pass near the welding machine.
- b) Radio or television transmitters and receivers.
- c) Computer or control equipment.
- d) Safety and industrial process control equipment.
- e) Calibration and measurement instruments.
- f) Check the level of electromagnetic immunity of the equipment operating in the work area.
- g) The health of people in the vicinity, for example people who use pacemakers and earphones for hearing.
- h) The daily duration of welding operations or other activities.

The other devices must be electromagnetically compatible. This operation may require additional protective measures.

The dimensions of the area to be considered depend on the structure of the building and the type of activity in progress.

PACEMAKERS AND HEARING AIDS

Magnetic fields deriving from high currents can affect the correct functioning of pacemakers and hearing aids. Wearers of electronic equipment should consult a physician before approaching arc welding operations.

METHODS FOR REDUCING EMISSIONS

A) Power supply

The welding or cutting device must be connected to the power supply following the manufacturer's recommendations.

When interference problems arise, it may be necessary to take measures to solve the problem, such as the addition of filters on the power supply.

In the case of permanent installation of the equipment, the metal shielding of the power cables can be taken into consideration. The shielding must be connected to the welding machine so that there is good electrical contact between it and the mantle of the welding machine itself.

B) Welding machine maintenance

The welding machine must be periodically subjected to maintenance, according to the manufacturer's instructions.

Remove dust or foreign materials every 6 months, which may have been deposited on the transformer or on the diodes of the rectifier unit; to do this use a jet of dry, clean air.

The mantle and all the possible accesses inside the

welding machine must be correctly closed during the welding and cutting operations. The welding machine must never be modified in any part except for modifications planned and authorised by the manufacturer and carried out by persons authorised by the manufacturer.

In particular, the distance of the arc from the work piece and the stabilisation devices must be adjusted and maintained according to the manufacturer's recommendations.

C) Cables

Cables must be kept as short as possible and must be placed close to each other and passed on the floor or as low as possible.

D) Work piece earthing

The earth connection of the work piece can reduce electromagnetic emissions in some cases.

The operator must pay attention to avoid that the earthing of the piece is not a source of danger for people and damage to the equipment. Where necessary, earthing must be carried out with a direct connection between the work piece and the ground, while in countries where this is not permitted, the connection must be made using a capacitor in accordance with the regulations of the country.

E) Shielding

Cable and equipment shielding in the work area can reduce interference. Shielding of the entire welding or cutting installation can be considered for special applications.

F) Equipotential connections

The equipotential connections of all metal components in and near welding installations should be considered.

In any case the metal components connected to the piece to be welded will increase the risk for the operator to receive an electric shock from the simultaneous contact with these metal components and the electrode. The operator should be isolated from all these metal components rendered equipotential.

Checks and inspections

Checks must be carried out by a qualified technician or a qualified and authorised technician; they must be visual and functional, with the aim of guaranteeing the safety of the machine.

They include:

- inspection of all supporting structures, which must not show any signs of cracking, breakage, damage, deformation, corrosion, wear or altera-

tion to the original characteristics;

- checking all mechanical parts;
- inspection of all the safety devices installed on the machine;
- ll connections with pins and screws;
- inspection of the machine operations;
- inspection of the machine status;
- verification of the correct operation and efficiency of the electrical system;
- checking the seal and efficiency of the pneumatic and/or hydraulic system.

The results of these checks must be reported on a specific sheet.

ATTENTION: If worn or faulty parts are not promptly replaced, the manufacturer cannot be held in any way liable for the damage caused by accidents that may result.

If faults or anomalies are detected, they must be eliminated before the machine is put into operation, and the expert carrying out the inspection will have to certify that the repair has been made, thus allowing the machine to be used.

If the person performing the inspection detects hazardous faults, they must promptly inform the machine manufacturer.

Place the machine out of service if operating faults are found while performing the appropriate checks/inspections and/or repairs. Check that no objects are left between the moving parts after any maintenance work.

In order to guarantee maximum safety of the machine it is, nonetheless, PROHIBITED to:

- Tamper with any part of the machine;
- Leave moving parts unattended;
- Use the machine when not operating at full efficiency;
- Modify the machine to change the originally established use, without explicit authorisation from the Manufacturer;
- Run moving parts with manual operations in case of power failure.

3.2. INTENDED USE

The system should only be used for the purpose for which it was manufactured meaning to generate an electrical arch for MIG/MAG, TIG, MMA welding or plasma cutting accordingly.

ATTENTION: It cannot therefore be used as a device for thaw pipes; any improper use automatically voids the warranty and excludes the manufacturer from any liability in case of damage to persons and property.

3.3. CONTRAINDICATIONS FOR USE

The machine must not be used:

- For uses other than those specified by the manufacturer, for different uses or not mentioned in this manual;
- In explosive, corrosive atmospheres or with a high concentration of dust or oily substances suspended in the air;
- In atmospheres with high fire risks;
- Exposed to adverse weather conditions;
- With safety devices bypassed or out of order;
- With electrical bridges and/or other means that exclude power/parts of the machine.

3.4. HAZARDOUS AREAS

The work area pertaining to the operator which is substantially the entire perimeter of the machine is considered hazardous.

It is the responsibility of the operator to keep the work area clear of persons or objects while using the machine and to avoid damage to persons, things or animals.

The use of the machine near other equipment or machines introduces additional risks. The operator is asked to evaluate these risks in order to prevent accidents.

3.5. SAFETY DEVICES

Welding machines are equipped with safety devices designed to prevent damage to the operator or to the welding machine itself. A safety device is any object or system that can reduce the risk of such damage. Do not tamper with active safety devices or their connections.

Do not operate with the welding machine without the metal covers or with non-insulated connections. If necessary, during installation and connection, they must be integrated with others in order to guarantee compliance with the laws in force.

IMPORTANT: Daily check that the safety devices are functioning properly and efficient.

3.6. SIGNS

The safety signs must always be clearly visible and it is absolutely forbidden to remove or hide them. Generally there are signals or signs on the machine or in the work environment that indicate dangerous situations, prohibitions or instructions during use or operations connected to it, as in the following examples:



Emission of optical radiation:
The risk of optical radiation exists where the sign is affixed. Cat. 2 (EN 12198).



Fire hazard:
Fire hazards exist where the sign is affixed.



General warning:
This symbol indicates a hazard of any nature that may cause personal and property damages.



Explosion hazard:
This symbol indicates the presence of explosive substances or explosion hazard.



Warning:
Contact injuries may occur in this point (i.e. Electrical shock).



Blinding:
Protection goggles or mask must be worn near this symbol.



Fatal hazard:

Pay the utmost attention near this indication!!! Never touch the area indicated by this symbol since it indicates a fatal hazard.



Noise:

Hearing protection must be worn near this symbol.

3.7. RESIDUAL RISKS

Careful use of the machine minimises the probability of accidents; however, during the use of the machine it is necessary to strictly observe the safety rules described in this manual.

4. INSTALLATION

4.1. SHIPPING

The shipment, also depending on the destination, can be carried out by different means.

The packed machine must be properly anchored to the means of transport in order to avoid uncontrolled movements.

The shipment is always carried out under the responsibility of the purchaser who assumes all charges for accidents and thefts that could occur during the transport itself.

4.2. PACKAGING

The machine is shipped packed in a special container and, if necessary, it is suitably stabilised with shock-proof material to ensure its integrity.

The packaging is made, with containment of the overall dimensions, also depending on the type of transport adopted.

To facilitate transport, the shipment can be performed with some components disassembled and properly protected and packaged.

THE PACKAGING CONTAINS:

- No. 1 **NOVAMIG 506 XP** welding machine
- No. 1 **FEEDER WP6 - 4R** wire feeder
- No. 1 **G.R.6** cooling unit
- No. 1 4 Mt. extension
- No. 1 Instruction manual

OPTIONAL ACCESSORIES:

- No. 1 Earth cable
- No. 1 Welding torch

4.3. MACHINE RECEIPT

Upon receipt of the machine, check that the information in the shipping document actually corresponds to the material received and check that the packaging is perfectly intact.

IMPORTANT: in case of damage or absence of some parts, immediately report the anomaly to the carrier, making any descriptive notes of the damage on the transport document before signing. Do not use the machine, but contact the seller to agree on the procedure to be adopted.

To this end, it is advisable to carry out a check of the packaging during the unloading phase and, in

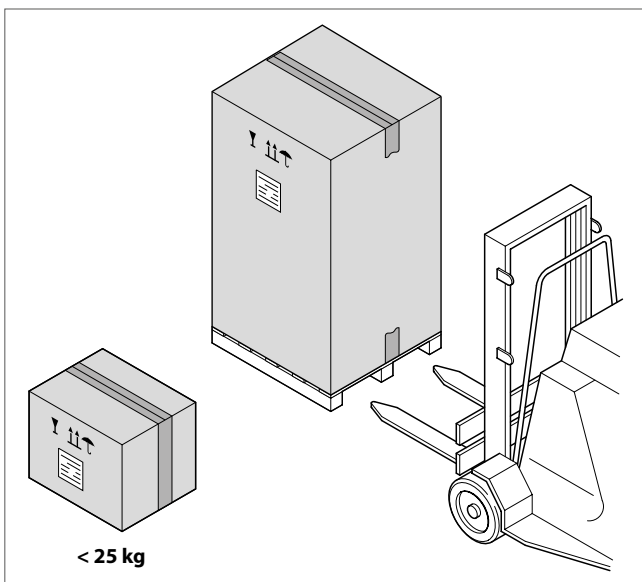
suspicious cases, open the packaging and to verify the safety of the machine and any loose units.

4.4. HANDLING AND LIFTING

ATTENTION: handling and lifting must be carried out by trained and qualified operators, using appropriate means and methods, to avoid risks to personal health and damage to the machine. Before carrying out handling and lifting, check the position of the centre of gravity of the load; always check the correct weight balance of the machine when it is transported, so as to prevent unexpected machine movements or falls. It is recommended to always use vehicles capable of supporting the weight and dimensions of the machine ("TECHNICAL SPECIFICATIONS" paragraph of this manual), so as to avoid damage to the machine or to persons or things around it.

IMPORTANT: the customer is always exclusively liable during the equipment loading and unloading phases.

For transport to the final installation site, it is preferable to use a forklift or pallet truck, taking care that the lifting forks support the entire crate.



For movements within the plant, the machine may be transported with a crane by properly harnessing it using cables with the appropriate resistance characteristics, depending on the weight of the machine itself. If the supply includes only the welding machine, generally weighing less than 25 kg, the packaging consists of a cardboard box without lifting pallets. It can be easily lifted by two operators and taken to the place of use.

ATTENTION: The machine must remain packed during unloading from the means of transport and until it is transferred to its destination.

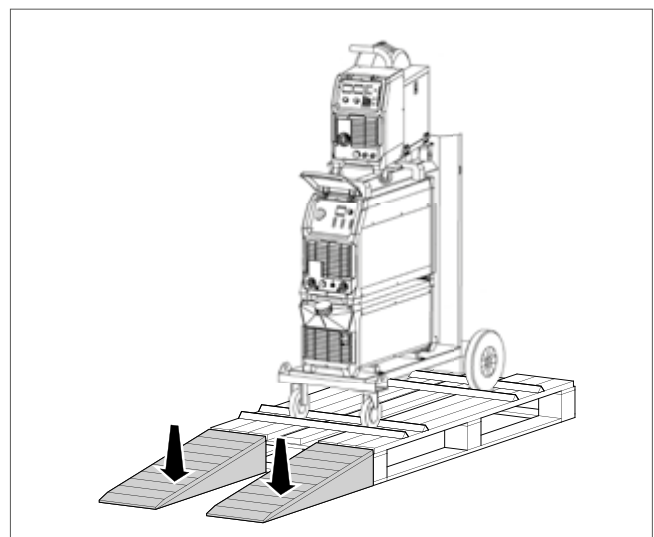
IMPORTANT: The Manufacturer cannot be held liable for damage caused to persons or property due to utilising lifting systems other than those described above.

4.5. UNPACKING

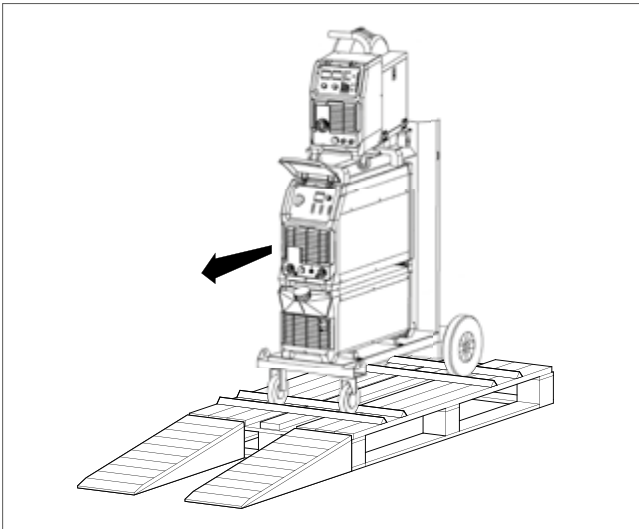
IMPORTANT: Consult the "Handling and lifting" paragraph to correctly handle the machine.

ATTENTION: To remove the machine from the packaging, use appropriate means and methods to avoid risks to human health. The packaging material must be properly disposed of in compliance with the laws in force.

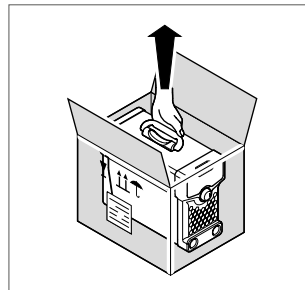
- Remove the protective covers such as straps, boxes, etc. using appropriate tools so as not to ruin the content.
- Remove the protective covers such as straps, boxes, etc. using appropriate tools so as not to ruin the content.
- Position appropriate descent ramps from the pallet verifying that the slides are well hooked to the pallet.



- Complete the unloading operations by carefully lowering the machine from the pallet.



If only the welding machine is present, this must be handled using the convenient handle on the upper part of the welding machine itself.



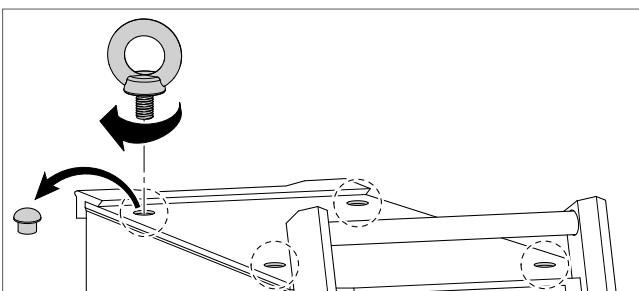
ATTENTION: risk of overturning when unloading the machine from the pallet equipped with descent ramps.

ATTENTION: when carrying out unpacking operations, it may be necessary to have two persons equipped with suitable personal protective equipment.

IMPORTANT: in addition to handling the machine using the special trolley, it can be lifted from the ground after having wrapped it with lifting straps, by slinging it from the bottom in a stable and safe way.

If provided, the machine must be lifted only and exclusively by using M10 eye-bolts which are not supplied.

Remove the protective caps from the threaded holes and tighten up the lifting eye-bolts.



Do not lift the machine by the FEEDER or generator handles.

The machine has a sturdy handle integrated in the frame for handling.

N.B. These lifting and handling devices comply with the provisions prescribed by European standards. Do not use other devices such as lifting and handling equipment.

4.6. STORAGE

In the case of inactivity, the machine must be stored in compliance with the following precautions:

- Store the machine in an enclosed area accessible only to employees; the storage area must have a stable support surface with an adequate load coefficient and must be free of fire and/or explosion risk; it must have adequate humidity and temperature and sufficient lighting.
- Protect the machine from any impact and stresses;
- Protect the machine from humidity and high temperatures;
- Ensure the machine does not come into contact with corrosive substances;
- In the event of prolonged storage, periodically check that there are no variations in the condition of the packages.

4.7. PREPARATIONS

Installation preparations

For the installation, it is necessary to prepare a manoeuvring area suited to the machine dimensions and selected lifting means. The machine must be positioned so that it is ideally ergonomic and provides maximum safety in the work place: leave an area around it large enough to allow easy operations and handling of the material to be processed and for maintenance and adjustment operations to be carried out.

Before installing the machine, check that the selected area is suitable and has the necessary authorisations to carry out the activity, sufficiently ventilated and illuminated, with a stable and levelled support surface. For installations on a raised floor, check that the slab can withstand the load.

Electrical system preparation

Connection to the electrical system which powers and combines the synchronisation with other machines should be done by specialised and qualified staff following the wiring diagram and arrangements set out in Laws and/or Technical Standards currently in force

for safety in workplaces and electrical installations. Appropriate safety devices must be provided for its operation in line with those required in the area of safety in the workplace.

IMPORTANT: The manufacturer cannot held liable for any damage to property, persons and/or animals caused by non-compliance with this provision.

To achieve an adequate level of safety, the electrical system to which the machine is connected must provide, at the user's full charge, an earthing system according to the provisions of the user's country, a circuit breaker to protect the power supply socket with value ΔI (current variation) not less than 30mA and anything else for a correct execution in a workmanlike manner, according to Laws and/or Technical standards in matters of safety in the workplace and electrical systems. Prepare connections for earthing the machine casing.

ATTENTION: These preparations are always the sole liability of the user and nothing can be attributed to the manufacturer for damage to property, persons and/or animals due to poor electrical connections.

4.8. ASSEMBLY/POSITIONING

WARNING: the assembly of any detached units and the installation of the machine must be carried out exclusively by technicians authorised by the manufacturer.

To allow for correct operations, the machine must always be positioned in places that comply with the environmental conditions described in this manual. The machine must always be positioned in a perfectly levelled area; levelling can also be carried out using any adjustment systems present on the machine.

ATTENTION: The machine must be positioned so as not to obstruct the entry and exit of the air from the cooling slots. REDUCED FLOW OF AIR causes overheating and possible damage to internal parts. Keep at least 500 mm of free space around the device.

IMPORTANT: Do not place any filtering device on the air intake passages of this welding machine. The warranty is void if any type of filtering device is used.

4.9. CONNECTIONS

Electrical connections

The machine's internal connections are carried out by qualified personnel sent by the manufacturer. The electrical connection between the machine panel and the customer's power distribution supply line must be carried out by qualified personnel from the Customer.

IMPORTANT: The personnel qualified to carry out the electrical connection must make sure of the perfect efficiency of the earthing of the electrical system and must check that the line voltage and the frequency correspond to the data shown on the identification plate. Incorrect supply voltages can cause serious damage to the system.

If the system is set to operate at single-phase 230 V at 50-60 Hz, wire the end of the power cable to an EEC plug with the same capacity as the socket on the line switch as per the following diagram:

SINGLE-PHASE connections

Wire colour	Connection
Brown	Phase
Blue	Neutral
Yellow/Green	Earth

If the system is set to operate at three-phase 400 V at 50-60 Hz, wire the end of the power cable to an EEC plug with the same capacity as the socket on the line switch as per the following diagram:

THREE-PHASE connections

Wire colour	Connection
Black	"R" phase
Brown	"S" phase
Blue/Grey	"T" phase
Yellow/Green	Earth

ATTENTION: Make sure the system line switch is in the "0" position before connecting the power cable.

ATTENTION: It is mandatory to install a circuit breaker with interlocked CEE socket, of adequate capacity and verifying that the earth socket is efficient and separate from the rest of the electrical system of the working environment.

ATTENTION: the yellow-green wire of the welding machine power cable must always be connected to the protection conductor (system earth). The yellow-green wire should NEVER be combined with another phase wire for a voltage withdrawal. Do not touch live parts.

Gas hose connection

ATTENTION: Cylinders can explode if damaged!!!

- Keep the cylinders upright and chained to the appropriate support.
- Keep the cylinders in a place where they cannot be damaged accidentally.
- Do not lift the machine with the cylinder attached.
- Never touch the cylinder with the welding wire.
- Keep the cylinder away from the welding area or from non-insulated electrical circuits.

The inert gas cylinder must be equipped with a pressure reducer and possibly also a flow meter. Only after having correctly positioned the cylinder, connect the gas hose, exiting from the rear of the machine, to the pressure reducer. Next you can open the cylinder and adjust the pressure reducer.

4.10. PRELIMINARY CHECKS

It is necessary to carry out the following operations before each machine start-up:

- Check all the safety systems;
- Check protection and signs.

Before putting the machine into operation, a number of checks and controls must be carried out in order to prevent errors or accidents during the Start-up phase:

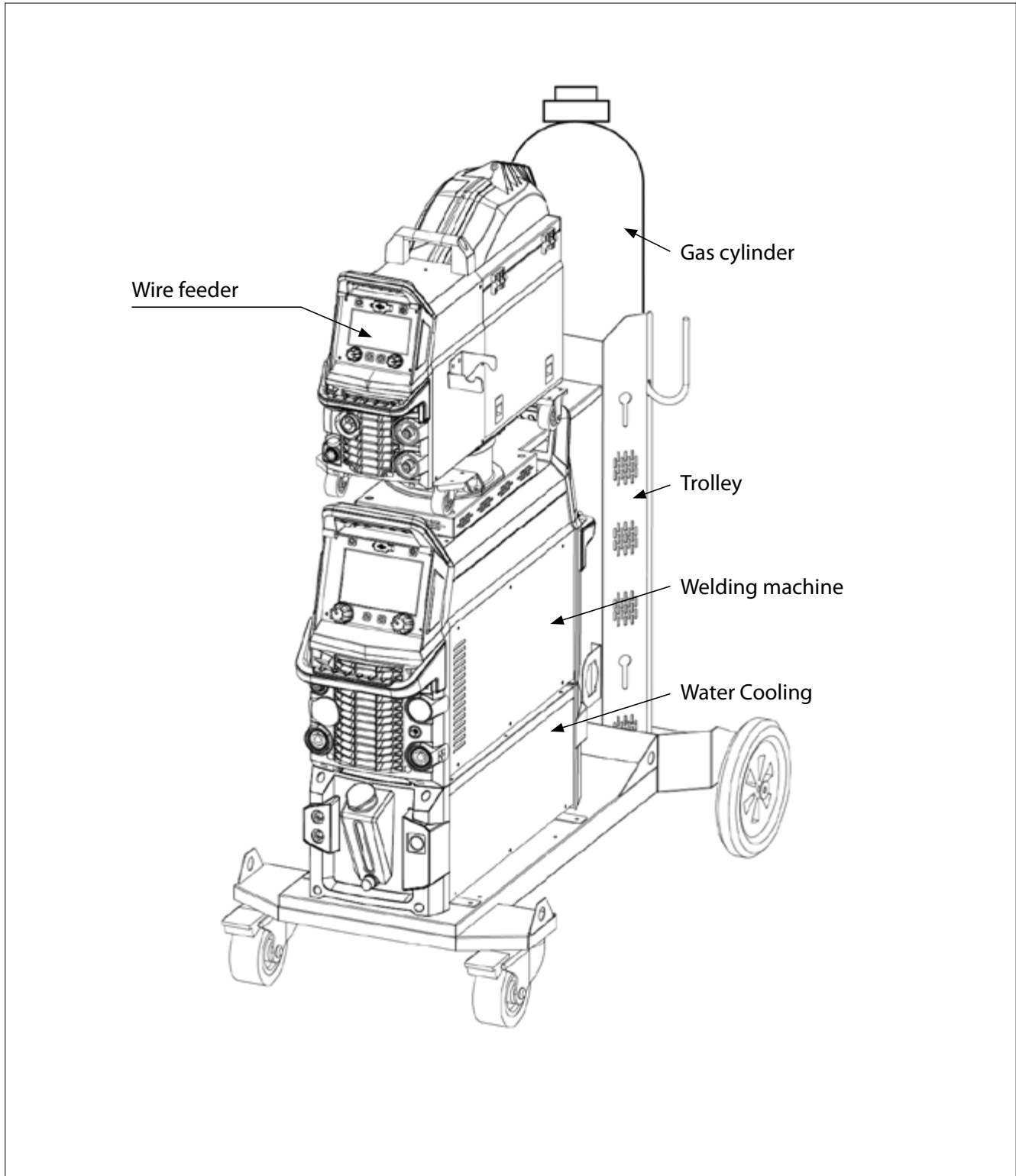
- Check that the machine has not been damaged during assembly;
- Verify, with particular care, the integrity of the electrical panels, control panels, electrical wiring and tubing;
- Check the exact connection of all external power sources;
- Check the free movement and free rotation of all moving parts;
- Check that hydraulic and pneumatic connections are tight so that they do not cause dangerous leakage.

5. MACHINE DESCRIPTION

5.1. OPERATING PRINCIPLE

NOVAMIG series welding systems have been designed for continuous wire welding under protection of gas, in short and spray arc, with the use of solid and animated steel, stainless steel and aluminium wires.

The **NOVAMIG** series welding system composition is shown below.



5.2. FEATURES AND MAIN COMPONENTS

- New PWM technology and IGBT inverter technology.
- MIG/MAG with Pulse SYN/Dual pulse SYN/Manual and SYN function
 - Synergic programs for aluminum, mill steel, stainless steel and CuSi
 - JOB mode (Save and call 100 different job records)
 - 2T /4T welding mode
 - Function parameter adjustment
- MMA function (Stick electrode)
 - VRD (Voltage Reduction Device)
 - Hot start (improves electrode starting)
 - Adjustable Arc Force
- DC TIG
 - Lift Arc ignition (prevents tungsten sticking during arc ignition)
 - 2T /4T Trigger Control
 - Adjustable Down slope
 - Gas/air cooling mode
- Internal wire feeder, gear driven for up to 300 mm Ø spool
- Euro style MIG torch connection
- IP23 rating for environmental/safety protection
- Tolerant to variable power supply
- Spool Gun Connection

5.3. ENVIRONMENTAL CONDITIONS

The machine does not require particular environmental conditions. The machine must be installed indoors in a well-lit, ventilated industrial building with solid and level flooring.

The machine is suitable for operating in environments that:

- have an altitude not exceeding 2000 m a.s.l.;
- temperature between + 5 ° and + 35 ° C;
- relative humidity not higher than 80%.

It is forbidden to use the machine in environments that are:

- dusty;
- in corrosive atmosphere;
- at fire risk;
- in an explosive atmosphere.

ATTENTION: The welding machine has an IP 23 protection grade, therefore its use is precluded in certain environmental situations, such as rain, excessive presence of metallic dust, presence of acids and corrosive atmospheres.

5.4. LIGHTING

The lighting of the area of installation must comply with the laws in force in the country where the machine is installed and must, however, ensure good visibility at all points, not create hazardous reflections and allow clear reading of the control panels as well as identification of emergency buttons.

As the machine does not have its own light, it is necessary for the working environment to be equipped with general lighting to guarantee the machine has a value of 200 and 300 lux at all points of the machine.

5.5. VIBRATIONS

Under operating conditions that comply with the indications for proper use, the vibrations are not such as to cause hazardous situations. If this happens, you must request technical assistance and suspend the use of the equipment until the fault is resolved.

5.6. NOISE

The equivalent continuous A-weighted sound pressure level, emitted by the machine at the workplace in full operating conditions, is less than 70 dB (A). These emissions comply with the limits of the regulations in force and are not such as to generate danger for operators.

Arc welding processes can, however, produce noise levels above this limit. Therefore, users must implement the precautions required by law.

5.7. TECHNICAL SPECIFICATIONS

The following table shows the main technical specifications relating to the machine:

Parameters	NOVAMIG 506 XP
Input Voltage (V)	3~380/400/440±10%
Frequency (HZ)	50/60
Input Current (A)	MIG 41
	TIG 33
	MMA 42
Input Power (kW)	MIG 10.9
	TIG 8.8
	MMA 11.2
Welding Current (A)	25-500 (MIG)
Welding Voltage (V)	15.25-39 (MIG)
No-load Voltage (V)	15
Duty cycle (40°)	60% 500A
	100% 387A
Diameter (mm)	Fe:0.8/0.9/1.0/1.2/1.6 Flu.Fe:1.0/1.2/1.6 Ss:0.8/1.0/1.2/1.6
	Flux-Ss:1.2 AlMg:1.0/1.2/1.6 CuSi:1.0/1.2/1.6
Protection class	IP21S
Insulation class	H
Dimensions (mm)	820x270x510
Weight (Kg)	40
Power Factor	0.7

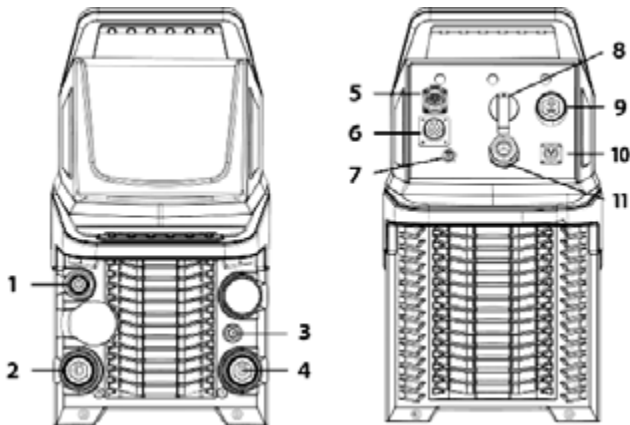
Note: The above parameters are subject to change with future machine improvement!

Parameters	FEEDER WP6 – 4R
Power voltage	Single-phase 24 Vdc
Frequency (HZ)	50/60
Maximum absorbed current (A)	3.5
Service factor	60% 500A
	100% 390A
Weldable wire diameter (mm)	0.8 ÷ 1.6
Dimensions (mm)	290 L x 530 H x 660 P
Weight (Kg)	18.9

6. MACHINE USE

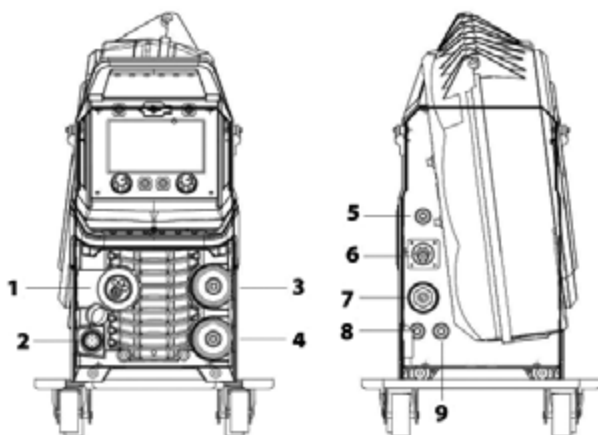
6.1. MACHINE LAYOUT DESCRIPTION

6.1.1. Front and rear panel layout of welding machine (NOVAMIG 506 XP)



1. TIG gun control connector
2. Negative (-) welding power output connection socket.
3. Gas outlet
4. Positive (+) welding power output connection socket.
5. The robot wire feeder control connector
6. The wire feeder control connector
7. Gas Inlet
8. Power switch
9. "+" Output terminal
10. The robot control connector
11. Input power cable

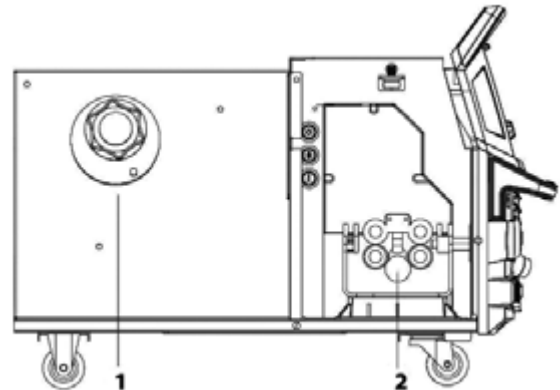
6.1.2. Front and rear panel layout of wire feeder



1. Mig Torch/Spool Gun Connector
2. Spool Gun Power Supply Connection
3. Water Inlet connector (blue)

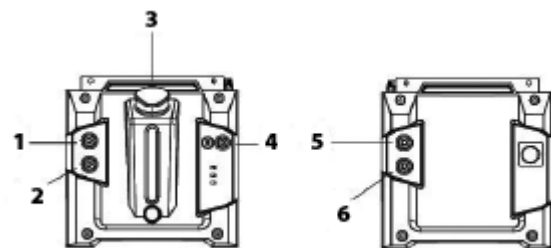
4. Water outlet connector (red)
5. Gas Inlet
6. The wire feeder control connector
7. "+" input terminal
8. Water Inlet connector (blue)
9. Water outlet connector (red)

6.1.3. Internal panel layout of wire feeder



1. Spool holder assembly
2. Wire feed assembly

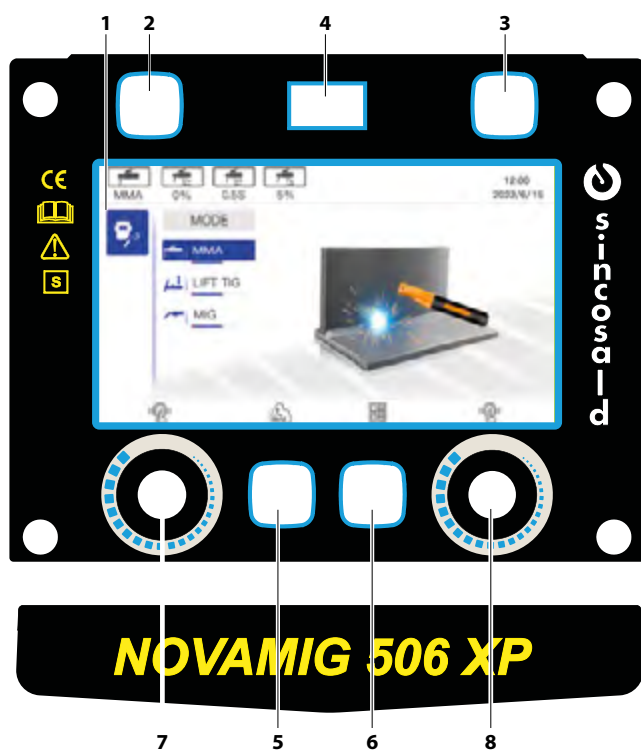
6.1.4. Front and rear panel layout of water cooling



1. Water inlet
2. Water Inlet connector (blue)
3. Water outlet connector (red)
4. The water cooling control connector
5. Water Inlet connector (blue)
6. Water outlet connector (red)

6.2. CONTROL PANEL OF WELDING MACHINE

6.2.1. Main Start-up Interface



1. 5 inch IPS screen
2. job button
3. Set button
4. USB Connection
5. Function button 1
6. Function button 2
7. Left encoder
8. Right encoder

Function selection interface:

The encoder button in 7 the rotation function interface can be selected from MMA, MIG, TIG three welding methods.



MMA



LIFT TIG



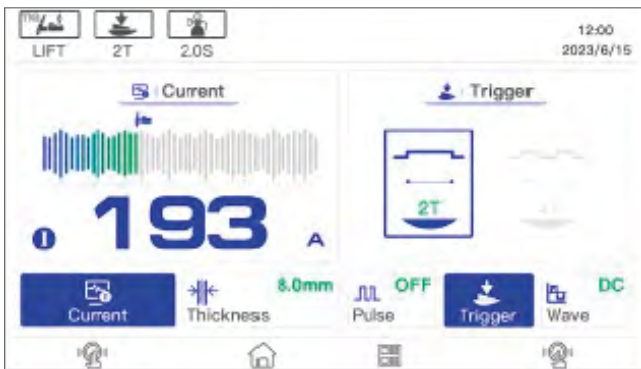
MIG

Welding parameter setting interface:


A welding parameter and its corresponding value may be selected and set by rotating the **7 8** encoder button in the welding interface.



MMA welding interface



LIFT TIG welding interface

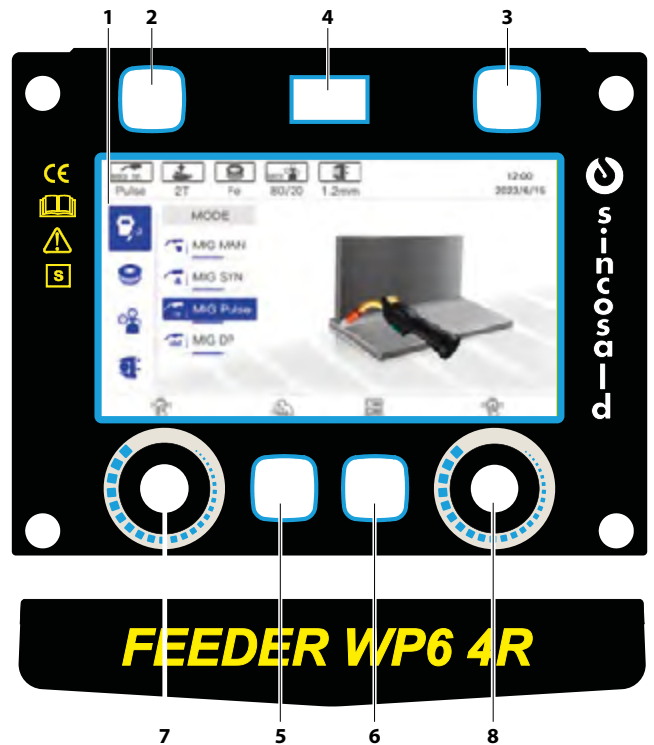
Press the **6** right button  you can call up the parameter interface, rotate and press the **7 8** encoder button to adjust the parameter values. The interface just as shown below:



LIFT TIG curve interface

6.3. WIRE FEEDER WELDER CONTROL PANEL

6.3.1. Main Start-up Interface



1. 5 inch IPS screen
2. job button
3. Set button
4. USB Connection
5. Function button 1
6. Function button 2
7. Left encoder
8. Right encoder

Function selection interface

Encoder button In the **7** mode selection interface can choose MIG, MAN, MIG, SYN, MIG Pulse, MIG DP four welding methods.



MIG MAN



MIG SYN



MIG Pulse



MIG DP

Synergic parameter selection interface

A synergic parameter may be selected by rotating the 7 encoder button in the SYN interface.



Wire



Gas



Diameter

6.4. SYNERGIC FUNCTION

This makes the setup of MIG welding more simple, the operator simply sets the welding current like MMA or TIG welding and the machine calculates the optimal voltage and wire speed for the material type, wire type and size and shielding gas being used. Obviously other variables such as welding joint type and thickness, air temperature affect the optimal voltage and wire feed setting, so the program provides a voltage fine tuning function for the synergic program selected. Once the voltage is adjusted in a synergic program, it will stay fixed at this variation when the current setting is changed. To reset the voltage for a synergic program back to factory default, change to another program and back again

Welding parameter setting interface

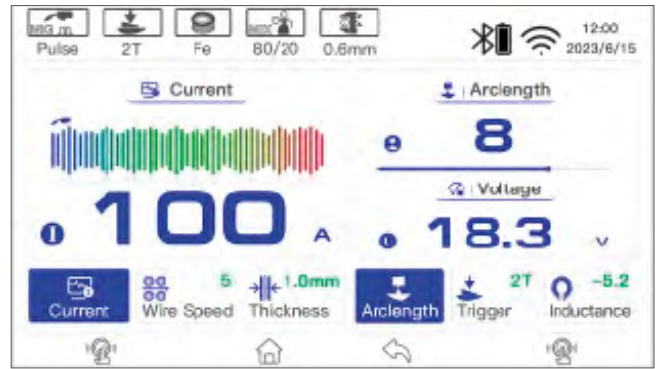
A welding parameter and its corresponding value may be selected and set by rotating the **7 8** encoder button in the welding interface.



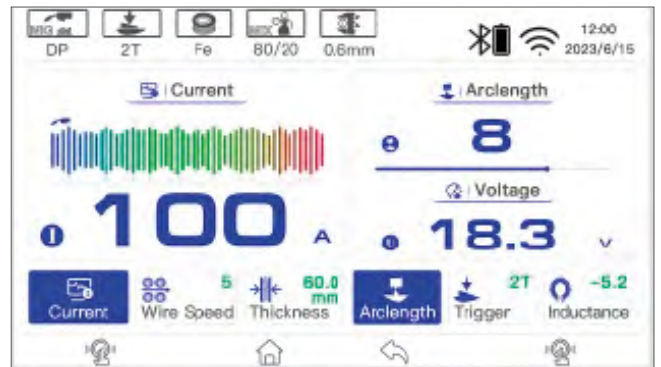
MIG Manual welding interface




MIG Synergic welding interface

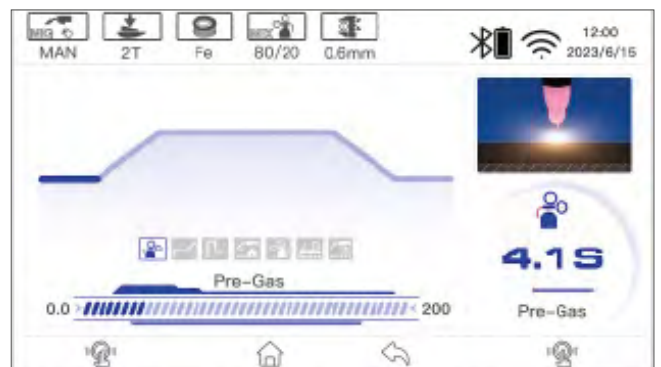
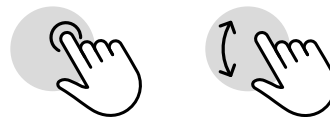


MIG Pulse welding interface



MIG Dual Pulse welding interface

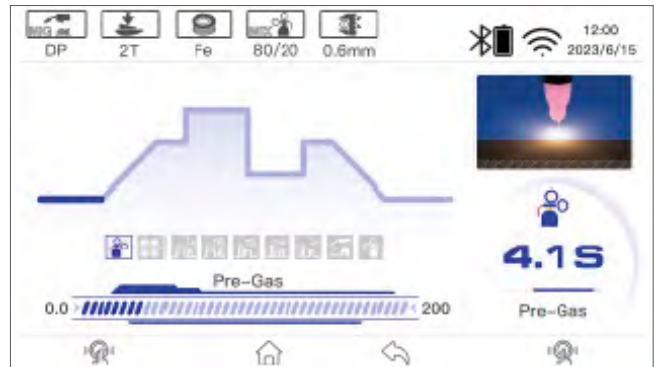
Press the **6** right button  you can call up the parameter interface, rotate and press the **7 8** encoder button to adjust the parameter values. The interface just as shown below:



MIG Manual Spot curve interface



MIG Synergic welding interface



MIG Dual Pulse 2T/4T curve interface



MIG Synergic S4T curve interface



MIG Dual Pulse S4T curve interface



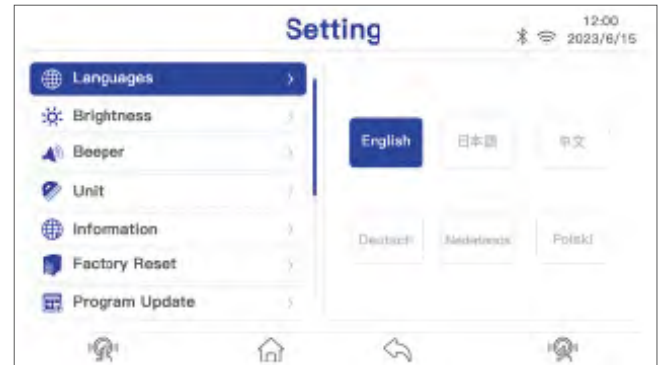
MIG Pulse S4T curve interface

6.5. IMPLICIT PARAMETER FUNCTION INTRODUCTION

FUNCTION	Campo regolazione	Modalità
Pre-Flow	0.0-20.0S	2T/4T
Post-Flow	0.0-20.0S	
Slow Feed	0-10	
Burn Back	0-10	
Spot Time	0.5-20.0S	Spot
Inductance	-10.0-10.0	MIG Manual/ SYN
Welding Volts	10.0-27.0V	
Welding Amp	25-110A	
Spool Gun	OFF/ON	MIG Manual
Wire Speed	3.0-13.0 m/min	MIG Dual Pulse/Pulse/SYN
Thickness	0.6-1.7mm	
Start Amp P	1-200%	
End Amp P	1-200%	
Start Amp AL	-10-10.0	
End Amp AL	-10-10.0	
Peak Amp	30-100A	Dual Pulse
Peak Time	0.01-20.0S	
Base Time	0.01-20.0S	S4T
Base Amp P	1-200%	MIG Dual Pulse/ Pulse
Base Amp AL	-10-+10	
Hot Start	0-10	MMA
Hot Start Time	0.5-5.0S	
Peak Amp	10-200A	
Arc Force	0-100	
Post-Flow	0.0-20.0S	TIG
Down Slope	0.0-20.0S	
Trigger	2T/4T	

System setting screen

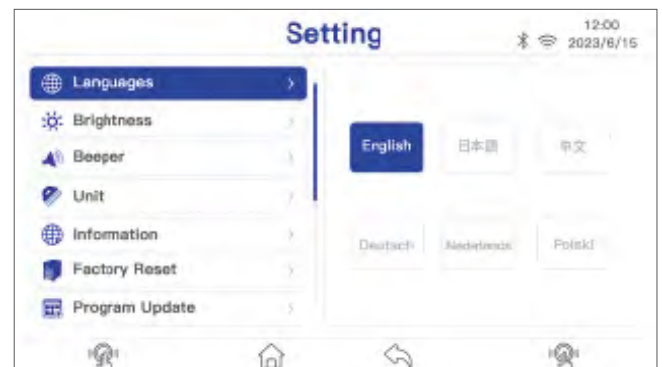
In any screen, press the **3** setting button to enter the screen. The interface is shown as follows:



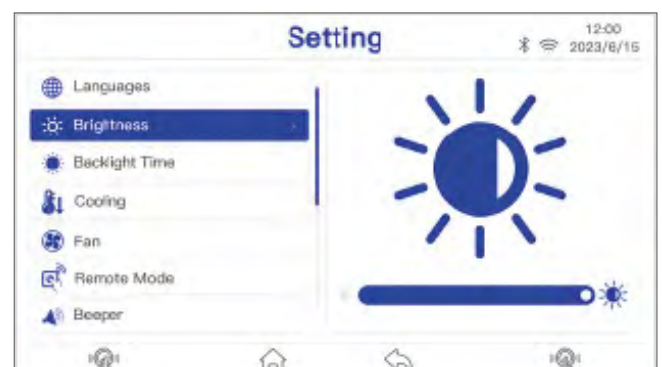
System parameters available by rotating Main Knob

Language	Inglese, ..
Brightness	1 - 10
Beeper	On/off
Information	Image Ver
Fan	Normale/Smart

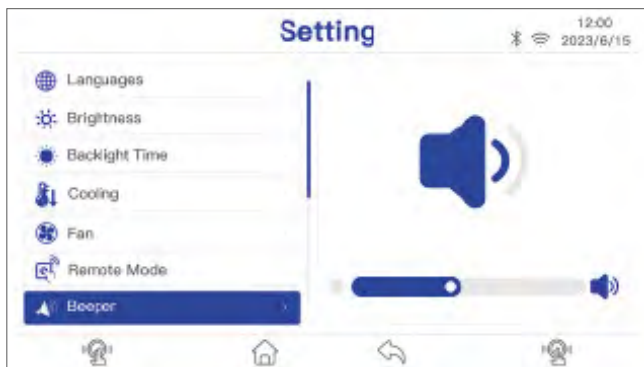
Language selection interface



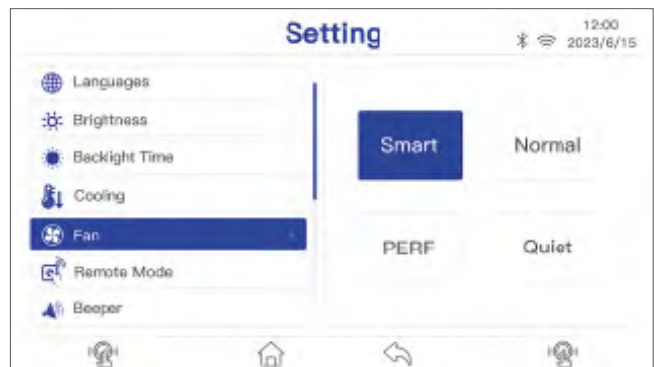
Brightness adjustment interface



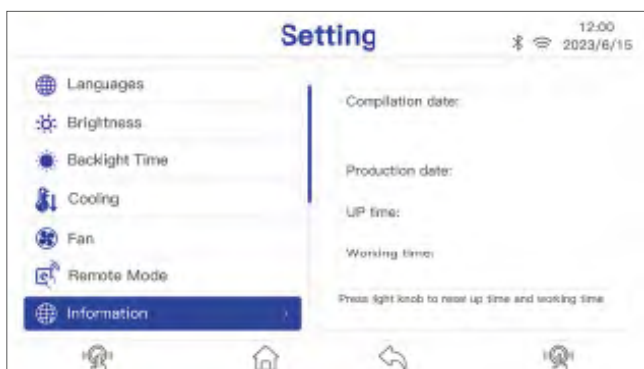
Beeper switching interface



Fan switching interface



Version Information interface



Note:

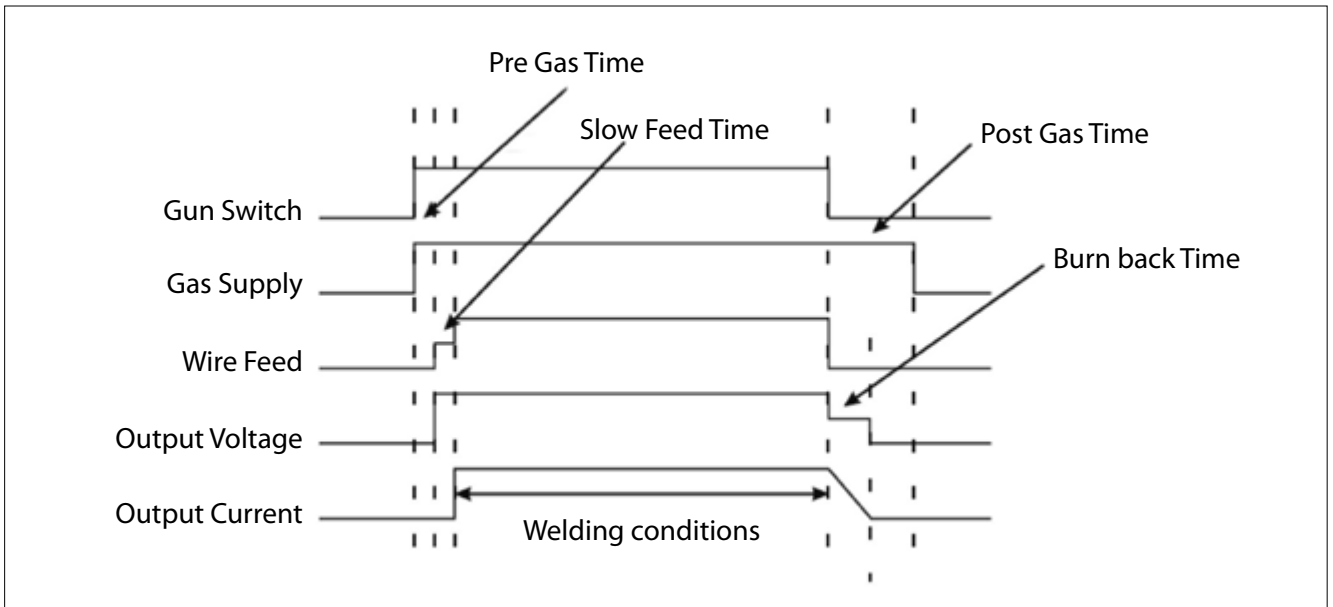
1. In the welding process, press the MENU key to return to the main interface and reset parameters, and then press the ENTER key to enter the welding interface.
2. In the function selection interface, rotate **5** Left button to select a welding method as required and press **7** Left button two times to directly enter the welding interface.

6.6. CONTROLS EXPLAINED

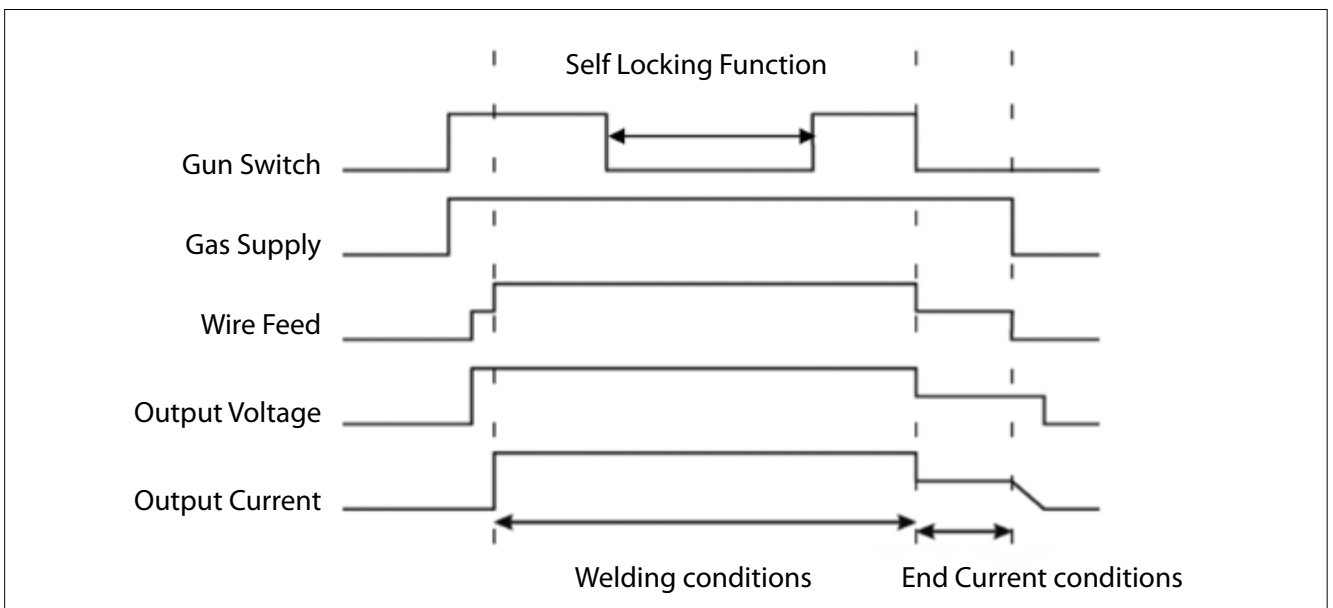
6.6.1. Trigger mode select



2T mode

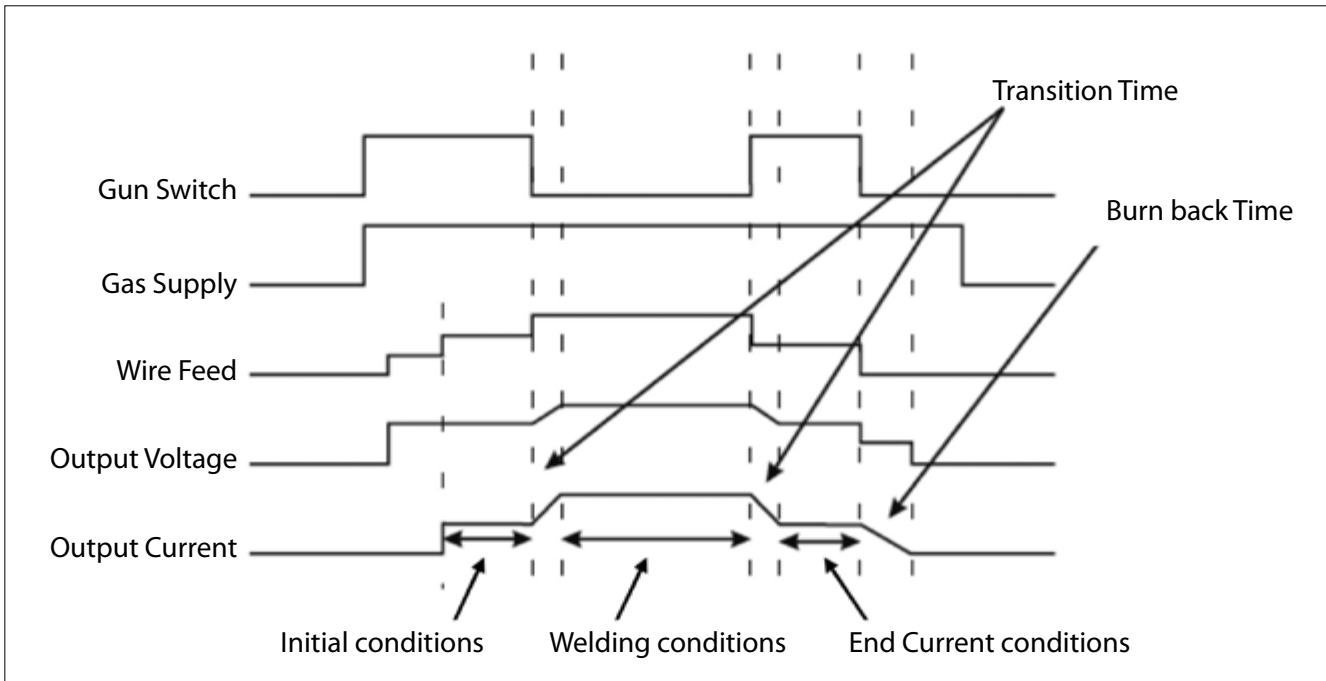


4T mode

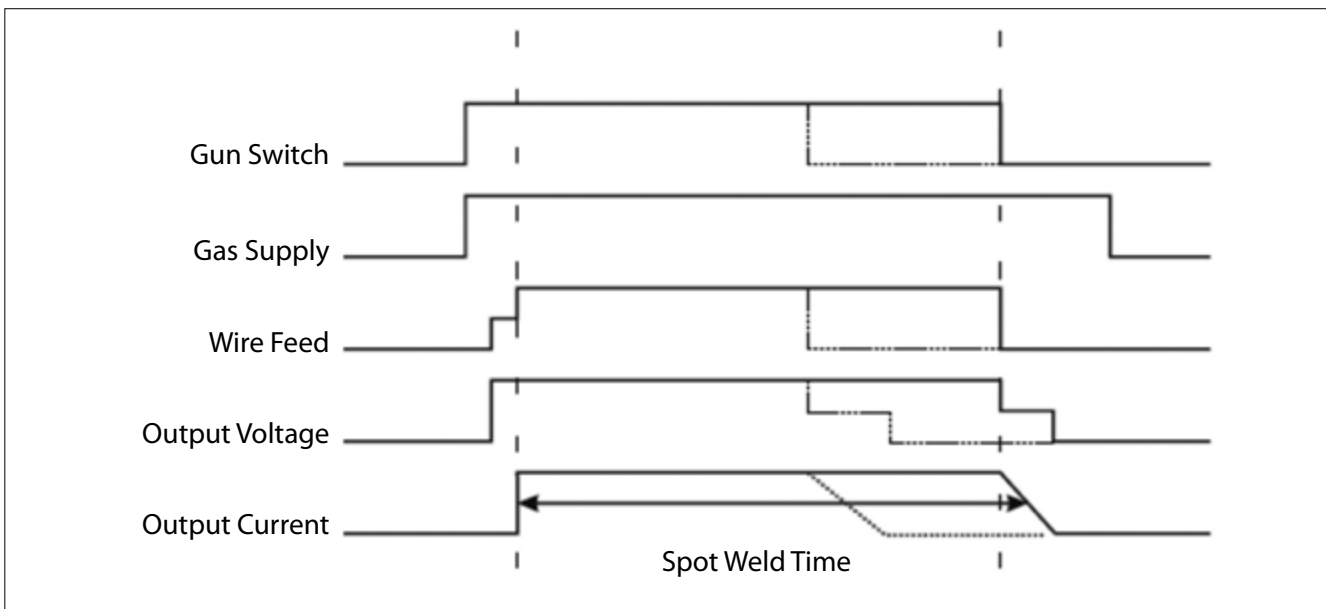




S4T mode

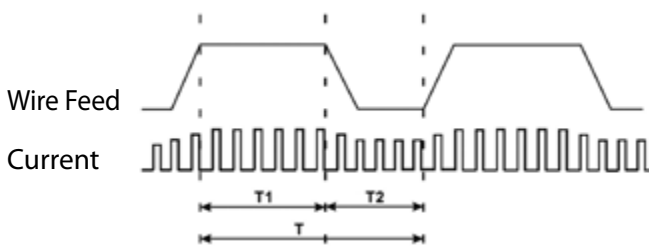


Spot weld



6.6.2. Dual pulse function introduction

Dual pulse welding in single pulse welding with low frequency modulated pulse, low frequency pulse frequency 0.5-3.0Hz. Single pulse compared to dual pulse has the advantages of: without welding swing, weld automatic fish squamous and fish scale pattern density, the depth can be adjusted; to be more precise control of heat input. During the low current, cooling the molten pool, reduce workpiece deformation, reduce the hot cracking tendency; and periodically stirring molten pool, grain refinement, the hydrogen gas from the molten pool in precipitation to reduce the porosity and reduce welding defects. Dual pulse reference waveform as shown below:



DUAL PULSE FREQUENCY

Set low frequency pulse frequency, as shown in Figure regulating the value of time T, namely, fish scale pattern of density regulation.

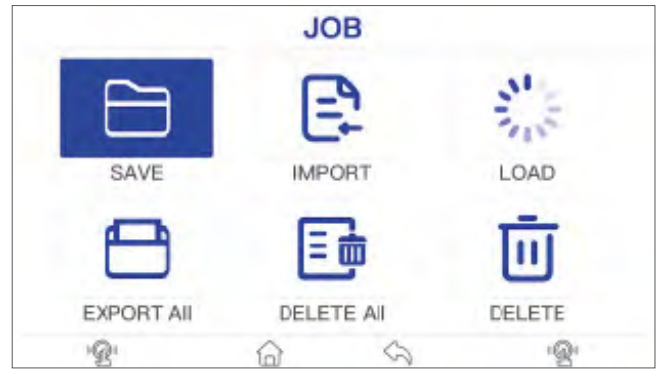
DUAL PULSE DUTY

Adjusting the duty cycle in the double-pulsed process allows you to adjust the T1 time (pulse duration), the ratio between the first and second currents, and the cycle frequency. This feature allows you to obtain a flat weld bead with the characteristic herringbone appearance.

The up-down function enables and disables the up/down movement of the torch. More specifically, with the up-down function ON, control is possible only via the torch, while in the OFF position, control is possible only the control panel.

6.6.3. JOB Interface

In the JOB mode, 10 different JOB records can be stored and called, improve the quality of welding process.



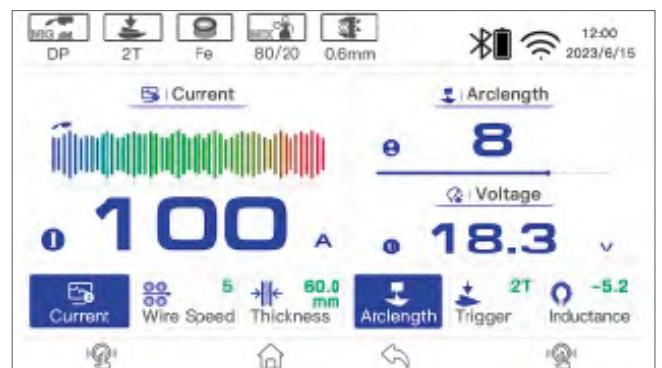
Save

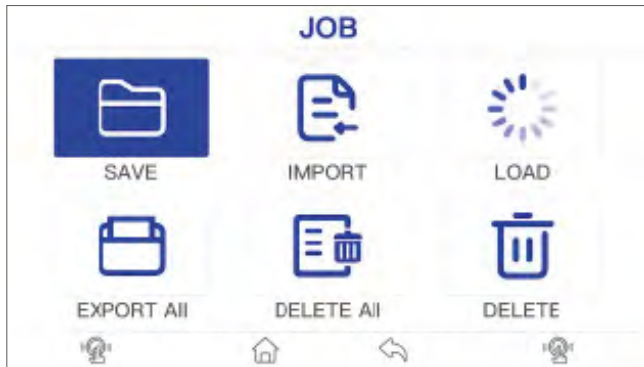


Load

6.6.4. Save the JOB programs

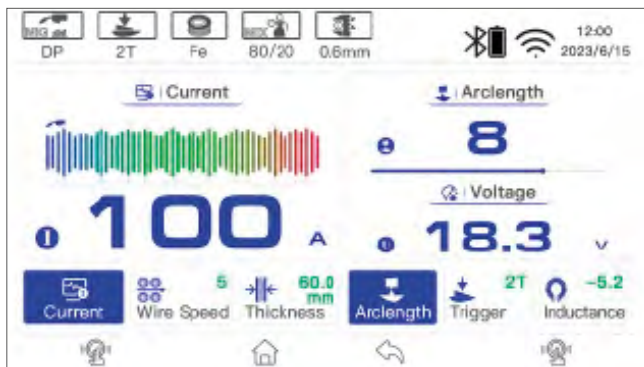
- Welding machine before leaving the factory did not save the JOB programs, to be called before, you must first save the JOB programs.
- Press **2** Save button on the welding interface to enter the save state.





6.6.5. Call the JOB programs

- Press **2** on the welding interface, or press **2** on the main interface to enter the loading state.



6.6.6. Alarm indicator

Lights when over voltage, over current, input phase loss or electrical overheating (due to exceeding duty cycle) is detected and protection is activated. When protection is activated, welding output will be disabled until the safety system senses the overload has reduced sufficiently and indicator lamp goes out. May also trigger if machine experiences an internal power circuit failure.



Over-heating (1st thermal relay)



Over-heating (2nd thermal relay)



Over-heating (Program in default)



Phase loss

6.7. INSTALLATION & OPERATION FOR MMA WELDING

6.7.1. Set up installation for MMA Welding

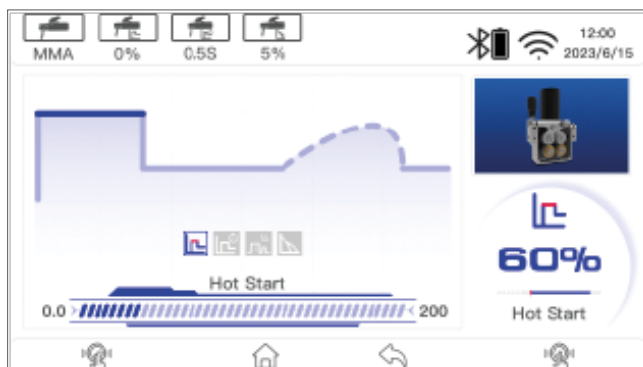
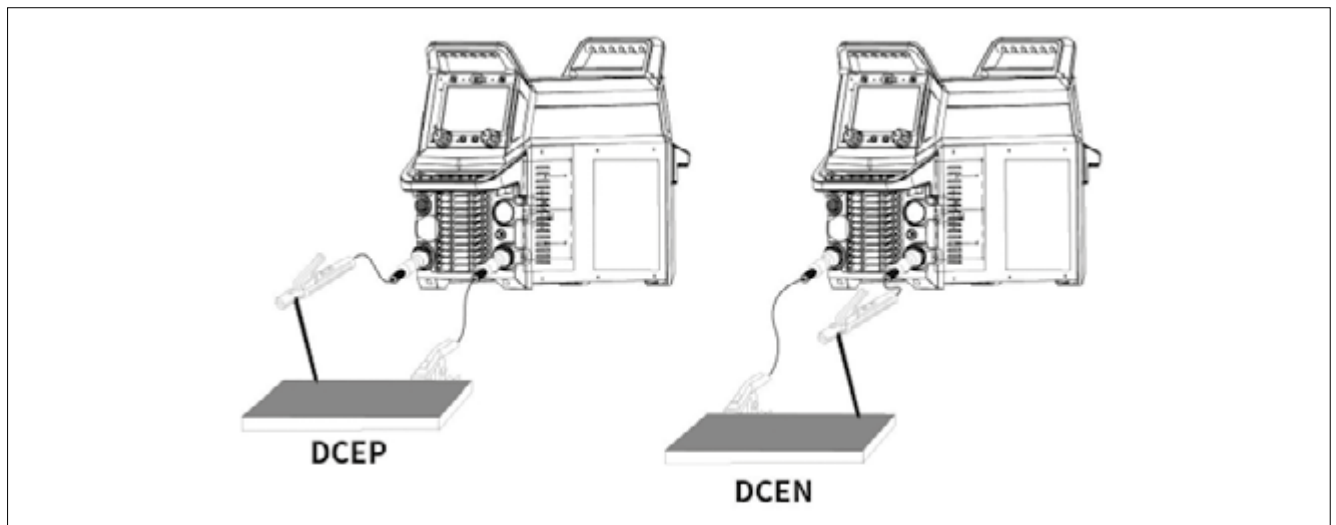
1. Connection of Output Cables Connection of Output Cables Two sockets are available on this welding machine. For MMA welding the electrode holder is shown be connected to the positive socket, while the earth lead (work piece) is connected to the negative socket, this is known as DCEP. However various electrodes require a different polarity for optimum results and careful attention should be paid to the polarity, refer to

the electrode manufacturers information for the correct polarity.

DCEP: Electrode connected to “—” output socket.

DCEN: Electrode connected to “+” output socket.

2. Turn the power source on and press the Main Knob to select the MMA function.
3. Set the Hot Start and Arc Force as required using the Main Knob.

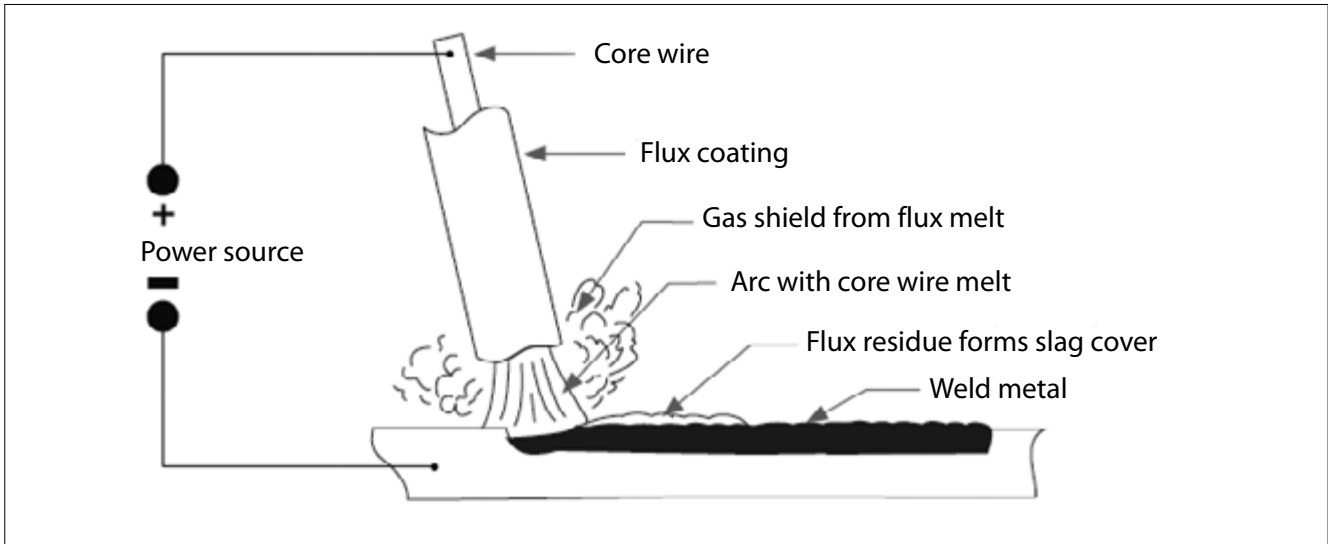


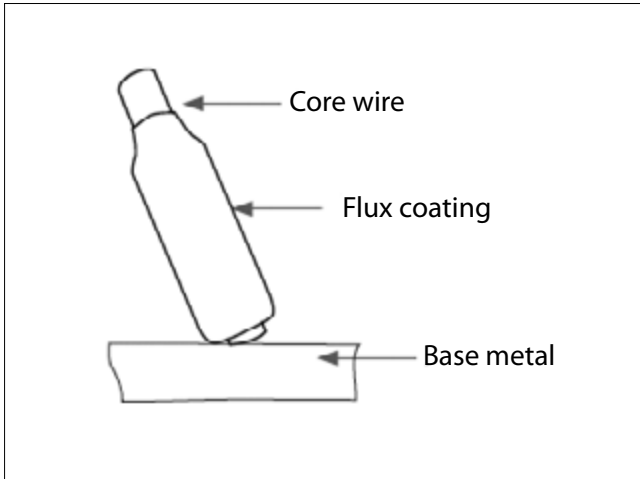
4. Set the welding current relevant to the electrode type and size being used as recommended by the electrode manufacturer.

5. Place the electrode into the electrode holder and clamp tight.
6. Strike the electrode against the work piece to create and arc and hold the electrode steady to maintain the arc.

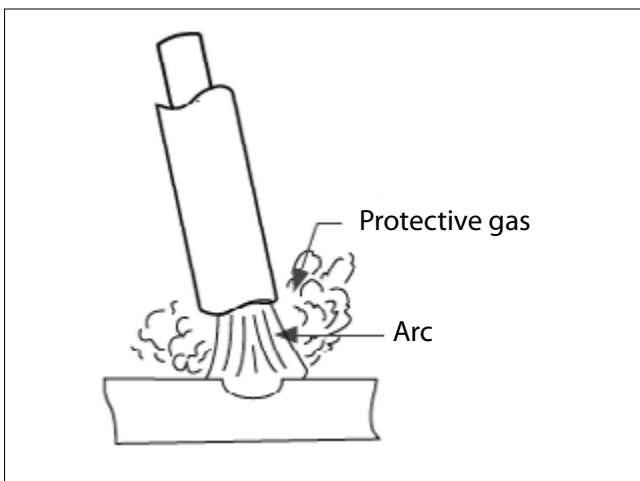
6.7.2. MMA Welding

One of the most common types of arc welding is manual metal arc welding (MMA) or stick welding. An electric current is used to strike an arc between the base material and a consumable electrode rod or 'stick'. The electrode rod is made of a material that is compatible with the base material being welded and is covered with a flux that gives off gaseous vapours that serve as a shielding gas and providing a layer of slag, both of which protect the weld area from atmospheric contamination. The electrode core itself acts as filler material the residue from the flux that forms slag covering over the weld metal must be chipped away after welding.

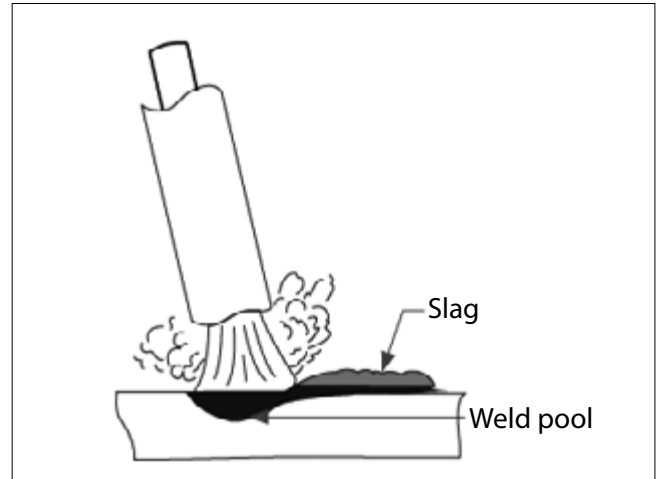




- The arc is initiated by momentarily touching the electrode to the base metal.
- The heat of the arc melts the surface of the base metal to form a molten pool at the end of the electrode.
- The melted electrode metal is transferred across the arc into the molten pool and becomes the deposited weld metal.
- The deposit is covered and protected by a slag which comes from the electrode coating.
- The arc and the immediate area are enveloped by an atmosphere of protective gas.



Manual metal arc (stick) electrodes have a solid metal wire core and a flux coating. These electrodes are identified by the wire diameter and by a series of letters and numbers. The letters and numbers identify the metal alloy and the intended use of the electrode. The Metal Wire Core works as conductor of the current that maintains the arc. The core wire melts and is deposited into the welding pool.



The covering on a shielded metal arc welding electrode is called Flux.

The flux on the electrode performs many different functions.

These include:

- producing a protective gas around the weld area
- providing fluxing elements and deoxidizer
- creating a protective slag coating over the weld as it cools
- establishing arc characteristics
- adding alloying elements.

Covered electrodes serve many purposes in addition to filler metal to the molten pool. These additional functions are provided mainly by the covering on the electrode.

6.8. INSTALLATION & OPERATION FOR TIG WELDING

6.8.1. Set up installation for TIG Welding

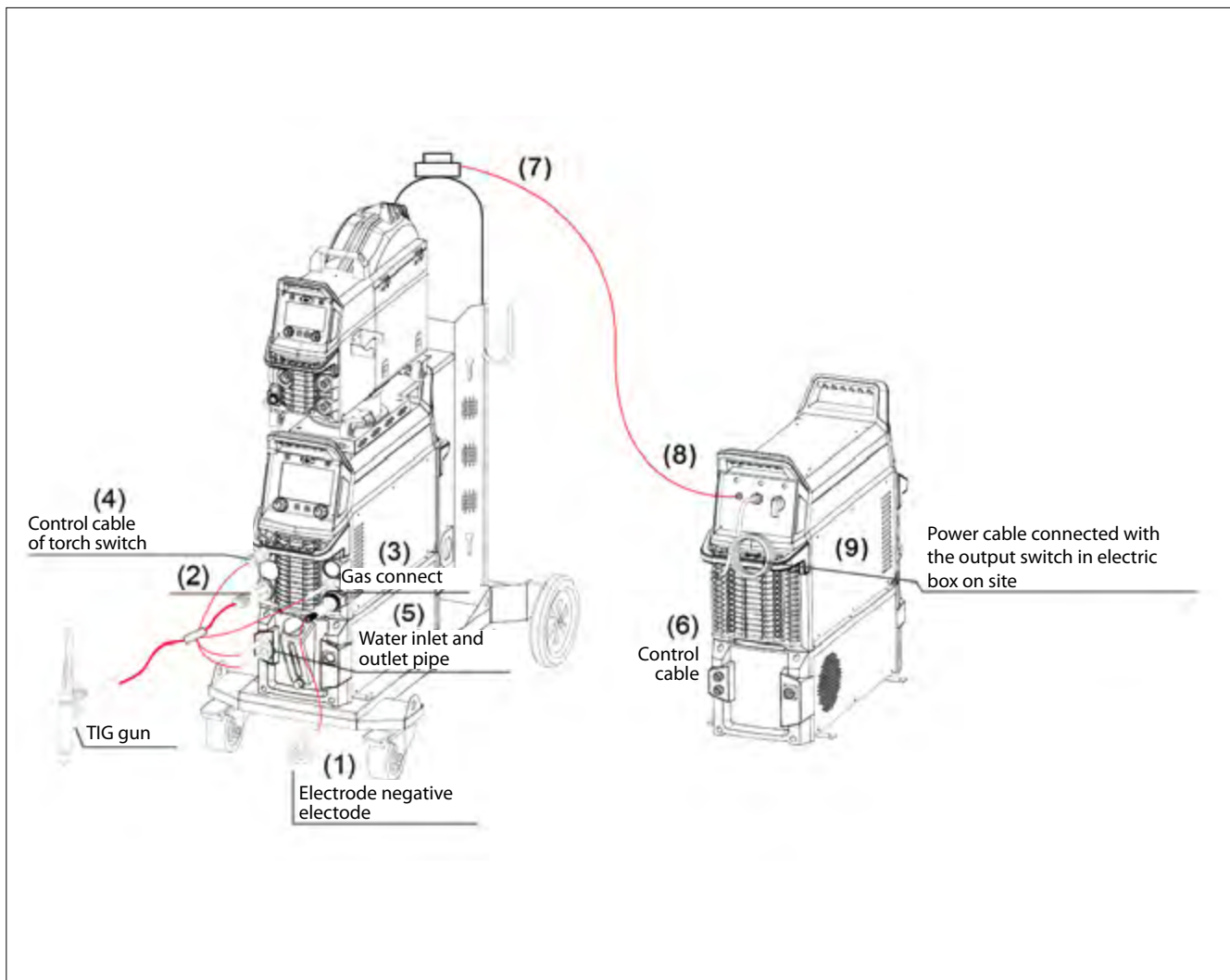
1. Insert the earth cable plug into the positive socket on the front of the machine and tighten it.
2. Plug the welding torch into the negative socket on the front panel, and tighten it.
3. Connect the gas line of TIG Gun to outlet gas connector on the front of the machine.

Check for Leaks!

4. Connect the control cable of torch switch to 12 pin socket on the front of the machine .
5. Connect the water inlet and outlet pipe of TIG Gun to inlet and outlet water connector on the front of the cooling water.
6. Connect the control cable of cooling water with the aero socket on the rear panel of welding machine.
7. Connect the gas regulator to the Gas Cylinder and connect the gas line to the Gas Regulator.

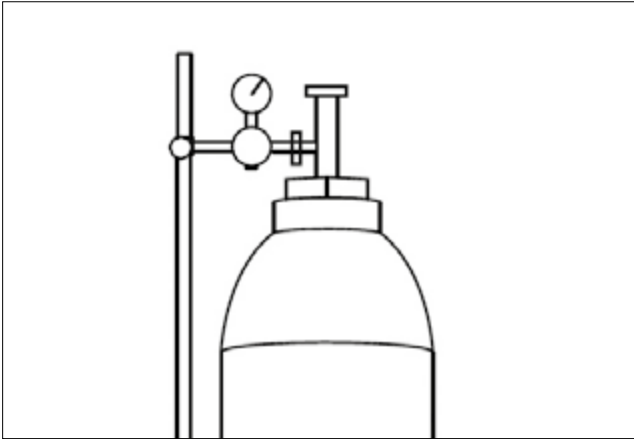
Check for Leaks!

8. Connect the gas line to the machine inlet gas connector via the quick push lock connector located on the rear panel. **Check for Leaks!**
9. Connect the power cable of welding machine with the output switch in electric box on site.



NOTE: Air cooling mode without cooling device and the water pipe is not needed for the air cooling mode.

10. Carefully open the valve of the gas cylinder, set the required gas flow rate.



11. Select TIG function on the front panel.

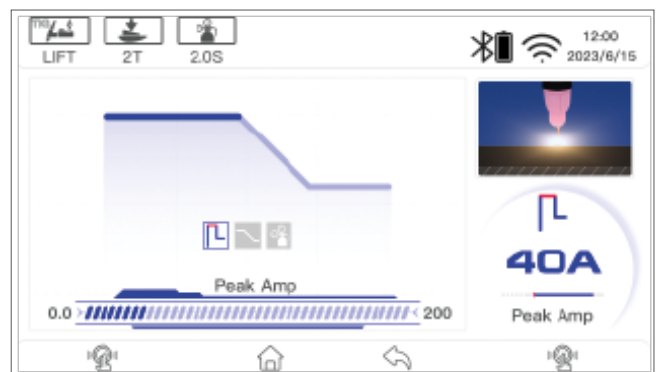


12. Set torch operation 2T / 4T.

- When 2T operation is selected press trigger Gas starts, touch and lift arc start, release trigger Gas and Arc stops.
- When 4T operation is selected press and release trigger Gas starts, touch and lift arc start, press and release trigger Gas and Arc stops.



13. Select cooling mode gas / water on the front panel.



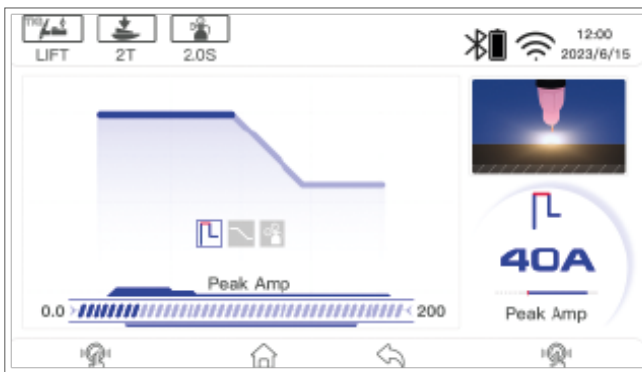
LIFT ARC DC TIG Operation

Lift Arc ignition allows the arc to be started easily in DC TIG by simply touching the tungsten to the work piece and lifting it up to start the arc. This prevents the tungsten tip sticking to the work piece and breaking the tip from the tungsten electrode. There is a particular technique called "rocking the cup" used in the Lift Arc process that provides easy use of the Lift Arc function.

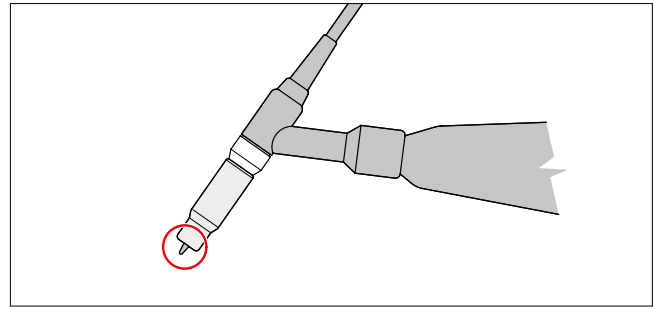
14. Set down slope time as required on the front panel. The down slope time will show on the digital meter.



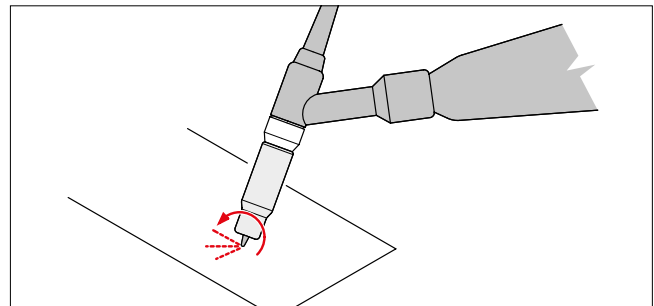
15. Assemble front end parts of the TIG torch making sure they are correctly assembled, use the correct size and type of tungsten electrode for the job, the tungsten electrode requires a sharpened point for DC welding.



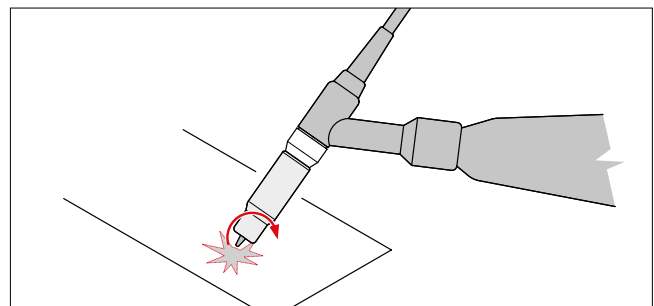
16. Lay the outside edge of the Gas Cup on the work piece with the Tungsten Electrode 1- 2mm from the work piece. Press and hold the torch switch to activate to gas flow and welding power.



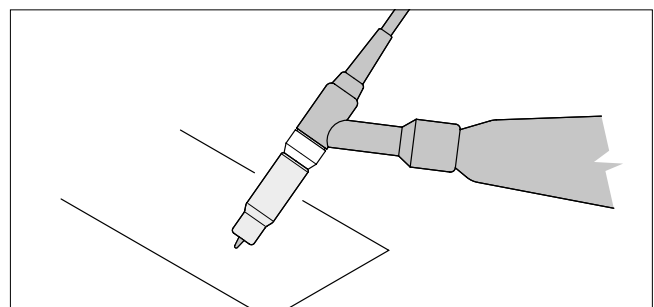
17. With a small movement rotate the Gas Cup forward so that the Tungsten Electrode touches the work piece.



18. Now rotate the Gas Cup in the reverse direction to lift the Tungsten electrode from the work piece to create the arc.



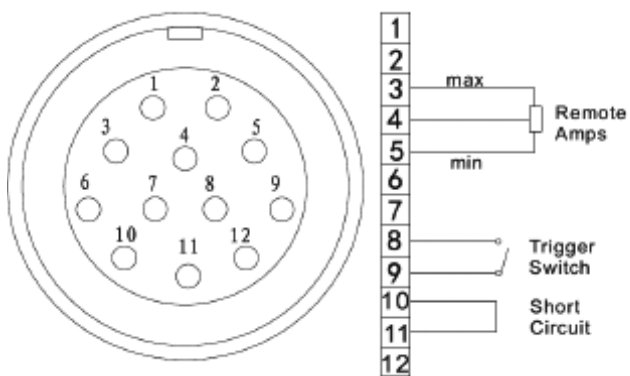
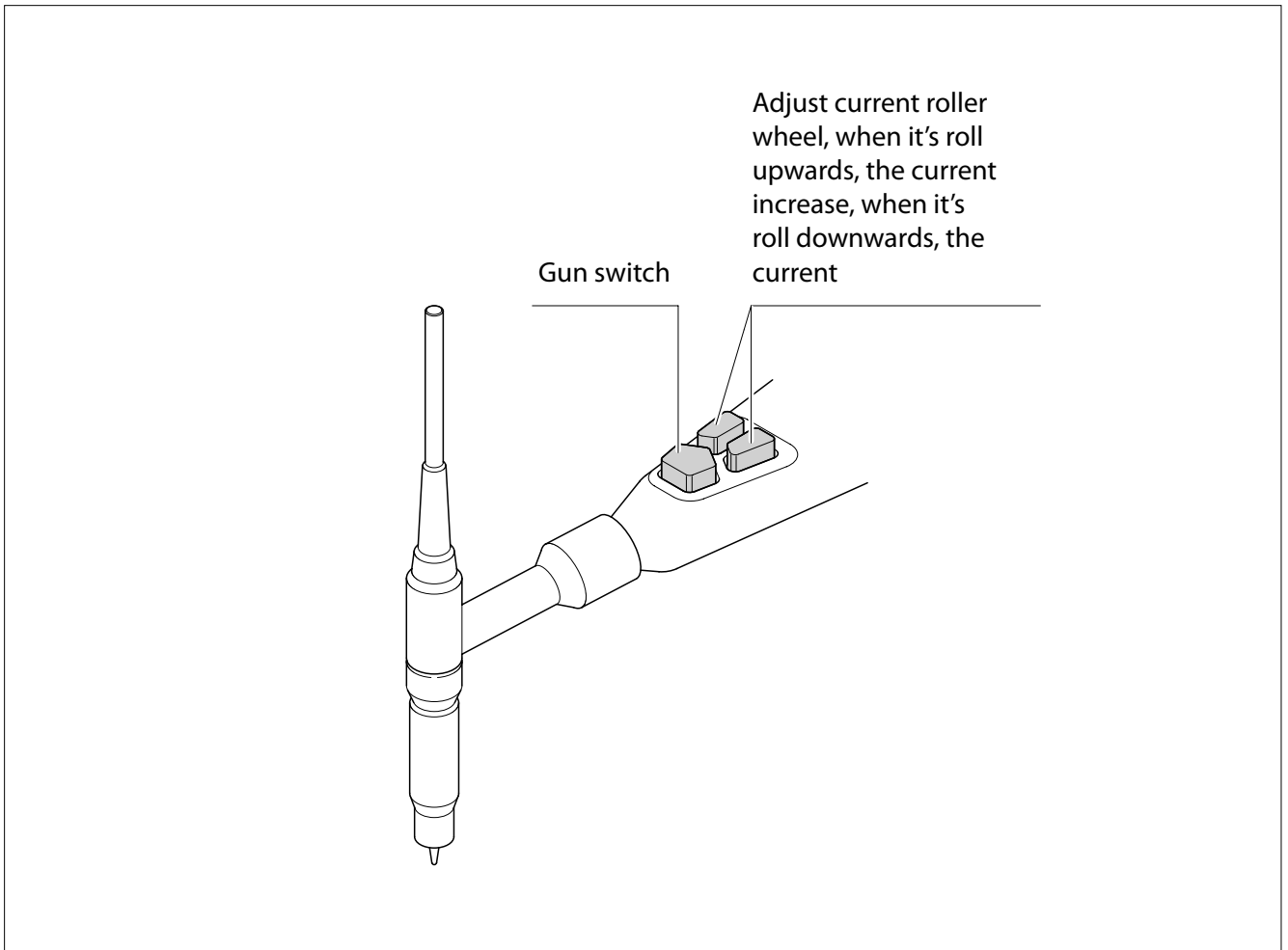
19. Release the trigger to stop the welding.



IMPORTANT! We strongly recommend that you check for gas leaks prior to operation of your machine. We recommend that you close the cylinder valve when the machine is not in use.

6.8.2. Gun switch control current

REMOTE GUN

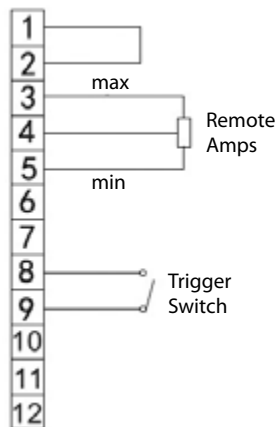
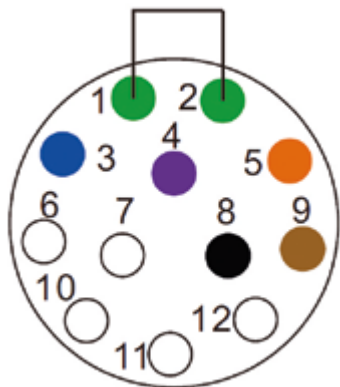
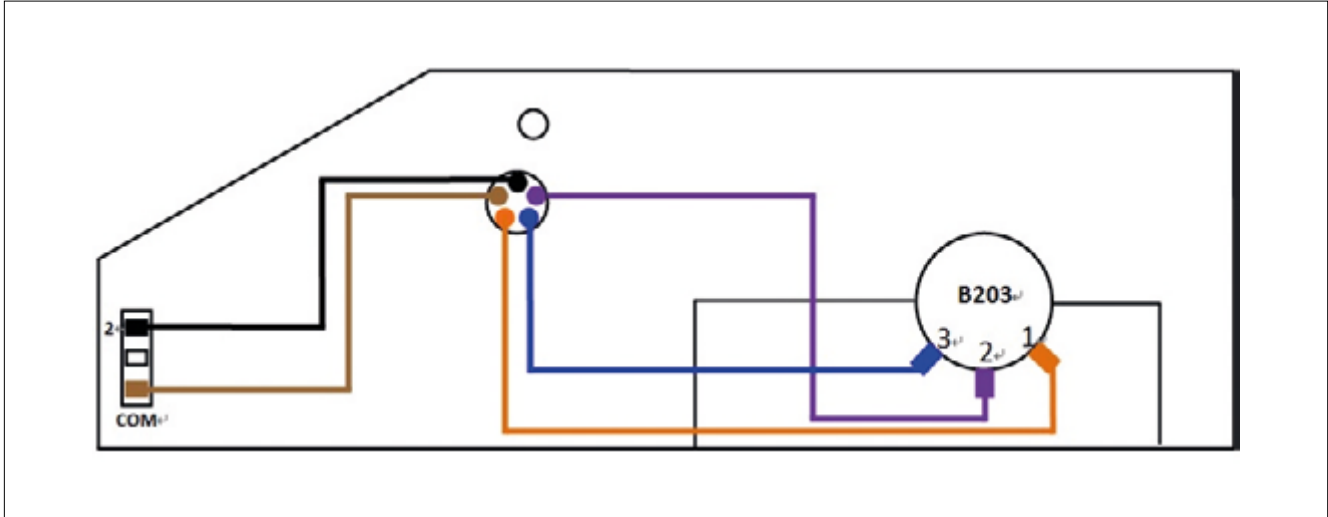


Remote Control Socket

Socket Pin	Function
1	Not connected
2	Not connected
3	10k ohm (maximum) connection to 10k ohm remote control potentiometer
4	Wiper arm connection to 10k ohm remote control potentiometer
5	Zero ohm (minimum) connection to 10k ohm remote control potentiometer
6	Not connected
7	Not connected
8	Trigger Switch Input
9	Trigger Switch Input
10	Be shorted with 11
11	Be shorted with 10
12	Not connected

6.8.3. Pedal switch control

- When plug the twelve-lead aero-socket of pedal switch in it. Welder will identify the pedal switch, the welding current knob on the front panel will can't use and only 2T can be selected.
- When use the adjustment knob of max-welding current beside the pedal, can set the max-current you want.



Remote control socket

Socket Pin	Function
1	Be shorted with 2
2	Be shorted with 1
3	10k ohm (maximum) connection to 10k ohm remote control potentiometer
4	Wiper arm connection to 10k ohm remote control potentiometer
5	Zero ohm (minimum) connection to 10k ohm remote control potentiometer
6	Not connected
7	Not connected
8	Trigger Switch Input
9	Trigger Switch Input
10	Not connected
11	Not connected
12	Not connected

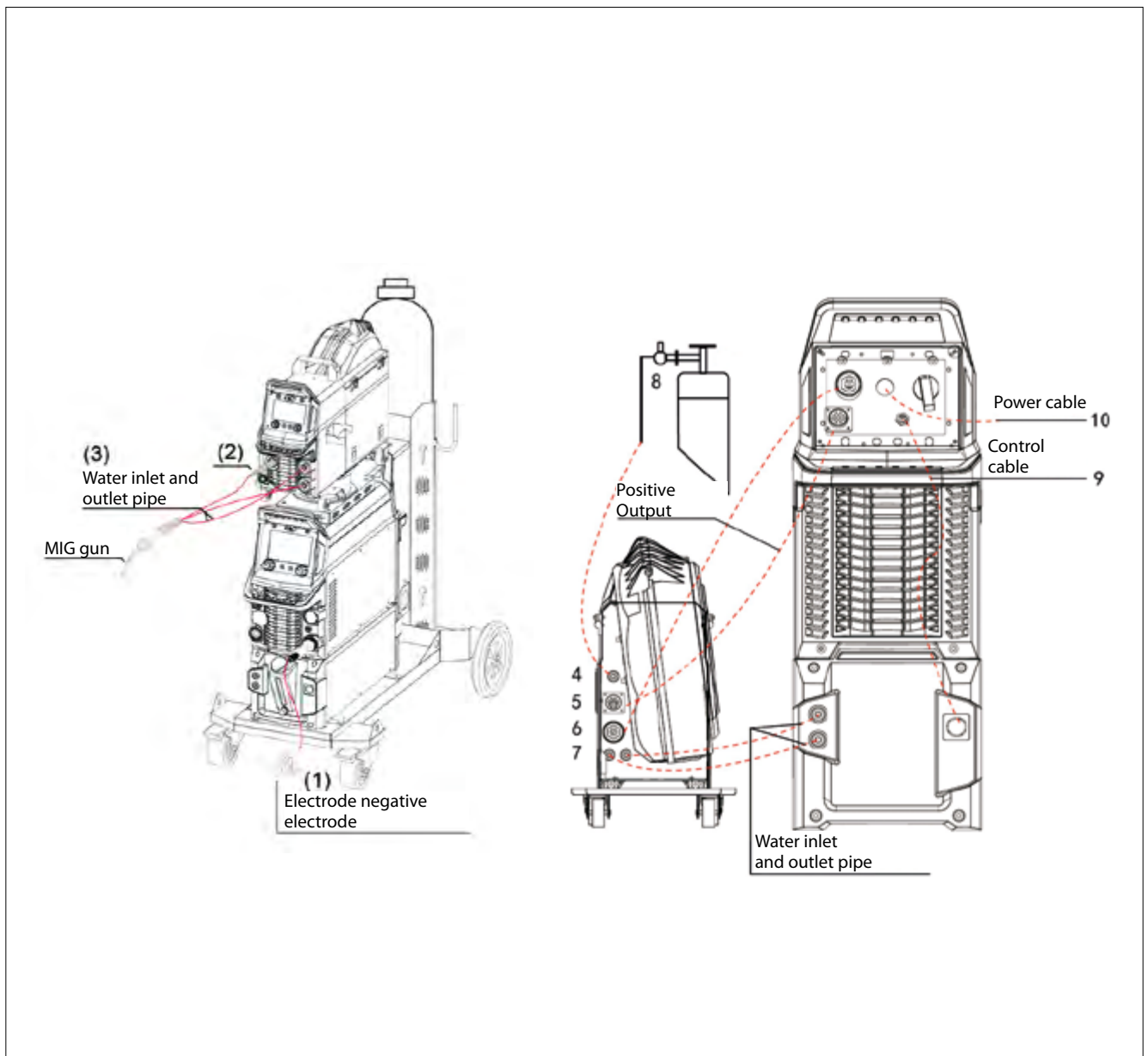
6.9. INSTALLATION & OPERATION FOR MIG WELDING

1. Insert the earth cable plug into the negative socket on the front of the machine and tighten it.
2. Plug the welding torch into the MIG torch connection socket on the front panel of the wire feeder, and tighten it.

IMPORTANT: When connecting the torch be sure to tighten the connection. A loose connection can result in the connector arcing and damaging the machine and gun connector.

3. (3) Connect the water inlet and outlet pipe of MIG Gun to the water inlet and outlet connectors on the front of the wire feeder.

4. Connect the gas line to gas connector on the rear panel of wire feeder. **Check for Leaks!**
5. Connect the control cable of wire feeder with the aero socket on the rear panel of welding machine.
6. Connect the cable of wire feeder with the positive output of welding machine.
7. Connect the water inlet and outlet pipe of wire feeder with the water inlet and outlet connectors on the rear front of cooling water.
8. Connect the gas regulator to the Gas Cylinder and connect the gas line to the Gas Regulator. **Check for Leaks!**
9. Connect the control cable of cooling water with the aero socket on the rear panel of welding machine.
10. Connect the power cable of welding machine with the output switch in electric box on site.

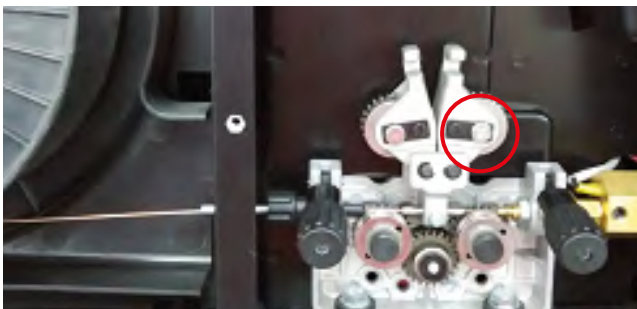


NOTE: Air cooling mode without cooling device and the water pipe is not needed for the air cooling mode.

11. Place the Wire Spool onto the Spool Holder. Snip the wire from the spool being sure to hold the wire to prevent rapid uncoiling. Feed the wire into the wire feeder inlet guide tube through to the drive roller.



12. Carefully feed the wire over the drive roller into the outlet guide tube, feed through about 150 mm into the torch receptacle. Check that the drive roller size is compatible with the wire diameter, replace the roller if necessary.



13. Align the wire into the groove of the drive roller and close down the top roller making sure the wire is in the groove of the bottom drive roller, lock the pressure arm into place. Apply a medium amount of pressure to the drive roller.



14. Remove the gas nozzle and contact tip from the torch neck.

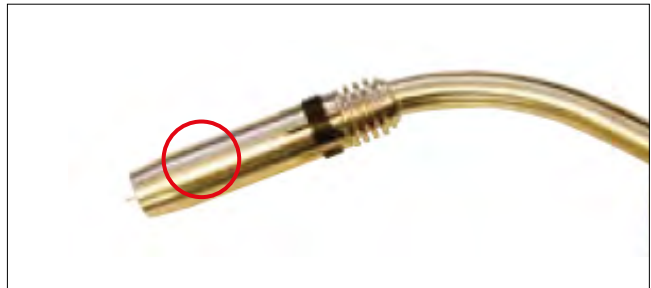


15. Press and hold the manual wire key to feed the wire through to the torch neck, release the manual wire key when the wire exits the torch neck.

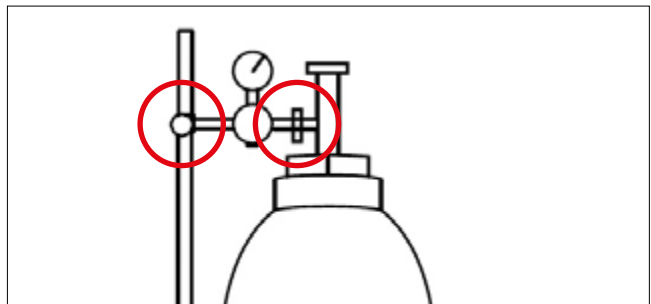
16. Fit the correct sized contact tip and feed the wire through it, screw the contact tip into the tip holder of the torch head and nip it up tightly.



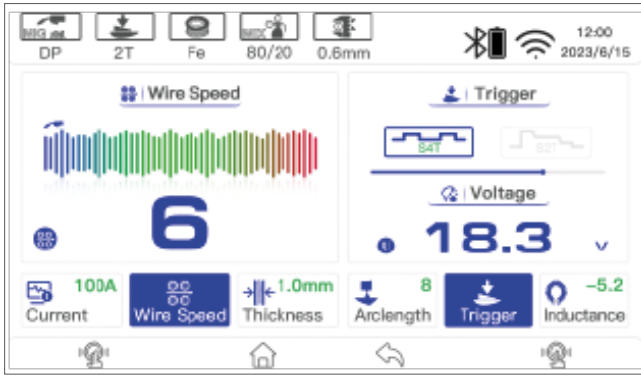
17. Fit the gas nozzle to the torch head.



18. Carefully open the gas cylinder valve and set the required gas flow rate.



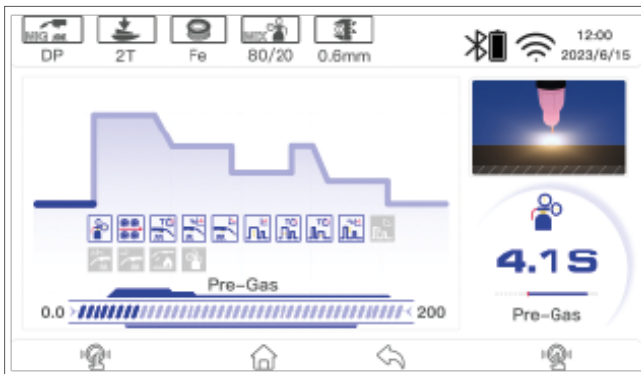
19. Select 2T/4T/S4T/Spot Weld trigger function.



20. Select the required MIG-MAG function, Select program number to suit the wire diameter and gas type being used, it will show on the digital meter.



21. Set the required welding parameters to suit the material thickness being welded, it will show on the digital meter.



6.9.1. Wire Installation and Set Up Guide

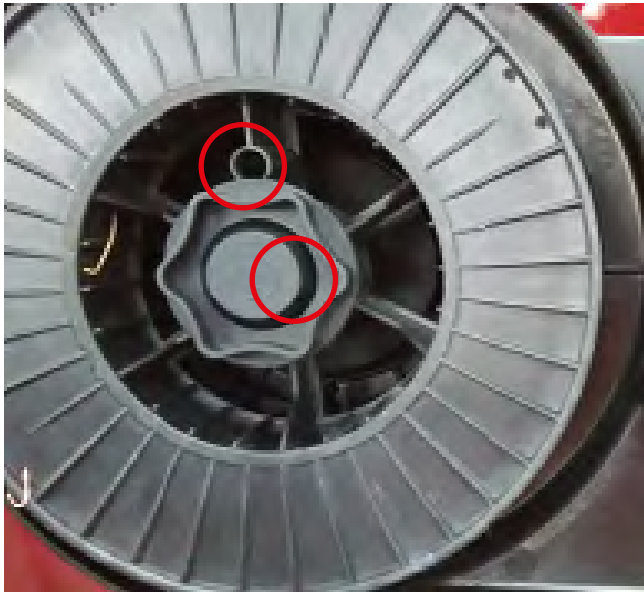
Again the importance of smooth consistent wire feeding during MIG welding cannot be emphasized enough. The correct installation of the wire spool and the wire into the wire feed unit is critical to achieving an even and consistent wire feed. A high percentage of faults with mig welders emanate from poor set up of the wire into the wire feeder. The guide below will assist in the correct setup of your wire feeder.



1. Remove the spool retaining nut.



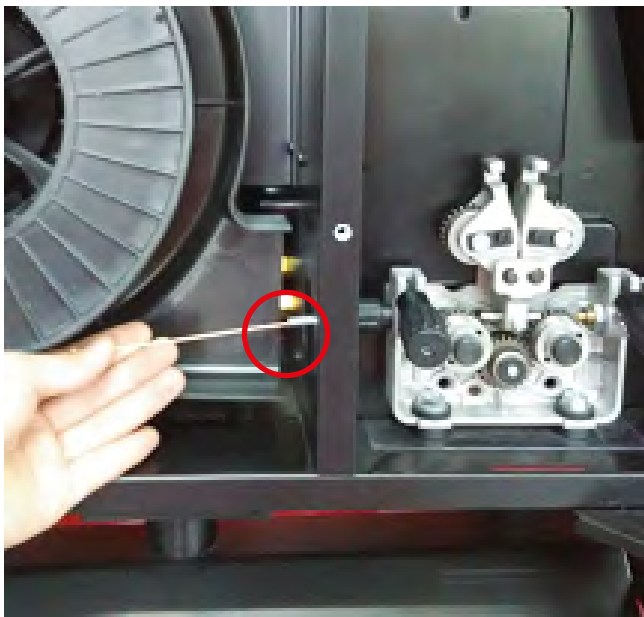
2. Note the tension spring adjuster and spool locating pin.



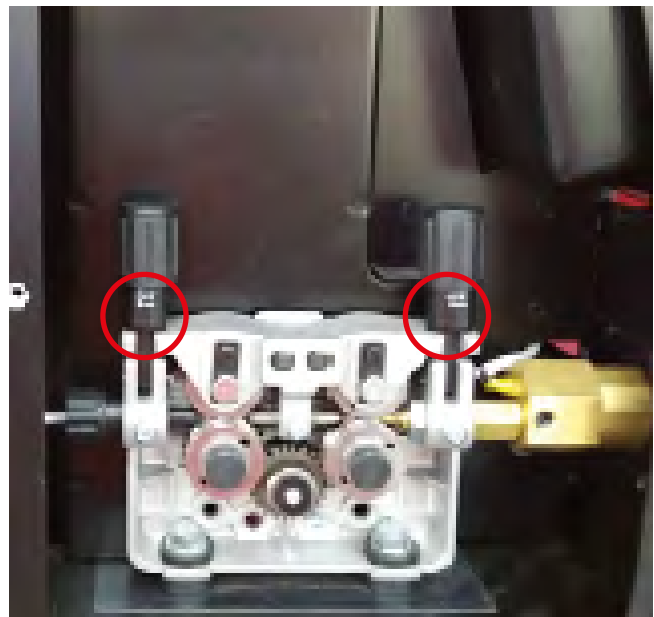
3. Fit the wire spool onto the spool holder fitting the locating pin into the location hole on the spool. Replace the spool retaining nut tightly.



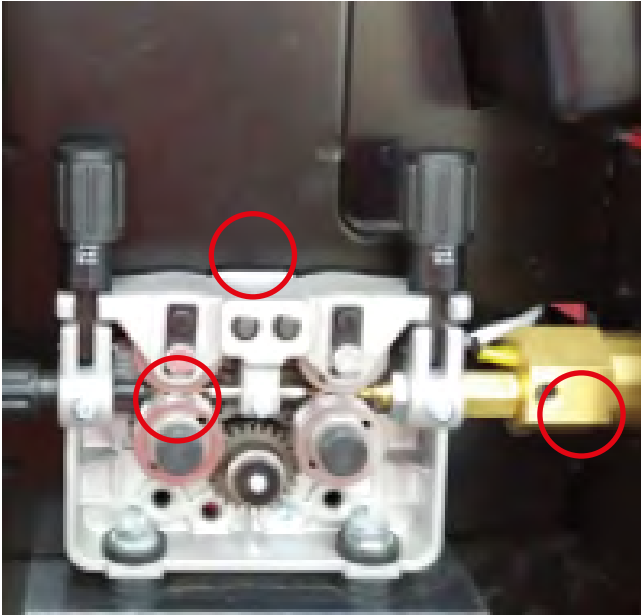
5. Feed the wire through the drive roller and into the outlet guide tube of the wire feeder.



4. Snip the wire carefully, be sure to hold the wire to prevent the spool uncoiling. Carefully feed the wire into the inlet guide tube of the wire feed unit.



6. Lock down the top pressure roller and apply a medium amount of pressure using the tension adjustment knob.



7. Check that the wire passes through the centre of the outlet guide tube without touching the sides. Loosen the locking screw and then loosen the outlet guide tube retaining nut too make adjustment if required. Carefully retighten the locking nut and screw to hold the new position.



8. A simple check for the correct drive tension is to bend the end of the wire over hold it about 100mm from your hand and let it run into your hand, it should coil round in your hand without stopping and slipping at the drive rollers, increase the tension if it slips.



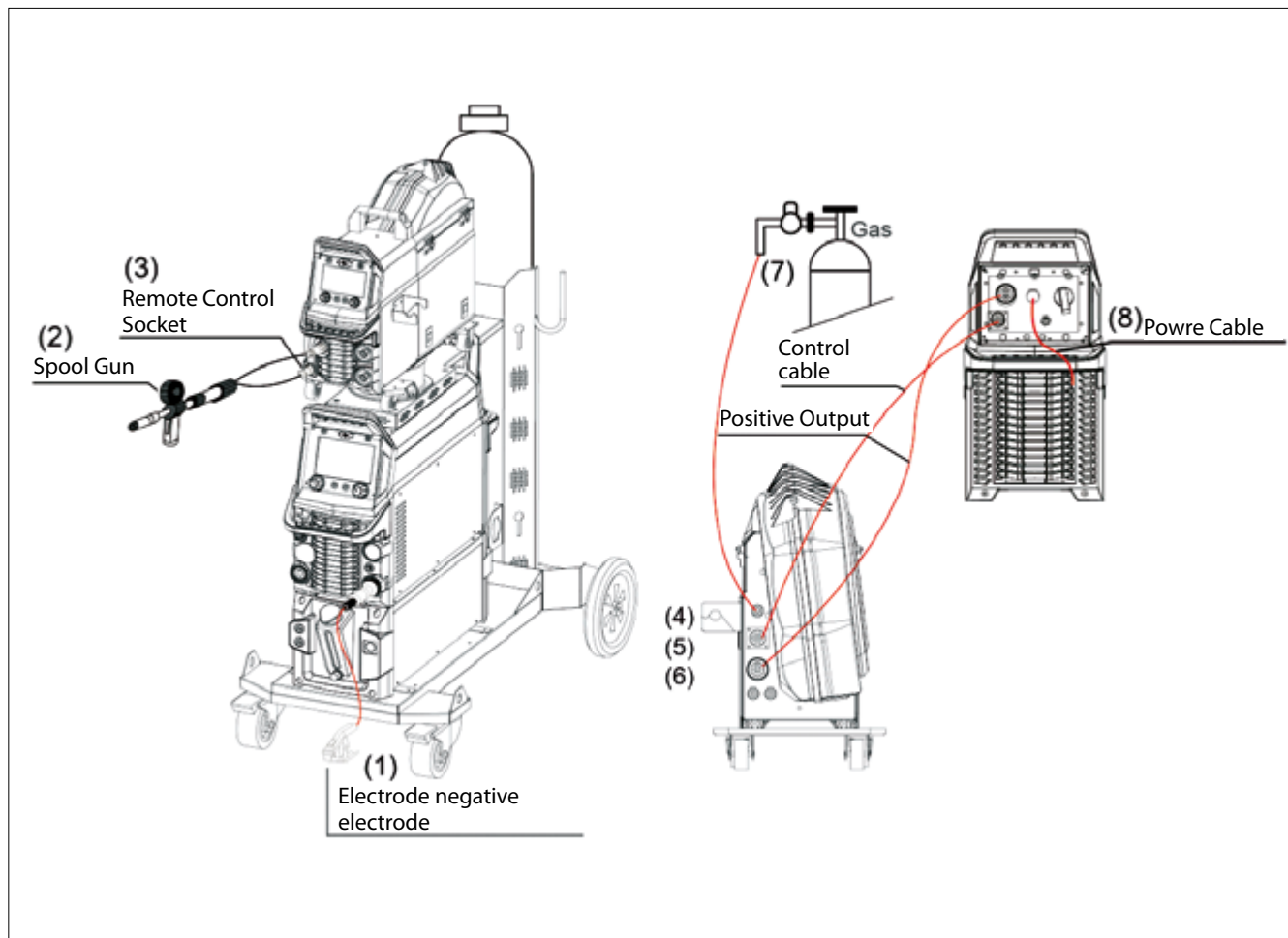
9. The weight and speed of the wire spool turning creates an inertia that can cause the spool to run on and the wire loop over the side of the spool and tangle. If this happens increase the pressure on the tension spring inside the spool holder assembly using the tension adjustment screw.

6.9.2. Set up installation for Spool Gun

1. Insert the earth cable plug into the Negative socket on the front of the machine and tighten it.
2. Connect the Spool Gun to the Mig torch connection socket on the front panel of the wire feeder, and tighten it.

IMPORTANT: When connecting the torch be sure to tighten the connection. A loose connection can result in the connector arcing and damaging the machine and gun connector.

3. Connect the Spool Gun control cable to the multipin receptacle on the front panel of the wire feeder.
4. Connect the gas line to gas connector on the rear panel of wire feeder.
5. Connect the control cable of wire feeder with the aero socket on the rear panel of welding machine.
6. Connect the cable of wire feeder with the positive output of welding machine.
7. Connect the gas regulator to the Gas Cylinder and connect the gas line to the Gas Regulator.



8. Connect the power cable of welding machine with the output switch in electric box on site.
9. Select Spool Gun using the Function key and Adjustment knobs.



10. Take the Spool Gun and remove the spool cover.



11. Place the Wire Spool onto the Spool Holder - Hold and snip the wire from the spool being sure to hold the wire to prevent rapid uncoiling.



12. Carefully feed the wire through the drive roller into the inlet guide tube. Swing back and clip down the wire tension swing arm.

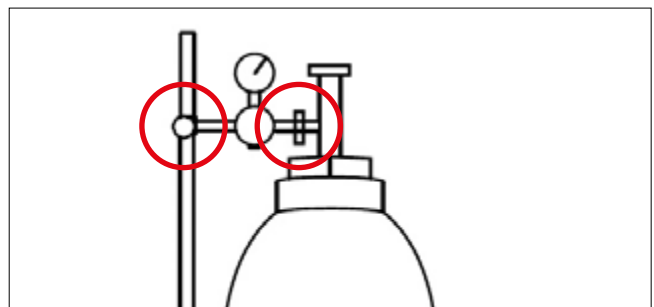


13. Pull the trigger to drive the wire through the neck until it exits the contact tip holder.



14. Close the wire feed housing cover, ready for welding.

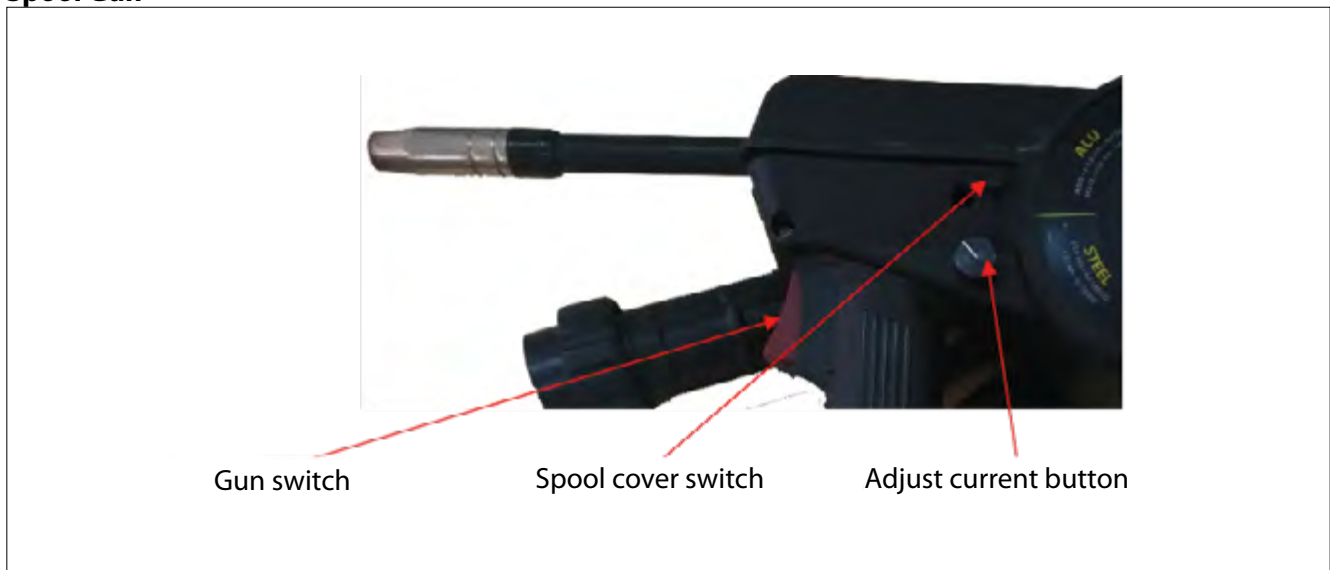
15. Carefully open the gas cylinder valve and set the required gas flow rate.



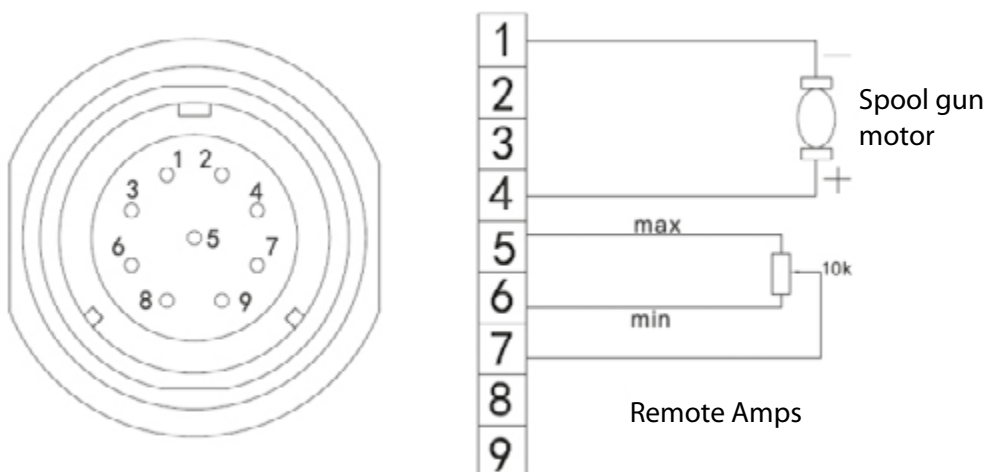
16. Set the welding parameters using the knobs.

6.9.3. MIG Torch /Spool Gun control

Spool Gun



Remote Control Socket



Socket Pin	Function
1	Spool gun motor
2	Not connected
3	Not connected
4	Spool gun motor
5	10k ohm (maximum) connection to 10k ohm remote control potentiometer.
6	Zero ohm (minimum) connection to 10k ohm remote control potentiometer.
7	Wiper arm connection to 10k ohm remote control potentiometer.
8	Not connected
9	Not connected

7. MAINTENANCE

7.1. MACHINE ISOLATION

Before carrying out any type of Maintenance or Repair, it is necessary to isolate the machine from the power supply and from all other energy sources present.

7.2. SPECIAL PRECAUTIONS

When carrying out any maintenance or repair work, the following recommendations should be followed:

- Before starting work, display a sign stating "MACHINE UNDER MAINTENANCE" in a visible spot;
- Do not use flammable materials or solvents;
- Be careful not to pollute the environment with coolants;
- To access the highest parts of the machine, use the appropriate means and procedures;
- Do not climb on the machine parts, as they are not designed to support people;
- When finished, refit and properly secure all safety guards and devices that may have been removed or opened.

IMPORTANT: The Manufacturer cannot be held liable for the failure to comply with the aforementioned recommendations nor for any other use that is inconsistent or not mentioned in these instructions.

7.3. CLEANING

Before carrying out any cleaning operation, disconnect the device from the mains and from the energy sources present.

Do not use corrosive cleaning products, flammable or containing substances harmful to health.

Make sure that the parts being cleaned are completely cold.

Do not wet the internal parts to avoid damaging the electrical and electronic components.

Do not direct any jets of compressed air directly on the electrical and electronic components so as not to damage them.

ATTENTION: Always use the appropriate PPE such as gloves, mask, glasses according to current safety standards.

7.4. ROUTINE MAINTENANCE

General requirements

The machine is designed to minimise routine maintenance, thus it is up to the operator to assess its condition and suitability for use.

It is recommended to stop and perform maintenance whenever non-optimal operation is detected, so as to ensure maximum efficiency at all times. Check the operation of safety devices monthly. In the event of faults or malfunction, entrust only qualified personnel to search for the fault or call the manufacturer's technical support. Check the continuity of the earth circuit every 2 years by performing the continuity measurement according to the provisions of the CEI 44 - 5 III Art. 19 standard. Visually check the condition of the individual parts of the machine, verifying that there is no alteration due to sagging or deformation.

At each use of the machine, if equipped with a cooling unit, check the coolant level and top up if necessary.

ATTENTION: Use only "SincoFluid" coolant supplied on request by the manufacturer or an authorised dealer.

The use of different coolants automatically voids the warranty and excludes the manufacturer from any liability.

ATTENTION: Allow the system to cool before proceeding with maintenance; hot surfaces can cause serious burns.

ATTENTION: For the entire duration of maintenance, it is necessary to stop the system by disconnecting the plug from the mains power supply or by disconnecting the power supply from the main panel circuit breaker, moving it to the "O" position and locking it with a special padlock.

Always use the appropriate PPE - Personal Protective Equipment:

- Gloves;
- Non-slip shoes;
- Suitable clothing.

Scheduled maintenance

The operations described below must be carried out in line with the schedules indicated.

IMPORTANT: Failure to comply with the above shall exempt the manufacturer from any liability as specified in the Warranty.

ATTENTION: These operations, although simple, must be performed by a Qualified or Qualified and Authorised Technician.

Remove dust or foreign materials every 6 months, which may have been deposited on the transformer or on the diodes of the rectifier unit; to do this use a jet of dry, clean air.

Do not direct the compressed air jet directly onto the electrical and electronic components so as not to damage them.

When reassembling the wire feeder roller, after having cleaned or replaced it, make sure that the groove is aligned with the wire and that it corresponds to the diameter of the wire used.

Keep the inside of the gas nozzle constantly clean, so as to avoid metal bridges consisting of welding sprays between the gas nozzle and the contact tip.

Make sure that the output hole of the current collector nozzle is not excessively enlarged, otherwise replace it.

Absolutely avoid beating the torch or subjecting it to violent impacts.

7.5. WELDING MACHINE REPAIRS

Experience has shown that many accidents originate from repairs not performed to perfection.

For this reason, careful and complete control over a repaired welding machine is just as important as that performed on a new welding machine. Moreover, in this way, manufacturers can be protected from being held liable for defects, when the liability is to be attributed to others.

Welding machine repairs must be carried out exclusively by trained and qualified personnel, in possession of the necessary requisites to guarantee a workmanlike repair and in full compliance with safety standards EN 60974-4.

A) Instructions to be followed for repairs

- After rewinding the transformer or the inductances, the welding machine must pass the same applied voltage tests, passed at the time of the first test according to the regulations in force.
- If no rewinding has been carried out, a welding machine, which has been cleaned and/or overhauled, must pass a particular applied voltage test with values given by current regulations.
- After rewinding and/or replacing parts, the no-load voltage must not exceed certain values given by current regulations.
- If repairs are not carried out by the manufacturer, repaired welding machines, in which some components have been replaced or modified, must be marked so that the person who carried out the repair can be identified.

B) Repair measures

- After having carried out a repair, be careful to re-order the wiring, so that there is a secure insulation between the primary side and the secondary side of the machine.
- Do not allow the wires to come into contact with moving parts (i.e. with the fan motor) or parts that become hot during operation.
- Also re-assemble all the clamps that hold the wiring, as originally arranged on the machine, so that, if a conductor is accidentally broken or disconnected, it is still possible to avoid a connection between the primary and the secondary.
- Avoid cleaning the electronic boards with a jet of compressed air to preserve the integrity of the components.
- At the end of any repair, make sure that you have not forgotten any tools inside the machine and close the machine with all the bulkheads available and taking care to replace all the fixing devices of the bulkheads themselves.

7.5.1. MIG welding trouble shooting

The following chart addresses some of the common problems of MIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

N°.	Trouble	Possible Reason	Suggested Remedy
1	Excessive Spatter	Wire feed speed set too high	Select lower wire feed speed
		Voltage too high	Select a lower voltage setting
		Wrong polarity set	Select the correct polarity for the wire being used - see machine setup guide
		Stick out too long	Bring the torch closer to the work
		Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
		Contaminated mig wire	Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc
		Inadequate gas flow or too much gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 6-12 l/min flow rate. Check hoses and fittings for holes, leaks Protect the welding zone from wind and drafts
2	Porosity - small cavities or holes resulting from gas pockets in weld metal.	Wrong gas	Check that the correct gas is being used
		Inadequate gas flow or too much gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 10 - 15 l/min flow rate. Check hoses and fittings for holes, leaks etc. Protect the welding zone from wind and drafts
		Moisture on the base metal	Remove all moisture from base metal before welding
		Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
		Contaminated mig wire	Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc.
		Gas nozzle clogged with spatter, worn or out of shape	Clean or replace the gas nozzle
		Missing or damaged gas diffuser	Replace the gas diffuser
		Mig torch euro connect o-ring missing or damaged	Check and replace the o-ring
3	Wire stubbing during welding	Holding the torch too far away	Bring the torch closer to the work and maintain stick out of 5-10 mm
		Welding voltage set too low	Increase the voltage
		Wire Speed set too high	Decrease the wire feed speed

continued...

N°.	Trouble	Possible Reason	Suggested Remedy
4	Lack of Fusion – failure of weld metal to fuse completely with base metal or a proceeding weld	Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
		Not enough heat input	Select a higher voltage range and /or adjust the wire speed to suit
		Improper welding technique	Keep the arc at the leading edge of the weld pool. Gun angle to work should be between 5 & 15°. Direct the arc at the weld joint. Adjust work angle or widen groove to access bottom during welding. Momentarily hold arc on side walls if using weaving technique.
5	Excessive Penetration – weld metal melting through base metal	Too much heat	Select a lower voltage range and /or adjust the wire speed to suit Increase travel speed
6	Lack of Penetration – shallow fusion between weld metal and base metal	Poor in incorrect joint preparation	Material too thick. Joint preparation and design needs to allow access to bottom of groove while maintaining proper welding wire extension and arc characteristics. Keep the arc at the leading edge of the weld pool and maintain the gun angle at 5 & 15° keeping the stick out between 5-10mm
		Not enough heat input	Select a higher voltage range and /or adjust the wire speed to suit. Reduce travel speed
		Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal

7.5.2. MIG wire feed trouble shooting

The following chart addresses some of the common WIRE FEED problems during MIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

N°.	Problema	Possibile causa	Soluzione suggerita
1	No wire feed	Wrong mode selected	Check that the TIG/MMA/MIG selector switch set to MIG position
		Wrong torch selector switch	Check that the Wire Feeder /Spool Gun selector switch is set to Wire Feeder position for MIG welding and Spool Gun when using the Spool gun
2	Inconsistent / interrupted wire feed	Adjusting wrong dial	Be sure to adjust the wire feed and voltage dials for MIG welding. The amperage dial is for MMA and TIG welding mode
		Wrong polarity selected	Select the correct polarity for the wire being used - see machine setup guide
		Incorrect wire speed setting	Adjust the wire feed speed
		Voltage setting incorrect	Adjust the voltage setting
		Mig torch lead too long	Small diameter wires and soft wires like aluminium don't feed well through long torch leads - replace the torch with a lesser length torch
		Mig torch lead kinked or too sharp angle being held	Remove the kink, reduce the angle or bend
		Contact tip worn, wrong size, wrong type	Replace the tip with correct size and type
		Liner worn or clogged (the most common causes of bad feeding)	Try to clear the liner by blowing out with compressed air as a temporary cure, it is recommended to replace the liner
		Wrong size liner	Install the correct size liner
		Blocked or worn inlet guide tube	Clear or replace the inlet guide tube
		Wire misaligned in drive roller groove	Locate the wire into the groove of the drive roller
		Incorrect drive roller size	Fit the correct size drive roller eg; 0.8mm wire requires 0.8mm drive roller
		Wrong type of drive roller selected	Fit the correct type roller (e.g. knurled rollers needed for flux cored wires)
		Worn drive rollers	Replace the drive rollers
		Drive roller pressure too high	Can flatten the wire electrode causing it to lodge in the contact tip - reduce the drive roller pressure
Too much tension on wire spool hub	Reduce the spool hub brake tension		
Wire crossed over on the spool or tangled	Remove the spool untangle the wire or replace the wire		
Contaminated mig wire	Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc		

7.5.3. DC TIG welding trouble shooting

The following chart addresses some of the common problems of DC TIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

N°.	Trouble	Possible Reason	Suggested Remedy
1	Tungsten burning away quickly	Incorrect Gas or No Gas	Use pure Argon. Check cylinder has gas, connected, turned on and torch valve is open
		Inadequate gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted.
		Back cap not fitted correctly	Make sure the torch back cap is fitted so that the o-ring is inside the torch body
		Torch connected to DC +	Connect the torch to the DC- output terminal
		Incorrect tungsten being used	Check and change the tungsten type if necessary
		Tungsten being oxidised after weld is finished	Keep shielding gas flowing 10-15 seconds after arc stoppage. 1 second for each 10amps of weld current.
2	Contaminated tungsten	Touching tungsten into the weld pool	Keep tungsten from contacting weld puddle. Raise the torch so that the tungsten is off of the work piece 2 - 5 mm
		Touching the filler wire to the tungsten	Keep the filler wire from touching the tungsten during welding, feed the filler wire into the leading edge of the weld pool in front of the tungsten
3	Porosity - poor weld appearance and colour	Wrong gas / poor gas flow / gas leak	Use pure argon. Gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 6-12 l/min. Check hoses and fittings for holes, leaks et
		Contaminated base metal	Remove moisture and materials like paint, grease, oil, and dirt from base metal
		Contaminated filler wire	Remove all grease, oil, or moisture from filler metal
		Incorrect filler wire	Check the filler wire and change if necessary
4	Yellowish residue / smoke on the alumina nozzle & discoloured tungsten	Incorrect Gas	Use pure Argon gas
		Inadequate gas flow	Set the gas flow between 10 - 15 l/min flow rate
		Alumina gas nozzle too small	Increase the size of the alumina gas nozzle
5	Unstable Arc during DC welding	Torch connected to DC +	Connect the torch to the DC- output terminal
		Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.
		Tungsten is contaminated	Remove 10mm of contaminated tungsten and re grind the tungsten
		Arc length too long	Lower torch so that the tungsten is off of the work piece 2 - 5 mm

continued...

N°.	Trouble	Possible Reason	Suggested Remedy
6	Arc wanders during DC welding	Poor gas flow	Check and set the gas flow between 10 - 15 l/min flow rate
		Incorrect arc length	Lower torch so that the tungsten is off of the work piece 2 - 5 mm
		Tungsten incorrect or in poor condition	Check that correct type of tungsten is being used. Remove 10mm from the weld end of the tungsten and re sharpen the tungsten.
		Poorly prepared tungsten	Grind marks should run lengthwise with tungsten, not circular. Use proper grinding method and wheel.
		Contaminated base metal or filler wire	Remove contaminating materials like paint, grease, oil, and dirt, including mill scale from base metal. Remove all grease, oil, or moisture from filler metal.
7	Arc difficult to start or will not start DC welding	Incorrect machine set up	Check machine set up is correct
		No gas, incorrect gas flow	Check the gas is connected and cylinder valve open, check hoses, gas valve and torch are not restricted. Set the gas flow between 10 - 15 l/min flow rate
		Incorrect tungsten size or type	Check and change the size and or the tungsten if required
		Loose connection	Check all connectors and tighten
		Earth clamp not connected to work	Connect the earth clamp directly to the work piece wherever possible

7.5.4. MMA welding trouble shooting

The following chart addresses some of the common problems of MMA welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

N°.	Trouble	Possible Reason	Suggested Remedy
1	No arc	Incomplete welding circuit	Check earth lead is connected. Check all cable connections.
		Wrong mode selected	Check the MMA selector switch is selected
		No power supply	Check that the machine is switched on and has a power supply
2	Porosity – small cavities or holes resulting from gas pockets in weld metal	Arc length too long	Shorten the arc length
		Work piece dirty, contaminated or moisture	Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from base metal
		Damp electrodes	Use only dry electrodes
3	Excessive Spatter	Amperage too high	Decrease the amperage or choose a larger electrode
		Arc length too long	Shorten the arc length
4	Weld sits on top, lack of fusion	Insufficient heat input	Increase the amperage or choose a larger electrode
		Work piece dirty, contaminated or moisture	Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from base metal
		Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
5	Lack of penetration	Insufficient heat input	Increase the amperage or choose a larger electrode
		Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
		Poor joint preparation	Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up
6	Excessive penetration - burn through	Excessive heat input	Reduce the amperage or use a smaller electrode
		Incorrect travel speed	Try increasing the weld travel speed
7	Uneven weld appearance	Unsteady hand, wavering hand	Use two hands where possible to steady up, practise your technique
8	Distortion – movement of base metal during welding	Excessive heat input	Reduce the amperage or use a smaller electrode
		Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
		Poor joint preparation and or joint design	Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up

continued...

N°.	Trouble	Possible Reason	Suggested Remedy
9	Electrode welds with different or unusual arc characteristic	Incorrect polarity	Change the polarity, check the electrode manufacturer for correct polarity

WARNING: For safety while maintaining the machine, please shut off the main input power and wait for 5 minutes, until capacitors voltage already drop to safe voltage 36V!

7.6. TROUBLESHOOTING

- **Before the welding machines are dispatched from the factory, they have already been tested and calibrated accurately. It is forbidden for anyone who is not authorized by our company to do any change to the equipment!**
- Maintenance course must be operated carefully. If any wire becomes flexible or is misplaced, it maybe potential danger to user!
- Only professional maintenance staff that is authorized by our company could overhaul the machine!
- **Be sure to shut off the Main Input Power before doing any repair work on the welding machine!**
- If there is any problem and there is no authorized professional maintenance personal on site, please contact local agent or the distributor!
- If there are some simple troubles with the welding machine, you can consult the following Chart:

N°.	Troubles	Reasons	Solution	
1	Close the breaker, but the power light isn't on	Breaker damaged	Change it	
		Fuse damaged	Change it	
		Input power damaged	Change it	
2	After welding machine is over-heat, the fan doesn't work	Fan damaged	Change it	
		The cable is loose	Screw the cable tight	
3	Press the gun switch, no output shielded gas	No output gas when test gas	No gas in the gas cylinder	Change it
		Output gas when test gas	Gas hose leaks gas	Change it
			Electromagnetic valve damaged	Change it
	Output gas when test gas	Control switch damaged	Repair the switch	
		Control circuit damaged	Check the PCB	

continued...

N°.	Troubles		Reasons	Solution
4	Wirefeeder doesn't work	Wire reel doesn't work	Motor damaged	Check and change it
			Control circuit damaged	Check the PCB
		Wire reel works	The press wheel is loosen or weld wire skids	Press it tightly again
			The wheel doesn't fit with the diameter of weld wire	Change the wheel
			Wire reel damaged	Change it
			Wire feed pipe is jammed	Repair or change it
Tip is jammed because of splash	Repair or change it			
5	No striking arc and no output voltage	Output cable is connected incorrectly or loosen	Screw it down or change it	
		Control circuit damaged	Check the circuit	
6	Welding stops, and alarm light is on	Machine has self-protection	Check over-voltage, overcurrent, over-temperature, lower-voltage and over-temperature, and solve it	
7	Welding current is run away and can be not controlled	The potentiometer damaged	Check or change it	
		The control circuit damaged	Check the circuit	
8	The crater current can be not adjusted	The PCB damaged	Check it	
9	No post-gas	The PCB damaged	Check it	

List of error code

Error Type	Error code	Description	Lamp status
Thermal relay	E01	Over-heating (1 st thermal relay)	Yellow lamp (thermal protection) always on
	E02	Over-heating (2 nd thermal relay)	Yellow lamp (thermal protection) always on
	E03	Over-heating (3 rd thermal relay)	Yellow lamp (thermal protection) always on
	E04	Over-heating (4 th thermal relay)	Yellow lamp (thermal protection) always on
	E09	Over-heating (Program in default)	Yellow lamp (thermal protection) always on
Welding machine	E10	Phase loss	Yellow lamp (thermal protection) always on
	E11	No water	Yellow lamp (lack water) always on
	E12	No gas	Red lamp always on
	E13	Under voltage	Yellow lamp (thermal protection) always on
	E14	Over voltage	Yellow lamp (thermal protection) always on
	E15	Over current	Yellow lamp (thermal protection) always on
	E16	Wire feeder over load	
Switch	E20	Button fault on operating panel when switch on the machine	Yellow lamp (thermal protection) always on
	E21	Other faults on operating panel when switch on the machine	Yellow lamp (thermal protection) always on
	E22	Torch fault when switch on the machine	Yellow lamp (thermal protection) always on
	E23	Torch fault during normal working process	Yellow lamp (thermal protection) always on
Accessory	E30	Cutting torch disconnection	Red lamp blink
	E31	Water cooler disconnection	Yellow lamp (lack water) always on
Communication	E40	Connection problem between wire feeder and power source	
	E41	Communication error	

8. ACCESSORIES AND SPARE PARTS

8.1. CUSTOMER SERVICE

The Manufacturer is always at your disposal for any type of information regarding the use, maintenance, and installation of the equipment.

It is suggested that the Customer asks clear questions, making reference to this Manual and the instructions listed.

8.2. SPARE PARTS

IMPORTANT: ALWAYS USE ORIGINAL SPARE PARTS. The Manufacturer cannot be held liable for breakages, malfunctions or damage to persons or property arising from the use of non-original parts.

In the event that non-original spare parts are used, the conditions of the Warranty (if still in place) and of the Manufacturer's liability in the use of the machine and any damage deriving to persons and/or property are void.

9. ADDITIONAL INSTRUCTIONS

9.1. WASTE DISPOSAL

It is the responsibility of the user, in accordance with the laws in force in their country, to ensure correct disposal of the waste produced by the machine during production.

The disposal of hydraulic oil lubricants and the replaced parts must be carried out in compliance with the regulations in force in the country where the machine is in use.

9.2. DECOMMISSIONING AND DISMANTLING

With reference to the WEEE Directive 2012/19 / EU (Waste Electrical and Electronic Equipment), the user, during disposal, must dispose of the equipment in the appropriate authorised collection centres, or return it still installed to the seller at the time of a new purchase.

IMPORTANT: do not dispose of polluting materials in the environment. Dispose of such products in compliance with legislation in force.

IMPORTANT: the illegal disposal of Waste Electrical and Electronic Equipment is punished with sanctions regulated by the laws in force in the territory in which the infringement is ascertained. Waste Electrical and Electronic Equipment may contain hazardous substances with potentially harmful effects on the environment and on people's health. It is recommended to dispose of it properly.

WEEE refers to Waste Electrical and Electronic Equipment (EEE) including all components, sub-assemblies and consumables that are an integral part of the product at the time the decision is made to discard it. The law divides these into 2 main categories called **PROFESSIONAL WEEE** or **DOMESTIC WEEE**.

PROFESSIONAL WEEE means all waste electrical and electronic equipment intended for purely industrial use.

DOMESTIC WEEE means all waste electrical and electronic equipment intended for mixed use both in an industrial environment and in a domestic environment.

DOMESTIC WEEE is identified as all single-phase power supply generators with output current MAX \leq 200A with their accessories.

There are 2 ways to discard **DOMESTIC WEEE**:

- a) If you decide to buy a new equivalent equipment, the user can deliver it to the distributor, who will have to collect it for free.
- b) Alternatively, it must be deposited in the Municipal pitch, in the container or specific area identified as "GROUPING 4".

As of the date of preparation of the Instruction Manual, as the application of the Regulations is not yet definitive, please contact the distributor and/or the manufacturer for information on **PROFESSIONAL WEEE** disposal.

THE SYSTEM DESCRIBED IN THE MANUAL BELONGS TO CATEGORY: PROFESSIONAL "EEE"

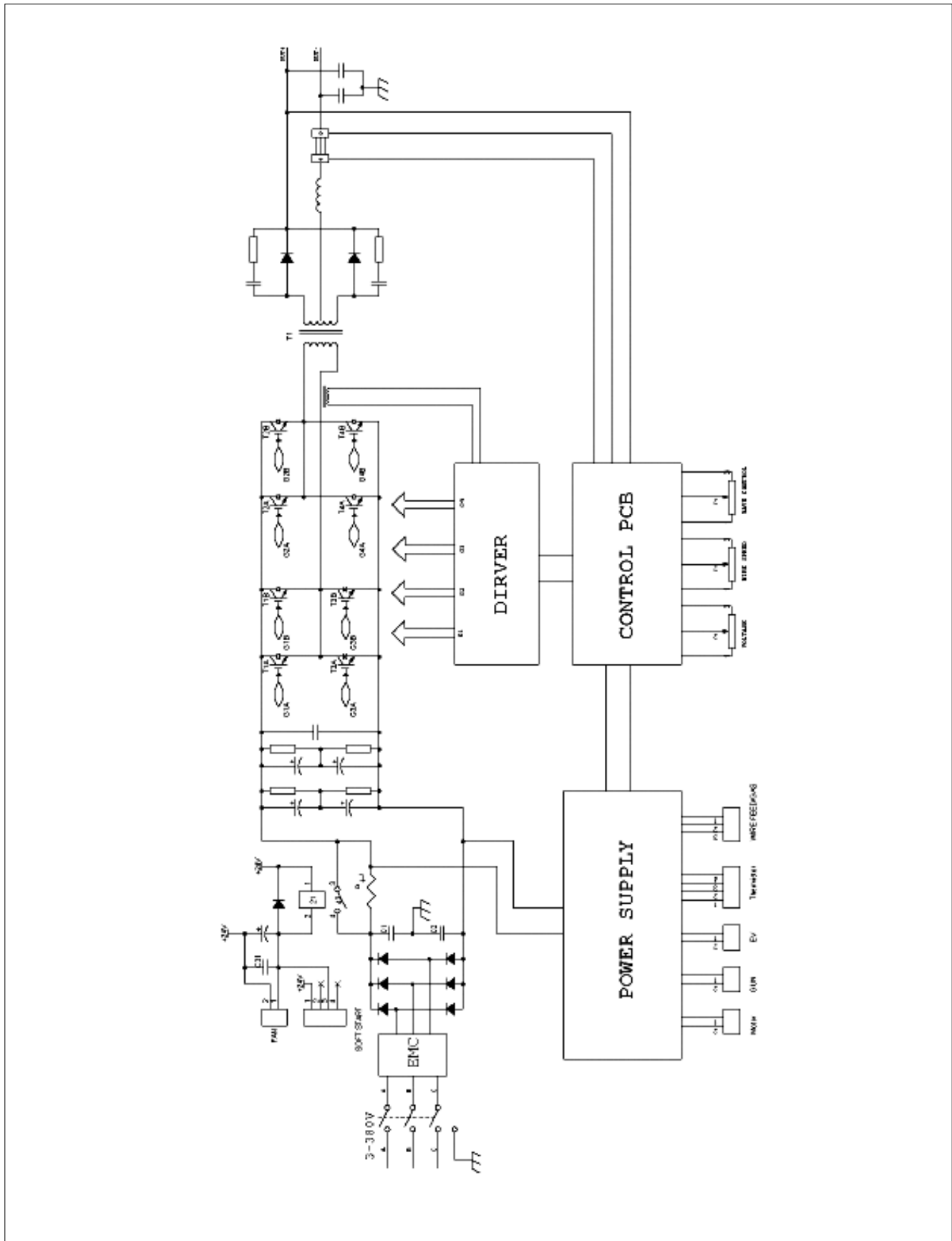
For the management of "WEEE", SINCOSALD relies on Erion Consortium.



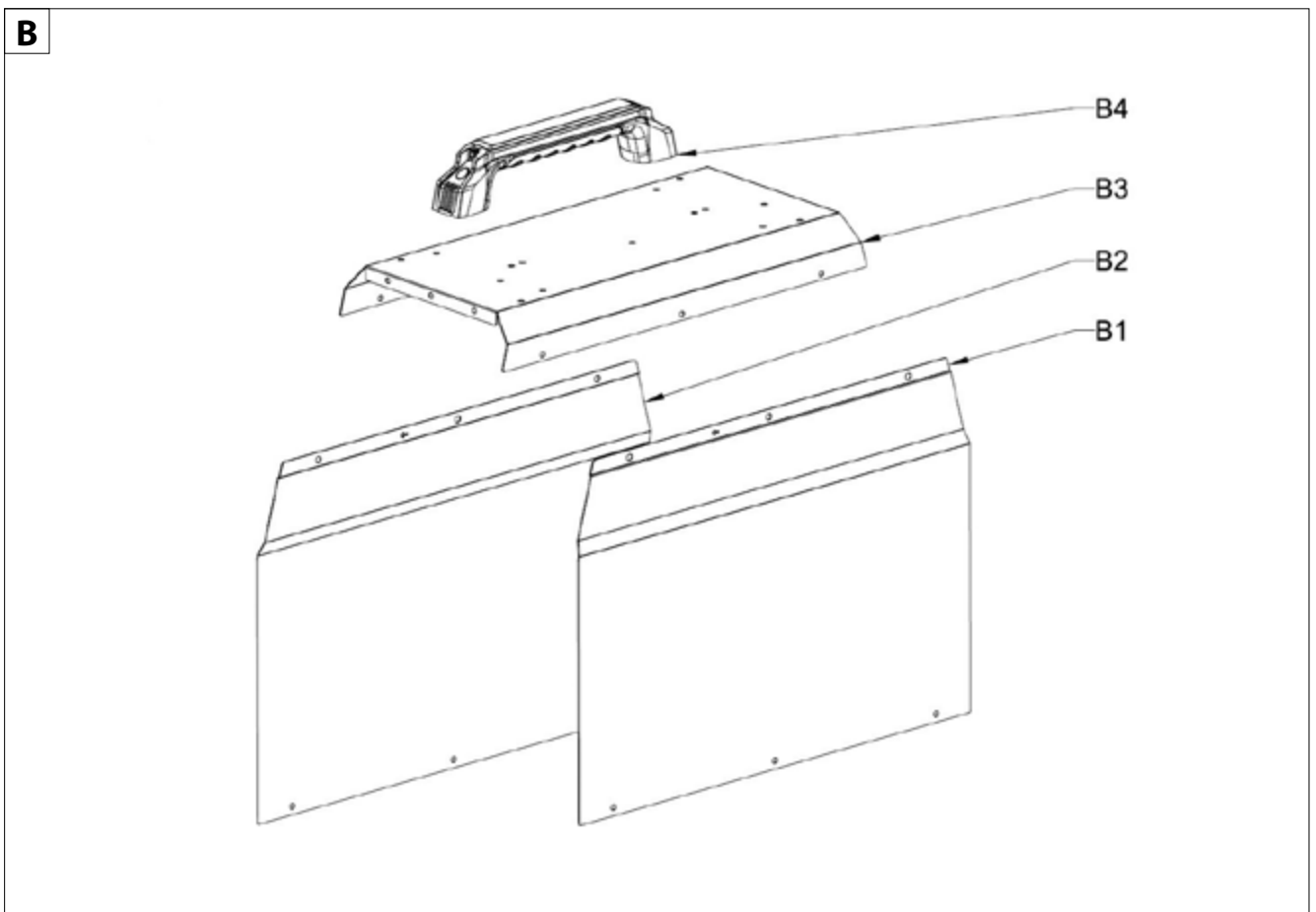
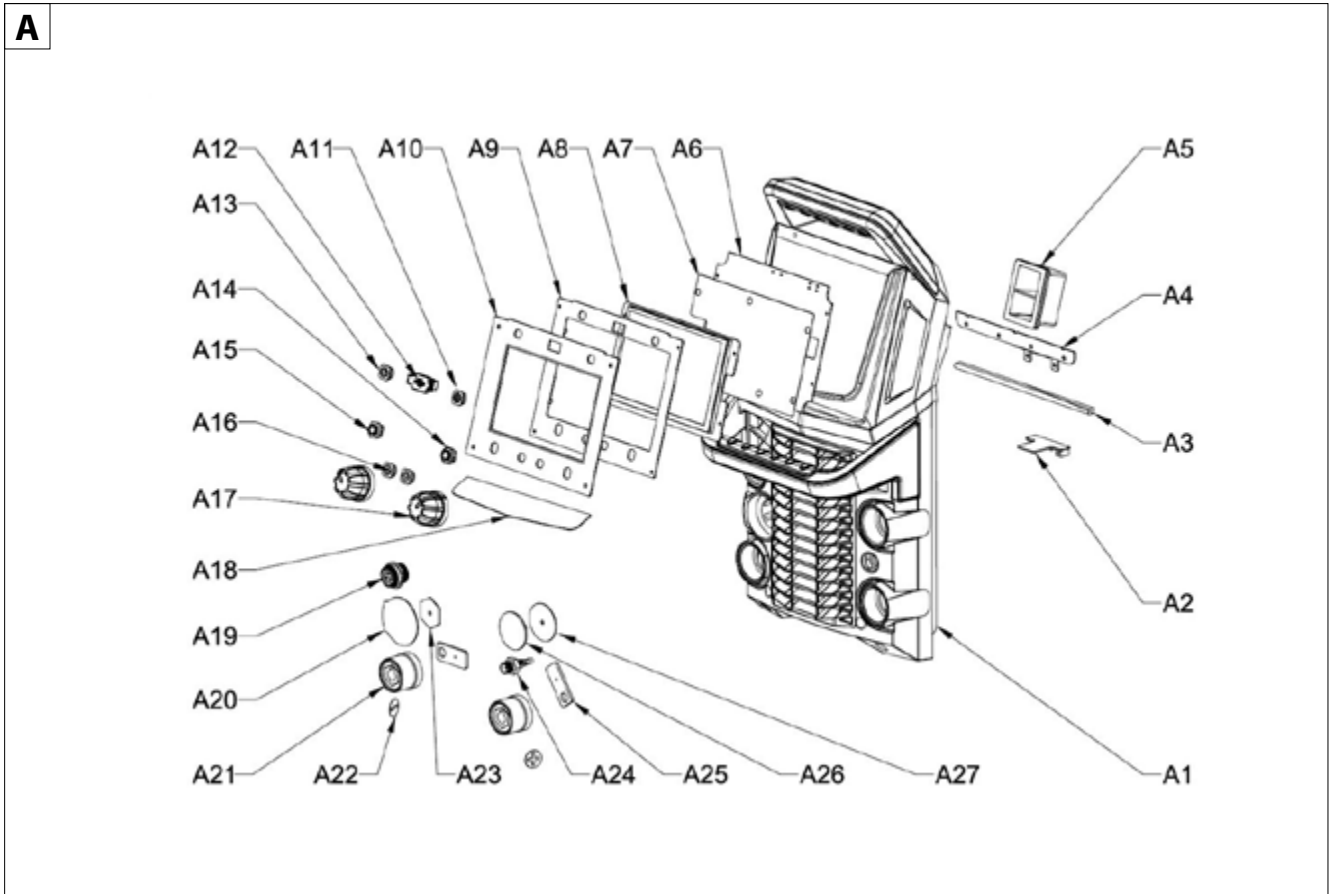
AS OF THE DATE OF THE PREPARATION OF THIS INSTRUCTION MANUAL THIS INFORMATION SHOULD BE CONSIDERED TO BE NON-DEFINITIVE AS SUBJECT TO POSSIBLE CHANGES ACCORDING TO THE OBLIGATIONS LINKED TO LEGISLATIVE DECREE N ° 151/2005 THAT WILL COMPLETE DIRECTIVE 2002/96/EC.

10. ANNEXES

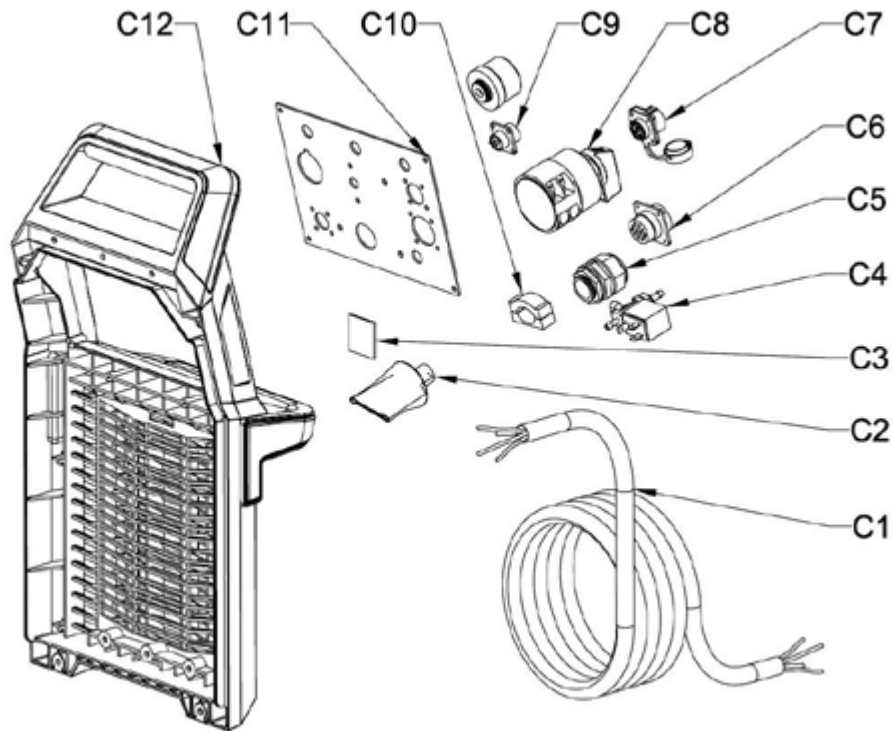
10.1. WIRING DIAGRAMS



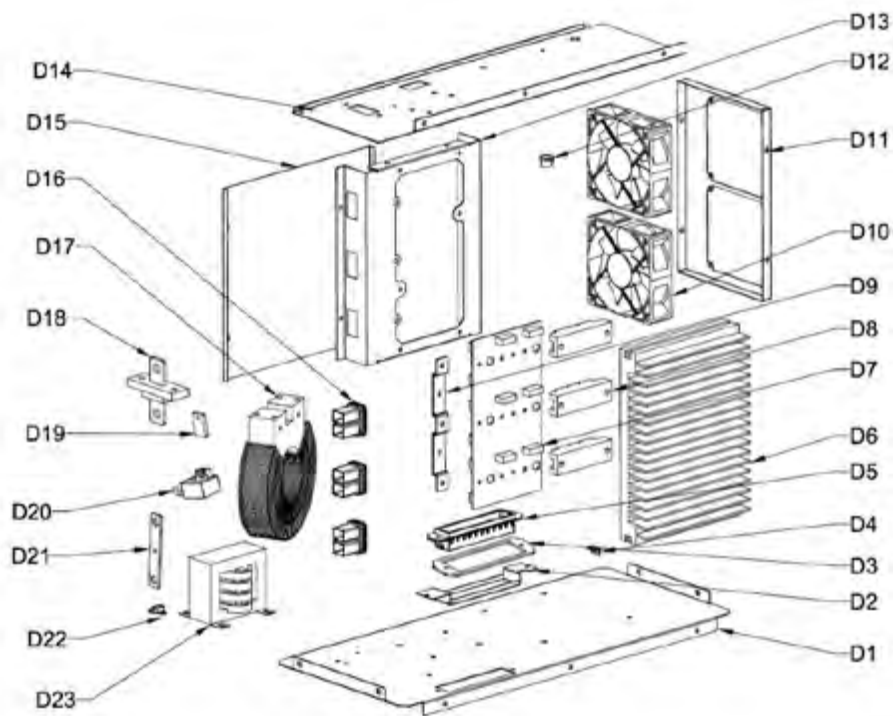
10.2. SPARE PARTS

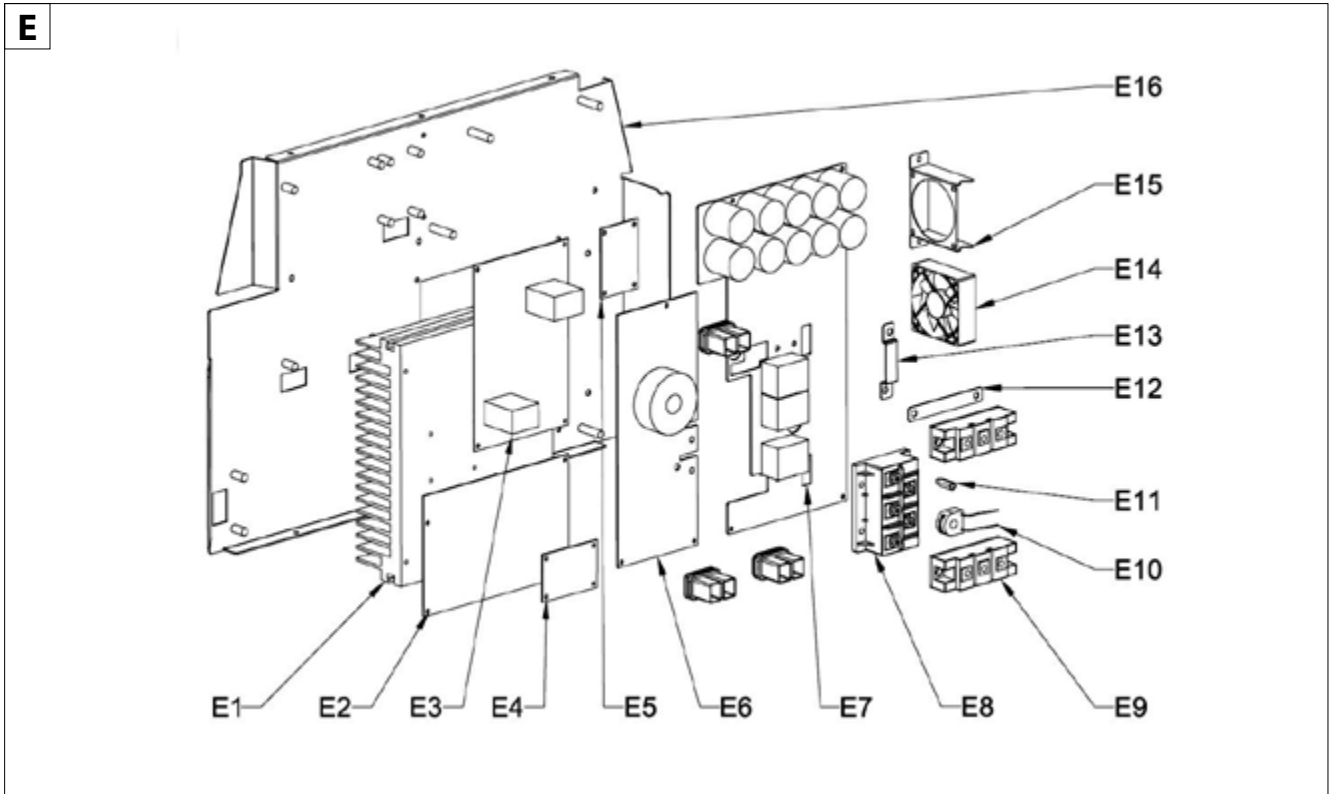


C



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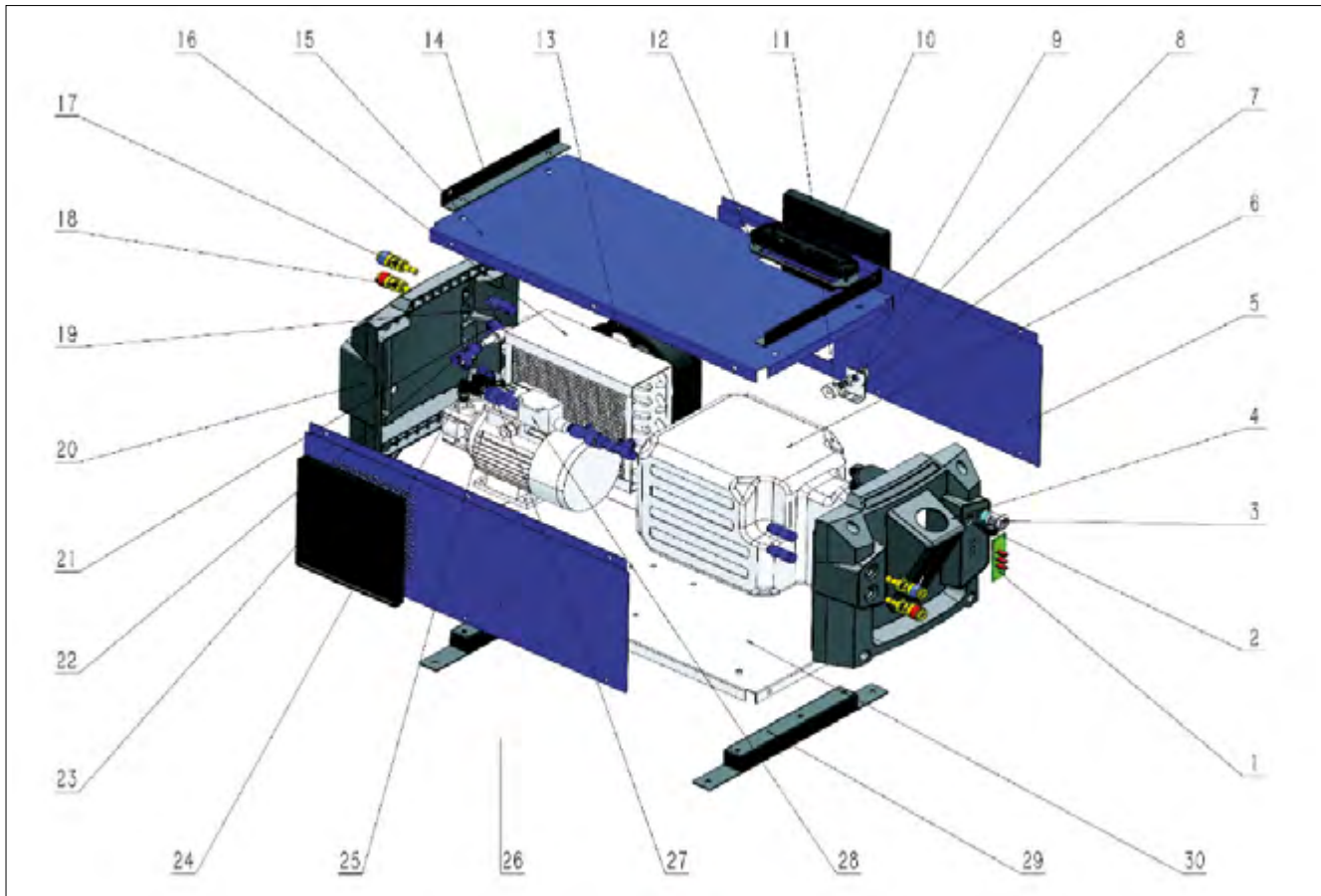




Pos.	Code	Description
A1	8.220.020	Front panel assembly No. 5
A2	8.233.039	Bluetooth communication PCB
A3	8.225.250	Flexible silicone light strip
A4	8.221.250	Bluetooth light strip mounting PCB
A5	8.221.251	Square hole protective coil
A6	8.225.251	LEZE7 Dual-Button Universal Display PCB
A7	8.225.252	Insulating strip
A8	8.225.253	Liquid crystal screen (touch)
A9	8.225.254	Plastic front cover PCB
A10	8.225.255	Front sticker
A11	8.225.097	Silicone buttons
A12	8.225.256	USB protective sleeve
A13	8.225.257	Silicone buttons
A14	8.225.258	Lead-free nuts
A15	8.225.259	Encoder dust-proof fixing piece
A16	8.225.100	Silicone buttons
A17	8.295.088	Knob
A18	8.225.260	Name label
A19	8.225.104	12-pin aviation socket
A20	8.225.261	Central socket cover (top)
A21	8.225.105	European-Chinese Fast Orbit
A22	8.225.262	Positive and negative labels (round shape)
A23	8.225.263	Central socket cover (bottom)
A24	8.291.054	Inlet Port
A25	8.225.264	Connect the copper busbar (thermistor)
A26	8.225.265	European middle partition (top)

Pos.	Code	Description
A27	8.225.266	European middle partition (bottom)
B1	8.221.252	Right side panel
B2	8.221.253	left side panel
B3	8.221.254	Cover
B4	8.225.267	Handle Assembly
C1	8.225.268	power cable
C2	8.225.269	Horn sleeve insulation (black)
C3	8.225.270	Three-phase surge protection PCB 380V
C4	8.225.271	Two-way two-port solenoid valve
C5	8.295.073	External compression cable connector
C6	8.295.069	14-pin aviation socket
C7	8.225.272	Five-pin aviation socket
C8	8.295.078	knob switch
C9	8.225.273	Three-pin aviation socket
C10	8.225.274	Circular clamp
C11	8.221.255	Back panel cover PCB
C12	8.220.021	Panel assembly No. 5
D1	8.221.256	Base plate
D2	8.225.275	Water-cooled connector baffle
D3	8.225.276	The gasket on the water-cooled connector
D4	8.225.107	Hanging panel
D5	8.225.108	Water-cooled connector (upper) assembly
D6	8.225.276	FRD Radiator
D7	8.223.207	Diode Absorption PCB
D8	8.225.277	Common cathode diode module
D9	8.225.278	Copper busbar connection (FRD)
D10	8.225.279	Fan

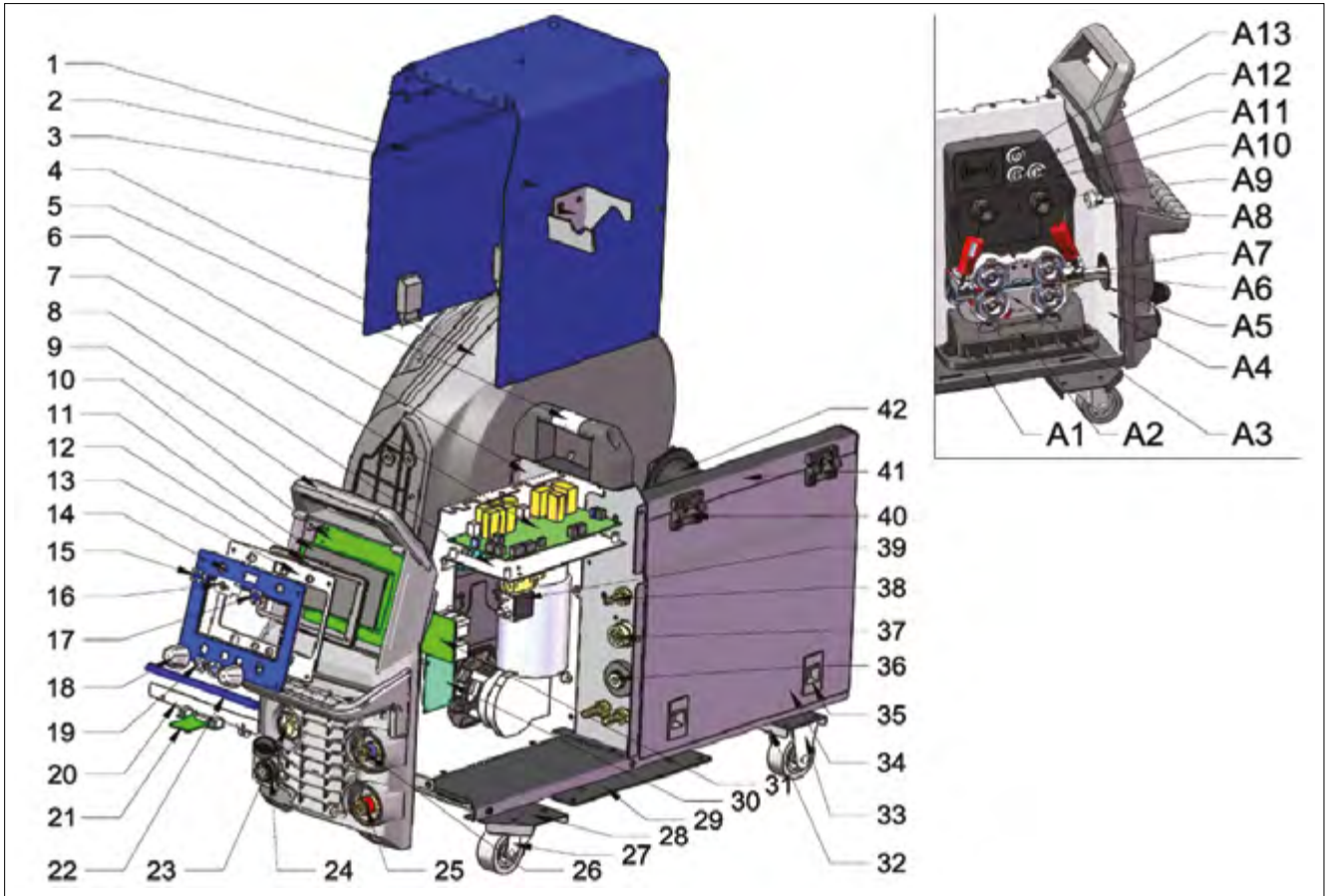
Pos.	Code	Description
D11	8.221.257	Fan installation box
D12	8.225.280	Snap-on wire protection sleeve
D13	8.221.258	FRD Sealing Box
D14	8.221.259	The installation plate of the circuit
D15	8.221.260	FRD insulating sheet
D16	8.225.115	Square hole protective coil
D17	8.222.210	Main transformer
D18	8.225.281	Panel-style European style
D19	8.225.282	Hall separator plate
D20	8.292.010	Hall-effect current sensor
D21	8.225.283	Connect the copper busbar (output)
D22	8.225.284	NTC thermistor sensor
D23	8.222.211	electrical inductance
E1	8.225.285	IGBT heat sink
E2	8.221.261	K platform control base PCB
E3	8.223.208	Power PCB
E4	8.221.262	Core PCB
E5	8.223.209	Auxiliary PCB
E6	8.223.210	EMC PCB
E7	8.223.211	Main PCB
E8	8.222.212	Three-phase rectifier bridge
E9	8.295.084	IGBT module
E10	8.222.024	current transformer
E11	8.225.286	copper stud nut
E12	8.225.287	Connect the copper busbar (rectifier bridge 1)
E13	8.225.288	Connect the copper busbar (rectifier bridge 2)
E14	8.225.289	Fan
E15	8.221.263	Fan mounting plate
E16	8.221.264	Median septum



Pos.	Code	Description
1	8.261.024	Intelligent water tank detection pcb
2	8.265.025	Fuse socket
3	8.265.026	Small push-button switch (for water tank lighting)
4	8.261.030	The front panel of the water tank
5	8.261.031	Right-side plate
6	8.265.005	Water tank
7	8.265.027	Lighting fixture mounting plate
8	8.265.028	Plastic hollow screw
9	8.265.029	Plastic screw nut
10	8.265.005	Water-cooled connector
11	8.265.030	LED lamp

Pos.	Code	Description
12	8.265.031	Water-cooled connector gasket below
13	8.235.046	FAN
14	8.261.032	Water tank main unit connection plate
15	8.261.033	Cover
16	8.265.032	Water tank heat pipe radiator
17	8.265.033	Quick water connection (blue)
18	8.265.034	Quick water connection socket (red)
19	8.265.035	Straight-through quick connector
20	8.261.034	Rear panel

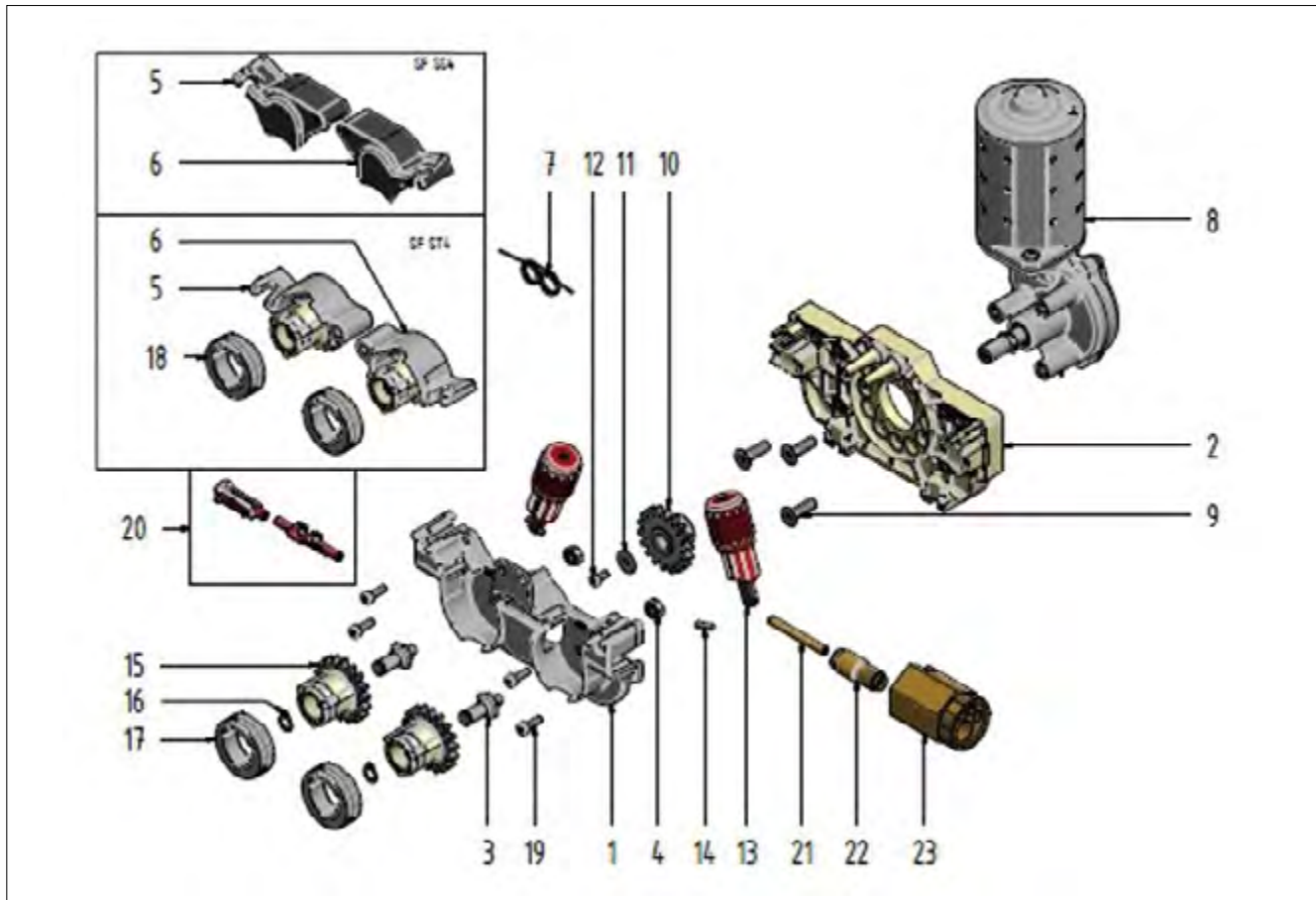
Pos.	Code	Description
21	8.265.036	Right-angle quick connector
22	8.265.037	T-shaped three-way connector
23	8.265.038	Window blinds after the third edge treatment
24	8.265.039	Right-angle quick connector
25	8.263.001	Water pump
26	8.261.035	Left side plate
27	8.265.040	Variable diameter direct connection
28	8.263.007	Water flow sensor
29	8.261.036	Water tank cart connection plate
30	8.261.037	Base plate



Pos.	Code	Description
1	8.251.035	left side plate
2	8.251.036	right-side plate
3	8.251.037	Welding gun support
4	8.251.038	Hanker Silk box, gray
5	8.255.209	Aluminum alloy handle
6	8.251.039	rear panel
7	8.253.010	Wire feeding drive board
8	8.251.040	Circuit installation board
9	8.251.041	Panel assembly of the wire feeding machine
10	8.223.062	Dual-Button Display pcb
11	8.215.211	LCD
12	8.215.212	5-inch screen edge protection film
13	8.221.056	Panel mounting plate
14	8.250.005	Front sticker
15	8.225.099	Silicone buttons
16	8.225.256	USB protective sleeve
17	8.225.097	Silicone buttons
18	8.225.102	Knob
19	8.225.100	Silicone buttons
20	8.225.106	Bluetooth light strip mounting plate
21	8.233.039	Bluetooth communication pcb
22	8.225.103	Flexible silicone light strip
23	8.215.213	Central socket
24	8.255.000	Nine-pin aviation socket (large)

Pos.	Code	Description
25	8.255.013	Quick water connection socket (red)
26	8.255.014	Quick water connection (blue)
27	8.255.003	Universal wheel
28	8.251.018	Universal wheel mounting plate
29	8.251.042	Feed wire machine base connection plate
30	8.253.003	Full Digital MIG Welding Gun Adapter pcb
31	8.253.011	Panel Hub pcb
32	8.251.019	Fixed wheel mounting plate
33	8.255.015	Fixed wheel
34	8.251.043	Back sealing plate
35	8.255.004	Square box buckle
36	8.255.210	European Chinese mother figure
37	8.255.211	14-pin aviation connector
38	8.255.012	Water supply quick connector
39	8.295.079	Two-way two-port solenoid valve
40	8.255.005	Hinge
41	8.255.008	Partition board (rear)
42	8.251.044	European-style silk spindle shaft
A1	8.251.045	Baseboard

Pos.	Code	Description
A2	8.251.046	Wire feeding machine base
A3	8.257.001	Dual-drive wire feeding motor
A4	8.251.047	Median septum
A5	8.255.212	Guard wire
A6	8.255.213	Stainless steel connecting rod
A7	8.255.214	Guidewire tube
A8	8.255.215	LED lamp
A9	8.251.048	Wire feeding wheel bracket
A10	8.251.049	Sealing box for wire feeding machine - Use until exhausted
A11	8.255.216	Small push-button switch (Gas detection)
A12	8.255.217	Small push-button switch (for feeding wire)
A13	8.255.218	Small push-button switch (for lighting)



Pos.	Code	Description	Qt.
01	SW.22531	4-R PLATE SF ST4 AND SS4, ALU	1
02	SW.700015-VM	4-R PLATE SF ST4 AND SS4, PA6GF35	1
03	SW.20205	FEED ROLL AXLE Ø8 X 14.75, 3.85MM, RECESSED FOR CIRCLIP	2
04	SW.24202	HEX-NUT M6	2
05	SW.22541	PRESSURE ARM ASSEMBLY, SF ST4 LEFT, WITH CARRIER GEAR	1
06	SW.22542	PRESSURE ARM ASSEMBLY, SF ST4 RIGHT, WITH CARRIER GEAR	1
07	SW.24394	TORSION SPRING, DOUBLE 180 DEG. ID 12MM, OD 14MM, SS4	1
08	8.257.002	MOTOR	1
-	SW.44805	ENCODER ME22- 200 PULSE, 2 CHANNEL	1
-	SW.44802	ENCODER CABLE 300MM FOR ME22	1
-	SW.44260	ENCODER COVER, NYLON, Ø 48MM, H 37MM, FOR ALU ENCODER SUPPORT	1
09	SW.24094	RECESSED COUNTERSUNK FLAT HEAD SCREW M6X20MM	3
10	SW.21100	DRIVE GEAR Ø37MM, WITH KEYWAY, H 18MM	1
11	SW.24184	WASHER, M4, WIDE	1
12	SW.24310	SOCKET HEAD CAP SCREW, M4X10	1
13	SW.41994	PRESSURE ADJUSTMENT UNIT, RED, SHORT VERSION	2
14	SW.24251	CYLINDRICAL PIN, Ø3X10	2

Pos.	Code	Description	Qt.
15	SW.43020	DRIVE GEAR Ø 37MM, QUICK CHANGE SYSTEM, BEARINGS, BEARINGS	2
16	SW.24346	SNAP RING FOR SHAFT 8 MM BN 818	2
17	SW.211012	FEED ROLL, Ø37MM, QUICK CHANGE, FOR HARD WIRES Ø1.0+1.2MM, RED + ORANG	2
18	SW.241012	FEED ROLL, Ø37MM, QUICK CHANGE, FLAT, FOR HARD WIRES Ø1.0+1.2MM, RED + OR	2
19	SW.24312	SOCKET HEAD CAP SCREW, M4X12	4
20A	SW.20220	WIRE INLET GUIDE, POM BLUE, ID Ø2.0MM, FOR WIRES Ø0.6-1.6MM, SS4-ST4	1
20B	SW.20222	CENTER WIRE GUIDE, POM BLUE, ID Ø2.0MM, FOR WIRES Ø0.6-1.6MM, SS4-ST4	1
21	8.255.214	WIRE GUIDE TUBE 5 X 2 X 91.5MM BRASS	1
22	8.255.213	CONNECTION SCREW SS4-ST4, FOR PRESS-FIT, WITH O-RING	1
23	8.215.213	EURO CONNECTOR 80MM, AMP 500MM	1



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