

NOTE

Dear customer , please read the manual before installation, use or servicing of the unit.

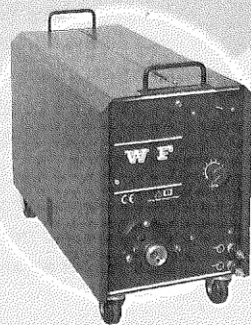
INSTRUCTION MANUAL



1956-X 1957-X & 1958-X



1960-X



1961-X



Caution! Read the instruction manual

We have the right to improve and update the machine.
The picture and the content are just for your reference.
Please be subject to the actual products if anything different or
updated. Please pardon me for not informing you in advance.

INSTRUCTION MANUAL FOR WIRE WELDING MACHINE

IMPORTANT: BEFORE STARTING THE EQUIPMENT, READ THE CONTENTS OF THIS MANUAL, WHICH MUST BE STORED IN A PLACE FAMILIAR TO ALL USERS FOR THE ENTIRE OPERATIVE LIFE-SPAN OF THE MACHINE. THIS EQUIPMENT MUST BE USED SOLELY FOR WELDING OPERATIONS.

1. SAFETY PRECAUTIONS

WELDING AND ARC CUTTING CAN BE HARMFUL TO YOURSELF AND OTHERS. The user must therefore be educated against the hazards, summarized below, deriving from welding operations. For more detailed information, order the manual.

ELECTRIC SHOCK - May be fatal.



Install and earth the welding machine according to the applicable regulations.

Do not touch live electrical parts or electrodes with bare skin, gloves or wet clothing.

Isolate yourselves from both the earth and the workpiece.

Make sure your working position is safe.

FUMES AND GASES - May be hazardous to your health.



Keep your head away from fumes.

Work in the presence of adequate ventilation, and use ventilators around the arc to prevent gases from forming in the work area.

ARC RAYS - May injure the eyes and burn the skin.



Protect your eyes with welding masks fitted with filtered lenses, and protect your body with appropriate safety garments.

Protect others by installing adequate shields or curtains.

RISK OF FIRE AND BURNS



Sparks (sprays) may cause fires and burn the skin; you should therefore make sure there are no flammable materials in the area, and wear appropriate protective garments.

NOISE



This machine does not directly produce noise exceeding 80dB. The plasma cutting/welding procedure may produce noise levels beyond said limit; users must therefore implement all precautions required by law.

PACEMAKERS

The magnetic fields created by high currents may affect the operation of pacemakers. Wearers of vital electronic equipment (pacemakers) should consult their physician before beginning any arc welding, cutting, gouging or spot welding operations.

EXPLOSIONS



Do not weld in the vicinity of containers under pressure, or in the presence of explosive dust, gases or fumes.. All cylinders and pressure regulators used in welding operations should be handled with care.

ELECTROMAGNETIC COMPATIBILITY

This machine is manufactured in compliance with the instructions contained in the harmonized standard EN50199, **and must be used solely for professional purposes in an industrial environment. There may be potential difficulties in ensuring electromagnetic compatibility in non-industrial environment.**

IN CASE OF MALFUNCTIONS, REQUEST ASSISTANCE FROM QUALIFIED PERSONNEL.

2 GENERAL DESCRIPTION

2.1 SPECIFICATIONS

This manual has been prepared for the purpose of educating personnel assigned to install, operate and service the welding machine.

The purchaser should address any complaints for losses or damage to the vector. Please indicate the article and serial number whenever requesting information about the welding machine.

3. INSTALLATION

Only skilled personnel should install the machine.

All connections must be carried out according to current regulations, and in full observance of safety laws.

3.1 PLACEMENT

Unpack the wire feeder and place it above the welding machine, using the flexible rotating cylinder provided(optional).

4 DESCRIPTION OF CONTROLS

4.1 CONTROLS ON THE WIRE FEEDER FRONT PANEL

A-Quick connect torch terminal

The welding torch is attached to this terminal.

D. Led (yellow or red color)

This Led light on when:

- that the thermostat has stopped welder operation.
- on machines fitted with a cooling unit, that the pressure switch indicates a low cooling liquid level or that the cooling unit is off. (only some model with the pressure switch)

E - Led (green color)

This led signals that the machine is on.

F - Knob

This knob. regulates the length of the wire that sticks out of the torch after welding is finished: "BURN-BACK"

G- Weld function selection switch

This switch selects among the following functions:

Manual welding cycle (2 step)

The machine begins welding when the torch trigger is pushed and stops welding when the torch trigger is released. Automatic welding cycle (4 step)

The machine begins welding when the torch trigger is pushed. Once welding has begun, however, the torch trigger can be released. To stop welding, the torch trigger must again be pushed and then immediately released. This function is useful when welding for long periods of time because it helps reduce operator hand fatigue due to having to keep the torch trigger constantly pushed during normal manual welding operations.

H- Wire feed speed control.

This knob adjusts the wire feed speed.

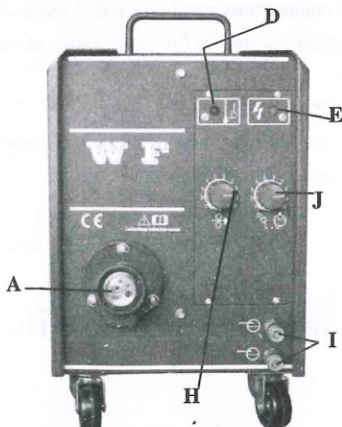
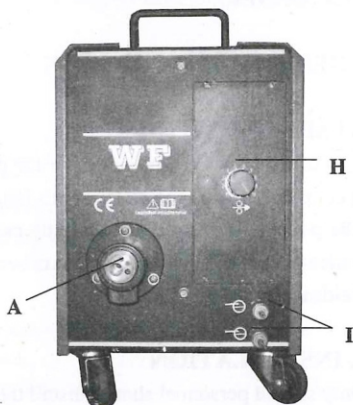
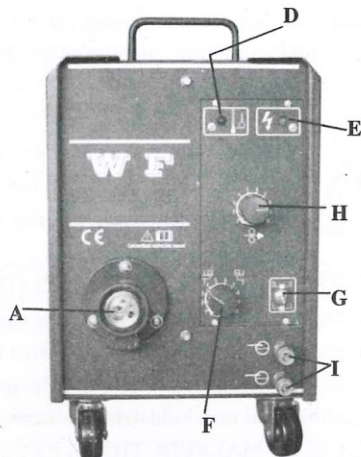
I-Quick-fit hose connectors for connection to water hoses of water-cooled torches.

Important: These connectors are colour-coded for safety.

Ensure that hose and connector colours match.

J: Spot welding time knob

Setting the time of the spot welding. (Note: turn off when normal use without spot function . Only the model like the picture with the function.)



4.2 CONTROLS ON THE WIRE FEEDER REAR PANEL

L-Gas hose fitting for extension gas hoses.

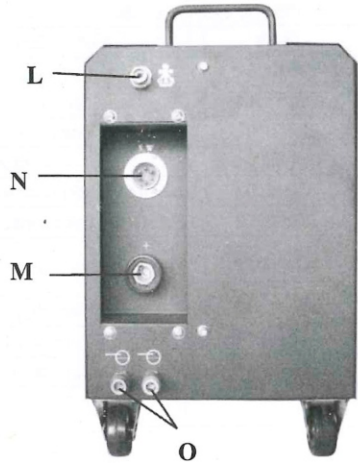
M - 6-pin socket connector for 6-pin plug connector

N-Socket for extension power supply plug.

O - Quick-fit hose connectors for connection to extension water hoses.

Important: These connectors are colour-coded for safety.

Ensure that hose and connector colours match.



5 START-UP

Assemble the welding torch on the central adapter (A).

Make sure that the wire diameter corresponds to the one indicated on the wire feed roller, and load the wire reel. Make sure that the welding wire passes through the groove in the roller.

Before connecting the generator power cable, make sure that the supply voltage corresponds to that of the welding machine, and that the earth socket functions properly.

Turn on the generator.

Remove the tapered gas nozzle.

Unscrew the contact tip.

Press the torch trigger and release it only when the welding wire comes out.

Welding wire can cause puncture wounds.

Never aim the torch at parts of the body when loading the welding wire.

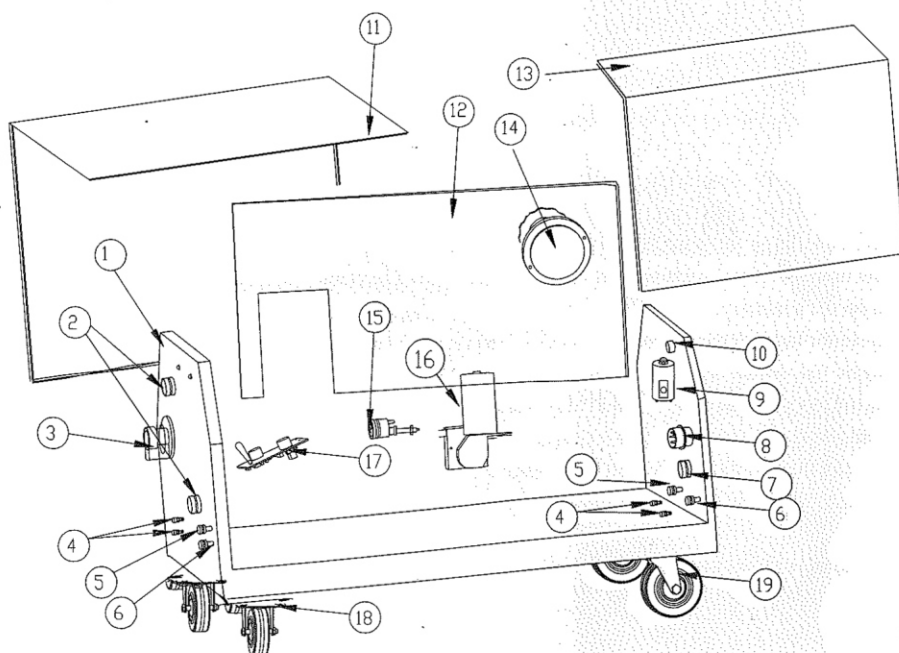
Screw the contact tip back on, making sure that the hole diameter corresponds to the wire used.

Slide the tapered gas welding nozzle back on.

6 ILLUSTRATION OF EXPLODED

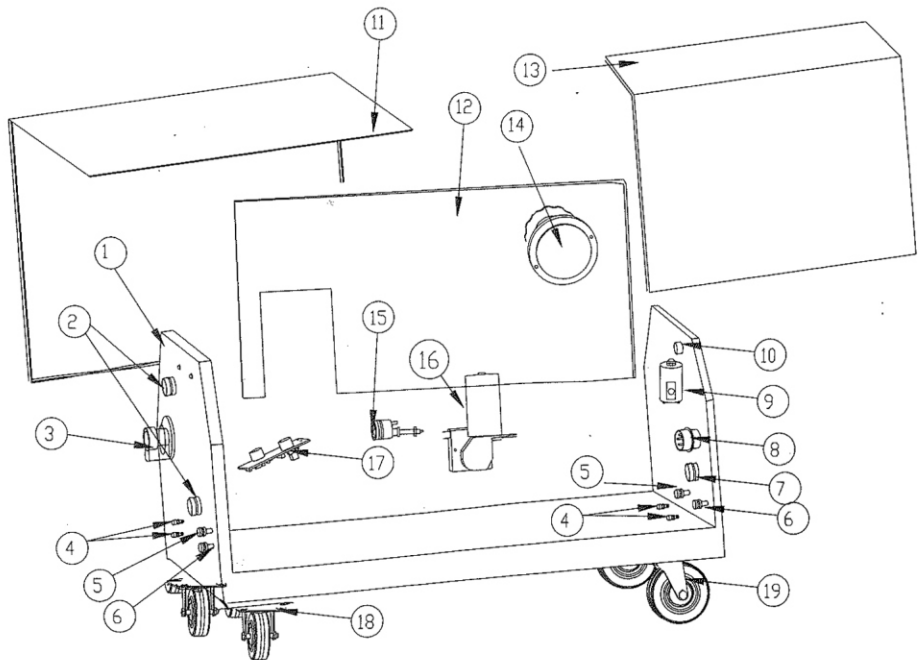
1956-X 1957-X 1958-X

NO.	Code	Description	NO.	Code	Description
1	EW062000-8-1	bottom case	11	EW062000-3-1	door panel
2	SE055001	knob	12	EW062000-8-4	inside baffle
3	JB055003	torch connector plastic case	13	EW062000-3-2	right panel
4	JC062000	water connector	14	SG055009-1	wire support
5	JC062001	socket for water connector(red)	15	JB055005	torch connector
6	JC062002	socket for water connector(blue)	16	MC074003	wire feeder motor
7	JC055017	ground socket	17	PA055007	wire feeder control circuit board PCB
8	JG055000	control plug	18	SG055011	front swivel caster
9	BF055011	solenenoid valve	19	SG055007	back fixed wheel
10	BF055004	valve connector			



1960-X

NO.	Code	Description	NO.	Code	Description
1	EW062000-8-1	bottom case	11	EW062000-3-1	door panel
2	SE055001	knob	12	EW062000-8-4	inside baffle
3	JB055003	torch connector plastic case	13	EW062000-3-2	right panel
4	JC062000	water connector	14	SG055009-1	wire support
5	JC062001	socket for water connector(red)	15	JB074000	torch connector
6	JC062002	socket for water connector(blue)	16	MC074007	wire feeder motor
7	JC055016	ground socket	17	PT055006	wire feeder control circuit board PCB
8	JG055000	control plug	18	SG055011	front swivel caster
9	BF055011	solenoid valve	19	SG055007	back fixed wheel
10	BF055004	valve connector			



1961-X

NO.	Code	Description	NO.	Code	Description
1	EW062000-8-1	bottom case	11	EW062000-3-1	door panel
2	SE055001	knob	12	EW062000-8-4	inside baffle
3	JB055003	torch connector plastic case	13	EW062000-3-2	right panel
4	JC062000	water connector	14	SG055009-1	wire support
5	JC062001	socket for water connector(red)	15	JB074000	torch connector
6	JC062002	socket for water connector(blue)	16	MC074007	wire feeder motor
7	JC055016	ground socket	17	RA064000	volatile resistor
8	JG055000	control plug	18	SG055011	front swivel caster
9	BF055011	solenoid valve	19	SG055007	back fixed wheel
10	BF055004	valve connector			

