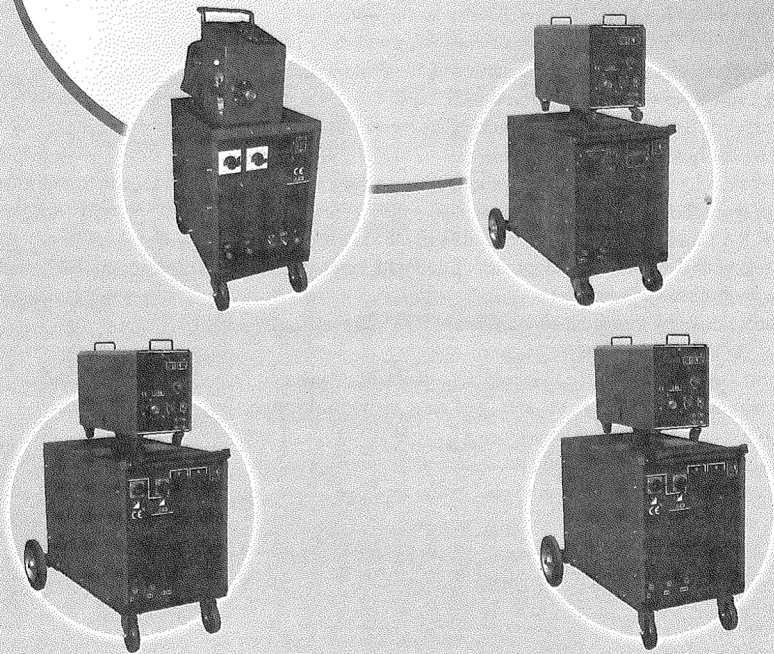


NOTE

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

INSTRUCTION MANUAL



Caution! Read the instruction manual

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, **and must be used solely for professional purposes in an industrial environment. There may be potential difficulties in ensuring electromagnetic compatibility in non- industrial environments.**

IN CASE OF MALFUNCTIONS, REQUEST ASSISTANCE FROM QUALIFIED PERSONNEL.

2 GENERAL TECHNICAL DESCRIPTIONS

2.1 SPECIFICATIONS

This manual has been prepared with the intent of instructing the operator on how to install, operate, and properly maintain this electric arc welding machine.

This machine is a constant voltage power source for MIG/MAG and OPEN-ARC welding.

Upon receiving and unpacking the machine, make a careful inspection to ensure that there are no damaged parts.

Should there be a claim for losses or damages it must be made by the purchaser directly to the shipper who handled the goods.

When requesting information about this welding machine please state the machine's part number and serial number to ensure receiving accurate information relating to your machine.

2.2 DESCRIPTION OF TECHNICAL SPECIFICATIONS

MODEL: The model of the machine

EN 60974-10:2003 International standards.

SN Machine Serial Number which must appear on requests or inquiries concerning the machine.



Single-phase transformer-rectifier



Three-phase transformer-rectifier

3-50/60Hz Three-phase input supply at 50 or 60 Hz

1-50/60Hz Single-phase input supply at 50 or 60 Hz.

U₀ Secondary no-load voltage (peak value).

X Duty-Cycle Percentage

The duty-cycle is the number of minutes, expressed as a percentage, the machine can operate (arc on) within a ten minute period without overheating. The duty cycle varies according to the output current.

I₂ Output welding current

I₁ Input Amps absorbed corresponding to different output levels (**I₂**).

U₂ Secondary voltage with welding current **I₂**.

U₁ Nominal supply voltage

IP21 Machine case protection class. The 1 in the second digit place means that this unit is not fit to work outdoors in the rain.

F Insulation Class

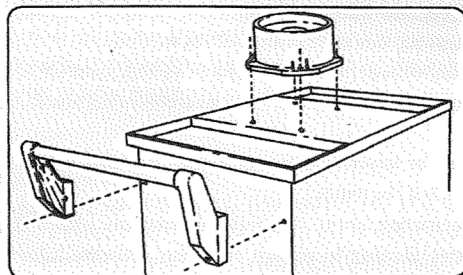
3 INSTALLATION

3.1 SETUP

Place the machine in a ventilated area.

Dust, dirt, or any other foreign material that might enter the machine may restrict the

ventilation which could affect the machine's performance. Fasten the rotating support to the machine top and fix the handle, the wheels, the bottle support and, if any, the cooling unit.



3.2 INPUT POWER CONNECTIONS

All sections concerning the installation of this machine must be read carefully.

This machine must be installed by skilled personnel.

Make sure that the input power plug has been disconnected before inspecting, maintaining, or servicing.

Connect the yellow-green wire to a good electrical ground..

Do not use water pipes as earth conductor.

After a final inspection, the machine should be connected to the input supply voltage marked on the input power cord.

If you wish to change the input supply voltage, remove the right side panel , locate the voltage-changing terminal board and arrange the connections as shown in ILLUSTRATION OF WORKING PRINCIPLE.

After having changed the supply voltage, re-place the upper cover.

This machine must never be used without the top and side covers. This is both for obvious safety reasons and to avoid interference with the machine's internal cooling system. The warranty is to be considered null and void if this machine is used without the protection of its top and side covers.

Mount a plug on the power supply cable that corresponds to the input power drawn by the machine.

3.3 OUTPUT CONNECTIONS

3.3.1 Wire feeder connection

This power source is compatible with the wire feeders. To connect the power source to the wire feeder units use the extension art. Performances and operating features of the wire feeder are described in the operating manuals supplied with the wire feeder itself.

3.3.2 Connecting the work return lead clamp.

Some versions have one impedance socket only.

Connect the male end of the work return lead to one of the impedance taps on the front panel of the machine. The impedance tap  designated by the provides the maximum amount of impedance which will produce nicely filleted weld beads. This tap is recommended when welding aluminium, stainless steel, and carbon steels of binary or ternary composition. The impedance tap  designated by the provides the least amount of impedance and is

recommended when using carbon dioxide as a shielding gas to weld carbon steels, in the upwards vertical position, of binary or ternary composition.

It is generally advisable to use low impedance values for small diameter wires and high values for big diameter wires.

After having selected the proper impedance tap, attach the work return clamp to the work to be welded.

Make sure that the ground clamp is tightly fastened to the work return cable and periodically check that this connection remains well tightened. A loose connection can cause weld current drops or overheating of the work return lead and clamp which, in turn, creates the risk of burns from accidental contact with the work return lead. The weld circuit must not be placed deliberately in direct or indirect contact with the ground conductor if it is not in the work to be welded.

If the work to be welded is attached deliberately to the ground by a protection lead, then the connection must be the most direct possible and it must be done using a lead that has a cross section that is at least equal to the cross section of the work return lead being used for the weld circuit. The protection lead must also be attached to the work at the same spot as the work return lead. To do so, a second ground clamp, fitted to the protection lead, must be attached next to the ground clamp of the work return lead.

3.3.3 Connecting the gas hose.

Keep the cylinders in an upright position by chaining them to their support.

Keep the cylinders in a place where they cannot be damaged.

Do not lift the machine with the cylinder on its support.

Keep the cylinder away from the welding area and uninsulated electric circuits.

Cylinders containing inert gas have to be equipped with a pressure reducer and a flowmeter.

After having positioned the cylinder, connect the gas hose that comes out from the rear of machine to the pressure reducer output.

Regulate the gas flow to 8-10 L/min.

4 WELDING

4.1 INSTALLATION AND STARTER

Machine installation must be done by a competent staff. All connections must correspond to the rules in force and must respect laws concerning accidents.

Check that the wire diameter corresponds to that indicated on the roll and mount the wire coil.

Connect the pipe coming out of the extension with the cylinder flowmeter.

Position the welding machine so as to allow free air circulation inside it and avoid that metal or any other.

4.2 THE MACHINE IS READY TO WELD

Connect the ground terminal to the part to be welded.

Turn the machine on.

Extract the conic gas nozzle by rotating it clockwise.

Unscrew the current nozzle.

Press the torch trigger to feed the wire until it comes out from the torch.

WARNING: Keep your face away from the terminal nozzle while the wire comes out.

Screw the current nozzle again, making sure that the hole diameter be the same as that the wire used.

Insert the welding conic gas nozzle by rotating it clockwise. Open the gas cylinder and adjust flowmeter at 8-10L/min.

WARNING: Check that the gas used is compatible with the material to be welded.

4.3 WELDING CARBON STEELS.

To weld carbon steels the following things are necessary:

1) The use of a binary shielding gas which is most commonly Argon and Carbon dioxide, in a ratio of 75-80 % Argon and 25-20% Carbon dioxide. Some applications, however, may require a mix of three gases: Argon, Carbon dioxide (CO₂), and dioxide (O₂). These gas mixtures generate heat during welding and as a result the weld bead will be well filleted and neat in appearance. The penetration, however, will not be deep.

The use of Carbon dioxide as the shield gas results in a narrow weld bead with deep penetration but the ionization of the gas will have an influence on arc stability.

2) The use of a filler wire of the same quality as the steel to be welded. It is recommended that high quality wires be used and that welding with rusted wires be avoided because they can give rise to defects in the weld bead. Generally, the current range within which a wire can be used is calculated in the following manner:

$\emptyset$ of wire x 100 = minimum number of Amperes.

$\emptyset$ of wire x 200 = maximum number of Amperes.

Practical example: 1.20 $\emptyset$ wire = 120 Amps minimum and 240 Amps maximum. These amperages are based on the use of an Argon/CO₂ mixture as the shield gas and welding in the Short Arc transfer mode.

3) Avoid welding on rusted work pieces or work having spots of oil and grease present on the surface.

4) The use of a welding torch suitable to the welding currents that are going to be used.

5) Periodically check that the two handles making up the ground clamp are not damaged and that the welding cables (torch cable and the work return lead) do not have any cuts or burn marks that would reduce their efficiency.

4.4 WELDING STAINLESS STEEL

Welding stainless steels in the 300 series (the austenitic series) must be done using a shield gas mixture of predominantly Argon with a small percentage of O₂ added to stabilize the arc. The recommended mixture is AR/O₂ in the ratio of 98/2. Do not use CO₂ or AR/CO₂ mixtures as the shield gas.

Do not touch the welding wire with your bare hands.

The filler metal (the wire) must be of a higher quality than the work to be welded and the weld area must be clean.

4.5 WELDING ALUMINIUM

The following is required for aluminium welding:

- 1) 100% Argon as welding protection gas.
- 2) A torch wire of composition suitable for the basic material to be welded.

For ALUMAN welding wire 3.5% silicon.

For ANTICORODAL welding wire 3.5% silicon.

For PERALUMAN welding wire 5% magnesium.

For ERGAL welding wire 5% magnesium.

- 3) A torch prepared for aluminium welding.

If you only have a torch for steel wires, the same shall be modified in the following way:

- Make sure that length of torch cable does not exceed 118 inches (it is advisable not to use longer torches).
 - Remove the brass sheath-holding nut, the gas and the current nozzles, then slip the sheath off.
 - Insert the teflon sheath for aluminium and ensure it protrudes from both ends.
 - Screw the current nozzle so that the sheath adheres to it.
 - Insert the sheath holding nipple, the O-Ring in the free end of the sheath and secure with the nut without tightening too much.
 - Slip the brass tube on the sheath and insert both into the adapter (after removing the iron tube which was fitted inside the adaptor).
 - Cut the sheath diagonally so that it stays as close as possible to the wire slide roller.
- 4) Use drive rolls that are suitable for aluminium wire. The drive rolls, when being installed, must be tightened as tight as possible.
 - 5) Use contact tips that are suitable for aluminium wire and make sure that the diameter of the contact tip hole corresponds to the wire diameter that is going to be used.
 - 6) Use abrasive grinders and tool brushes specifically designed for aluminium. Never use these tools on other materials. **REMEMBER that cleanliness equals quality.**

The wire spools must be stored in plastic bags with a dehumidifier.

5 WELDING DEFECTS

- 1- DEFECT- **Porosity** (in, or on the surface of the weld bead)

CAUSES Bad wire (rust on the surface).

Insufficient gas shielding due to:

- Inadequate gas flow due to a block in the gas line.
- Defective flowmeter.
- Gas regulator covered with frost because a gas heater was not used to heat the CO₂ shielding gas.
- Failure of gas valve solenoid.
- Gas nozzle plugged up with spatter.
- Gas flow holes plugged up.
- Air drafts in the welding area.

- 2- DEFECT- **Shrinkage Cracks**

CAUSES Welding wire or work to be welded dirty or rusty.

Weld bead too small.

Weld bead too concave.

Too much weld bead penetration.

3- DEFECT- **Lateral cracking**

CAUSES Welding speed too fast.

Low current and high arc voltages.

4- DEFECT- **Too much Spatter**

CAUSES Voltage too high

Insufficient impedance

No gas heater used for CO₂ shielding gas.

6 MACHINE MAINTENANCE

Gas nozzle . Periodically clean the nozzle of all weld spatter that may have accumulated during welding operations If the nozzle should become distorted or oval in shape then it must be replaced.

Contact tip . A good contact between the contact tip and the wire ensures a stable arc and optimal current output. Therefore, following steps must be followed:

A) The contact tip hole must be kept free of dirt or oxidation.

B) After lengthy welds, spatter can easily accumulate on the contact tip and prevent the wire from being fed. The contact tip must be cleaned regularly and if necessary it must be replaced.

C) The contact tip must always be screwed tightly on to the body of the torch. The thermal cycles which the torch undergoes during operation may loosen the contact tip which, in turn, may cause the torch body and nozzle to overheat or cause unsteady wire feed.

The Wire Liner is an important part that must often be checked since, during normal operations, the wire can deposit copper dust or tiny metal shavings in the lining. Periodically clean the liner and the gas line with a jet of dry, compressed air. Wire liners are exposed to continual wear and therefore they must be replaced after a certain period of time.

Wire feed motor. Periodically clean the wire feed assembly and the drive rolls from any rust or metal shavings due to the feeding of the wire. A periodic check of all the components of the wire feed assembly, spool holder, drive rolls, wire liner and the contact tip is recommended.

7 TROUBLESHOOTING

TROUBLE	PROBABLE CAUSE	REMEDY
Limited electric output	A phase missing	Check the phase of the feed line and/or the remove control switch contacts
	A line fuse is burnt	Replace it
	Wrong connection on the voltage changer terminal board	Check the terminal board connections by following the plate scheme
	The rectifier diode are burnt	Replace the rectifier
	Loosened torch or ground connections	Tighten all connections
	Welding regulation commutator has an uncertain contact	Replace the commutator
	Transformer wire interrupted on the commutator	Unscrew the commutator contact remove the wire insulation and put it under the contact

Welding with a lot of metal spatter	Wrong adjustment of the welding parameters	Select the correct parameters through the welding voltage switch and the wire-speed adjustment potentiometer
	Wire advancing improperly	Uncorrected sheath diam.
	Insufficient grounding	Check grounding connections
Wire not advancing or	Wire roller with too wide groove	Replace roller
advancing improperly	Obstructed or clogged liner	Extract it and clean
	Loose wire pressing roller.	Tighten it
	Coil reel friction too tight	Loosen and adjust it
	Current nozzle clogged	Replace it
The wire jams or entangles between the drive rolls and the torch infeed wire guide	Wrong current nozzle diameter	Replace it
	wrong roller groove alignment	Align it
	Obstructed or clogged sheath	Remove and clean

Note: All repair work must be done by qualified personnel.

Disconnect the power input cable from the mains supply before replacing cables or before removing the unit covers. The machine is equipped with a thermostat that shuts the machine down when the power source overheats. After the thermostat intervenes, let the power source cool down for several minutes before resuming welding operations.

The troubleshooting table lists troubles, causes and remedies for those troubles that occur most commonly.

8 WELDING MACHINE SERVICING

Experience has shown that many fatal accidents originated from servicing improperly executed. For this reason, a careful and thorough inspection on a serviced welding machine is just as important as one carried out on a new welding machine.

Furthermore, in this way producers can be protected from being held responsible for defects stemming from repairs not carried out by the manufacturer.

8.1 Prescriptions to follow for servicing

After rewinding the transformer or the inductance, the welding machine must pass the applied-voltage test in accordance with indications of the international standard.

If the servicing is not done by the manufacturers, the repaired welding machines which underwent replacements or modifications of any component shall be marked in a way such that the identity of the person having serviced it is clear.

After making repairs, take care to re-order the cables so that there is sure to be insulation between the primary and secondary sides of the machine. Make sure that the wires cannot come into contact with moving parts or parts that heat during operation. Replace all clamps in their original positions on the machine, to prevent a connection between the primary and secondary circuits if a conductor accidentally breaks or disconnects.

9 DESCRIPTION OF CONTROLS

9.1 CONTROLS ON GENERATOR FRONT PANEL

A: Rotary weld voltage switch:

This switch adjusts the weld voltage range.

B: Rotary weld voltage switch:

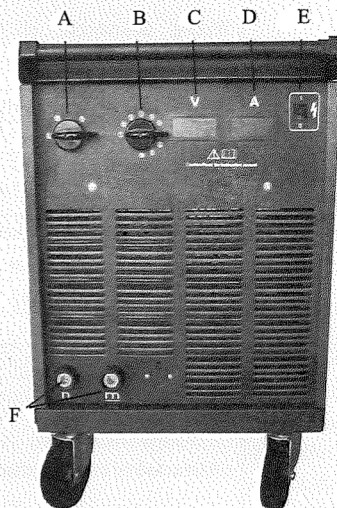
This switch allows the fine tuning of the welding voltage selected with switch G. (Step adjustment) Some model without the Function.

C: Voltmeter (optional)

D: Ammeter (optional)

E: Power switch

F: Quick connector for work return lead
(some model the quantity is different)



9.2 CONTROLS ON GENERATOR REAR PANEL

A: Power fuse

B: Support for cylinder

C: Input power cable (Confirm the power voltage before use)

D: Cooling fan

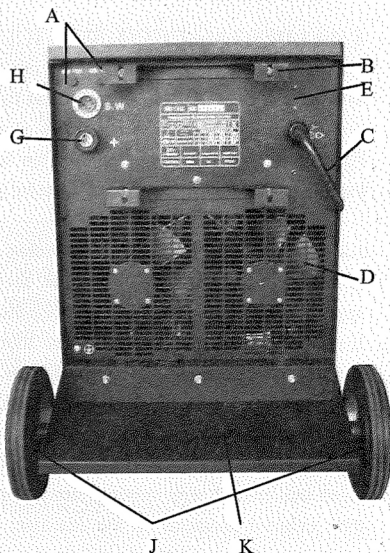
E: Socket for heater of regulator (optional)

G: Welding Output connector (some model on front panel)

H: Control socket (some model on front panel)

J: Back fixed Wheel (optional)

K: Cylinder tray (optional)



9.3 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.

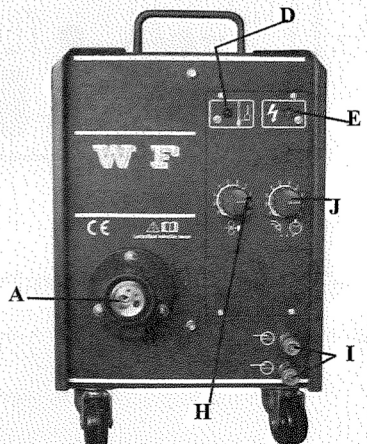
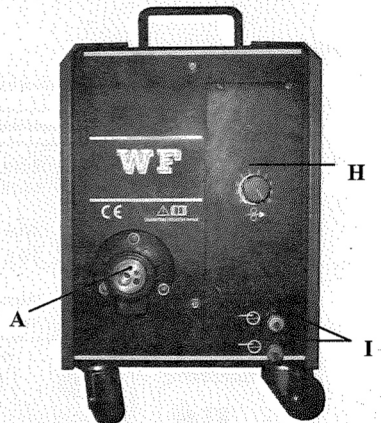
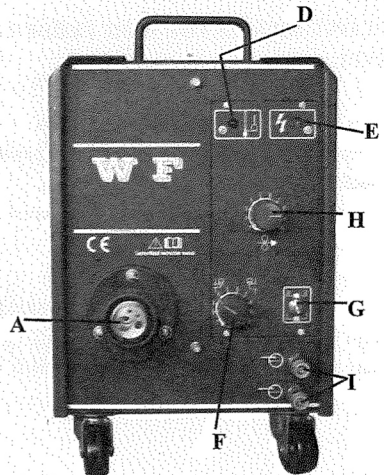
This knob adjusts the wire feed speed.

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.)



9.4 CONTROLS ON THE WIRE FEEDER REAR PANEL

L-Gas hose fitting for extension gas hoses.

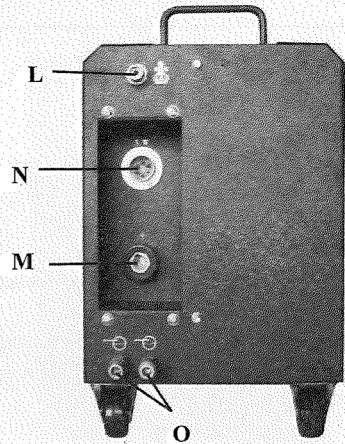
M - 6-pin socket connector for 6-pin plug connector

N-Socket for extension power supply plug.

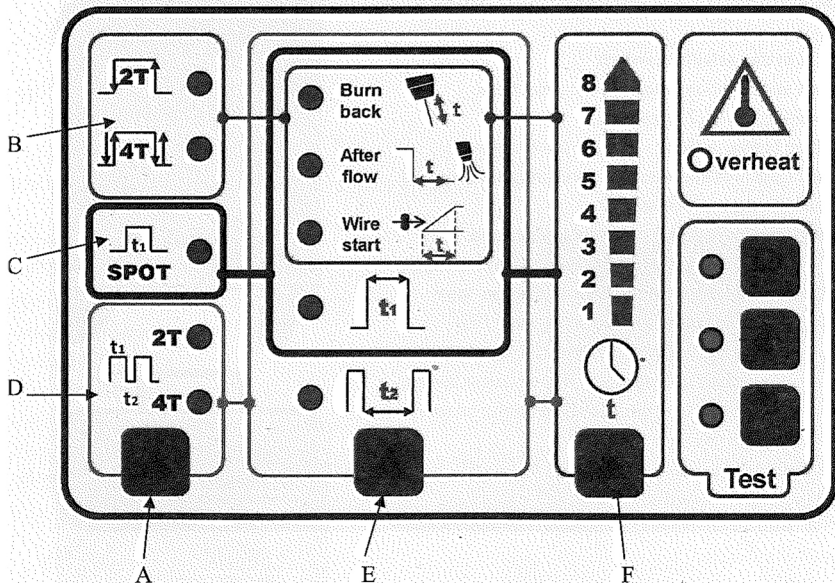
O - Quick-fit hose connectors for connection to extension water hoses.

Important: These connectors are colour-coded for safety.

Ensure that hose and connector colours match.



9.5 Digital Control description



A---Trigger Function Selection: Three modes to select

B---Normal welding mode  ---normal welding 2T mode (non-latching)

 ---normal welding 4Tmode (latching)

C---Spot welding mode

D---Stitch welding mode ☐ **2T**  ---Stitch welding 2Tmode

4T  ---Stitch welding 4Tmode

E---Parameter setting

Please note the wire frame on the panel:

RED frame for normal MIG welding modes

BLACK frame for Spot welding modes

GREEN frame for Stitch welding modes

 ---burn back ☐  ---gas after flow ☐  ---wire start

t1---Welding time for 撈pot?or 撈titch ON?operation.

t2---Welding time for 撈titch OFF?operation.

F---Welding time setting

The higher the number, the longer the time for function selected.

 **Overheat** ---Overheat warning. Machine will auto-reset after cooling period and light will go off.

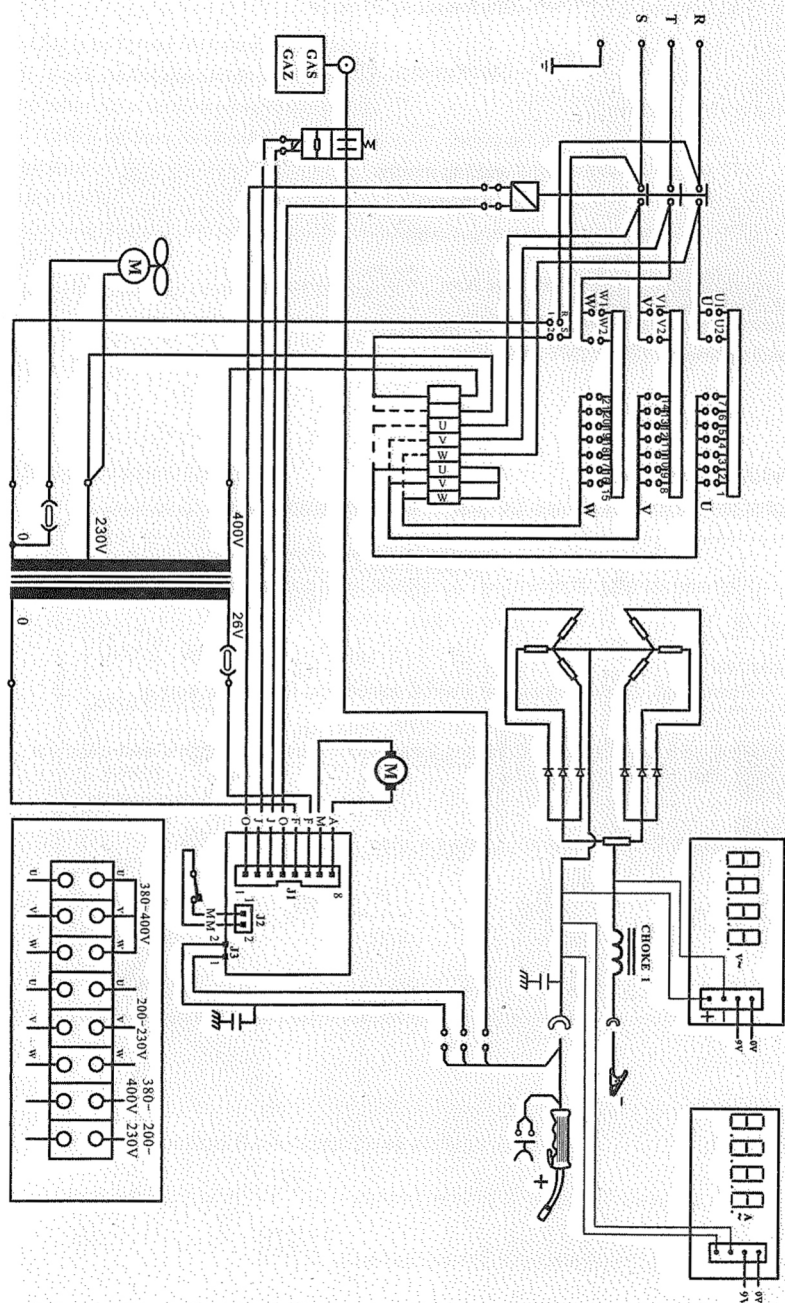
 **P**
ower ---Power test. Confirms machine is wired correctly to line power supply.

 ---Fast wire feeding test. Confirms wire feed motor is functional and used for set-up.

 ---Gas test. Confirms shield gas input system is functional.

ILLUSTRATION OF WORKING PRINCIPLE

2932



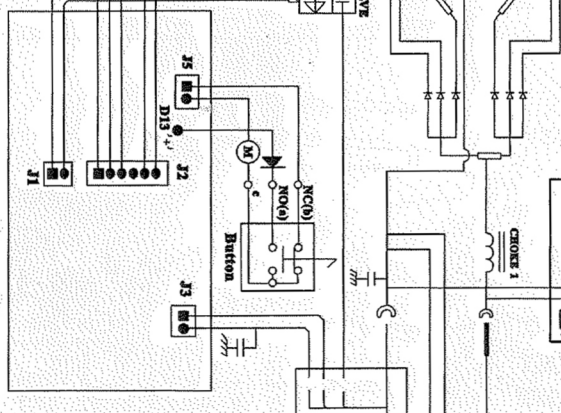
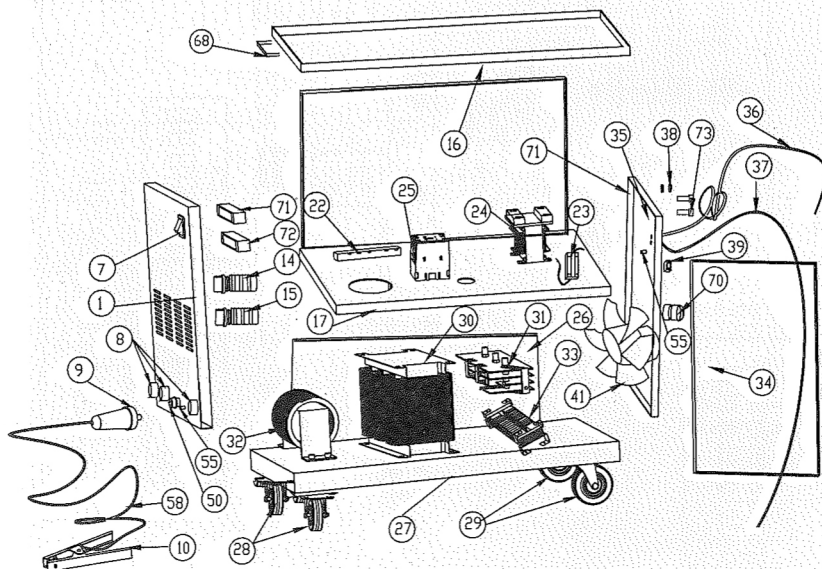


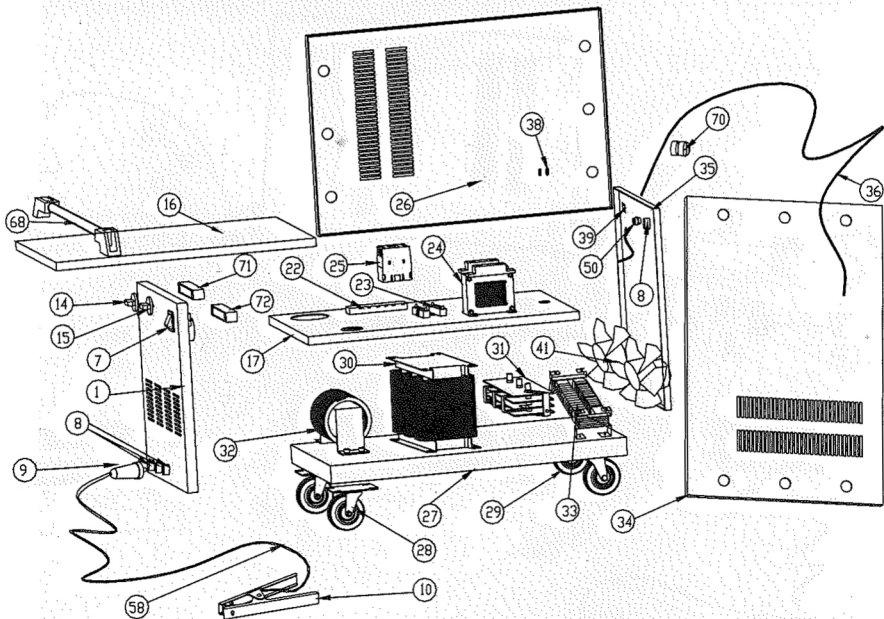
ILLUSTRATION OF EXPLODED

2932

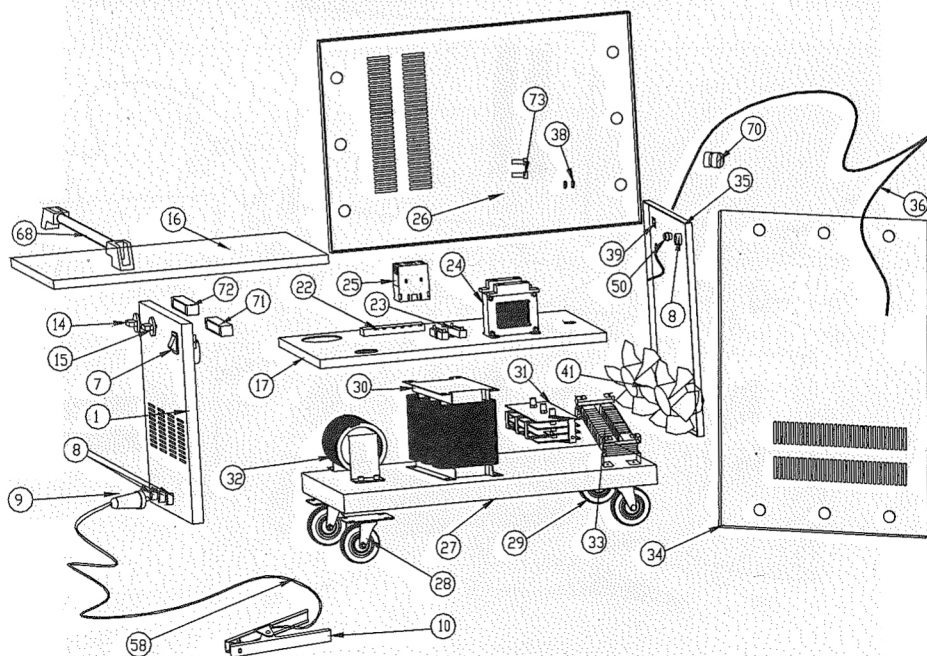
NO.	Code	Description	NO.	Code	Description
1	EW055719-4-1	front panel	32	WA055003	inductance
7	KE055004	power switch	33	WB055000	balance reactance
8	JC055016	quick socket	34	EW055085	right panel
9	JC055018	quick plug	35	EW055719-1-2	back panel
10	JA055003	earth clamp	36	XE073000	power cord
14	KC055005	steps switch(3 Steps)	37	SD055001	gas pipe
15	KC072000	steps switch (4 Steps)	38	DG063001-E	power fuse
16	EW055081	top tray	39	JG055003	heating socket
17	EW055082	inside baffle	40	BF055011	solenoid valve
22	JK055000	terminal board	41	MF055002-2	fan
23	RD055022	resistor 2W 50Ω	50	JG055000	control socket
24	VC055002	control transformer	55	JC055002	gas connector
25	KB055008	magnetic switch	58	XC055002	work return lead
26	EW055083	left panel	68	SC055003	handle
27	EW055084	bottom board	70	SE055004	gland
28	SG055000	front swivel caster	71	BA055000	ammeter
29	SG055001	back fixed wheel	72	BB055000	voltmeter
30	VM055006-2	main transformer	73	DG063001-E	fuse-holder
31	AA055003	rectifier			



NO.	Code	Description	NO.	Code	Description
1	EW055744-5-1	front panel	30	VM064004	main transformer
7	KE055004	power switch	31	AA055006	rectifier
8	JC055016	quick socket	32	WA055007	inductance
9	JC055018	quick plug	33	WB072002	balance reactance
10	JA055004	earth clamp	34	EW055125	right panel
14	KC055004	steps switch(3 Steps)	35	EW055744-2-1	back panel
15	KC055003	steps switch (10 Steps)	36	XF055000	power cord
16	EW055744-2-5	top tray	38	DG055005	power fuse
17	EW055122	inside baffle	39	JG055003	heating socket
22	JK055002	terminal board	41	MF055002-2	fan
23	RD055004	resistor 2W50Ω	50	JG055000	control socket
24	VC055003	control transformer	58	XC055003	work return lead
25	KB055008	magnetic switch	68	SC055003	handle
26	EW055123	left panel	70	SE055005	gland
27	EW055744-2-2	bottom board	71	BA055000	ammeter
28	SG055000	front swivel caster	72	BB055000	voltmeter
29	SG055001	back fixed wheel	73	DG063001	power fuse holder



NO.	Code	Description	NO.	Code	Description
1	EW055771-1-8	front panel	30	VM064006	main transformer
7	KE055004	power switch	31	AA064000	rectifier
8	JC055017	ground socket	32	WA055007	inductance
9	JC055019	ground plug	33	WB072002	balance reactance
10	JA055005	earth clamp	34	EW055155	right panel
14	KC055004	steps switch(coarse)	35	EW055771-1-1	back panel
15	KC055003	steps switch (fine)	36	XF055001	power cord
16	EW055771-1-5	top tray	38	DG063002-E	power fuse
17	EW055152	inside baffle	39	JG063000	heating socket
22	JK055002	terminal board	41	MF055002-2	fan
23	RD055022	resistor 2W50Ω	50	JG055000	control socket
24	VC064003	control transformer	58	XC055003	work return lead
25	KB055008	magnetic switch	68	SC074000-E	handle
26	EW055153	left panel	70	SE055005	gland
27	EW055771-1-2	bottom board	71	BA055001	ammeter
28	SG064009	front swivel caster	72	BB055000	voltmeter
29	SG073000	back fixed wheel	73	DG063001-E	power fuse holder



NO.	Code	Description	NO.	Code	Description
1	EW055771-1-8	front panel	28	SG064009	front swivel caster
4	SE055001	wire speed knob	29	SG073000	back fixed wheel
7	KE055004	power switch	30	VM064005	main transformer
8	JC055017	ground socket	31	AA055017	rectifier
9	JC055019	ground plug	32	WA055009-1	inductance
10	JA055005	earth clamp	33	WB055005-1	balance reactance
14	KC064003	3 steps switch(coarse)	34	EW055155	right panel
15	KC064004	10 steps switch (fine)	35	EW055771-1-1	back panel
16	EW055771-1-5	top tray	36	XF055001	power cord
17	EW055152	inside baffle	38	DG063002-E	power fuse
20	SG055009-1	wire support	39	JG055003	heating socket
22	JK055002	terminal board	41	MF055002-2	fan
23	RD055022	resistor 2W 50Ω	58	XC055005	work return lead
24	VC055003	control transformer	59	BA055000	ammeter
25	KB055009	magnetic switch	60	BB055000	voltmeter
26	EW055153	left panel	68	SC074000	handle
27	EW055771-1-2	bottom board	70	SE055005	gland
			73	DG063001-E	fuse-holder

