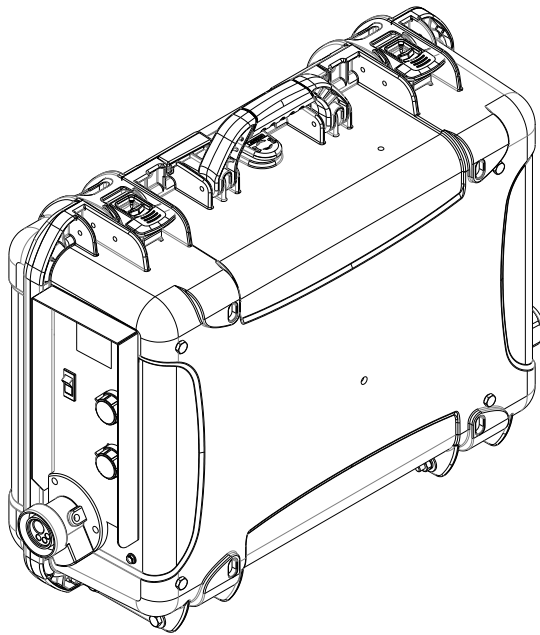


COMPARC™

S - 512P CV

VOLTAGE-SENSING WIRE FEEDER



PROCESSES



MIG (GMAW)

FLUX CORED (FCAW)



READ THE MANUAL BEFORE OPERATING THE UNIT




GIVE THIS MANUAL TO THE OPERATOR


OWNER'S MANUAL

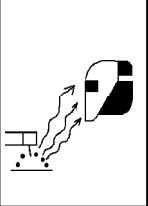
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SECTION 1 - SAFETY PRECAUTIONS - READ BEFORE USING

	<h2>WARNING</h2>	<h2>ARC WELDING can be hazardous.</h2>
<p>- DANGER! - Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text</p> <p>- Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.</p> <p>- The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards.</p> <p>- Only qualified persons should install, operate, maintain, and repair this unit.</p> <p>- During operation, keep everybody, especially children, away.</p>		

	<h3>ELECTRIC SHOCK can kill.</h3> <p>Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.</p>	<ol style="list-style-type: none"> 1.- Do not touch live electrical parts. 2.- Wear dry, hole-free insulating gloves and body protection. 3.- Insulate yourself from work and ground using dry insulating mats or covers. 4.- Disconnect input power or stop engine before installing or servicing this equipment. 5.- Properly install and ground this equipment according to this Owner's Manual and national, state, and local codes. 6.- Turn off all equipment when not in use. 7.- Do not use worn, damaged, undersized, or poorly spliced cables. 8.- Do not wrap cables around your body. 9.- Ground the workpiece to a good electrical (earth) ground. 10.- Do not touch electrode while in contact with the work (ground) circuit. 11.- Use only well-maintained equipment. Repair or replace damaged parts at once. 12.- Wear a safety harness to prevent falling if working above floor level. 13.- Keep all panels and cover securely in place.
---	--	---

	<h3>ARC RAYS can burn eyes and skin; NOISE can damage hearing.</h3> <p>Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin. Noise from some processes can damage hearing.</p>	<ol style="list-style-type: none"> 1.- Wear a welding helmet fitted with a proper shade of filter (see ANSIZ49.1 listed in Safety Standards) to protect your face and eyes when welding or watching. 2.- Wear approved safety glasses. Side shields recommended. 3.- Use protective screens or barriers to protect others from flash and glade; warn others not to watch the arc. 4.- Wear protective clothing made from durable, flame- resistant material (wool and leather) and foot protection. 5.- Use approved ear plugs or ear muffs if noise level is high.
---	--	--

	<h3>FUMES AND GASES can be hazardous to your health.</h3> <p>Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.</p>	<ol style="list-style-type: none"> 1.- Keep your head out of the fumes. Do not breath the fumes. 2.- If inside, ventilate the area and / or use forced ventilation at the arc to remove welding fumes and gases. 3.- If ventilation is poor, use an approved air-supplied respirator. 4.- Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instruction for metal, consumables, coatings, and cleaners. 5.- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Shielding gases used for welding can displace air causing injury or death. Be sure the breathing air is safe. 6.- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases. 7.- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.
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	<h3>FLYING SPARK AND HOT METAL can cause injury</h3> <p>Chipping and grinding cause flying metal . As welds cool, they can throw off slag.</p>	<ol style="list-style-type: none"> 1.- Wear approved face shield or safety goggles. Side shields recommended. 2.- Wear proper body protection to protect skin.
---	--	--



WELDING can cause fire or explosion.

Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.

- 1.- Protect yourself and others from flying sparks and hot metal.
- 2.- Do not weld where flying sparks can strike flammable material.
- 3.- Remove all flammables within 35ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.

- 4.- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- 5.- Watch for fire, and keep a fire extinguisher nearby.
- 6.- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- 7.- Do not weld on closed containers such as tanks or drums.
- 8.- Connect work cable to the work as close to the welding areas as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock and fire hazards.
- 9.- Do not use welder to thaw frozen pipes.
- 10.- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- 11.- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.



CYLINDERS can explode if damaged.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- 1.- Protect compressed gas cylinders from excessive heat, mechanical shocks, and arcs.
- 2.- Install and secure cylinders in an upright position by chaining them to a stationary support or equipment cylinder rack to prevent falling or tipping.
- 3.- Keep cylinders away from any welding or other electrical circuits.

- 4.- Never allow a welding electrode to touch any cylinder.
- 5.- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- 6.- Turn face away from valve outlet when opening cylinder valve.
- 7.- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- 8.- Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.



WARNING

ENGINES can be hazardous.



ENGINE EXHAUST GASES can kill.

Engines produce harmful exhaust gases.
1.- Use equipment outside in open, well-ventilated areas.

- 2.- If used in a closed area, vent engine exhaust outside and away from any building air intakes.



ENGINE FUEL can cause fire or explosion.

Engine fuel is highly flammable.

- 1.- Stop engine before checking or adding fuel.

- 2.- Do not add fuel while smoking or if unit is near any sparks or open flames.
- 3.- Allow engine to cool before fueling. If possible, check and add fuel to cold engine before beginning job.
- 4.- Do not overfill tank - allow room for fuel to expand.
- 5.- Do not spill fuel. If fuel is spilled, clean up before starting engine.



MOVING PARTS can cause injury.

Moving parts, such as fans, rotors, and belts can cut fingers and hands and catch loose clothing.

- 1.- Keep all doors, panels, covers, and guards closed and securely in place.
- 2.- Stop engine before installing or connecting unit.
- 3.- Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.


- 4.- To prevent accidental starting during servicing, disconnect negative (-) battery cable from battery.
- 5.- Keep hands, hair, loose clothing, and tools away from moving parts.
- 6.- Reinstall panels or guards and close doors when servicing is finished and before starting engine.




SPARKS can cause BATTERY GASES TO EXPLODE; BATTERY ACID can burn eyes and skin.


Batteries contain acid and generate explosive gases.
1.- Always wear a face shield when working on a battery.
2.- Stop engine before disconnecting or connecting battery


- 3.- Do not allow tools to cause sparks when working on a battery.
- 4.- Do not use welder to charge batteries or jump start vehicles.
- 5.- Observe correct polarity (+ and -) on batteries.


	<p>STEAM AND PRESSURIZED HOT COOLANT can burn face, eyes, and skin.</p> <p>The coolant in the radiator can be very hot and under pressure.</p>	<p>1.- Do not remove radiator cap when engine is hot. Allow engine to cool.</p> <p>2.- Wear gloves and put a rag over cap area when removing cap.</p> <p>3.- Allow pressure to escape before completely removing cap.</p>
---	---	---


- Additional Symbols For Installation, Operation, And Maintenance


	<p>NOISE can damage hearing.</p> <p>Noise from some processes or equipment can damage hearing.</p> <ul style="list-style-type: none"> - Wear approved ear protection if noise level is high. 	
---	--	--

	<p>FALLING EQUIPMENT can injure</p> <ul style="list-style-type: none"> - Use lifting eye to lift unit and properly installed accessories only, NOT gas cylinders. Do not exceed maximum lift eye weight rating (see Specifications). 	<ul style="list-style-type: none"> - Use equipment of adequate capacity to lift and support unit. - If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit. - Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
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
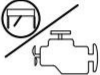













	<p>OVERUSE can cause OVERHEATING</p> <ul style="list-style-type: none"> - Allow cooling period; follow rated duty cycle. - Reduce current or reduce duty cycle before starting to 	<p>weld again.</p> <ul style="list-style-type: none"> - Do not block or filter airflow to unit.
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	<p>STATIC (ESD) can damage PC boards.</p> <ul style="list-style-type: none"> - Put on grounded wrist strap BEFORE handling boards or parts. - Use proper static-proof bags and boxes to store, move, or ship PC boards. 	
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	<p>ARC WELDING can cause interference.</p> <ul style="list-style-type: none"> - Electromagnetic energy can interfere with sensitive electronic equipment such as microprocessors, computers, and computer-driven equipment such as robots. - Be sure all equipment in the welding area is electromagnetically compatible. <p>- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.</p>	<ul style="list-style-type: none"> - Locate welding operation 100 meters from any sensitive electronic equipment. - Be sure this welding machine is installed and grounded according to this manual. - If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.
---	---	--




	<p>-Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.</p>	
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- Definitions

	Stop Engine		Fast (Run, Weld/Power)		Fast/Slow (Run/Idle)		Slow (Idle)
	Start Engine		Read Operator's Manual	A	Amperes	V	Volts
	Engine Oil		Fuel		Battery (Engine)		Engine
	Temperature		Check Valve Clearance		Do not switch while welding		Work Connection
+	Positive	-	Negative		Alternating Current (AC)		Output
	Welding Arc (Electrode)		MIG (GMAW), Wire		Stick (SMAW)		TIG (GTAW)
h	Hours	s	Seconds		Time		Protective Earth (Ground)
	Circuit Protector						

SECTION 1 SAFETY SIGNAL WORDS

The following safety alert symbol and signal words are used throughout this manual to call attention to and identify different levels of hazard and special instructions.

	WARNING	WARNING statements identify procedures or practices which must be followed to avoid serious personal injury or loss of life.
	CAUTION	CAUTION statements identify procedures or practices which must be followed to avoid minor personal injury or damage to this equipment.
	CAUTION	Images shown in this manual must be taken as a reference and the real unit may change slightly.

IMPORTANT: Statements identify special instructions necessary for the most efficient operation of this equipment.

SECTION 2. SPECIFICATIONS

Specifications	Description
Type of input power:	1 Phase, 24 Vac, 3A, 50/60Hz.
Maximum current in the welding circuit:	100 Volts, 500 Amperes, 100% Duty Cycle.
Power Supply (Including Generators):	Constant Voltage (CV) DC,
Wire feeder speed range:	1.9 to 23 m/min (75 to 900 Plgs/min)
Range of cable diameters:	0.6 to 2.0 mm (0.023 to 5/64")
Welding Process:	Solid Wire (GMAW) and Flux Cored (FCAW).
Length of the unit's power cable:	4 mts. (13 Ft).
Dimensions:	Length: 21-1/2" (546mm); Width: 8-1/2" (216mm); Height: 17" (432mm).
Weight:	34 Lb (15,5 kg)

Table 2-1 Unit Specifications

SECTION 3 INSTALLATION

3-1 TYPICAL CONNECTIONS

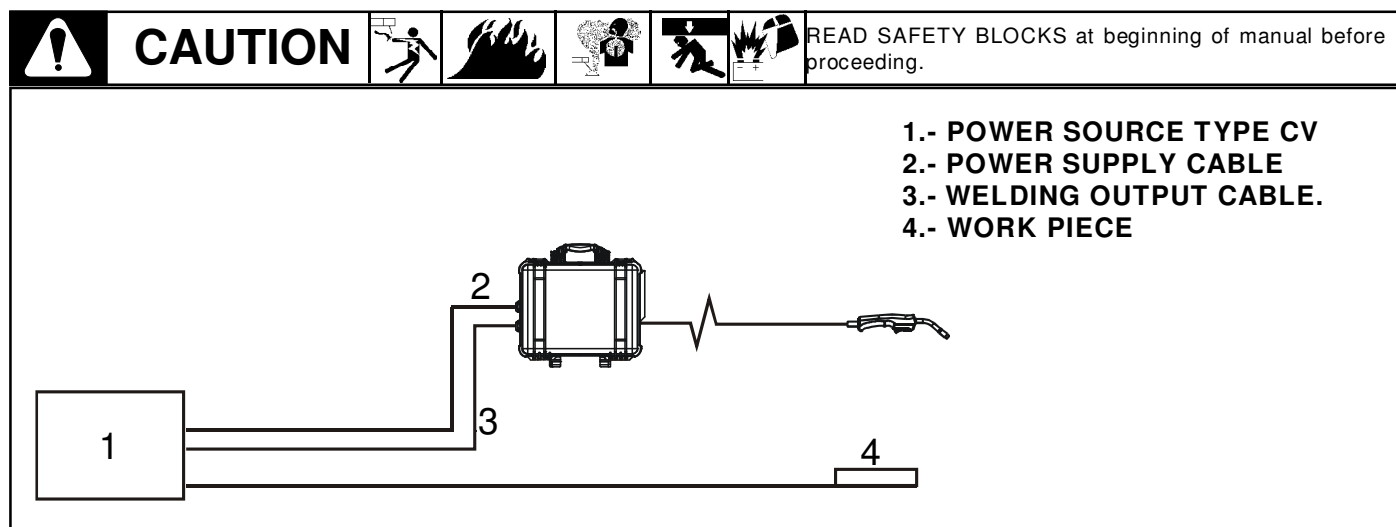


FIGURE 3-1 Typical Connections

3-2 WIRE FEEDER COMPONENTS



WARNING



ELECTRIC SHOCK can kill; ARCING can damage unit. MOVING PARTS can cause injury.

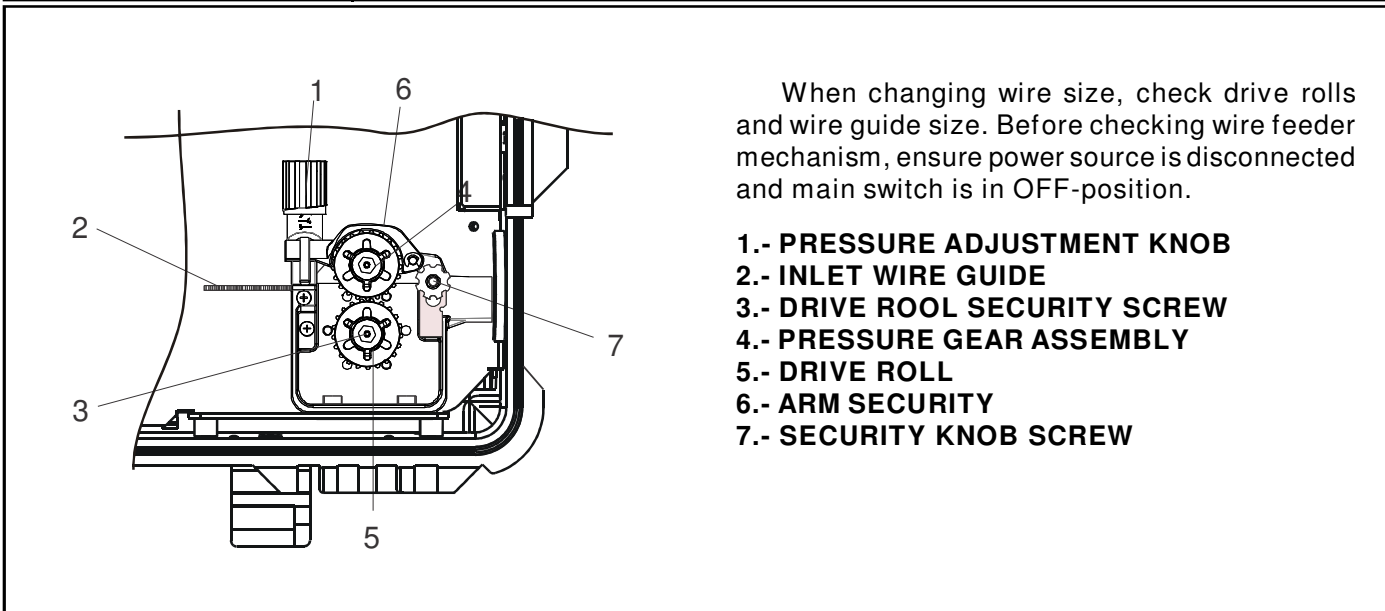


FIGURE 3-3 Gear Motor

3-3 WIRE FEEDER CONNECTIONS

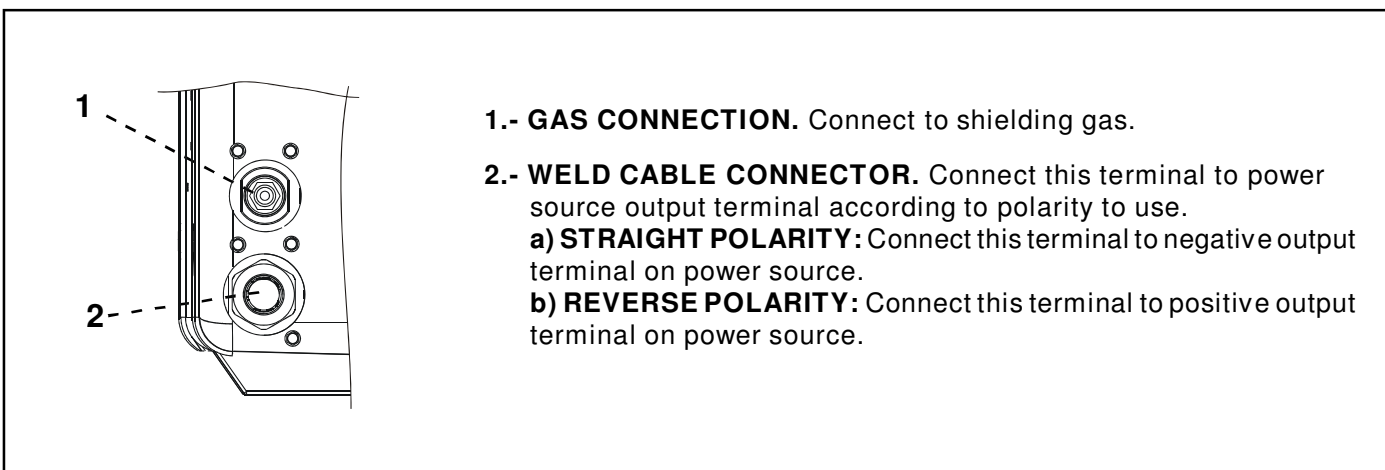
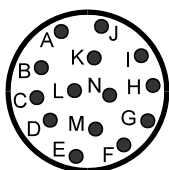



FIGURE 3-4 Wire Feeder, Rear View

3-4. CONNECTING 14-PIN PLUG



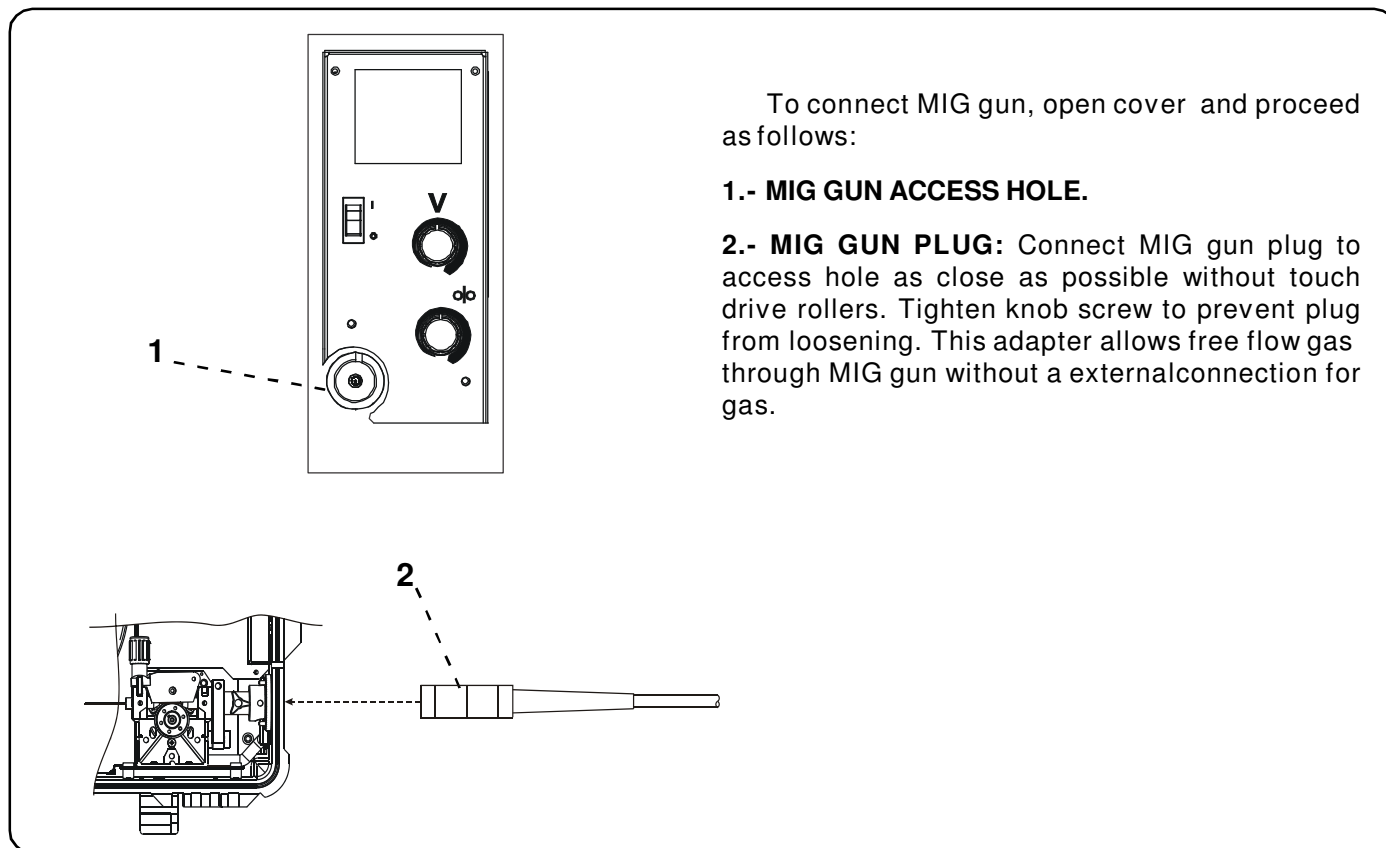
This PLG2 remote receptacle is a 14-contact "AMPHENOL" plug that provides a connection point between the wire feeder and the welding machine; it energizes the wire feeder and controls the machine's welding contactors through the switch on the torch trigger, as well as current and voltage feedback from the equipment's meters. To make connections, align the plug slot with the receptacle and insert and turn the threaded collar of the plug fully clockwise.

The remote receptacle is connected as follows:

REMOTE-14	Socket	INFORMATION
 OUTPUT (CONTACTOR)	A	24 V a.c. Protected by CB2 (10 Amperes).
	B	Contact closure to "A" completes 24 V a.c. contactor control circuit.
G N D	I	120 V a.c. Protected by CB1(10 Amperes).
	J	Contact closure to "I" completes 120 V a.c. contactor control circuit.
REMOTE OUTPUT CONTROL	G	Circuit common for 24 and 115 V a.c. circuits.
	K	Chassis common.
A / V	C	Command reference 10 V d.c.
	E	0 to +10 V d.c. input command signal from remote control.
	D	Remote control circuit common.
	F	Current feedback 1 V d.c. 1 Volt per 100 weld output Amperes.
	H	Voltage feedback 1 V d.c. 1 Volt per 10 weld output Volts

NOTE: Remaining sockets are not used

3-5 MIG GUN CONNECTIONS



To connect MIG gun, open cover and proceed as follows:

1.- MIG GUN ACCESS HOLE.

2.- MIG GUN PLUG: Connect MIG gun plug to access hole as close as possible without touch drive rollers. Tighten knob screw to prevent plug from loosening. This adapter allows free flow gas through MIG gun without a external connection for gas.

FIGURE 3-2 MIG Gun Connections

3-6. SPOOL WIRE INSTALLATION.

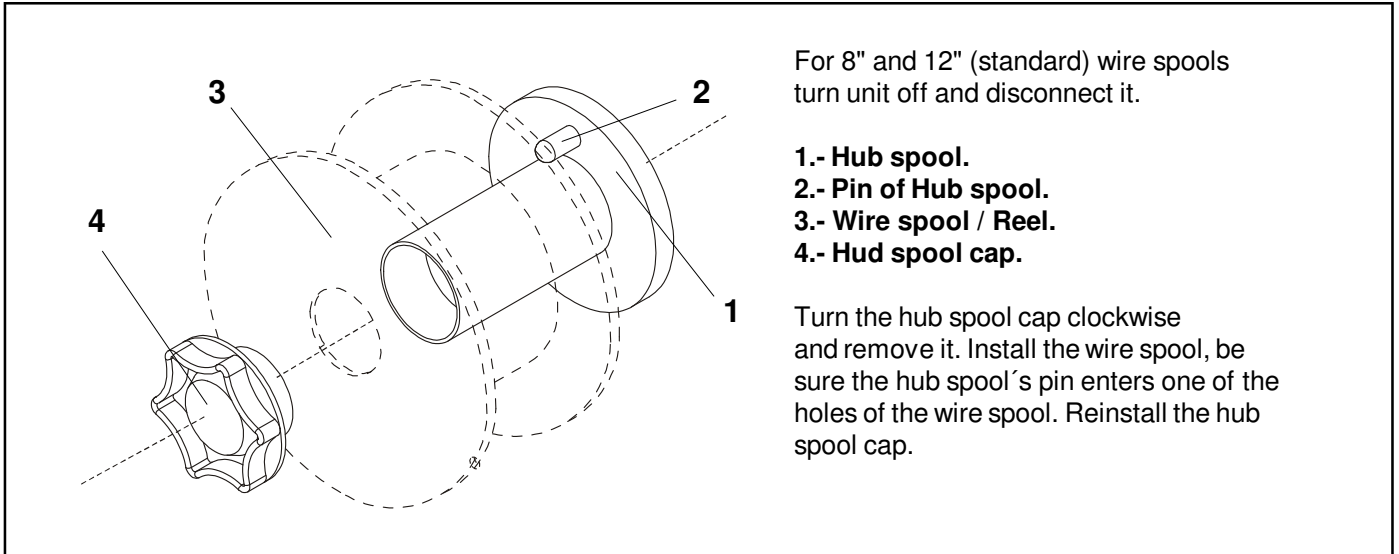


FIGURE 3-3 Spool Wire Installation.

3-7 GAS CONNECTIONS

	WARNING		CYLINDERS can explode if damaged. FUMES AND GASES can be hazardous to your health.
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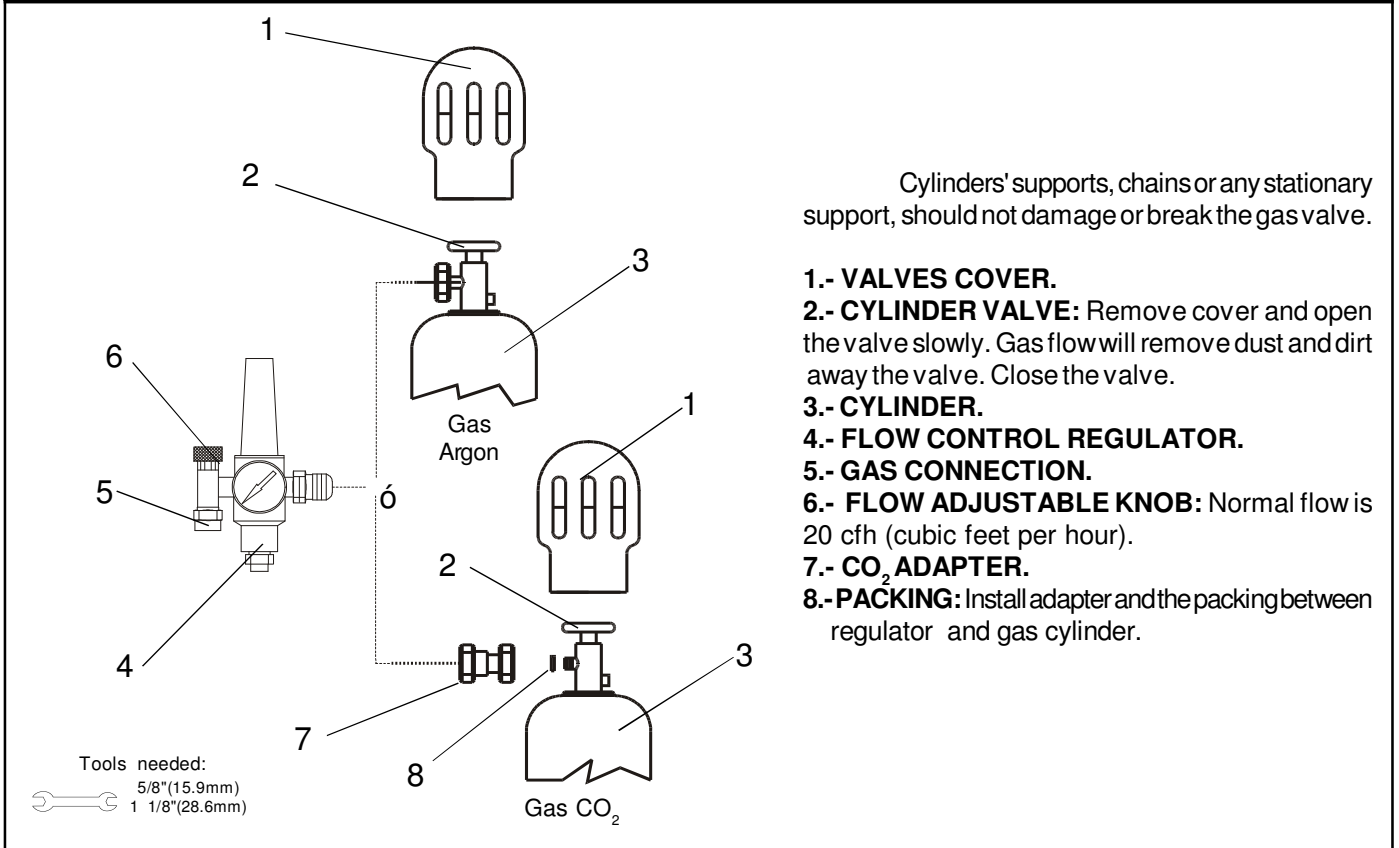


FIGURE 3-4 Gas Connections

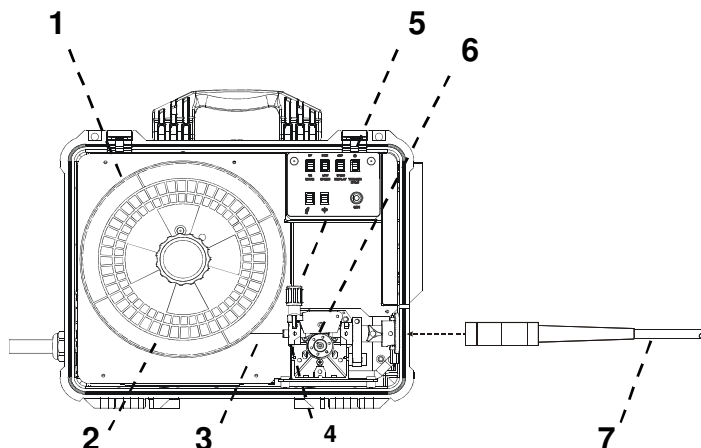
3-8 WELDING WIRE INSTALLATION



WARNING



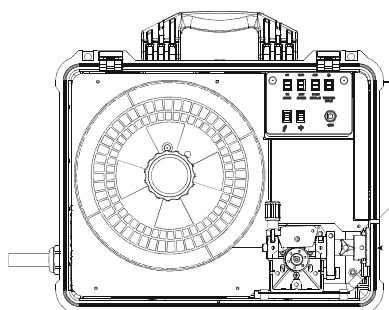
SEE SAFETY PRECAUTIONS at the beginning of manual for basic welding information.



- 1.- WIRE SPOOL
- 2.- WELDING WIRE
- 3.- WELDING WIRE ACCESS
- 4.- INLET WIRE GUIDE
- 5.- PRESSURE ADJUSTMENT KNOB
- 6.- DRIVE ROLL
- 7.- GUN CONDUIT CABLE

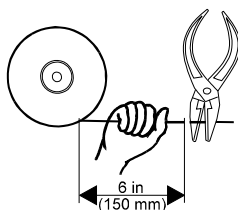


Hold wire tightly to keep it from unraveling.

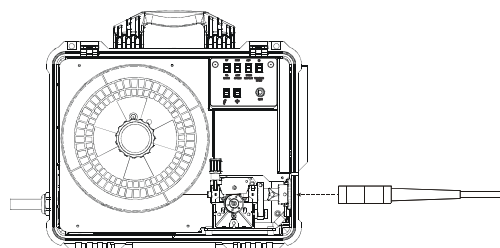


Open pressure gear assembly.

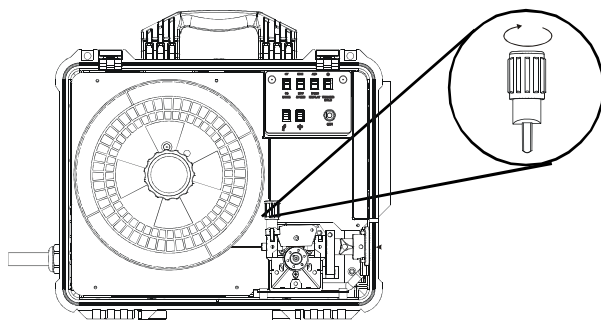
Pull to Release



Pull and hold wire; cut off end.

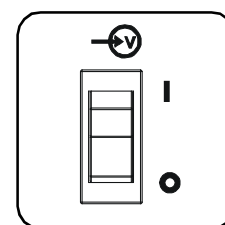


Push wire through guides into gun; continue to hold wire.

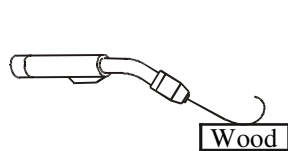


Once wire is in inlet guides, close, latch and tighten pressure gear assembly and let go of wire.

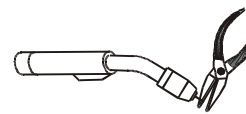
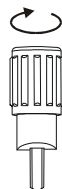
Assure the gun connector with the hasp and turn tightly security knob screw.



Turn on Wire Feeder



Feed wire to check drive roll pressure. Tighten knob enough to prevent slipping.



Cut off wire. Close and latch door.

SECTION 4 CONTROLS

4-1 CONTROLS

CAUTION SEE SAFETY BLOCKS at beginning of manual before proceeding.

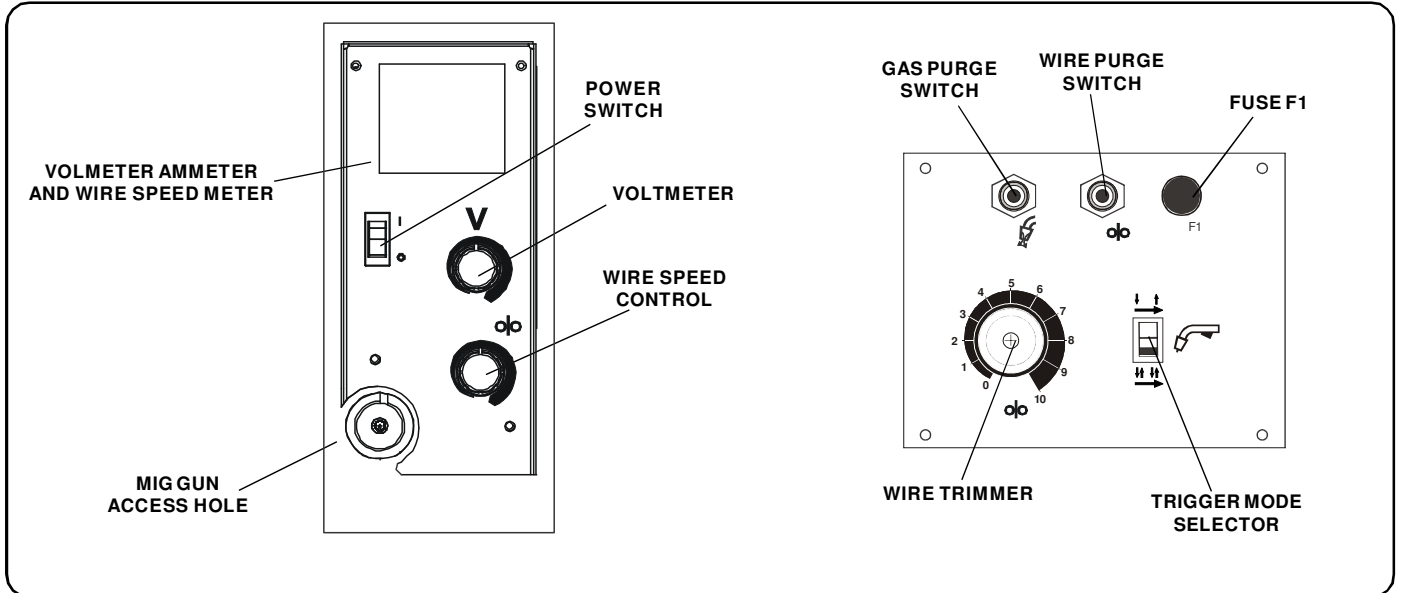


FIGURE 4-1 Controls

1- INSULATING GLOVES.
 2- SAFETY GLASSES WITH SIDE SHIELDS.
 3- WELDING HELMET.
 Wear dry insulating gloves, safety glasses with side shields, and a welding helmet with a correct shade of filter (see ANSI Z49.1).

FIGURE 4-2 Safety Equipment

1.- WORK CLAMP: Use wire brush or sandpaper to clean metal at weld joint area. Use chipping hammer to remove slag after welding. Connect work clamp to a clean, paint-free location on workpiece, as close to weld area as possible.

Tools needed:

FIGURE 4-3 Work Clamp

WARNING ELECTRIC SHOCK can kill. Do not touch electrical live parts. Do not touch weld receptacles while contactor is energized. Do not TOUCH electrode and work piece AT SAME TIME.

POWER SWITCH
 Use power switch to turn On/Off wire feeder.

FIGURE 4-4 Power Switch

WIRE SPEED CONTROL

Use this control to select wire speed within a range selected.

Turning control in clockwise sense wire speed will increase. The scale is calibrated in a percentage respect max. rated output (900plg/Min).

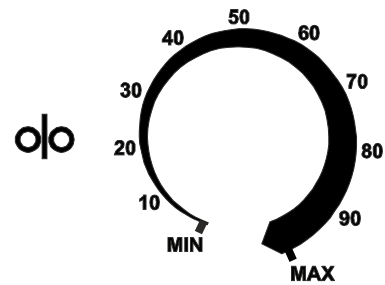
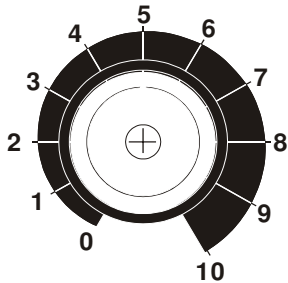


FIGURE 4-5 Wire Speed Control



BURNBACK TIME. This control enables to operator select the amount of time the electrode wire remains electrically hot after wire stops feeding. The correct burnback time allows wire to burn back just free of the weld puddle, if the burnback time is too long, wire could burn back into contact tube. Rotating the control clockwise increases time from 0 to 0.25 seconds. The control scale is calibrated in percent and does not indicate actual burnback time.

FIGURE 4-6. BURNBACK TIME.



1.- JOG BUTTON

Push and hold button to momentarily energize feed welding wire at speed set on wire speed control without energizing welding circuit of shielding gas valve.

FIGURE 4-7 JOG BUTTON



GAS PURGE BUTTON.

Push and hold button to momentarily energize gas solenoid and purge air from gun shielding gas regulator without energizing the welding circuit.

FIGURE 4-8 PURGE BUTTON



TRIGGER MODE SELECTOR. Use this control to select the desired trigger mode.

Select always one trigger mode:

1. **2T Trigger mode:** When trigger is depressed, weld starts. When trigger is released, weld stops.
2. **4T Trigger mode:** When trigger is depressed, weld starts. When trigger is released, weld remains. After depressing and releasing the trigger for the second time, weld stops.

FIGURE 4-9 TRIGGER MODE SELECTOR.

1-DIGITAL VOLTMETER.

It shows the output terminals voltage (in Volts) of the machine, but not necessarily the arc voltage, due to the resistance of the weld cables, loose connections, etc.

2-DIGITAL AMMETER.

It shows the weld current value in Amperes.

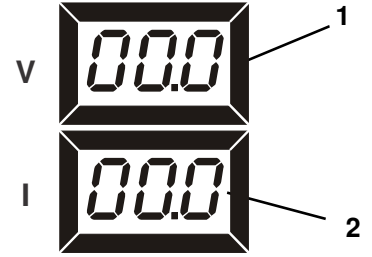


FIGURE 4-10. Voltmeter and Ammeter



**REMOTE VOLTAGE
ADJUSTMENT**

REMOTE VOLTAGE ADJUSTMENT

Use this control to set the arc voltage.

FIGURE 4-11. REMOTE VOLTAGE ADJUSTMENT

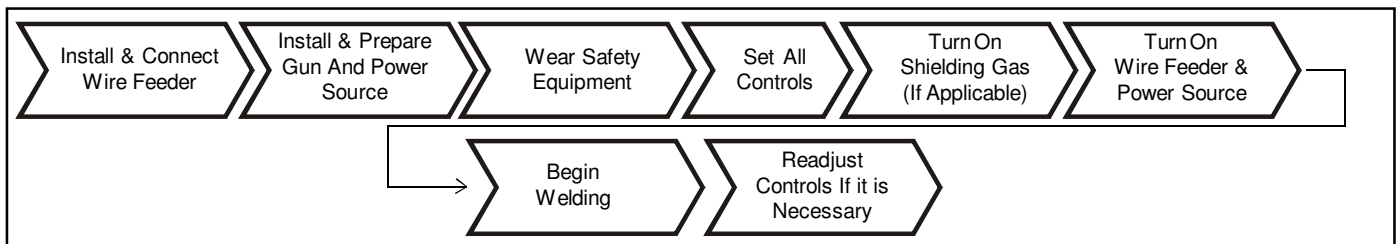






FIGURE 4-11 MIG Welding Procedure (GMAW) & Flux Cored Arc Welding (FCAW)

SECTION 5 MAINTENANCE & TROUBLESHOOTING

5-1 ROUTINE MAINTENANCE

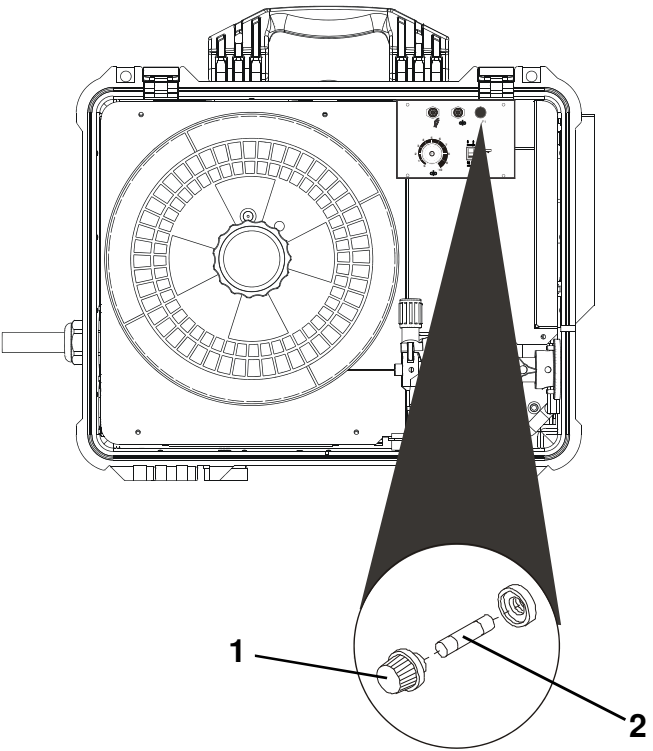
	WARNING	  	SEE SAFETY SIGNAL at the beginnig this manual.
TIME	MAINTENANCE		
Each 3 Months	Replace unreadable labels, clean and tighten weld terminals, tape or replace cracket weld cable, replace cracket parts (such as 14-pin cord, gas hose, cable gun), clean and tighten input/output terminals.		
Each 6 Months	Blow out or vacuum inside, during heavy service clean monthly, clean drive rolls.		

5-2 TROUBLESHOOTINGS

TROUBLE	PROBABLE CAUSE	REMEDY
WIRE FEEDER DOES NOT WORK	F1 Fuse.	Check F1 fuse and replace if necessary.
	Incorrect or wrong trigger connection.	Check trigger connections.
	Gun trigger.	See owner's manual of MIG gun.
	Motor.	Replace motor.
	PC1 control board.	Replace PC1.
ERRATIC WIRE FEED	Drive rolls pressure.	Readjust drive roll pressure by turning clock pressure assembly gear until getting required pressure.
	Incorrect drive rolls size according applications.	Change to correct size drive rolls.
	Worn drive rolls.	Replace drive rolls.
	Dirty drive rolls.	Cleand or replace drive rolls.
	PC1 control board.	Replace PC1.
WIRE DOES NOT BE FEEDED	Slags acumulation on MIG gun tip.	Remove carefully slags arround tip gun using wood, NEVER USE METALIC TOOLS.
WIRE DOES NOT BE FEEDED UNTIL TRIGGER IS PULLED, BUT CONTINUES TO FEED AFTER TRIGGER IS RELEASED	Check for short circuit between welding gun trigger leads and weld cable.	Replace gun. Reset CB1 and change F1 if necessary.
GAS VALVE IN FEEDER IS RATING LOUDLY ALONG WITH POSSIBLY ERRATIC OR SLOW WIRE FEED SPEED	Check for short circuit between welding gun trigger and weld cable.	Replace the gun. Restart CB1 and change F1 if necessary.

5-3 OVERLOAD PROTECTION

	WARNING				READ SAFETY BLOCKS at beginning of manual before proceeding.
--	----------------	--	--	--	--



Side view of feeder

DISCONNECT and turn off wire feeder and power source **BEFORE** proceed.

INAPPROPRIATE FUSES can damage unit. Be sure to select correct fuse size and capacity according amperage used.

- 1.- FUSE COVER.** Remove fuse cover.
- 2.- FUSE F1 (10 Amp.).** F1 fuse protects against overloads to wire feeder. If F1 opens, unit shutdown. Replace F1.

FIGURE 5-1 Overload Protection

5-4 CHANGING CONTACT TUBE


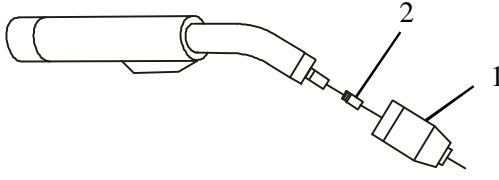
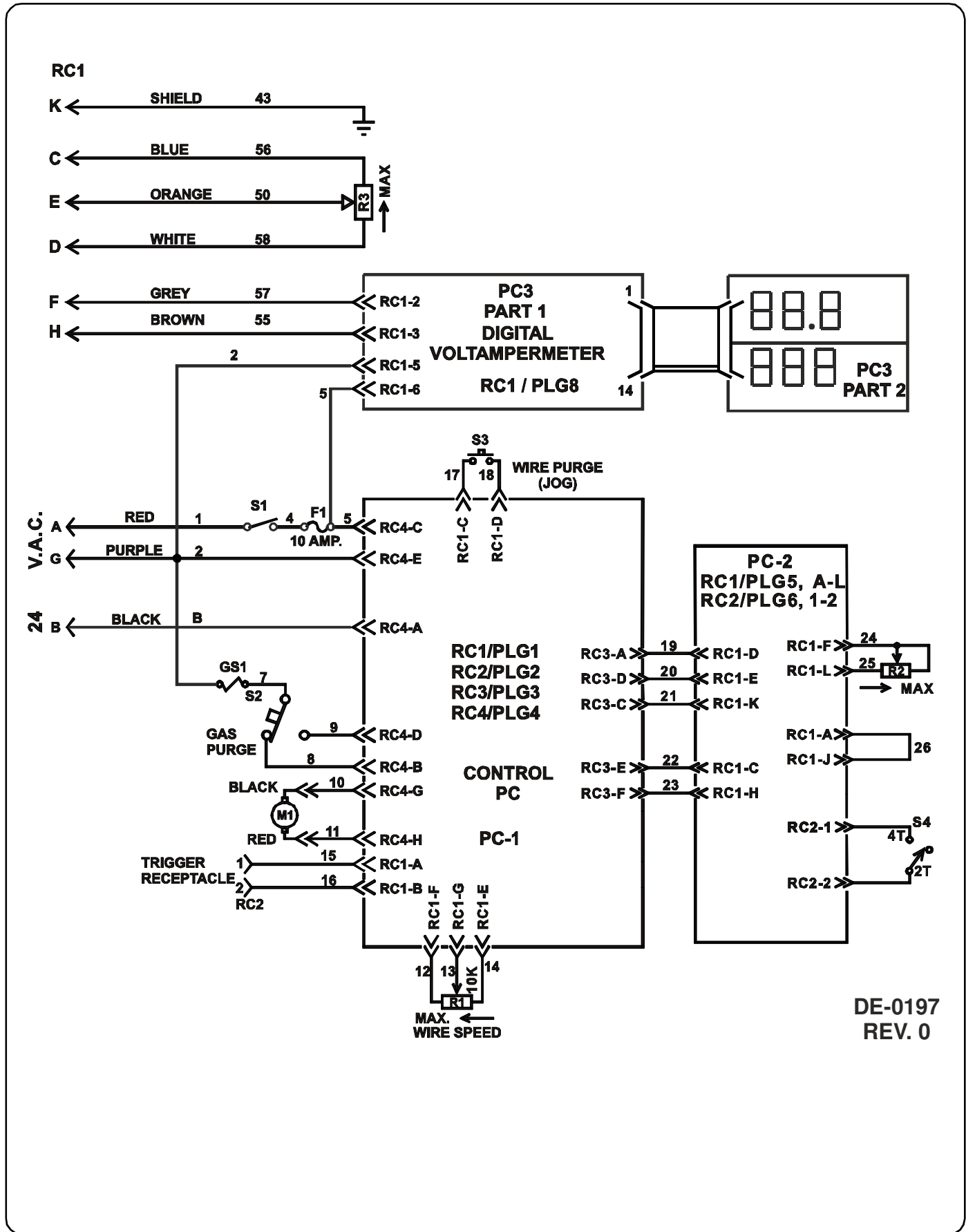
<p>Tools needed</p> 		<p>Turn off and disconnect the unit and welding power source.</p> <ol style="list-style-type: none">1.- NOZZLE.2.- CONTACT TIP. Cut wire remaining of the contact tip. Remove nozzle, remove the contact tip and install the new one. Reinstall nozzle.
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FIGURE 5-2 Changing Contact Tube

SECTION 6 ELECTRICAL DIAGRAM



DE-0197
REV. 0

SECTION 7 PARTS LIST

IT. No.	PART No.	DESCRIPTION	QUANTITY
1	PM1017	SUITCASE	1
2	PC2497	CHASSIS	1
3	PM1397	GEARMOTOR	1
4	PS1612	HUB SUPPORT	1
5	MP08414	HUB	1
6	MM04279	GAS HOSE	1
7	PA1056	GEARMOTOR INSULATOR	1
8	MS03964	WIRE TIE	1
9	PT1071	NUT OFF NYLAMID	1
10	MM04282	DYSPLAY FRAME	1
11	PT2566	COVER, COMPONENTS	1
12	PP3907	PLATE, INNER CONTROLS	1
13	PP3905	FRONT	1
14	PA0928	MALE INSULATOR	6
15	PA0929	ISOLATING FEMALE	8
16	PS1634	MOTORGEAR SEPARATOR	1
17	PS1636	MOTORGEAR SEPARATOR	1
18	MS03965	SQUARE BRA	14
19	PC1864	CABLE WELD	1
20	MS04004	STRAIN RELIEF BUSHING	1
21	PT2889	BACK COVER	1
22	MV00768	VALVE SOLENOID	1
23	MF02310	OVERLOAD PROTECTION. CONSISTING OF:	
	MF00819	FUSE 10A	1
	MP00014	FUSE HOLDER	1
24	MT08380	CIRCUIT CARD, CONTROL	1
25	MI01178	SWITCH 1P 1T	1
26	MI00665	SWITCH	2
27	MP02512	POTENTIOMETER	2
28	PC2137	EURO CONNECTOR	1
29	PT2287R	TIMER CARD	1
30	MP03020	POTENTIOMETER 2W	1
31	MP3020	KNOB	3
32	PT2609	DIGITAL VOLTAMMETER CARD	1
33	MI00665	SWITCH	1
34	PS1810	BUS BAR (NOT ILLUSTRATED)	1

LIST 7-1 Part List Wire Feeder

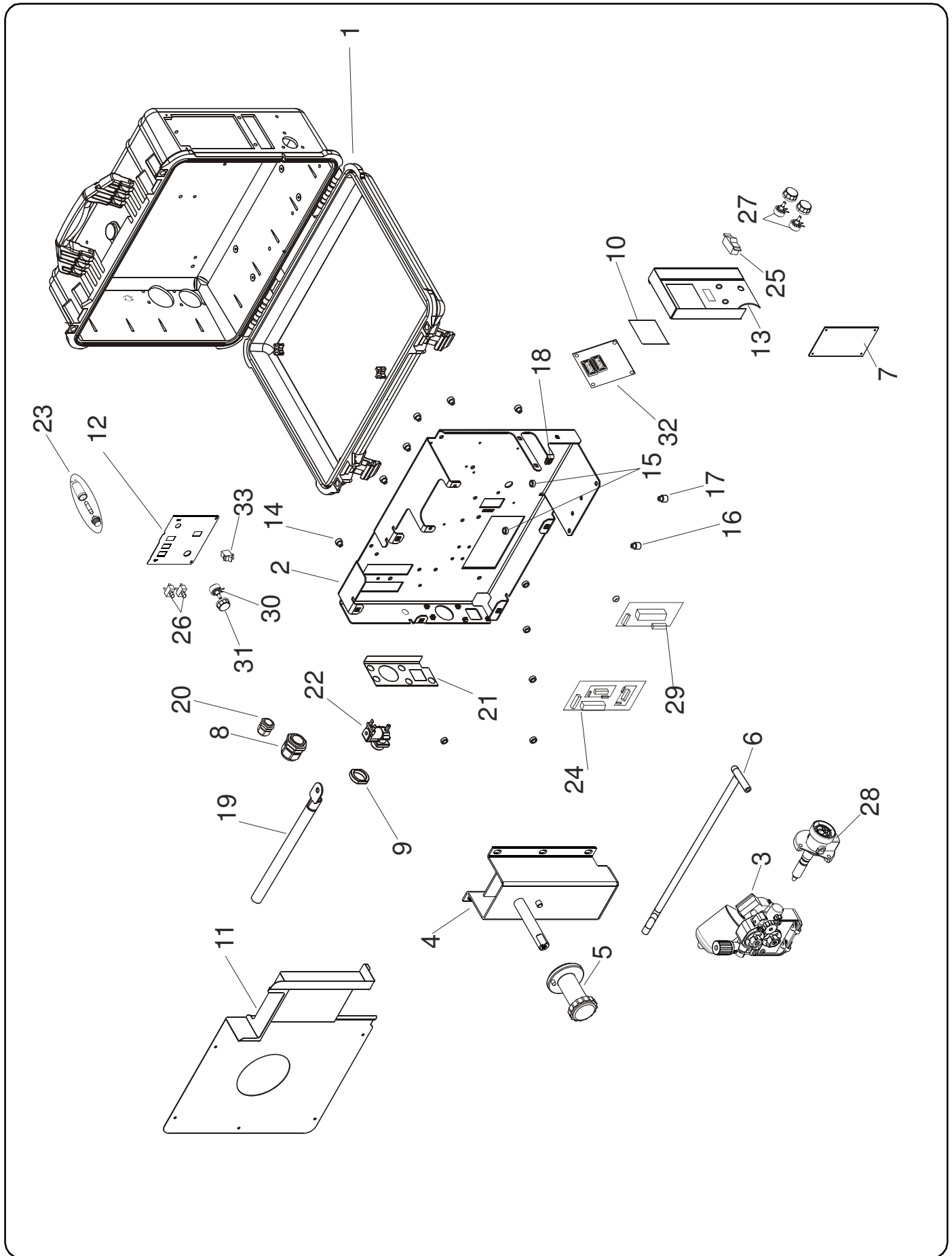


FIGURE 7-1 General Assembly

GUIDE TO INSTALL HEELS

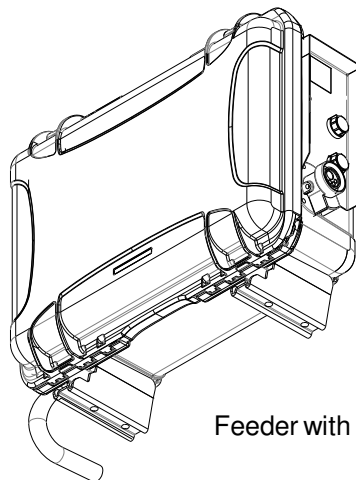
To install the heels on the case supports, read the following instruction.

Feeder offers the choice of using 2 heels to keep it balanced while the cover is opened.

If required this choice, proceed as next:

- a) Find front and rear heels.
- b) Set each heel to the base as the figure shows, using the appropriate screws.

- 1.- PR1177 Internal reinforcement (2 pieces)
- 2.- MT08699 Screw (4 pieces)
- 3.- PP4556 heel (2 pieces)



Feeder with heels placed

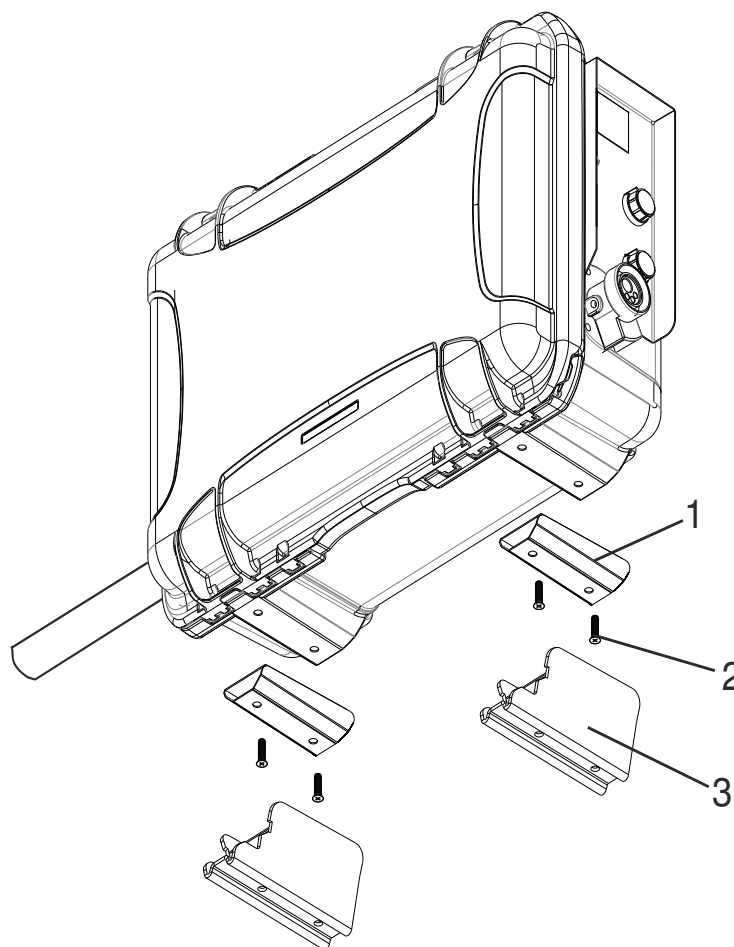


FIGURE 7-2 Heels Installation

LIST 7-2 Wire drive and gear

IT. No	PART No.	DESCRIPTION	QUANTITY
1	PB2303	Feed plate with groove	1
2	MB06011R	Arm compl (With central gear)	1
3	MF02408R	Shaft	1
4	MB06013R	Wire pressure knob	1
5	ME02417R	Drive gear	1
6	-----	Roll (Ask to your distributor)	2
7	MG02226R	Inlet guide tube	1
8	PP4429	Fix knob (Gun loking tab)	1
9	MT08685R	Fix bolt	1
10	MO00033	Opressor	1
11	ME02451	Moving arm central gear	1

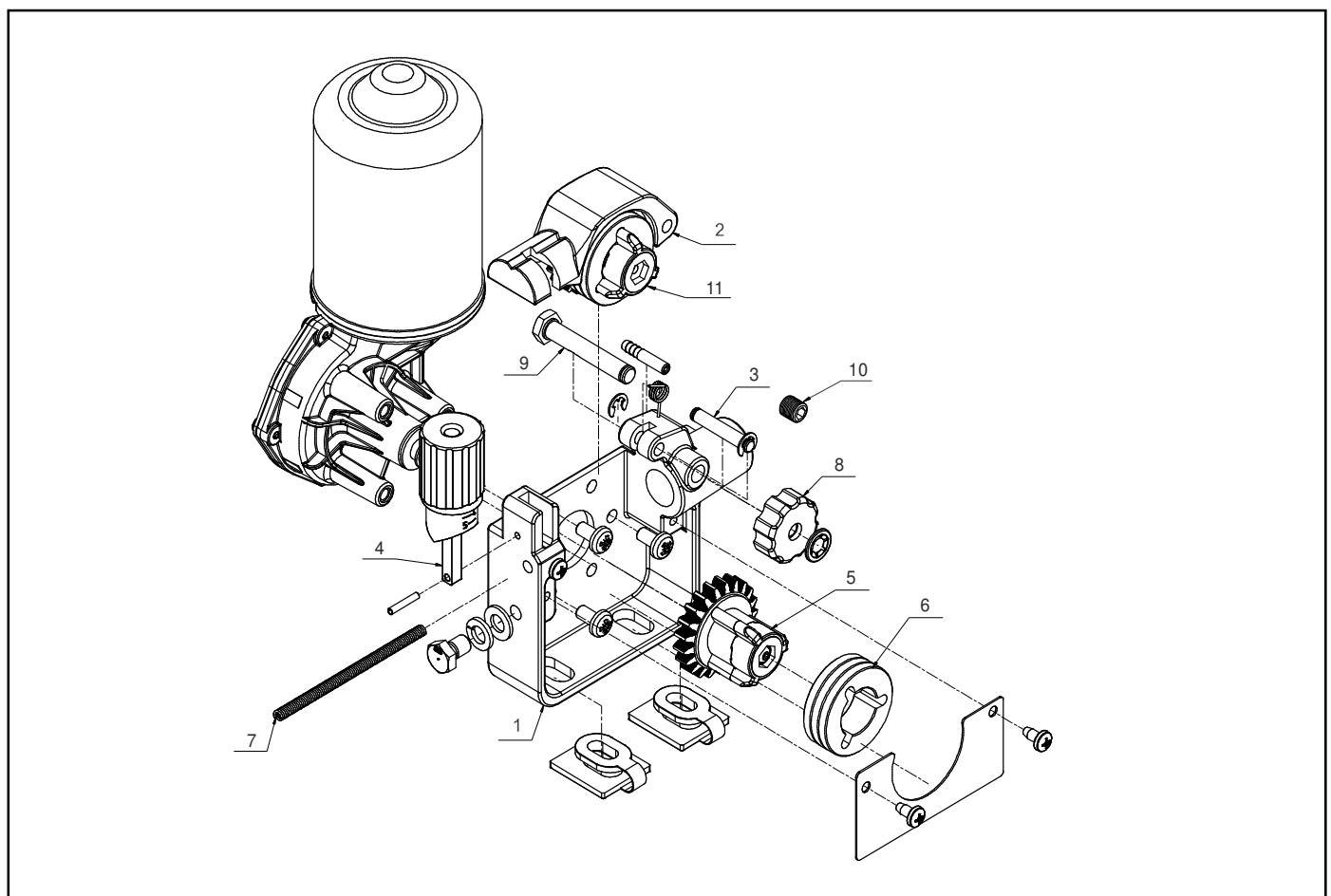


FIGURE 7-3 Wire drive and gear

WARRANTY POLICY

UNIFORM WARRANTY FOR SIISA MACHINES.

SOLDADORAS INDUSTRIALES INFRA, S.A. DE C.V. (SIISA), Warants his equipments (welding power sources, plasma cutting and accessories), from the delivery date to the customer within the warranty periods listed below, the manufacturer will repair or replace any warranted parts or components that fail due to such defects in material or workmanship on factory or service centers.

STATIC WELDING MACHINES AND PLASMA CUTTING

TRANSFORMER 3 YEARS

PORTABLE INVERTER TYPE WELDING MACHINES

PORTABLE INVERTER WELDING MACHINE 2 YEARS

ENGINE DRIVEN WELDING MACHINES

RANGE AND POLARITY SWITCH 1 YEAR

STATOR 3 YEARS

ROTOR 3 YEARS

KOHLER ENGINE 3 YEARS

(Manufacturer of engine "KOHLER" gives the warranty period).

ACCESSORIES

WIRE FEEDER (Wire feed Mechanism) 1 YEAR

TORCHES AND GUN TORCHES(MIG/TIG Process) 3 MONTHS

PLASMA CUTTING TORCHES 3 MONTHS

REMOTE CONTROL 3 MONTHS

WATTER RECYCLER 3 MONTHS

RECTIFIER 1 YEAR

CIRCUIT CARDS 3 MONTHS

ALL ELECTRICAL PARTS 30 DAYS

UNDER THE FOLLOWING CONDITIONS.

1°.- For making efective this warranty you should just have to show this policy with the product to the nearest service center or workshop throughout the country.

2°.- **SOLDADORAS INDUSTRIALES INFRA S.A. DE C.V.** warranty will be F.O.B. Factory at Naucalpan México, or F.O.B. at an authorized service facility as determined by manufacturer. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

3°.- Repair time should not be more than 30 days starting from the reception of the product.

4°.- Spare parts could be adquired in the address attached to this policy.

5°.- The customer could ask the store where he bought the product to make efective this policy.

IN THE FOLLOWING CASES THIS WARRANTY IS NOT VALID:

a).- The warranty will not validin the case machines have been repaired or altered its performance order by a non-authorized person by **SOLDADORAS INDUSTRIALES INFRA S.A. DE C.V.** or has been used out of specifications of the same, abuses negligence or suffered any accident.

b).- This warranty *is not applied* to: contacts tubes, nozzles, electrodes, insulators, adapters contact tips, etc.

c).- in case the routine maintenance has not been applied.

d).- Ouput power terminals has not warranty when terminals lug usednot according to amperage to use and has not been tighten.

NOTE: In case this warranty is lost during the warranty period, **SOLDADORAS INDUSTRIALES INFRA S.A. de C.V.** will supply another one to the customer, presenting the purchasing bill or invoice.

It is recomended you write down this information and sending it to disribution center where you bought the product and sent it to **SOLDADORAS INDUSTRIALES INFRA S. A. de C. V.** Calle Plasticos no. 17 Naucalpan de Juárez Estado de México. Also when your equipment requires any repair, demand the previus form be filled by the Service Center Technician.

Customer Name: _____

Adress: _____

Model: _____

Serial No: _____

Date of Purchase: _____

Invoice No: _____

SOLDADORAS INDUSTRIALES INFRA, S.A. DE C.V.

Plásticos No. 17 Col. San Francisco Cuautlalpan C.P. 53560

Naucalpan de Juárez Edo. de México

Phone: (52) 53-58-41-83 53-58-87-74 53-58-44-00

Fax: (52) 55-76-23-58