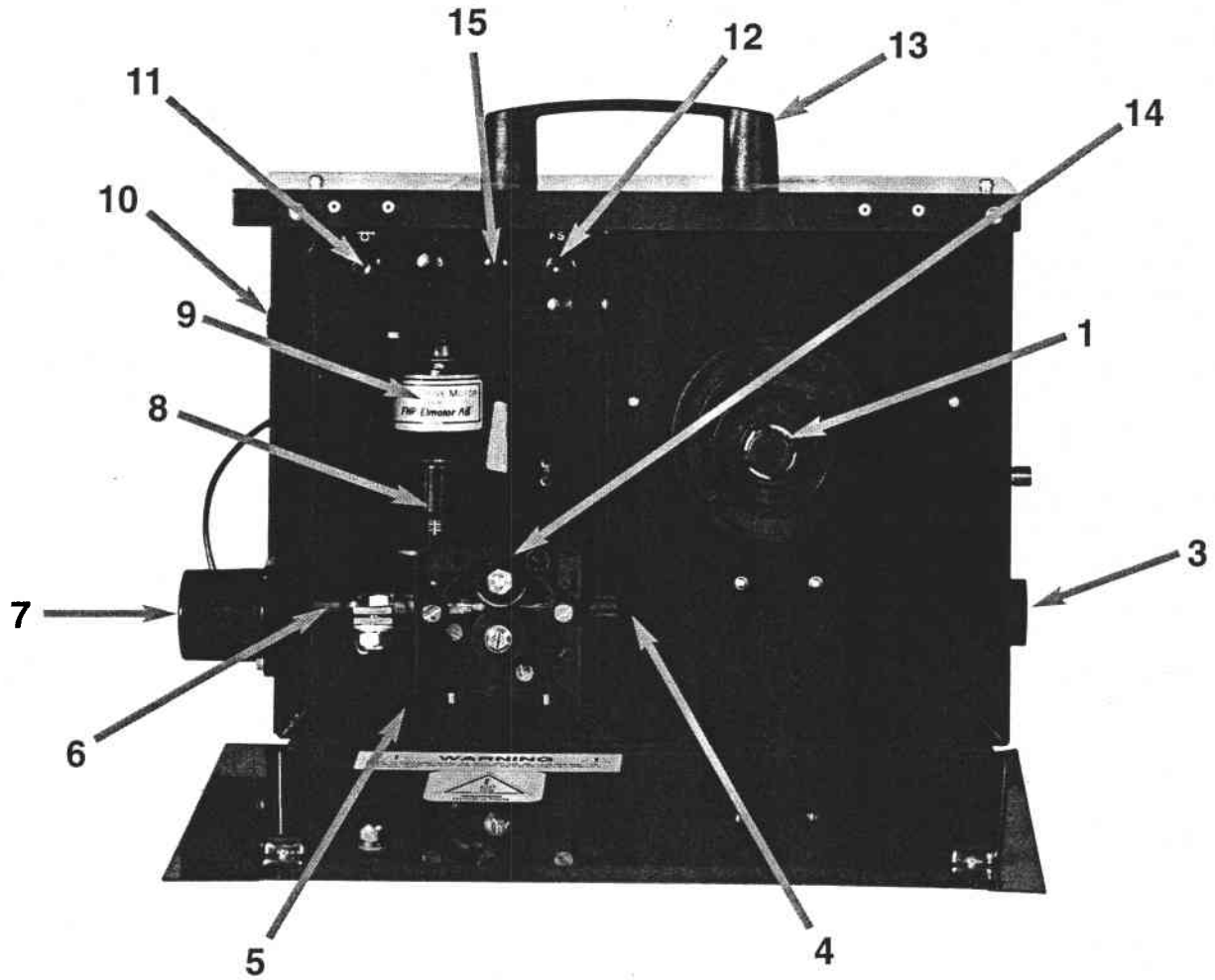
PARTS LIST



Item	Part No.	Description	Item	Part No.	Description
1	1414548	Reel Hub	11	1415817	Switch
3	678339	Dins Plug	12	-	Potentiometer 10k
4	1413103	Inlet Guide	13	1414550	Handle
5	1413106	Feed Block	14	1413101	Pressure Arm Assy
6	1414541	Brass Connection Tube	Behind	1413087	Control PCB
	1414542	Outlet Guide Tube Liner	15	1414552	Fuse Holder
7	1411524	Central Adaptor Block	-	-	Fuse 10AT 20mm
8	1413102	Pressure Device	Behind	1415815	Main Contactor
9	1413100	Motor	Behind	1415814	Gas Valve (110V)
10	1413089	Potentiometer 2.5k	Behind	1415816	Rectifier Bridge

METER CALIBRATION (where supplied)

Meter Unit Calibration Voltmeter
Referring to the main AVC pcb - preset potentiometer VR1 sets the voltmeter scaling.

Using a calibrated standard voltmeter between the power source terminals, adjust VR1 so that the voltmeter reading is correct.

WFS Meter
Referring to the main AVC pcb - preset potentiometer VR3 adjusts the WFS meter scaling.

Note: *A jumper link is installed across R33 on the main pcb at the factory to give 10m/min range as standard.*
Remove the jumper if 20m/min range is required.

Calibrate WFS meter as follows
Set the front panel control to 50%.

Energise the welding power source and press the torch trigger. Feed the wire for 15 seconds and measure the length of wire. Multiply the measurement by 4 to determine amount of wire that will be fed in 1 minute. Press the torch trigger and adjust VR3 so that this value is indicated on WFS meter.

OPTIONAL EXTRAS

Item		Part No.
15kg reel holder base plate complete		1411397
Spiral inlet guide - for use with baseplate		1411502
Feed rolls	0.8 - 1.0H	1411471
	1.0 - 1.2H	1411493
	1.2 - 1.6S	1411682
	1.2 - 1.6K (standard)	1411494
Key:	H = Hard (V groove)	
	S = Soft (U groove)	
	K = Knurled for tubular wires	