

PF 44 & 46

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Spare Parts

SP50274/50275 REV04
27/05

ASSEMBLY PAGE NAME			Machine Assembly	Machine Assembly	Machine Assembly	Divider Assembly	Wire Drive Assembly	User Interface Assembly	Miscellaneous Items
CODE NO.:	K NO.:	FIGURE NO.:	A	B	C	D	E	F	-
50274	K14108-1	PF 44	1	1	1	1	1	1	1
50275	K14109-1	PF 46	2	2	2	2	2	2	2

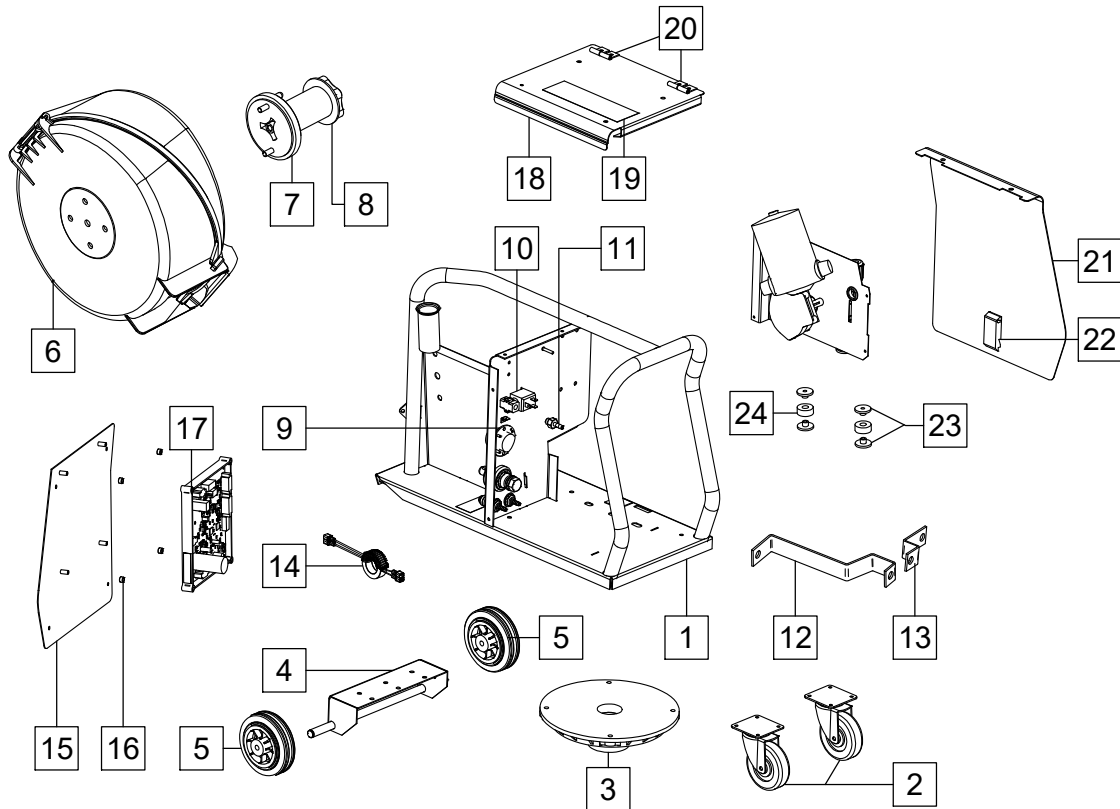


Figure A

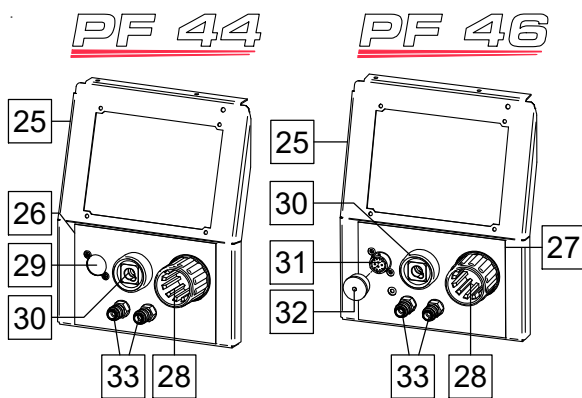


Figure B

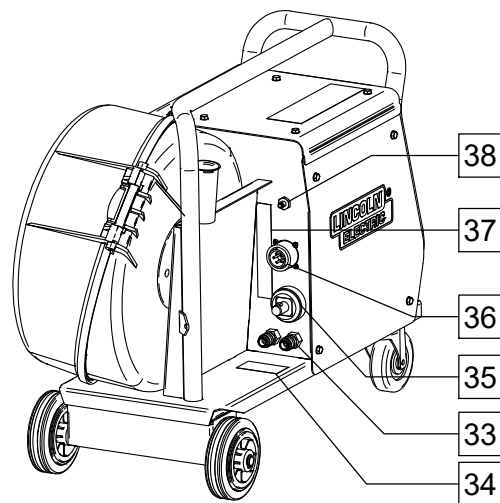
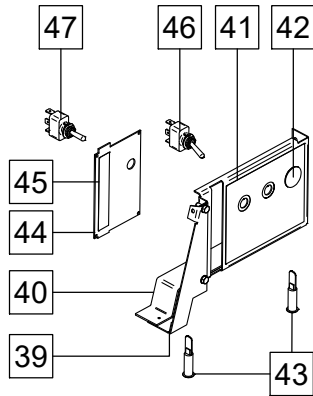


Figure C

Figure A, B, C: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
1	RACK	R-3019-315-1/08R	1	X	X					
2	FRONT WHEELS	1029-660-004R	2	X	X					
3	ROTARY BRACKET	1361-598-180R	1	X	X					
4	WHEELS BRACKET	R-1019-356-1/08R	1	X	X					
5	REAR WHEELS	1029-660-006R	2	X	X					
6	PLASTIC COVER	R-0010-178-1R	1	X	X					
7	REEL HUB STANDARD	0744-000-192R	1	X	X					
8	PLASIC NUT	B11035-1	1	X	X					
9	RING	R-2013-032-5R	1	X	X					
10	GAS SOLENOID	W8500004R	1	X	X					
11	COUPLER	R-2013-060-1R	1	X	X					
12	CONDUCTOR RAIL	R-1010-040-1R	1	X	X					
13	CONDUCTOR RAIL	R-1010-039-1R	1	X	X					
14	CHOKE	R-5041-228-1R	1	X	X					
15	LEFT SIDE PANEL	R-1019-227-1R	1	X	X					
16	SLEEVES	1131-155-001R	4	X	X					
17	MOTOR BOARD	R-6042-053-1R	1	X	X					
18	COVER	R-3019-162-1/02R	1	X	X					
19	STICKER	2719-107-728R	1	X	X					
20	HINGLES	D-3574-007-1/33R	2	X	X					
21	WIRE DRIVE DOOR	R-1019-224-1R	1	X	X					
22	LOCK	0654-610-004R	1	X	X					
23	SLEEVS	1361-599-720R	4	X	X					
24	SLEEVS	D-1869-033-3R	2	X	X					
25	FRONT PANEL	R-3019-275-8/08R	1	X	X					
26	STICKER (FRONT PANEL)	R-0010-477-2R	1	X	-					
27	STICKER (FRONT PANEL)	R-0010-468-1R	1	-	X					
28	EURO SLEEVE	1361-599-708R	1	X	X					
29	SHIELD	R-1019-361-1/08R	1	X	-					
30	SOCKET X3	C-2986-001-3R	1	X	X					
31	SOCKET X10	1158-641-149R	1	-	X					
32	SOCKET X10 CAP	1158-641-159R	1	-	X					
33	QUICK CONNECTOR FEMALE	0744-000-152R	4	X	X					
34	STICKER	R-0010-290-1R	1	X	X					
35	SOCKET X2	D-2985-002-1R	1	X	X					
36	SOCKET X1	1158-641-148R	1	X	X					
37	STICKER	R-0010-354-1R	1	X	X					
38	QUICK CONNECT COUPLING	0744-000-149R	1	X	X					

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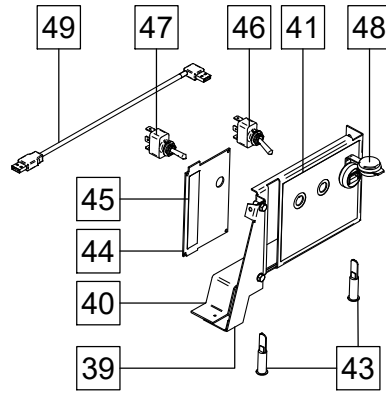


Figure D.

Figure D: Divider Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
39	DIVIDER	R-3019-287-5/08R	1	X	X					
40	SHIELD	R-0010-528-1R	1	X	X					
41	STICKER	R-0010-484-1R	1	X	X					
42	HOLE PLUG	0744-000-258R	1	X	-					
43	LED 1 , 2	0917-421-049R	2	X	X					
44	SHIELD	R-1019-329-1/08R	1	X	X					
45	STICKER	R-0010-502-1R	1	X	X					
46	SWITCH S2	1115-280-005R	1	X	X					
47	SWITCH S1	1115-280-004R	1	X	X					
48	USB SOCKET X11	1158-641-061R	1	-	X					
49	USB CABLE	R-0010-495-1R	1	-	X					

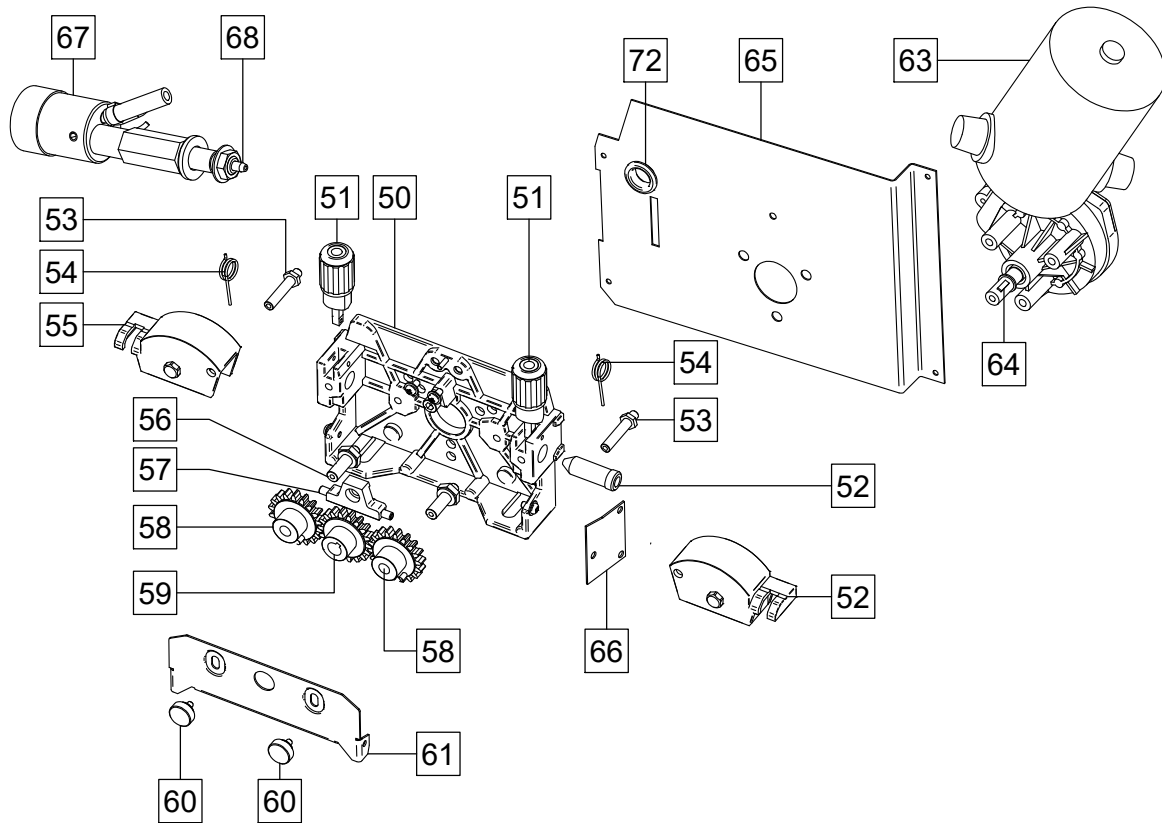


Figure E

Figure E: Wire Drive Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
	WIRE DRIVE ASSEMBLY	0744-000-241R	1	X	X					
50	FEED PLATE	0646-233-002R	1	X	X					
51	FIXING ARMS COMPL.	0646-233-015R	2	X	X					
52	INLET GUIDE	0646-233-025R	1	X	X					
53	AXIS PRESSURE ARMS	0646-233-003R	2	X	X					
54	SPRING PRESSURE ARMS	0646-233-013R	2	X	X					
55	PRESSURE ARM COMPL.L	0646-233-007R	1	X	X					
56	AXIS DRIVE ROLL	0646-233-020R	1	X	X					
57	INTERMEDIATE GUIDES	0646-233-023R	2	X	X					
58	GEAR WHEEL ROLLS	0646-231-090R	2	X	X					
59	GEAR WHEEL MOTOR	0646-233-028R	1	X	X					
60	FIXING CAPS	0744-000-190R	2	X	X					
61	METAL COVER	0646-233-027R	1	X	X					
62	PRESSURE ARM COMPL.R	0646-233-005R	1	X	X					
63	MOTOR	R-8040-024-4R	1	X	X					
64	WOODROF KEY	0646-231-102R	1	X	X					
65	DIVIDER	R-1019-207-1/08R	1	X	X					
66	WIRE DRIVE SHIELD	R-1019-385-1/08R	1	X	X					
67	EURO SOCKET X3	R-8040-140-7R	1	X	X					
68	OUTLET GUIDE	D-1829-066-3R	1	X	X					
69	RUBBER BUSH	1373-182-002R	1	X	X					

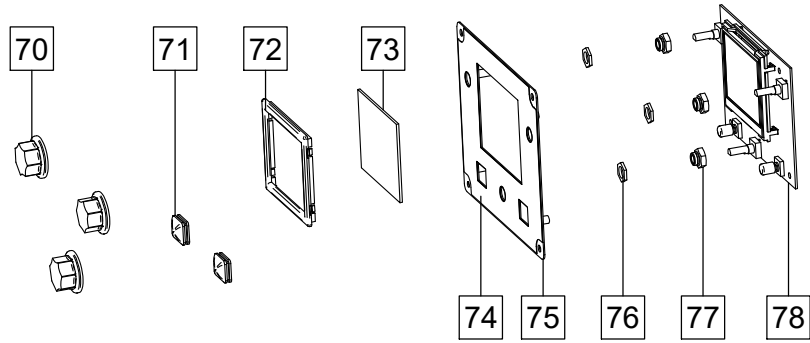


Figure F

Figure F: User Interface Assembly

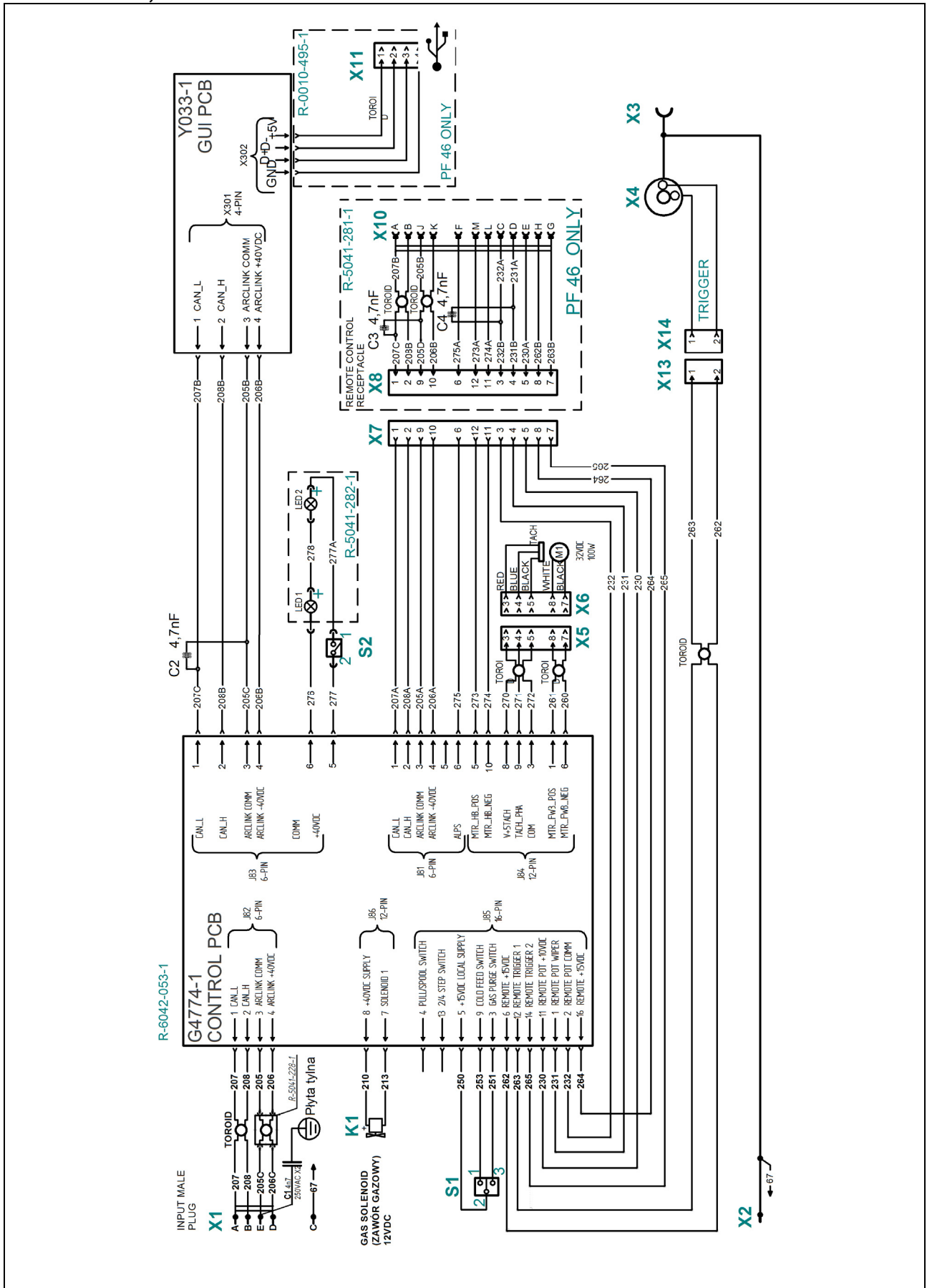
Item	Description	Part Number	QTY	1	2	3	4	5	6	7
70	CONTROLS	9SS18425-1	3	X	X					
71	BUTTONS	1373-182-005R	2	X	X					
72	FRAME	R-0010-423-1R	1	X	X					
73	PROTECTIVE SCREEN	R-0010-450-1R	1	X	X					
74	STICKER	R-0010-469-1R	1	X	X					
75	PANEL	R-3019-274-1/08R	1	X	X					
76	NUT	R-2013-128-1R	3	X	X					
77	SLEEVE NUT	R-2013-124-1R	3	X	X					
78	USER INTERFACE (WITH DISPLAY)	R-6042-066-1R	1	X	-					
	USER INTERFACE (WITH DISPLAY)	R-6042-067-1R	1	-	X					
	DISPLAY	W4505306R	1	X	X					

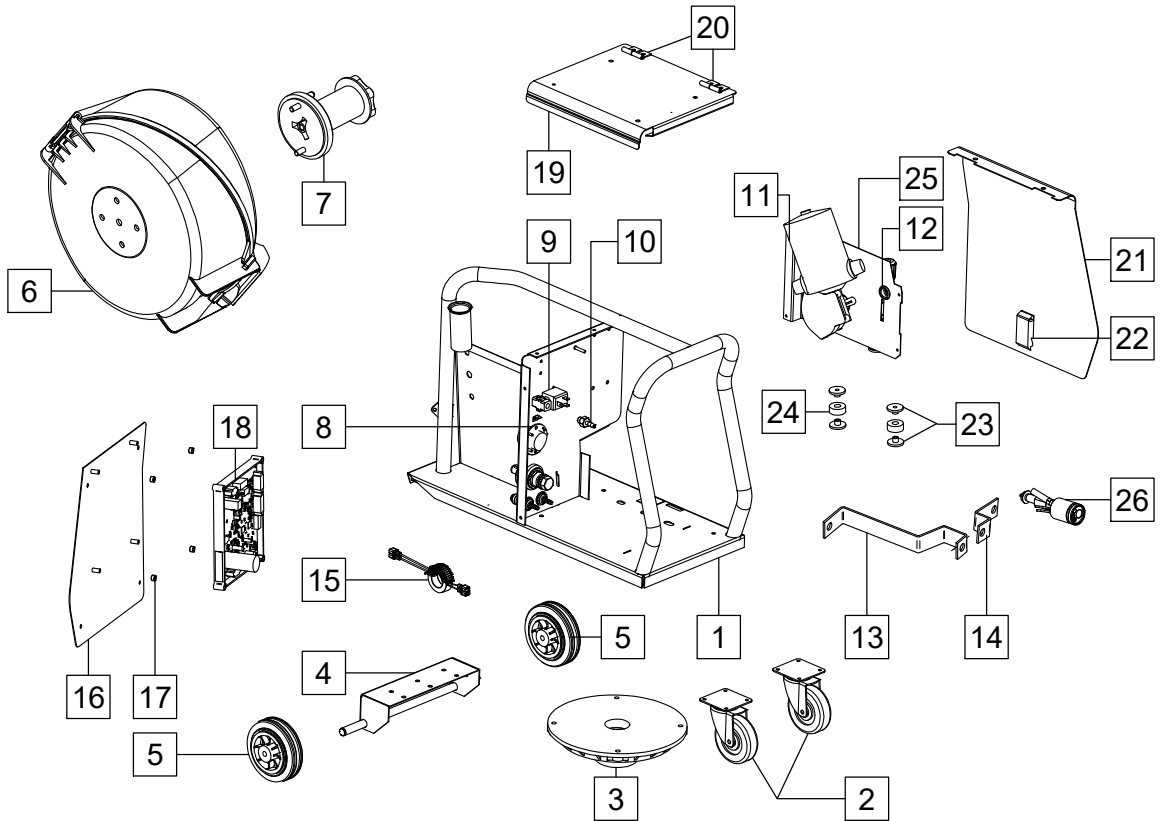
Miscellaneous Items (not shown in figure A, B, C, D, E, F)

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
79	WIRING HARNESS	R-5041-280-1R	1	X	X					
80	LED HARNESS	R-5041-282-1R	1	X	X					

Electrical Schematic

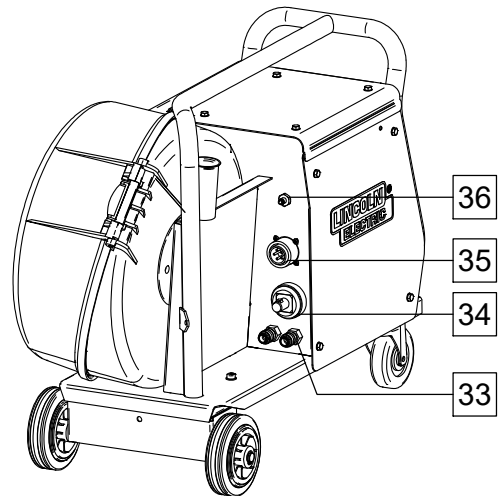
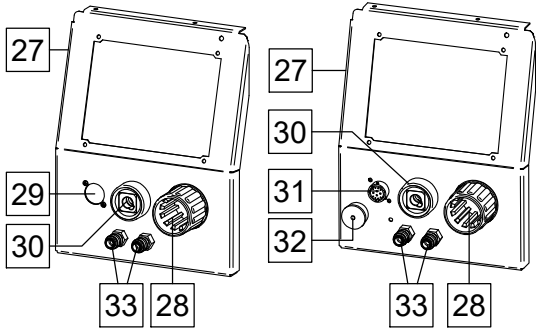
CODE: 50274, 50275





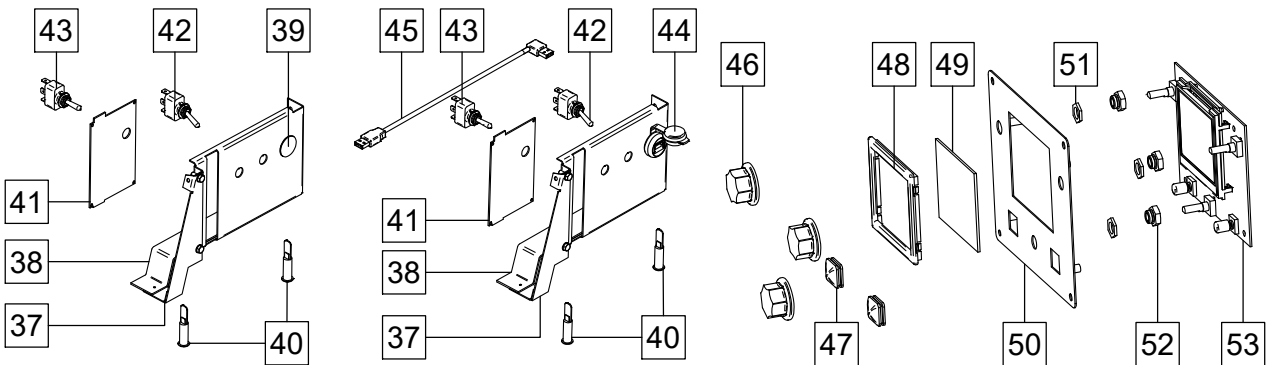
PF 44

PF 46



PF 44

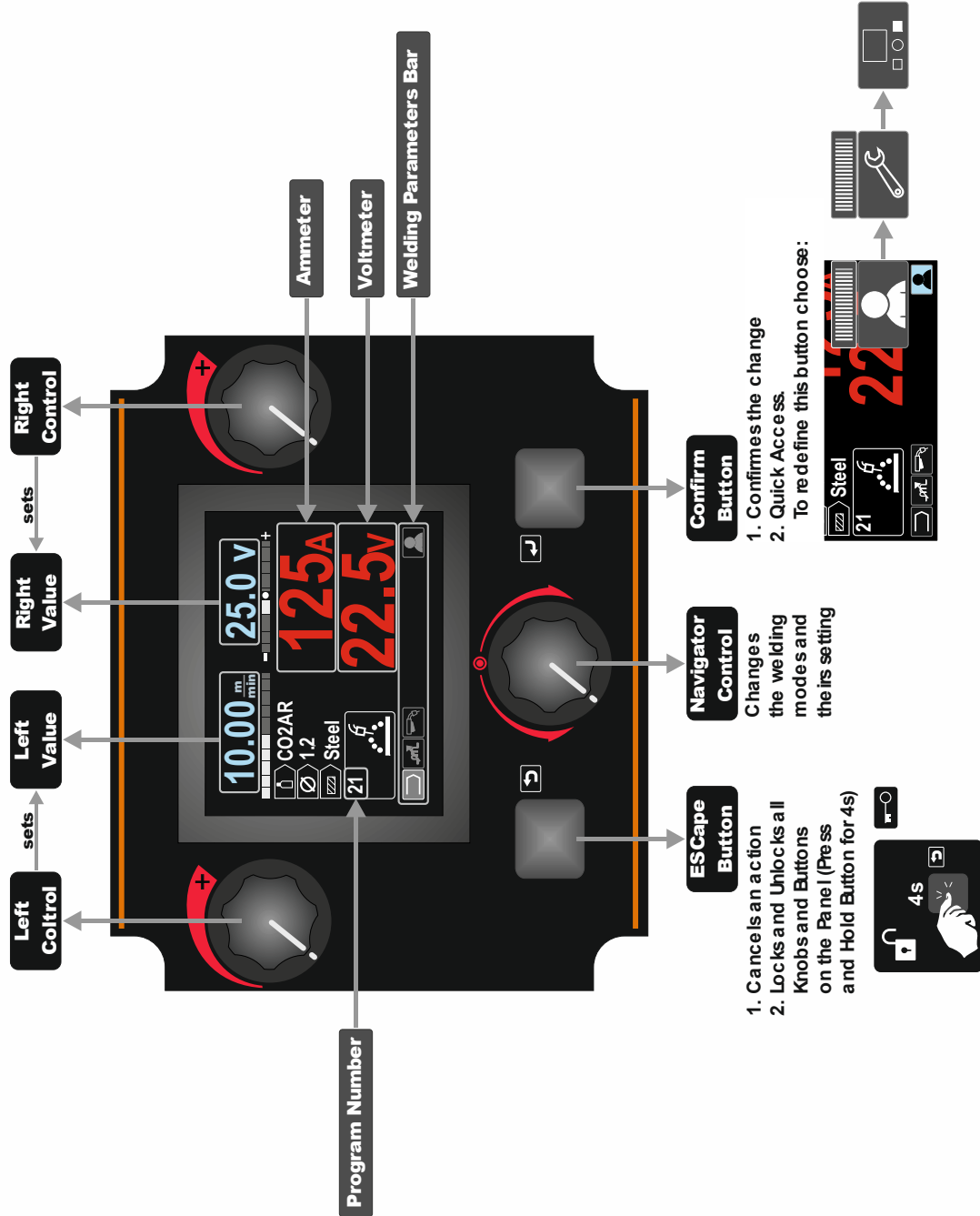
PF 46



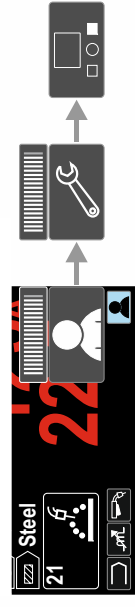
Description	Ref.	Recycle				ST				
		Fe	Al	Cu	Brass	Boards	Plastics	Liquid Cristal	External Electric Cables	Capacitors
RACK	1	X								
COVER	19	X								
SIDE PANEL	16, 21	X								
LOCK	22						X			
HINGLES	20	X								
WHEELS	2, 5		X				X			
ROTARY BRACKET	3						X			
WHEELS BRACKET	4	X								
PLASTIC COVER	6						X			
REEL HUB	7	X					X			
RING	8		X							
GAS SOLENOID	9	X		X	X					
COUPLER	10, 33, 36				X					
WIRE DRIVE ASSEMBLY	11	X		X			X			
RUBBER CABLE BUSH	12						X			
CONDUCTOR RAILS	13, 14			X						
CHOKE	15	X							X	
P.C. BOARDS	16, 53					X				
SLEEVES	17, 23, 24						X			
DIVIDER	25, 37	X								
EURO SOCKET	26				X					
FRONT PANEL	27	X								
EURO SLEEVE	28						X			
SHIELD	29, 41	X								
SHIELD	38						X			
SOCKETS	30, 31, 34, 35	X		X			X			
CAP	32						X			
SWITCHES	42, 43	X			X					
HOLE PLUG	39						X			
LED LAMPS	40	X			X		X			
USB SOCKET	44	X			X					
USB CABLE	45	X			X		X		X	
PANEL	50	X								
CONTROLS	46						X			
BUTTONS	47						X			
PROTECTIVE SCREEN	49						X			
FRAME	48						X			
WASHERS	51,52	X								

Quick Guide

QUICK GUIDE I



1. Confirms the change
2. Quick Access. To redefine this button choose:



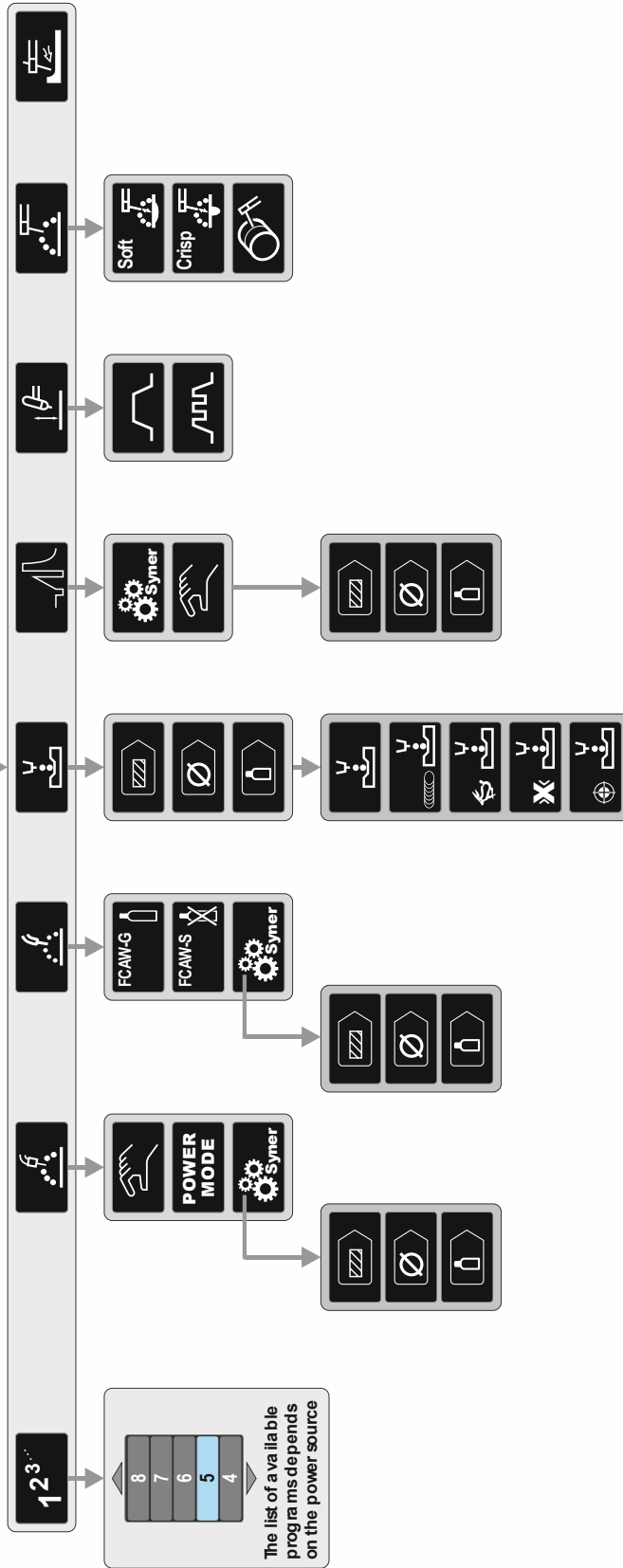
- Changes the welding modes and the iris setting

1. Cancels an action
2. Locks and Unlocks all Knobs and Buttons on the Panel (Press and Hold Button for 4s)



QUICK GUIDE II

Welding Program Selection



Available Welding Programs (06Aug2013)

Process	Mode	SMAW (MMA) / STAW (TIG) / Gouge / GMAW (MIG / FCAW)						
		1	2	4	9	3	8	40
Stick Soft (7018)	1							
Stick Chisp (6010)	2							
Stick Pipe	4							
Gouging (Compressed Air)	9							
TIG Lift	3							
TIG Lift Pulse	8							
GMAW STANDARD CV	5							
GMAW POWER MODE®	40							
FCAW-SS, STANDARD CV	6							
FCAW-GS, STANDARD CV	7							

Material	Gas	Synergic: GMAW (MIG), Standard CV						
		0,8	0,9	1,0	1,2	1,4	1,6	
Steel	CO ₂	93	138	10	20	24	-	
Steel	AMiX	94	139	11	21	25	107	
Stainless	AMiX	81	29	31	41	-	-	
Stainless	ArHe/CO ₂	83	-	33	43	-	-	
Aluminium AISI (4043)	Ar	-	-	71	-	73	-	
Aluminium AlMg (6356)	Ar	-	-	151	75	77	-	
MetaCore	AMiX	-	-	-	81	-	-	
CordWire	CO ₂	-	-	-	90	-	-	
CordWire	AMiX	-	-	-	91	-	-	

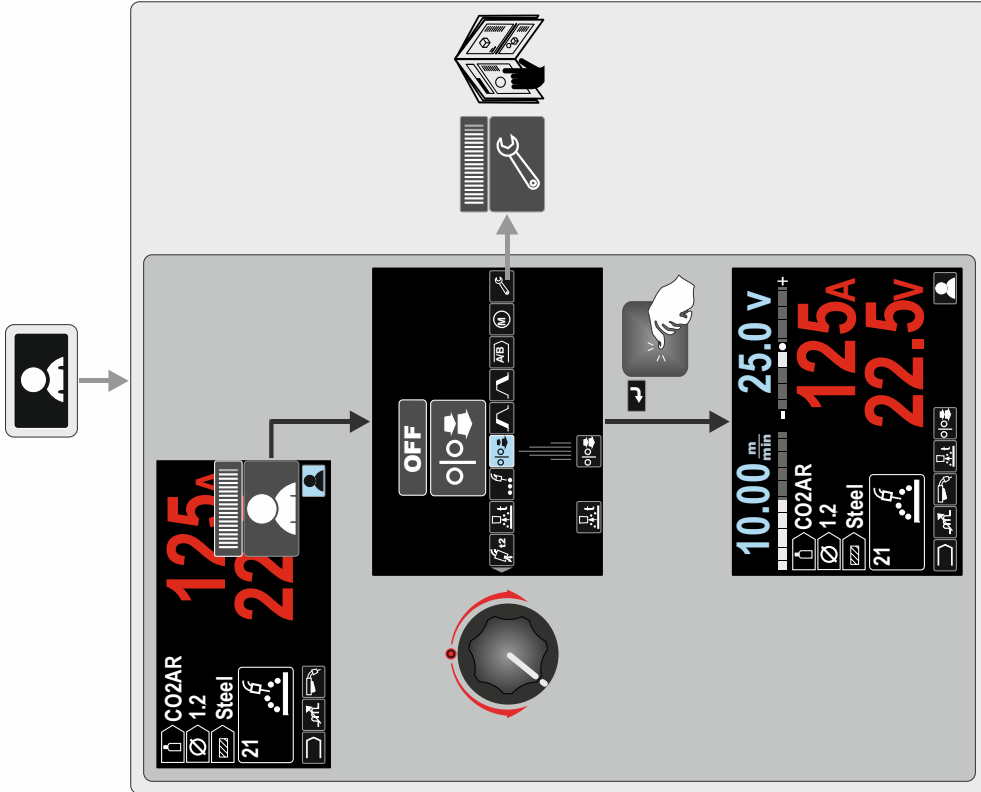
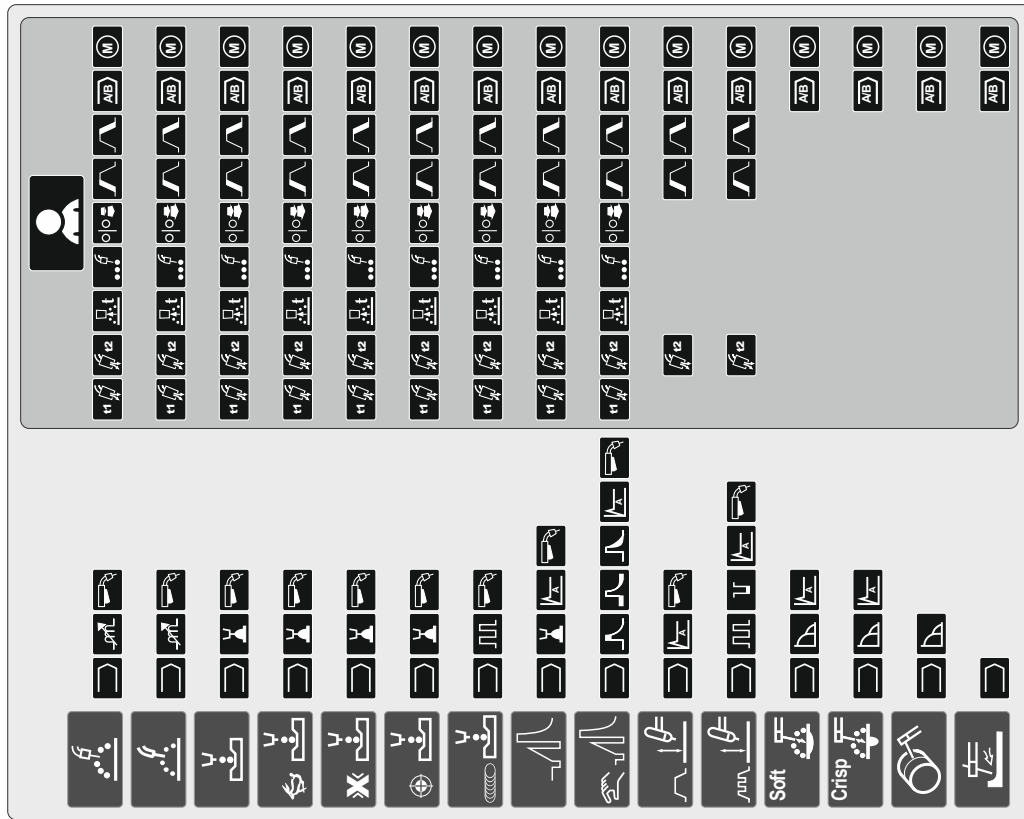
Material	Gas	GMAW-PP (Pulse) / GMAW-PP (Pulse-on-Pulse®)						
		0,8	0,9	1,0	1,2	1,4	1,6	
Steel	AMiX	95	140	12	22	26	108	
Steel (RapidArc®)	AMiX	141	13	18	27	-	-	
Steel (Precision Pulse™)	AMiX	410	411	412	413	-	-	
Stainless	AMiX	66	30	36	46	-	-	
Stainless	ArHe/CO ₂	64	-	34	44	-	-	
Stainless (Precision Pulse™)	ACO ₂	-	-	-	421	422	423	
MetaCore	AMiX	-	-	-	82	84	-	
N Alloy	70Ar/30He	-	-	-	170	175	-	
Si Bronze	Ar	-	-	-	192	-	-	
Copper	ArHe	-	-	-	198	196	-	
Aluminium AISI	Ar	-	-	-	72	74	-	
Aluminium AISI - PP	Ar	-	-	-	98	99	100	
Aluminium AlMg	Ar	-	-	-	152	76	78	
Aluminium AlMg - PP	Ar	-	-	-	101	102	-	

Material	Gas	Rapid X™						
		0,8	0,9	1,0	1,2	1,4	1,6	
Steel	Ar/AMiX	-	-	273	274	-	-	
Stainless	Ar/AMiX	-	-	283	284	-	-	
MetaCore	Ar/AMiX	-	-	-	294	-	-	

Material	Gas	STI®						
		0,8	0,9	1,0	1,2	1,4	1,6	
Steel (Non-Synergic)	CO ₂	-	304	306	308	-	-	
Steel (Non-Synergic)	AMiX	-	305	307	309	-	-	
Steel (Synergic)	CO ₂	-	324	326	328	-	-	
Steel (Synergic)	AMiX	-	325	327	329	-	-	
Stainless (Non-Synergic)	AMiX	-	344	346	348	-	-	
Stainless (Non-Synergic)	ArHe/CO ₂	-	345	347	349	-	-	
Stainless (Synergic)	Ar/AMiX	-	364	366	368	-	-	
Stainless (Synergic)	Ar/He/CO ₂	-	365	367	369	-	-	

QUICK GUIDE III

Welding Parameter Bar & User Settings



NOTE
PF46 ONLY

QUICKGUIDE

	Select Welding Process		Run-in WFS		UltimArc™		Restore Factory Setting
	Select Welding Program		Spot Welding Setting		Setting and Configuration Menu		View Software and Hardware Version Information
	Non-synergic Programs		Spot Timer		Memory Limits (PF46 only)		Setup Menu
	Synergic Programs		Start Procedure		Display Configuration Settings		Switch Off Output Voltage (TIG/MMA only)
	GMAW Process (MIG/MAG)		Crater Procedure		Big Meters Menu (factory default)		Switch On Output Voltage (TIG/MMA only)
	GMAW Process POWER MODE®		A/B Procedure (PF46 only)		Standard Menu		Welding Current
	FCAW Process		Memory (PF46 only)		Weld Score™ Menu		Wire Feed Speed in [m/min]
	FCAW-SS Process		Save to the User Memory (PF46 only)		True Energy™ Menu		Wire Feed Speed in [in/min]
	FCAW-GS Process		Recall from The User Memory (PF46 only)		Assign Function to the Right Button		Welding Voltage
	GMAW-P Process		Arc Force		Disabled		Trim
	GMAW-P Process RapidArc® Program		Hot Start		Check Mark		Power in kW
	GMAW-P Process RapidX™ Program		Frequency Settings (GTAW-PULSE)		Resignation Mark		Cold Feed
	GMAW-P Process Precision Pulse™ Program		Frequency (GTAW-PULSE)		Wave Controls		Gas Purge
	GMAW-P Process Pulse-On-Pulse® Program		Background Settings (GTAW-PULSE)		Brightness Level		Error
	STT® Process		Background Current (GTAW-PULSE)		Lock / Unlock Settings		USB Memory (PF46 only)
	Electrode Wire Type Selection		Background Current (STT®)		Locked		USB Memory is connected (PF46 only)
	Wire Size (diameter) Selection		Peak Current (STT®)		Unlocked		ESCape Button
	Gas Selection		TailOut (STT®)		Set Passcode		Confirm Button
	GMAW Process (TIG)						
	GMAW Welding						
	GMAW-PULSE Welding						
	GMAW Program						
	GMAW-PULSE Program						
	SMAW Process (MMA)						
	SMAW-Soft Process						
	SMAW-Crisp Process						
	SMAW-Pipe Process						
	Gouging						
	User Settings						
	Pinch						
	Select Function of Gun Trigger (2-Step/4-Step)						
	2-Step						
	4-Step						
	Prewflow Time						
	Postflow Time						
	Burnback						