



Transmatic 4 x 4 HDM Wire Feed Unit Instruction Sheet

This instruction sheet is to be read in conjunction with the Transmatic 2x2, 4x4, 4x4HD Instruction Manual, Part Number 100473.

Introduction

The Transmatic 4x4HDM wire feed unit is a special version of the Transmatic 4x4HD unit, for use with the Transmig Synergic 500 multiprocess package.

The wire feed speed potentiometer on the wire feed unit is removed and the wire feed speed is controlled by the current potentiometer on the remote pendant, attached to the power source.

The gas supply solenoid valve is controlled by the power source (relay CR3).

Parts List

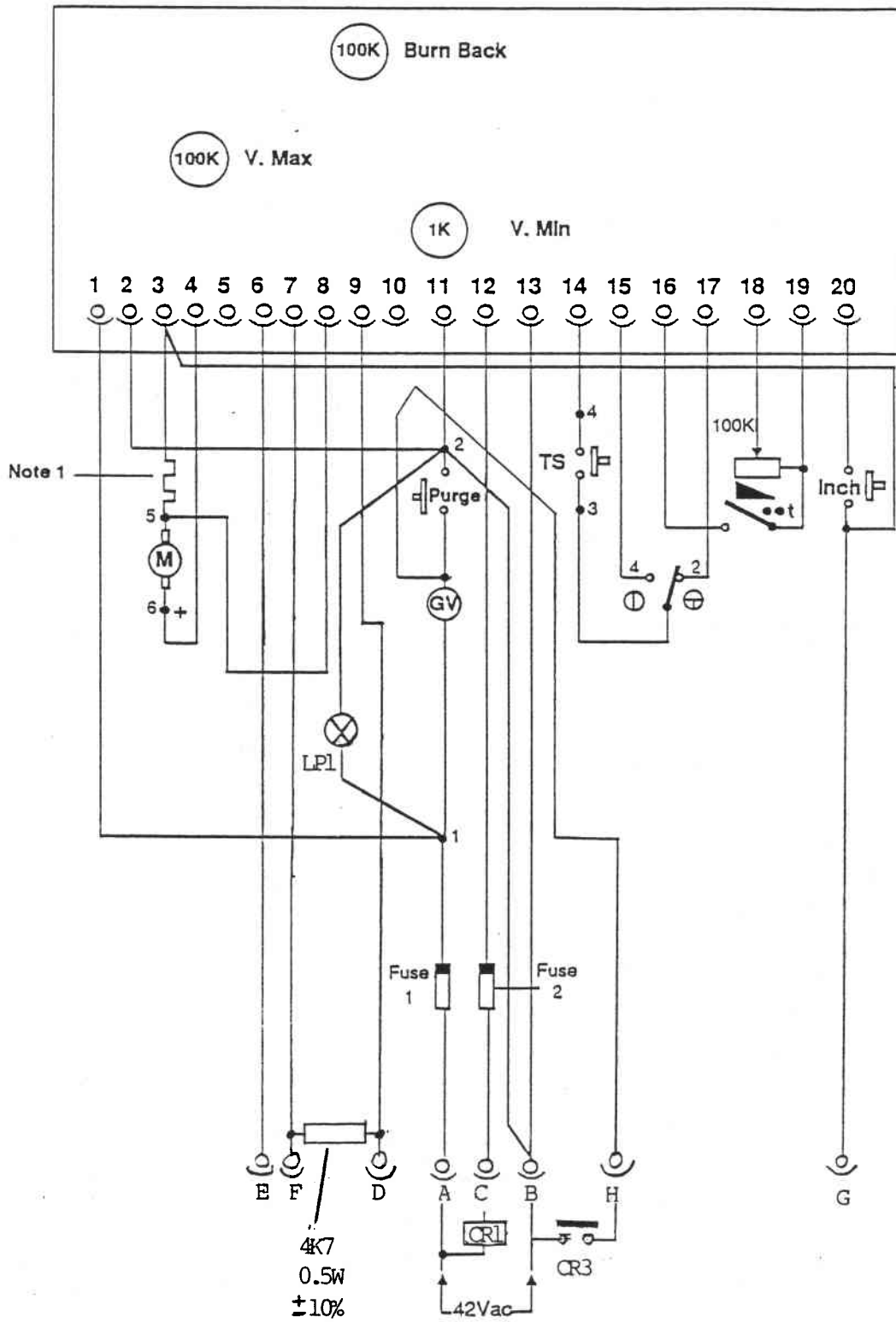
Changes to the standard Transmatic 4x4HD parts list for the M Version includes the following:

	Items	Part No.	Description
Delete	1	1409041	Potentiometer - wire speed
Add	2	----	Resistor 4.7K Ω 0.5W \pm 10%

Circuit Diagram - see overleaf

<p>Pt. No. 100502 Issue 1</p>

4x4HDM



Note 1: "IR" compensation resistor = 500mm 0.5mm² copper