

Transmig 350i and Transmatic 4x4P



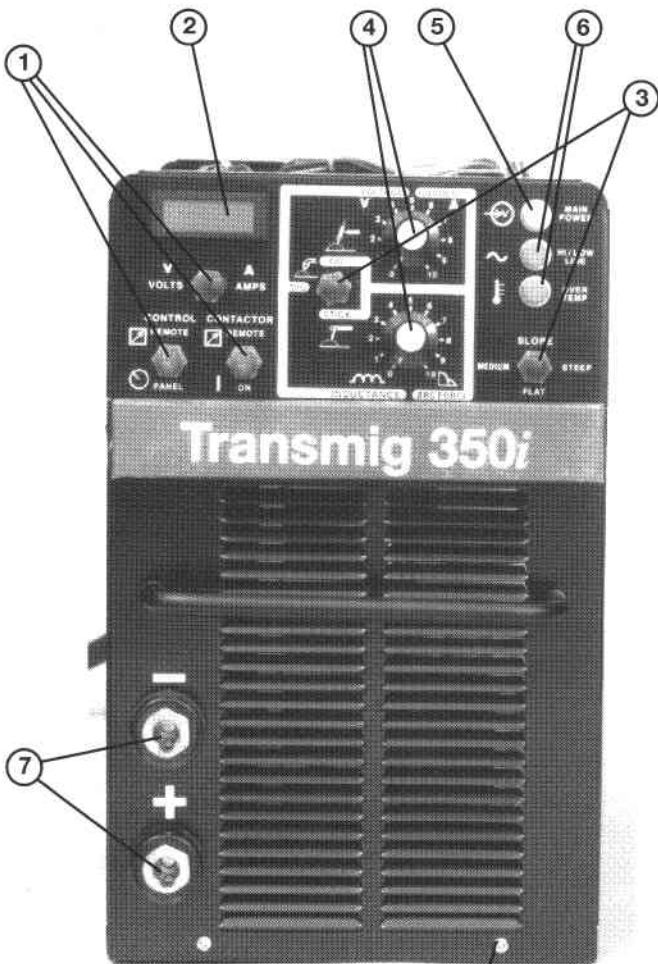
**Please ensure that this
Instruction Manual is made
available to the user of
the equipment**

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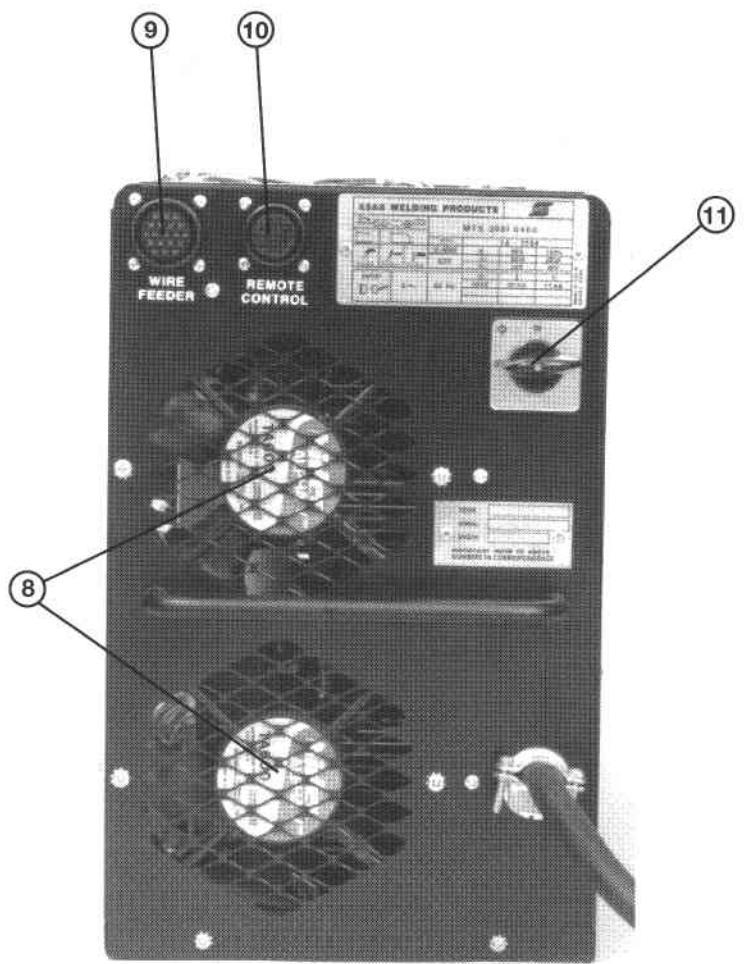
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OPTIONS

	PART NO.
<p>ULTRA PULSE REMOTE PENDANT CONTROL</p> <p>An easy to use Synergic pulse control unit which provides precise parameters for pulsed Mig welding. Simply select the desired wire type and diameter on the control dial, set the wire feed speed and start welding. As you change the wire feed speed the pulse parameters automatically adjust to maintain a high quality pulsed arc.</p>	1415227
<p>TIG PULSE/SLOPE PENDANT CONTROL</p> <p>Provides "slope up"/slope down and pulse functions for the welding current in the TIG mode.</p>	1415230
<p>HC-5 REMOTE CONTROL UNIT (10M)</p> <p>Provides remote control of the majority of the front panel functions. Including:- Process selection switch, contactor switch, output control and arc force.</p>	1415229
<p>FC-5B FOOT CONTROL UNIT (10M)</p> <p>Provides remote control and contactor on/off control.</p>	1415231
<p>DIGITAL METER/PRESET MODULE (TRANSMATIC 4x4P)</p> <p>Provides a digital display of the wire feed speed. The meter will read the "Preset" wire speed when not feeding wire and actual wire speed when feeding wire. If the volts mode is selected the meter reads the actual volts.</p>	1415228
<p>DUAL SCHEDULE KIT (TRANSMATIC 4x4P)</p> <p>Provides control for a second set of welding parameters (wire feed speed and voltage). The operator can select schedule A or schedule B on a switch located on the front of the wire feeder or select remotely via an optional torch mounted schedule selector switch.</p>	1415232
<p>REMOTE SCHEDULE SELECTOR SWITCH</p> <p>Torch mounted, two position switch provides remote schedule selection (A or B). (To be used in conjunction with dual schedule kit pt.no. 1415232)</p>	1415234
<p>TC-2B TIG TORCH CONTROL WITH 14 PIN PLUG</p> <p>Provides contact on/off and current control remotely from the TIG torch.</p>	1415233

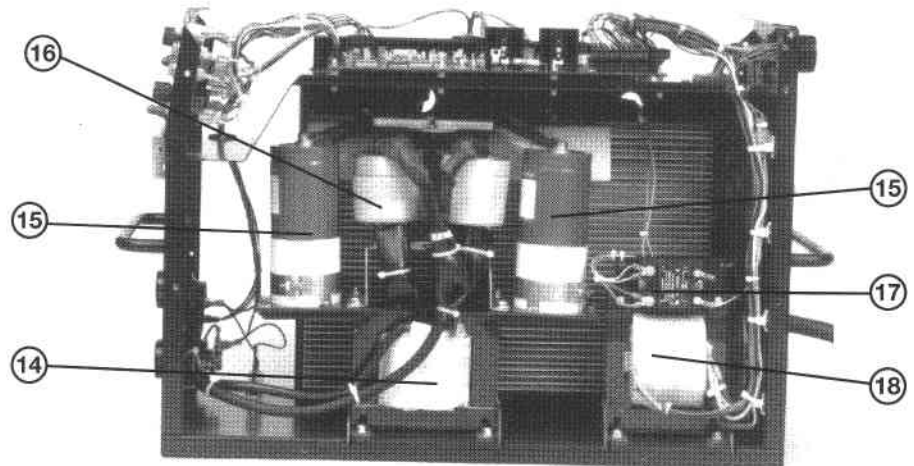
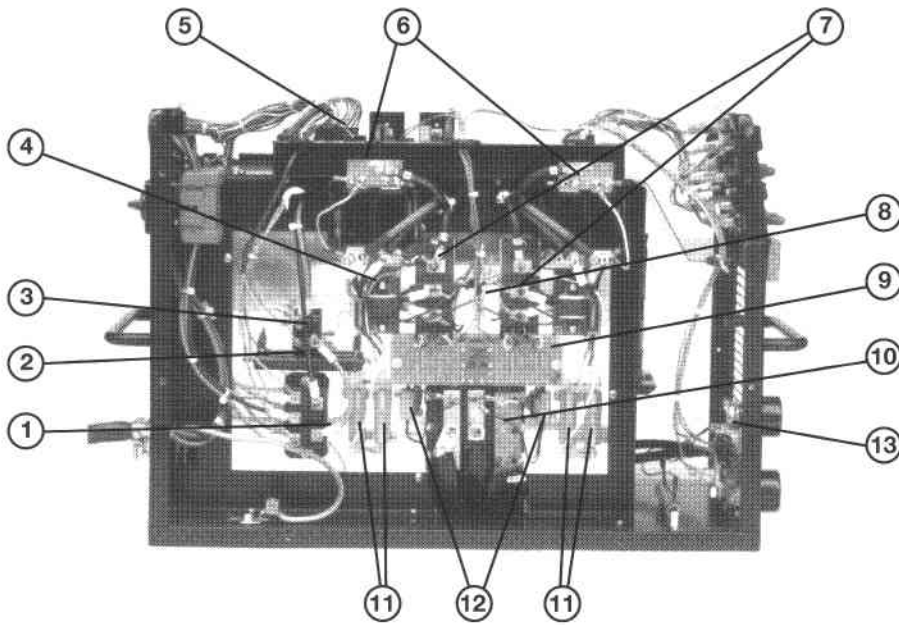


FRONT PANEL

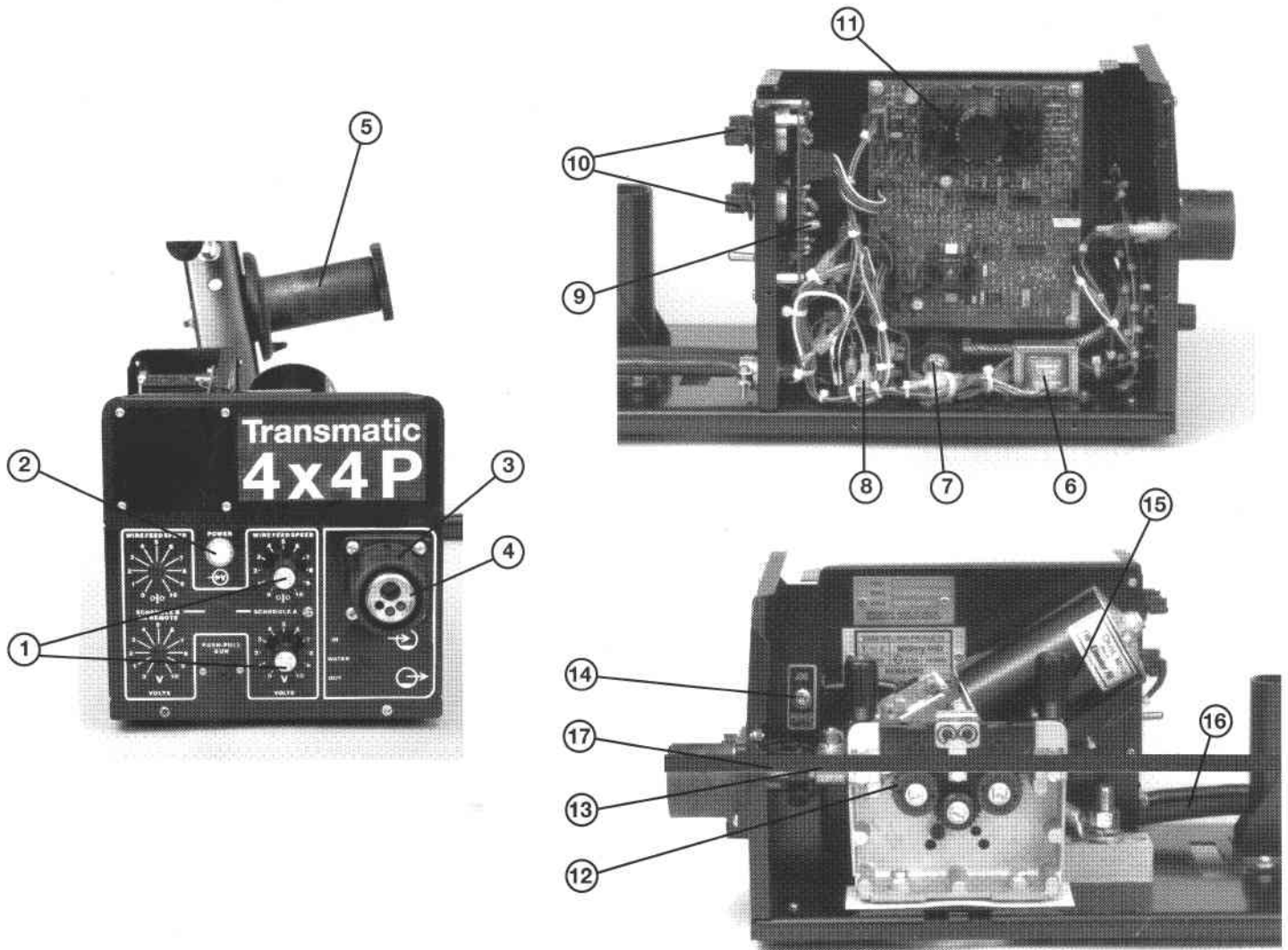


REAR PANEL

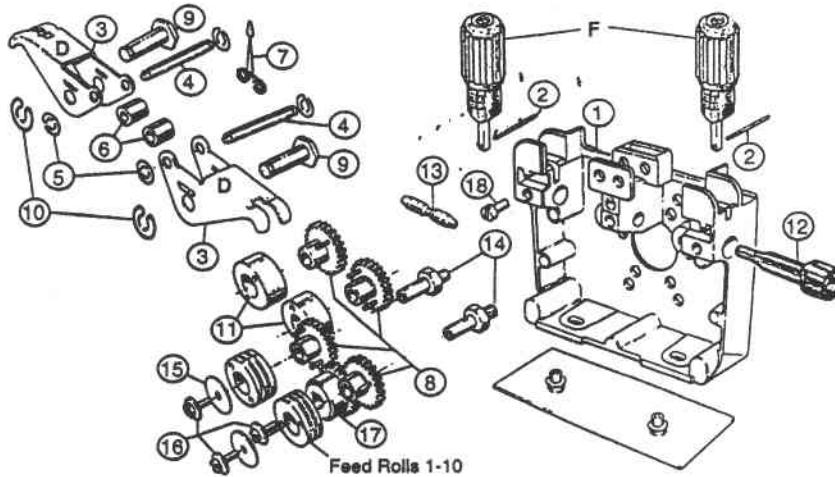
Item No.	Part Number	Description	Circuit Ref.
1	673213	Switch SPST	S4, 5, 6
2	951826	Digital Meter	DPM
3	1414975	Switch SPDTCO	S2, 3
4	1414963	Potentiometer 10K 2W	R11,12
-	1414954	Knob for items 4	
5	951814	Lamp white	PL1
6	951815	Lamp yellow	PL2, 3
7	17242	Dinse Socket	
8	951816	Fan 230v	M1,2
9	1414965	Socket 19 pin	J1
10	1414964	Socket 14 pin	J2
11	951817	Switch Power Disc 30A 600V	S1



Item No.	Part Number	Description	Circuit Ref.
1	951207	Diode Module	BR1
2	1414989	Resistor 5ohm 50w	R1
3	1414971	Thyristor	SCR1
4	34901	Current Transformer	T4
5	838004	Main Control PCB	PCB1
6	1414355	Capacitor 20uf 400v	C2, 3, 6, 7
7	951825	IGBT Module 140A 600V	Q1
8	951835	Thermal Switch	TS1
9	838012	PCB IGBT Driver	PCB3
10	1414951	Diode Module	Di,2,3
11	17750020	Resistor 20 ohm 50w	R4,8,13,14
12	1414968	Resistor 50 ohm 25w	R9,10
13	951819	Shunt/PCB	PCB2 SHI
14	34880	Inductor Assembly	L1
15	951635	Capacitor 1900 uF 450v	C1,5
16	34881	Main Transformer	T1
17	951818	Relay	K1
18	35284	Control Transformer	T1



Item No.	Part Number	Description	Circuit Ref.
1	1414963	Potentiometer 10K 2W	R1, R2
-	1414954	Knob for item 1	
2	13792157	Indicator lamp	PL1
3	23610528	Moulding central adaptor	
4	23610696	Central adaptor assembly	
5	1415245	Reel hub assembly	
-	23600010	Reel hub nut	
Not shown	13730623	Door catch	
6	993717	Control transformer	T1
7	13792051	Gas solenoid	SOL1
8	13730469	Rectifier bridge	BR1
9	31471	Spot/Burnback PCB	
10	599670	Potentiometer 250k 2w	
-	1414982	Knob for item 5	
11	31463	Control PCB	PCB1
12	see consumables	Steel Guide Tube	
13	23612590	Brass Support Tube	
14	950087	Switch 3 Position SPDT	S1
15	951529	Drive Motor	M1
-	1413860	Brushes for Item 4	
16	951528	Control Cable Assembly	
17	951553	Current Detector	



Item No	Qty Rec.	Part No.	Description
Rear-D	1	1413876	4 Roll geared wire drive system consists of:
F	1	1413451	Pressure arm geared complete (incl. 3,8,9,10,11)
1	1	1413866	Pressure device with scale
2	2	1413873	Feed Plate
3	2	1413861	Locating pin, pressure device
4	2	1415236	Pressure arm
5	4	1413857	Locating pin, pressure arm
6	2	1413858	Circlip, locating pin, pressure arm
7	1	1415237	Spacer tube, pressure arm
8	4	1413867	Spring, pressure arm
9	2	1411790	Geared adaptor, pressure and drive rolls
10	2	1415238	Axle, pressure roll
11	2	1415239	Circlip, axle, pressure roll
12	1		Pressure roll (see consumables)
13	1		inlet guide (see consumables)
14	2		Intermediate guide (see consumables)
15	2	1413391	Axle shaft, drive roll
16	3	1411547	Washer, retaining screw
17	1	1413104	Retaining screw, drive roll
18	3	1411791	Main gear drive
		1413104	Screw

CONSUMABLES

Note: as standard the 4x4P is supplied fitted for 1.0 - 1.2 Hard Wires

Wire Size & Type	Inlet Guide	Feed Rolls (Pack of 2)	Pressure Roll (2 req'd)	Intermediate Guide	Outlet Guide Tube Liner
0.6-0.8H	1413103	1409001	1413844(P)	1411769	1415240
1.0-1.2H	1413103	1409002	1413844(P)	1411769	1415241
1.2-1.6H	1413103	1409003	1413844(P)	1411769	1415242
1.2-1.6T	1413103	1411533	1413745(K)	1411769	1415242
1.6-.2.4T	1413854	1419005	1413745(K)	1411770	1415242
2.8-3.2T	1413854	1409006	1413745(K)	1411770	Not required
1.0-1.2S	1413103	1413460	1413844(P)	1411769	1415243*
1.2-1.6S	1413103	1414891	1413844(P)	1411769	1415243*
2.4-3.2S	1413854	1414392	1413844(P)	1411770	Not required

Key: P = Plain K = Knurled

*Requires support tube 1415244



NOTES