

180 = LKA 180 240 = LKA 240

C = component designation in the circuit diagram

Item no.	Qty 180	Qty 240	Ordering no.	Denomination	Notes	C
101	1	1	469 368-001	Cover plate		
102	1	1	469 369-001	Rear panel		
	1	1	469 664-001	Rear panel	Only for the Australian market	
103	1	-	469 447-001	Side panel	With text	
	-	1	469 456-001	Side panel	With text	
104	1	1	469 409-880	Welding gun PSG 14	1) Complete	
105	1	1	469 518-881	Gas nozzle	1) Standard	
	1	1	469 518-886	Gas nozzle	1) For spot welding, option	
106	1	1		Contact tip	1) See item 152, 153 and 154	
107	1	-	469 572-880	Return cable	Complete	
	-	1	469 443-880	Return cable	Complete	
108	1	1	469 518-885	Wire liner	1) Wire liner of steel spiral see also item 154	
109	1	1	469 361-001	Front panel		
110	2	2	469 468-001	Link wheel		
	8	8		Screw	MRX M6 x 16 mm	
111	1	1	368 265-001	Securing strap		
120	2	2	469 453-001	Attachment		
121	1	1	469 516-001	Shaft		
122	2	2		Washer	D 21/36	
123	2	2	469 469-001	Wheel		
124	2	2	192 859-126	Locking washer		
125b	1	1	146 967-881	Brake hub	From machine no. 547 612	
126	1	1	469 437-001	Handle		
	2	2		Screw	MRX M6 x 16mm	
127	1	1	469 518-887	Gas diffuser	1) With spring coil	
128	1	1	469 518-894	O-ring	1)	
129	1	1	469 518-891	Swan neck	1)	
130	1	1	469 518-892	Handle	1)	
131	1	1	469 518-893	Switch	1) Complete	SB1

SPARE PARTS SETS

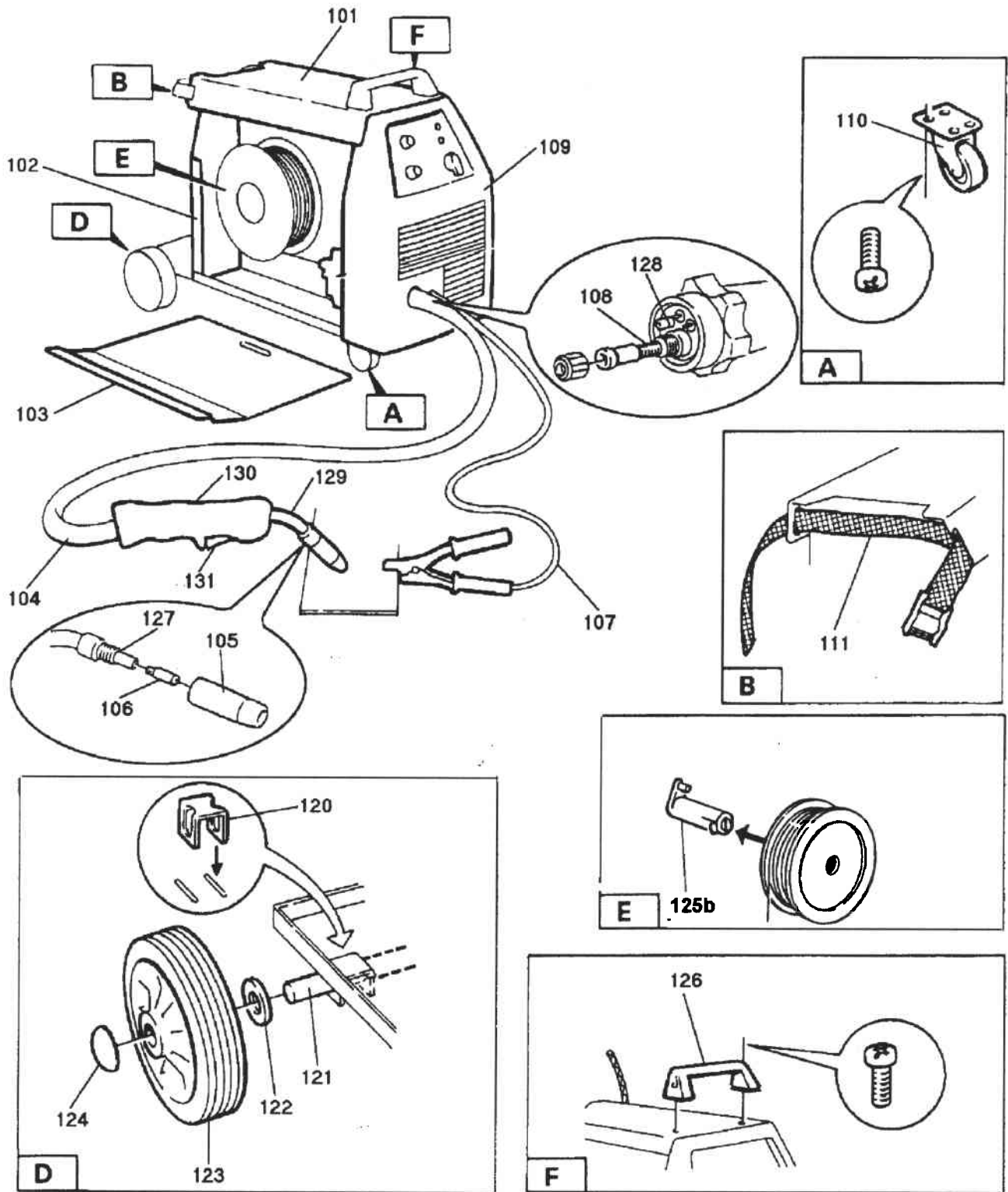
Item	Ordering no.	Denomination	Notes
152	469 518-882 469 518-896 469 518-895	Contact tip Contact tip Contact tip	1) Contains item 106, 5 contact tip \varnothing 0.6 and 5 contact tip \varnothing 0.8 1) Contains item 106, 10 contact tip \varnothing 0.6 1) Contains item 106, 10 contact tip \varnothing 0.8
153	469 518-883	Contact tip	1) Contains item 106, 5 contact tip \varnothing 1.0
154	469 518-884	Spare parts set	1) Contains item 106 5 contact tip \varnothing 1.0 and item 108 wire liner of teflon, for aluminium welding
155	155 716-880	Gas flow gauge	1) For protection gas

1) Only for machines supplied with the PSG 14 welding gun

Inlet Nozzle – 367206001

Outlet Nozzle – 469395001

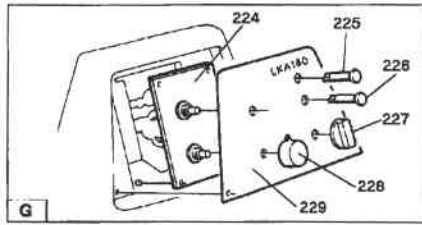
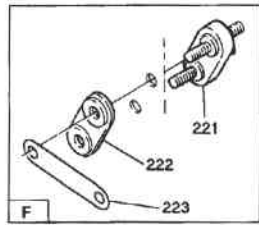
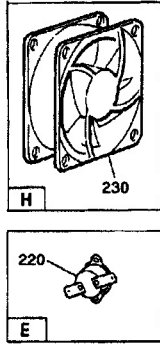
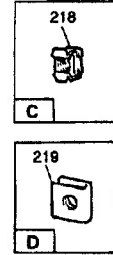
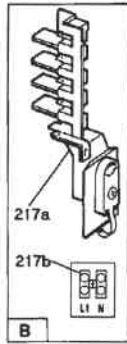
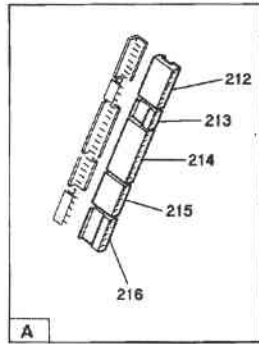
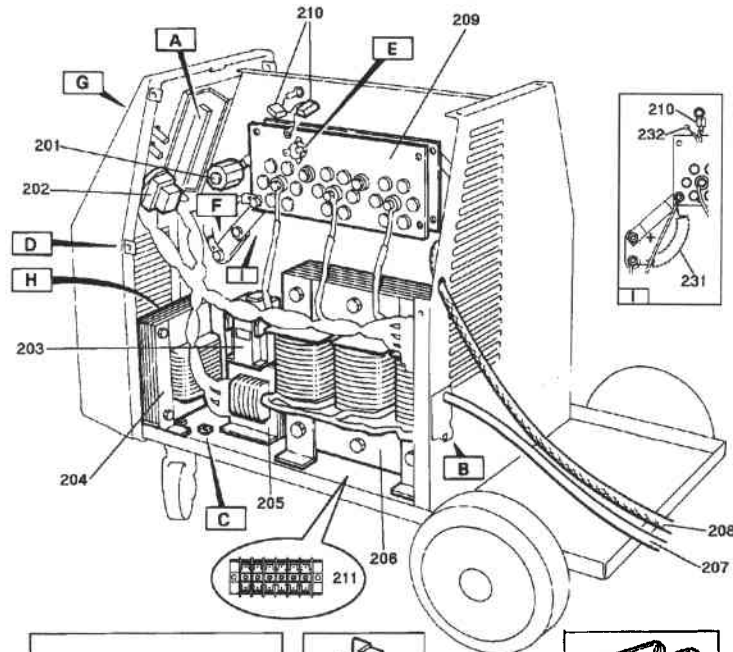
Parts list only for machines with serial number before 618



180= LKA180 240= LKA240 1ph= 1 phase 230V rec= reconnectable 230/400V 400= 400 V mains supply voltage
C = component designation in the circuit diagram

Item no	Qty 180 1ph	Qty 180 400	Qty 180 rec	Qty 240 400	Qty 240 rec	Ordering no.	Denomination	Notes	C
201	1	1	1	1	1	193 054-002	Gas valve		YV1
202	1	-	-	-	-	469 659-001	Switch	With knob (item 227)	QF1
	-	1	-	-	-	469 472-001	Switch	Without knob (item 227)	QF1
	-	-	1	-	-	469 564-001	Switch	With knob (item 227)	QF1
	-	-	-	1	-	469 473-001	Switch	With knob (item 227)	QF1
	-	-	-	-	1	469 566-001	Switch	With knob (item 227)	QF1
203	1	-	-	-	-	193 297-101	Contacteur		KM1
	-	1	1	1	1	193 296-104	Contacteur		KM1
204	1	-	-	-	-	469 300-880	Inductor		L1
	-	1	1	1	1	469 295-880	Inductor		L1
205	1	-	1	-	1	469 563-001	Control transformer	Primary voltage 230/400 V	TC1
	-	1	-	1	-	469 470-001	Control transformer	Primary voltage 400 V	TC1
206	1	-	-	-	-	469 660-880	Main transformer	Thermal cutout ST1 included	TM1
	-	1	1	-	-	469 285-880	Main transformer	Thermal cutout ST1 included	TM1
	-	-	-	1	1	469 290-880	Main transformer	Thermal cutout ST1 included	TM1
207	1	-	-	-	-	2626 133-14	Mains cable	3 x 2.5 mm ² 2.5 meter	
	-	1	-	1	-	2626 134-05	Mains cable	4 x 1.5 mm ² 2.5 meter	
	-	-	1	-	1	192 106-117	Mains cable	4 x 2.5 mm ² 2.5 meter to be ordered per meter	
208	1	1	1	1	1	190 315-102	Gas hose	To be ordered per meter 1.5 meter as delivered	
209	1	-	-	-	-	469 662-880	Diode bridge		V1 - V6
	-	1	1	-	-	469 318-880	Diode bridge		V1 - V6
	-	-	-	1	1	469 346-880	Diode bridge		V1 - V6
210	1	1	1	1	1	469 380-880	Capacitor	Set of 2 capacitors, PME 0.1µF 400V, with cable lugs	C1 +C2
211	-	-	1	-	1	466 884-006	Terminal	6-pole	XT3
	-	-	1	-	1	469 569-001	Insulation	With text	
212	1	1	1	1	1	193 260-006	Connector	7-pole	XS3
213	1	1	1	1	1	193 260-151	Connector	3-pole, to R49 on AP1	
214	1	1	1	1	1	193 260-157	Connector	9-pole	XS1
215	1	1	1	1	1	193 260-153	Connector	5-pole, before ser.no. 618 ...	XS2
	1	1	1	1	1	193 260-150	Connector	2-pole, from ser.no. 618 ...	
	1	1	1	1	1	193 260-151	Connector	3-pole, from ser.no. 618 ...	
216	1	1	1	1	1	193 260-153	Connector	5-pole, to R50 on AP1	
217a	-	1	1	1	1	469 477-002	Cable inlet	With mains terminal	XT1
	1	-	-	-	-	469 477-001	Cable inlet		
217b	1	-	-	-	-	162 781-011	Mains terminal	Delivered as 12-pole, to be cut to 2-pole With text	XT1
	1	-	-	-	-	468 882-005	Insulation		
218	6	6	6	6	6	192 562-105	Cage nut	M6	
219	3	3	3	3	3	469 381-001	Speednut		
220	1	-	-	-	-	321 229-003	Thermal cutout	Opens at 110°C	ST2
	-	1	1	1	1	320 918-001	Thermal cutout	Opens at 130°C	ST2
221	1	1	1	1	1	469 377-001	Connection block		XT2
222	1	1	1	1	1	469 378-001	Insulation		
223	1	1	1	1	1	469 379-001	Bus bar		
224	1	1	1	1	1	486 159-880	Circuit board	Before ser.no. 618, and from ser.no. 717	AP1
	1	1	1	1	1	486 159-882	Circuit board	From ser.no. 618	AP1
225	1	1	1	1	1	193 759-002	Light-emitting diode	Yellow	V7
226	1	1	1	1	1	193 759-001	Indicating lamp	White, 28 V	HL1
227	-	1	-	-	-	366 296-001	Knob	Included in item 202	
	1	-	1	1	1		Knob		
228	2	2	2	2	2	191 510-104	Knob		

Item no	Qty 180 1ph	Qty 180 400	Qty 180 rec	Qty 240 400	Qty 240 rec	Ordering no.	Denomination	Notes	C
229	1	1	1	-	-	469 365-001	Panel	With text	
	-	-	-	1	1	469 366-001	Panel	With text	
230	1	-	-	1	1	469 479-001	Fan	24 V DC	EV1
231	1	-	-	-	-	467 169-001	Resistor		R1
232	1	-	-	-	-	369 864-881	Resistor	5.6 kΩ 5 W	R2



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