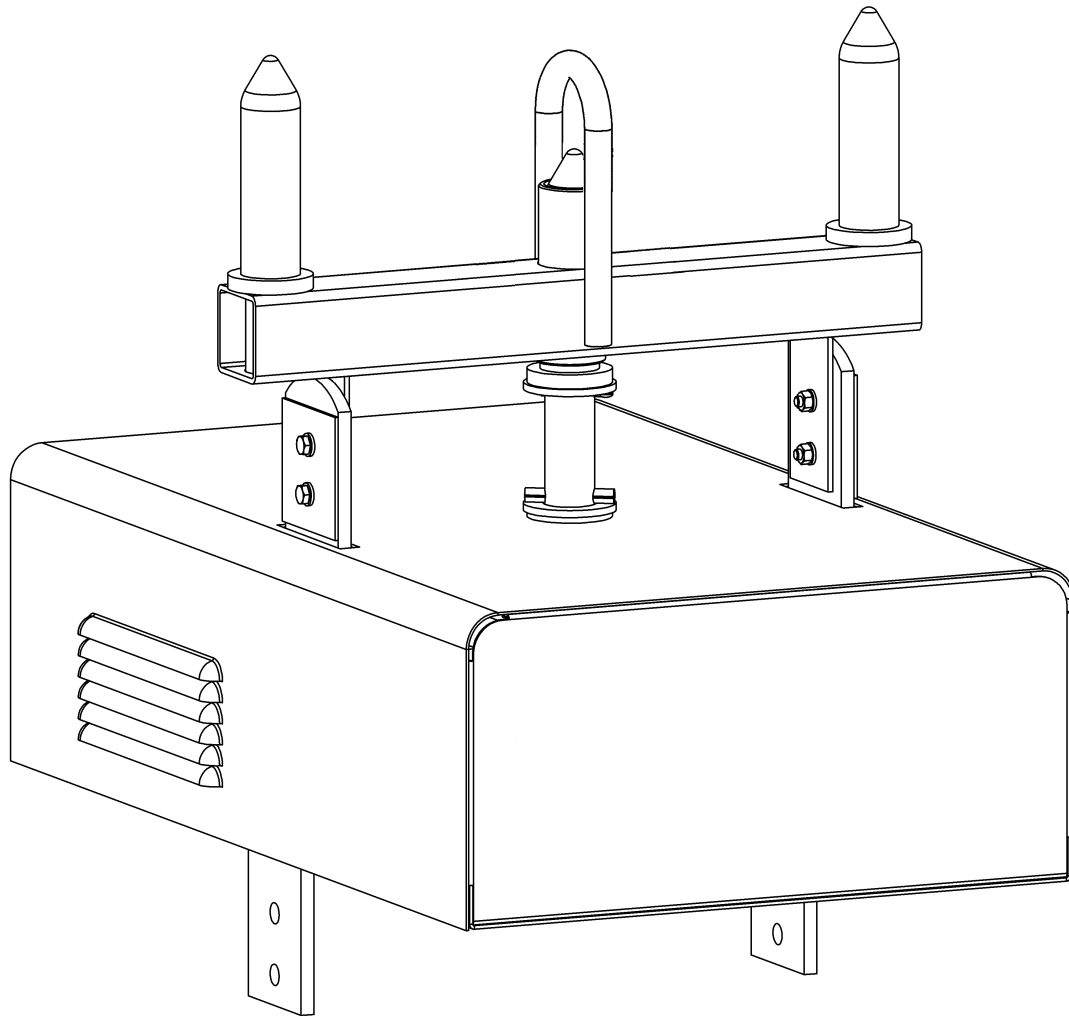




FEED SELECTOR



INSTRUCTION MANUAL

0349 301 099 Edition 120120

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Do not dispose of electrical equipment together with normal waste!

In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and returned to an environmentally compatible recycling facility. As the owner of the equipment, you should get information on approved collection systems from our local representative.

By applying this European Directive you will improve the environment and human health!

1 DIRECTIVE

DECLARATION OF CONFORMITY

ESAB Welding Equipment AB, S-695 81 Laxå, Sweden, gives its unreserved guarantee that Feed selector from serial number 450 complies with standard IEC/EN 60974-1, in accordance with the requirements of directive (73/23/EEC).

Laxå 22-07-2005



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2 SAFETY

Users of ESAB welding equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of welding equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the welding equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the welding equipment must be familiar with:

- its operation
- location of emergency stops
- its function
- relevant safety precautions
- welding

2. The operator must ensure that:

- no unauthorised person is stationed within the working area of the equipment when it is started up.
- no-one is unprotected when the arc is struck

3. The workplace must:

- be suitable for the purpose
- be free from draughts

4. Personal safety equipment

- Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves.
- do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.

5. General precautions

- make sure the return cable is connected securely.
- work on high voltage equipment **may only be carried out by a qualified electrician.**
- appropriate fire extinguishing equipment must be clearly marked and close at hand.
- lubrication and maintenance must **not** be carried out on the equipment during operation.

3 INTRODUCTION

Feed selector is switch unit for completing two wire feeders with one welding rectifier for welding with use of two different electrode wires and one or two shielding gases.

It switches one pole of the welding rectifier and all needed control circuits between wire feeders. Switching is performed automatically, by the signal from wire feeder. Wire feeder that is not used is automatically disabled for the welding.

Thus it enables welding only with the same polarity for both processes.

Feed selector is basically intended for chopper and thyristor welding rectifiers, as they provide possibility of remote voltage adjustment. In very limited cases it may be used also for primary-tapped welding rectifiers, however they don't provide remote voltage adjustment and changing the wire feeder will be accompanied with manual voltage changing.

4 TECHNICAL DATA

Permissible load	
Outputs:	
35% duty cycle	630 A
60% duty cycle	500 A
100% duty cycle	400A
Input:	
60% duty cycle	630A
100% duty cycle	500A
Control voltage	42V 50/60 Hz
Dimensions l x w x h	605x375x180
Weight	34 kg
Enclosure class	IP23

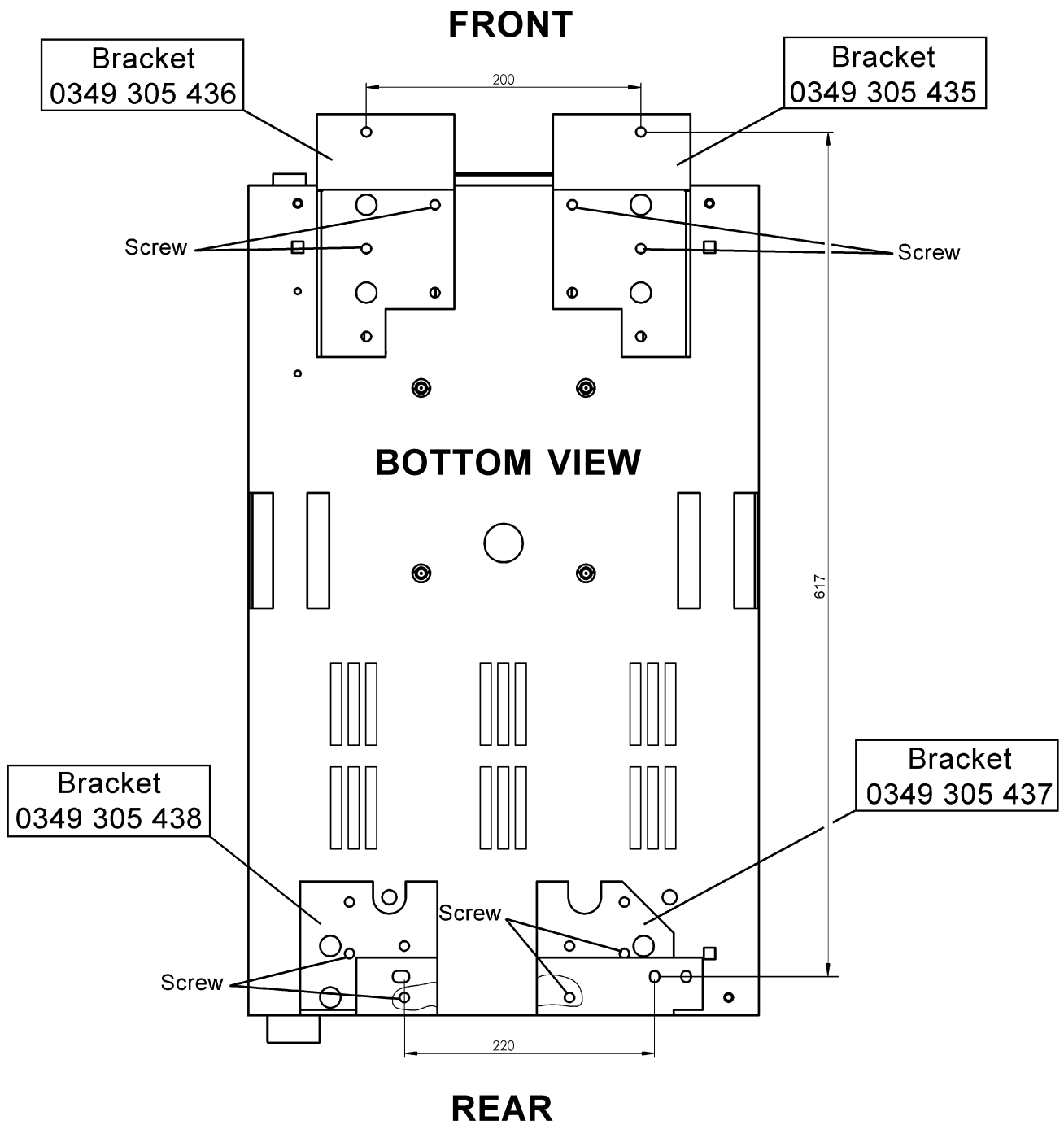


Fig. 1. Mounting brackets fastening on Origo™ Mig 410, 510.

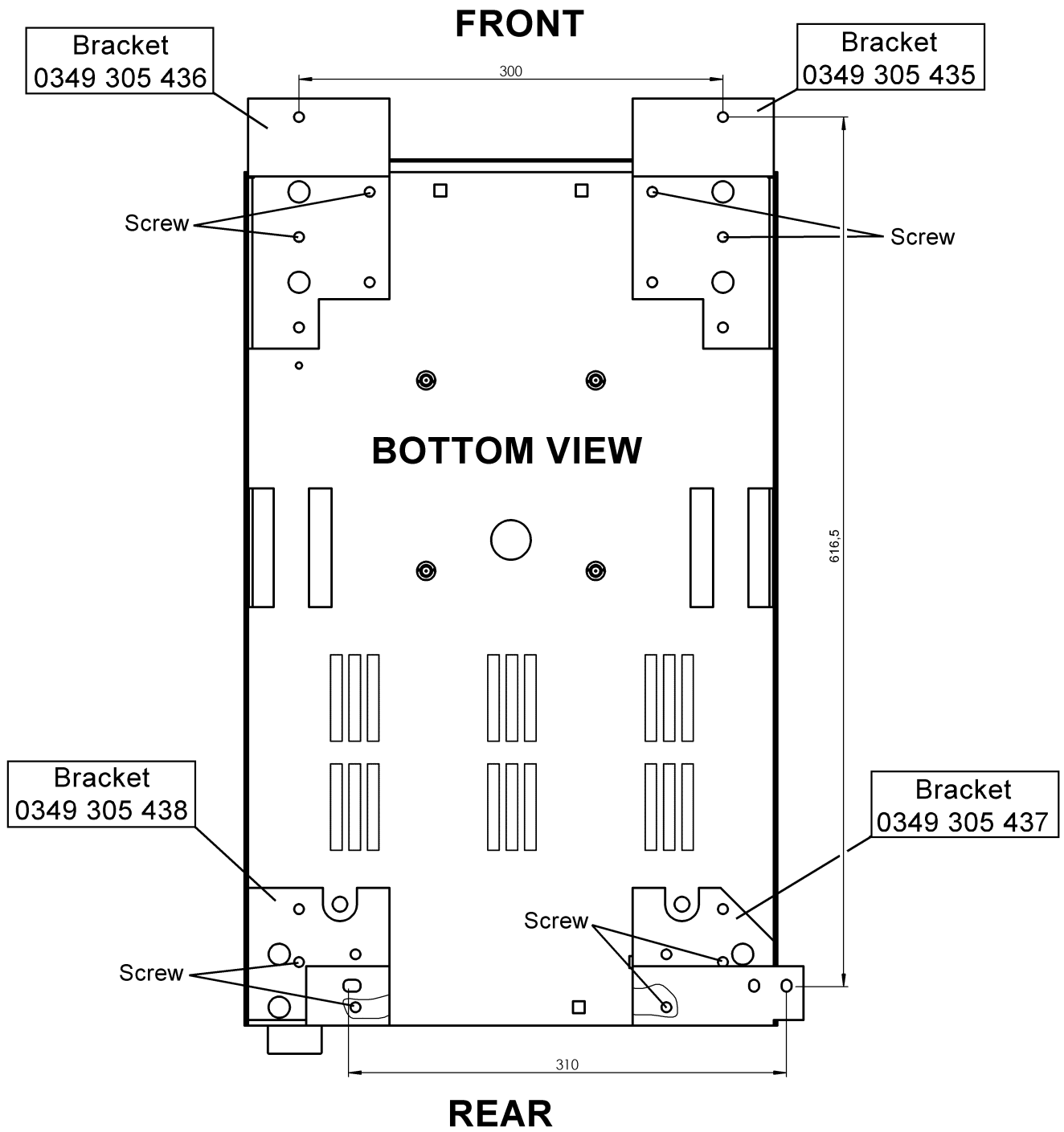


Fig. 2 Mounting brackets fastening on Origo™ Mig 400t, 500t.

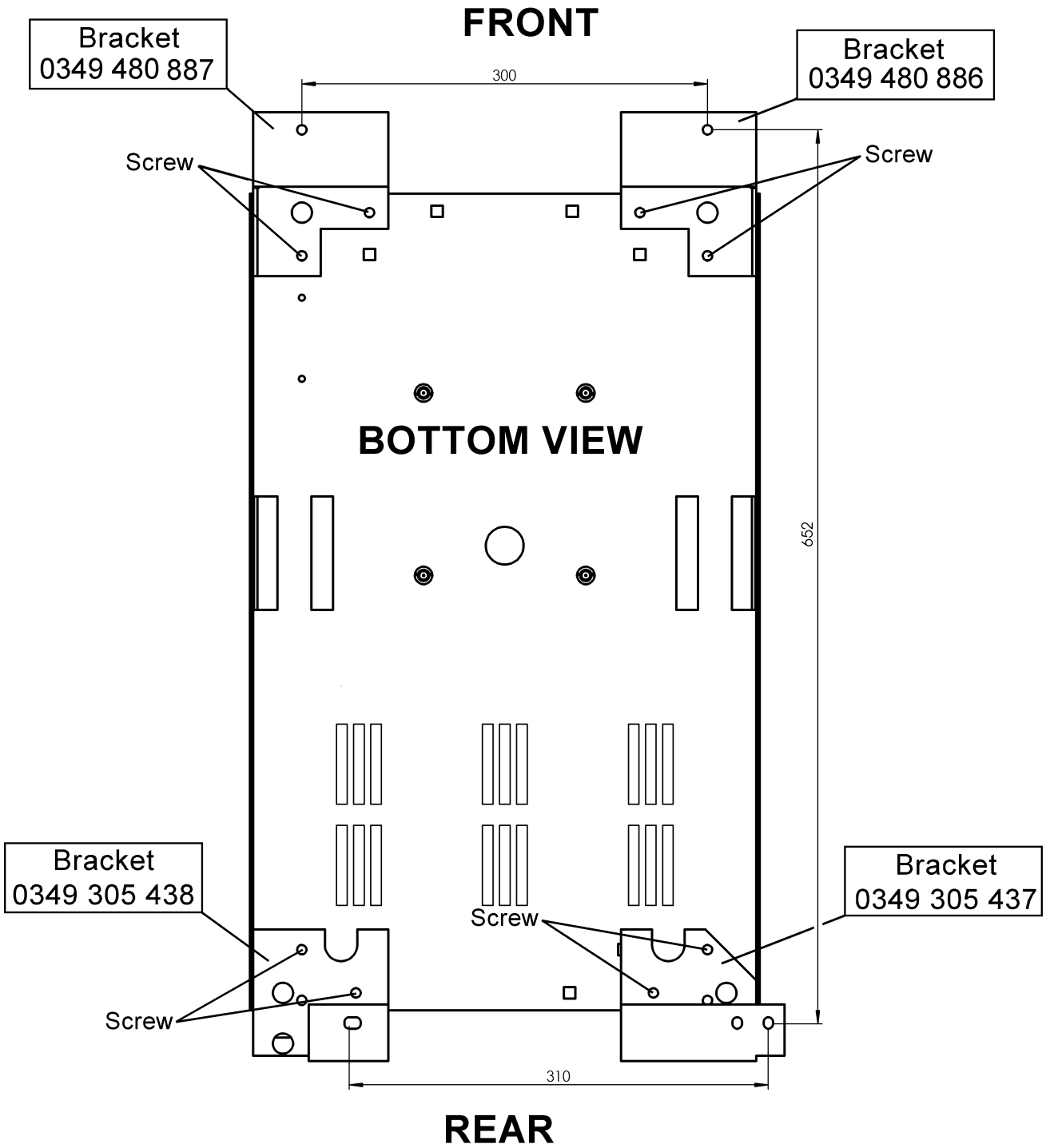


Fig. 3 Mounting brackets fastening on Origo™ Mig 402c/cw, 502c/cw, 652c/cw.

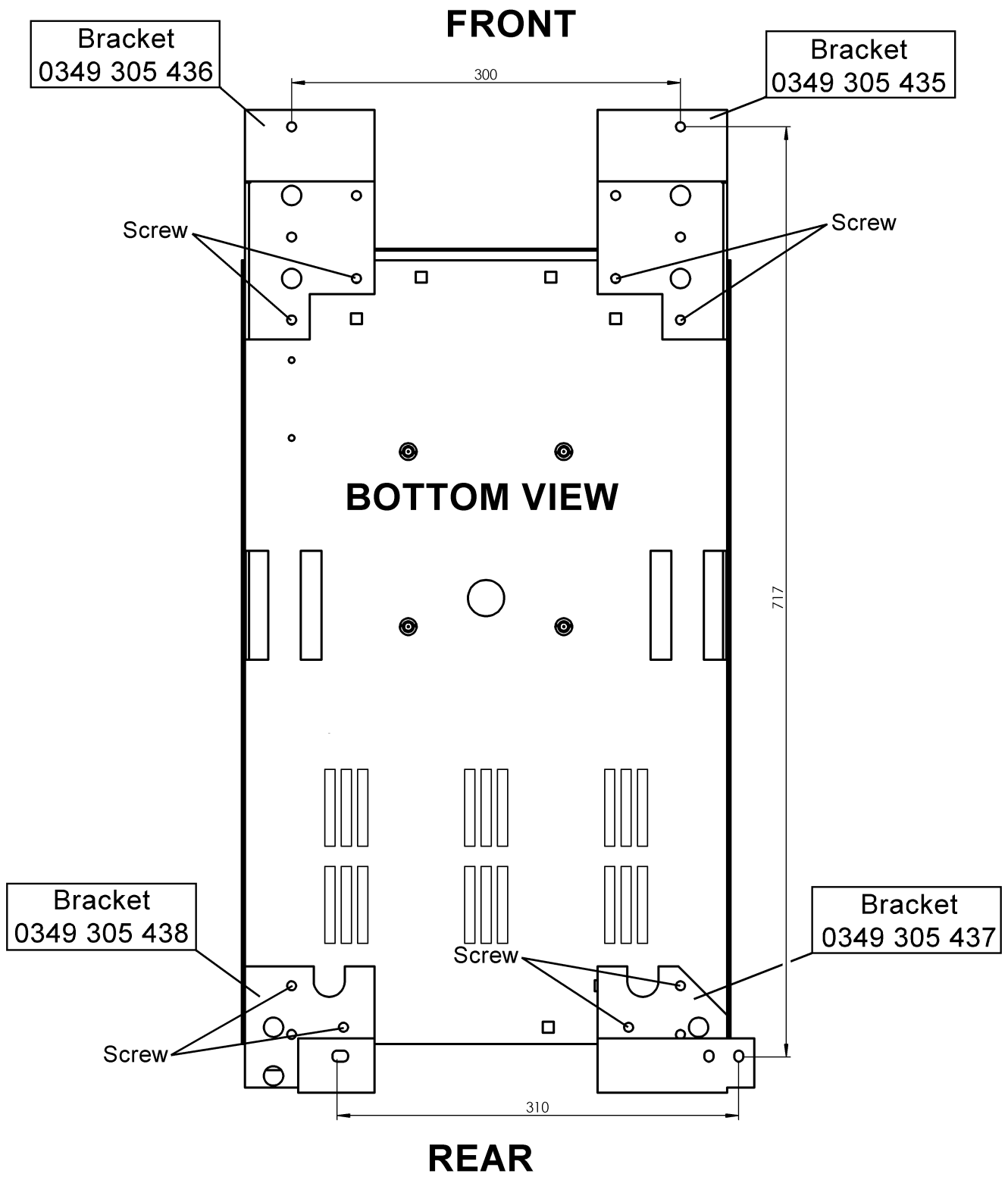


Fig. 4 Mounting brackets fastening on Origo™ Mig 630t.

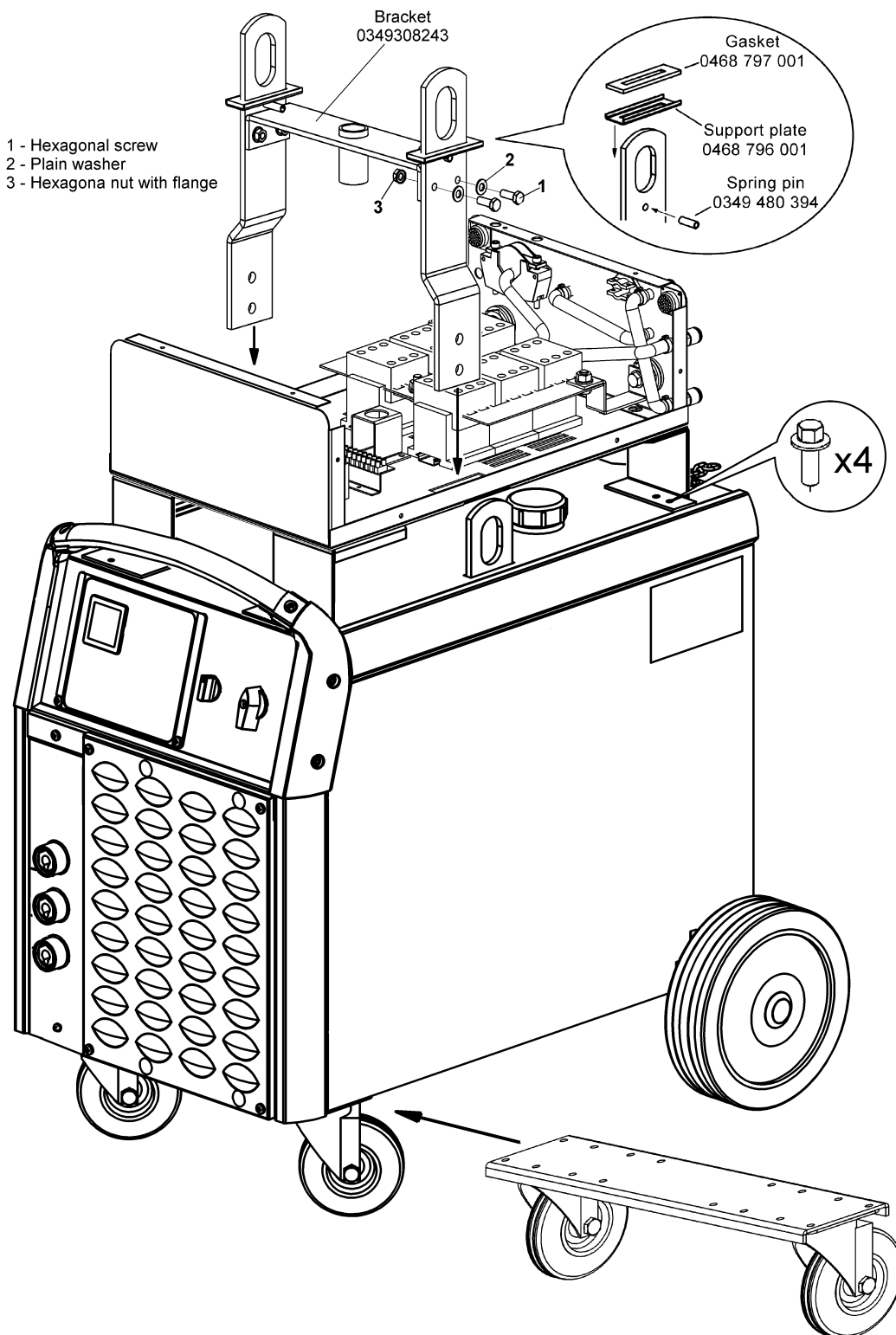


Fig. 5. Mounting scheme.

Attention: To provide required stability of the whole set, application of the stabilizer kit 0349303474 for welding rectifiers Origo™ Mig 410, 510 is strictly demanded.

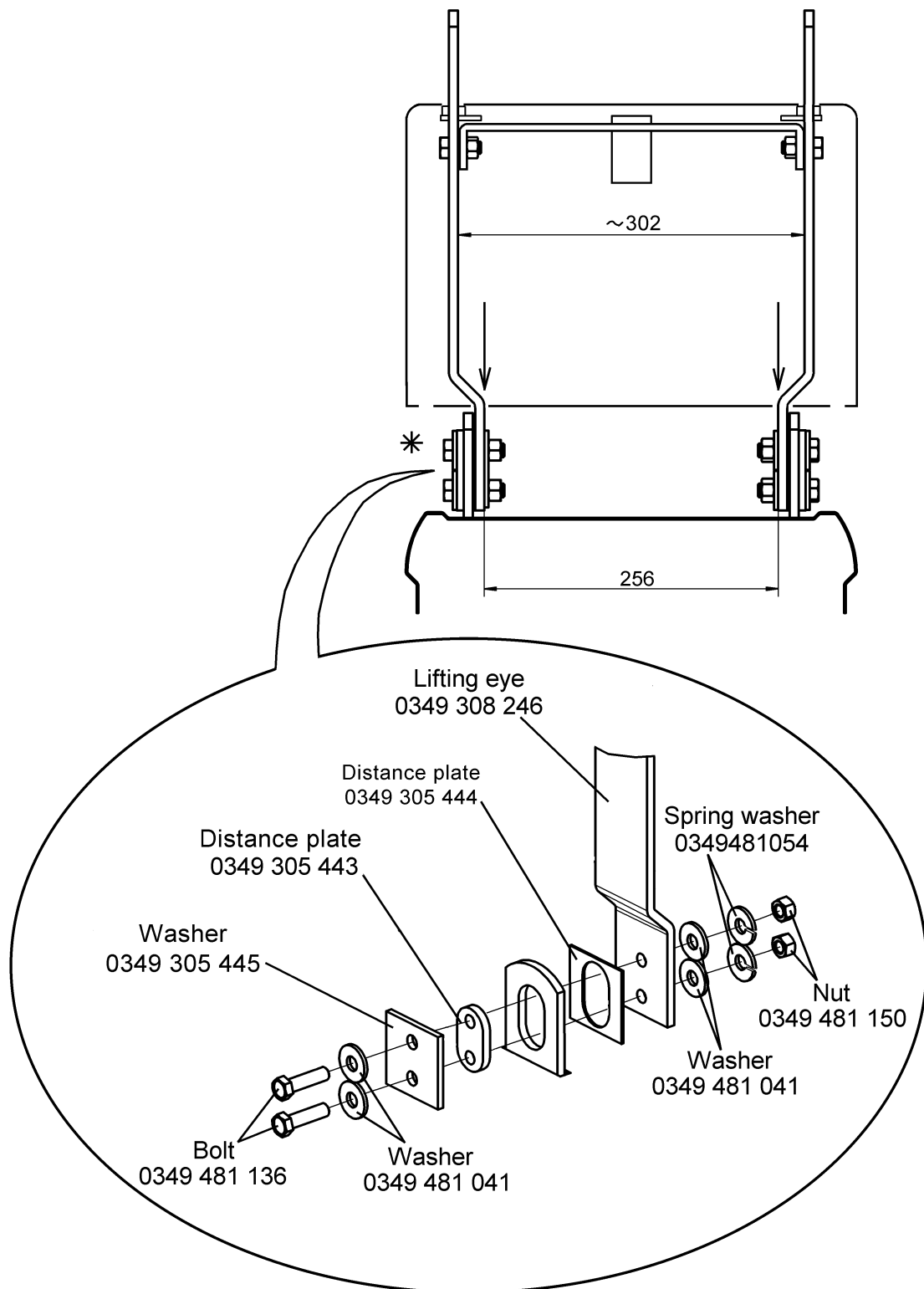


Fig. 6 Mounting on Origo™ Mig 410, 510.

* Coupling should be made loosely until assembling according to fig.8. Once completed, they should be finally tightend.

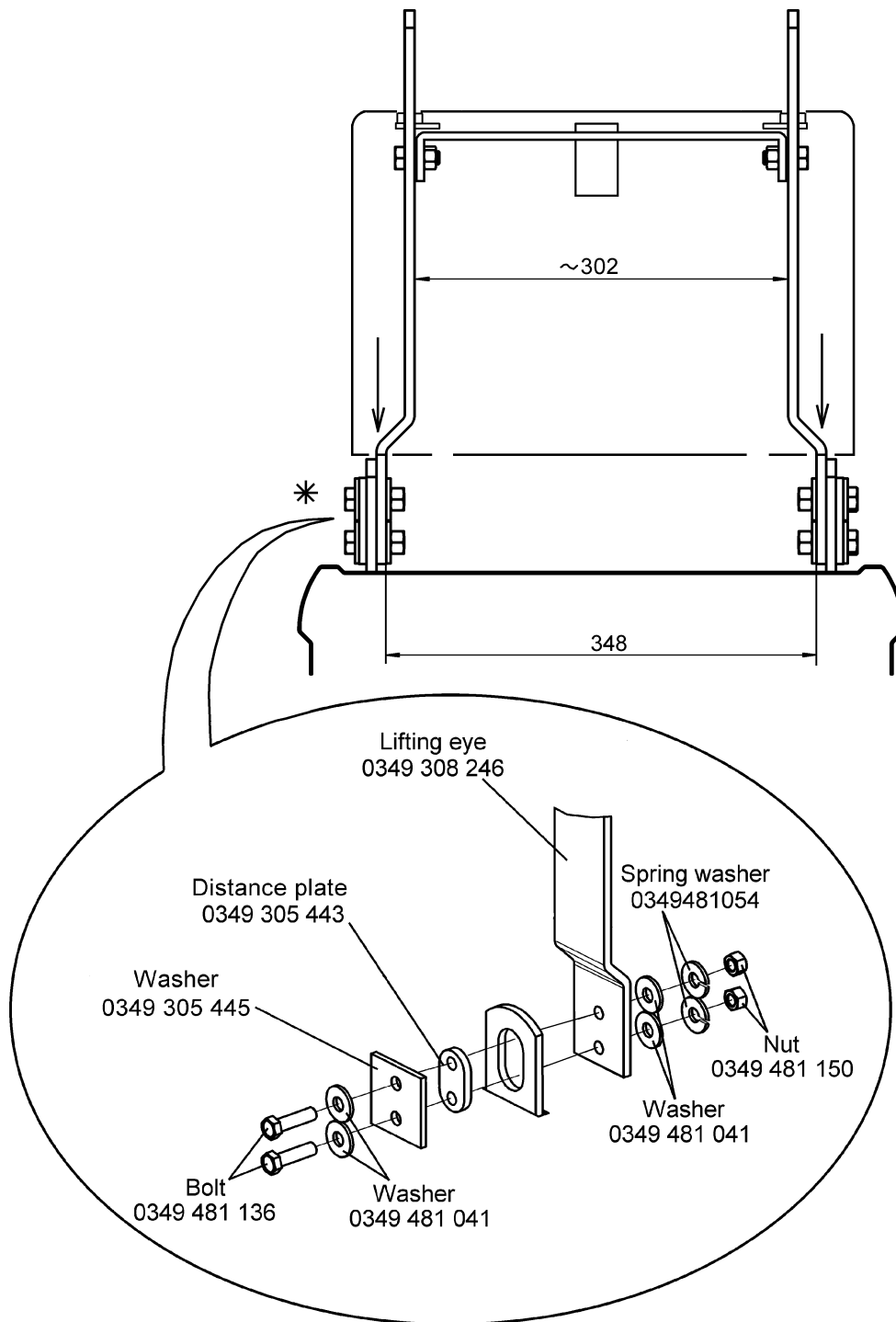


Fig. 7 Mounting on Origo™ Mig 400t, 500t, 630t, 402c/cw, 502c/cw, 652c/cw.

* Coupling should be made loosely until assembling according to fig.8. Once completed, they should be finally tightend.

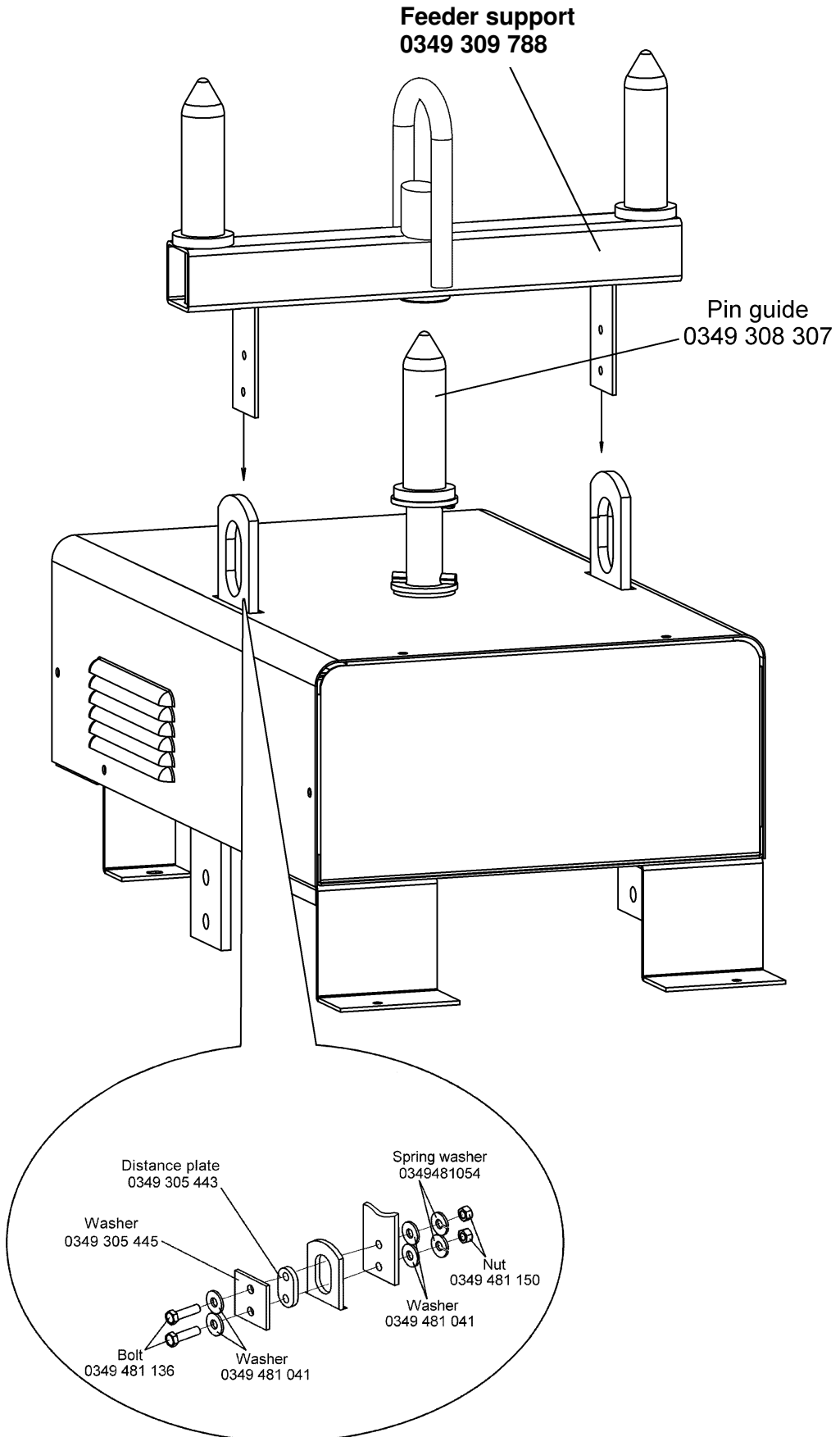


Fig. 8. Mounting of the feeder's carrier.

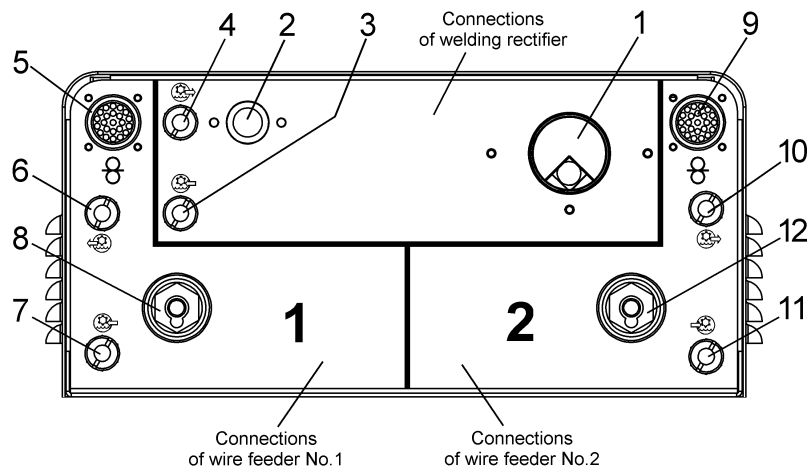


Fig. 9. External connections - rear panel .

1. Input current cable to welding rectifier.
2. Control cable to welding rectifier.
3. Cooler output connection.
4. Cooler input connection.
5. Control cable socket to wire feeder No 1.
- 6,7. Water connection of wire feeder No 1.
8. Connection for welding current to wire feeder No1.
9. Control cable socket to wire feeder No 2.
- 10,11. Water connection of wire feeder No 2.
12. Connection for welding current to wire feeder No2.

Attention:

If only one water cooled welding gun is used respective water connection: 6-7 or 10-11 should be closed by means of the connector 0349308662 to open the way o water circulation.

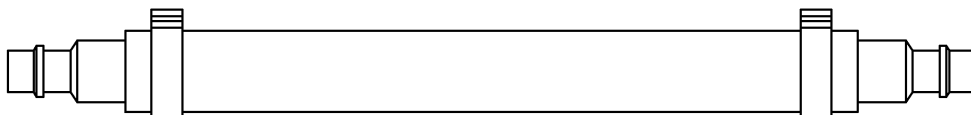


Fig. 10. Water connector.

Attention:

Depending on applied welding rectifier and anticipated welding currents respective cross section of the cable providing current to wire feeder should be applied.

6 MAINTENANCE

Inspection and cleaning.

Check regularly that the unit is free from dirt. The unit should be regularly blown clean using dry compressed air at reduced pressure. More frequently in dirty environments.

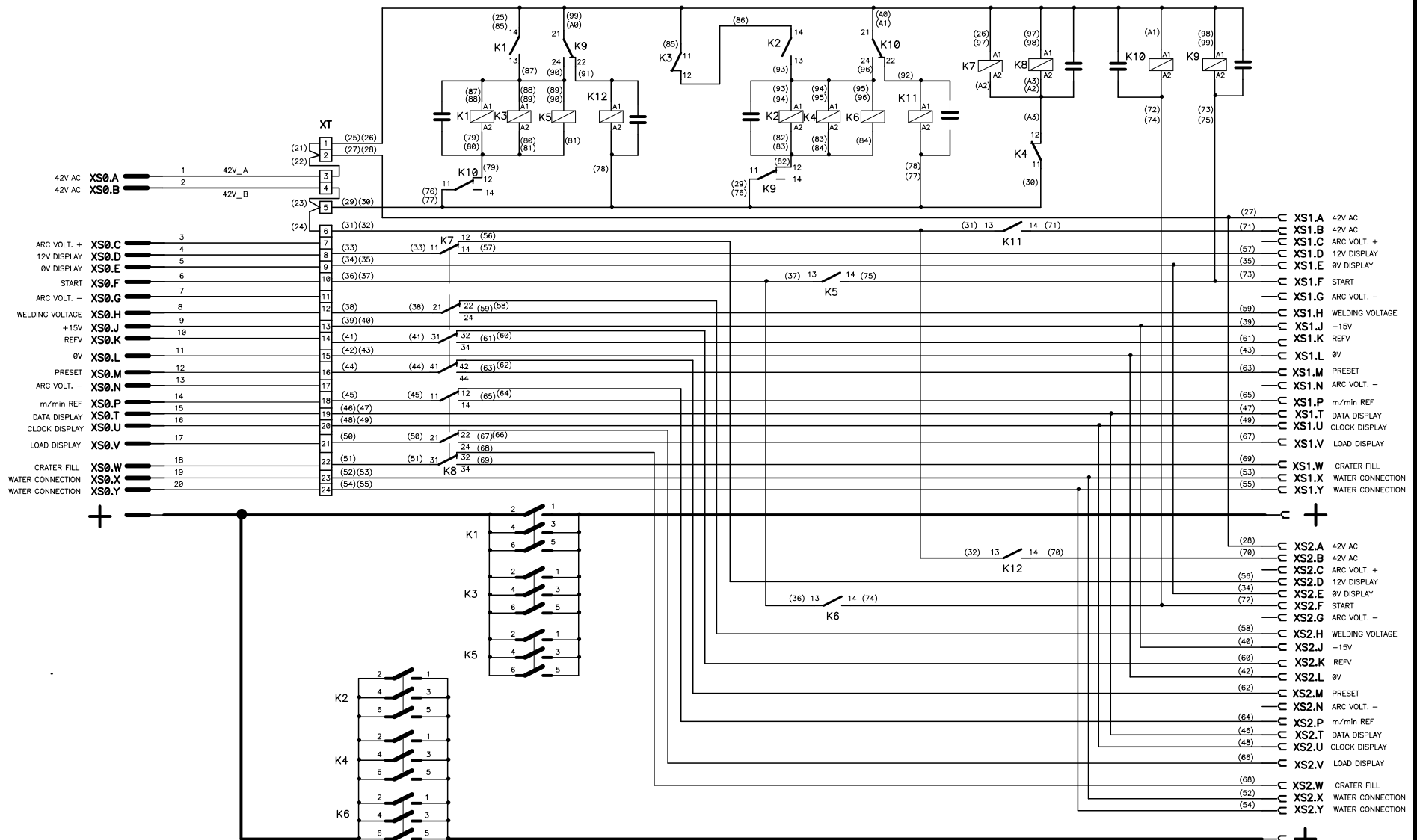


Fig. 11. Feed selector for Origo™ Mig 410, 510, 400t, 500t, 630t

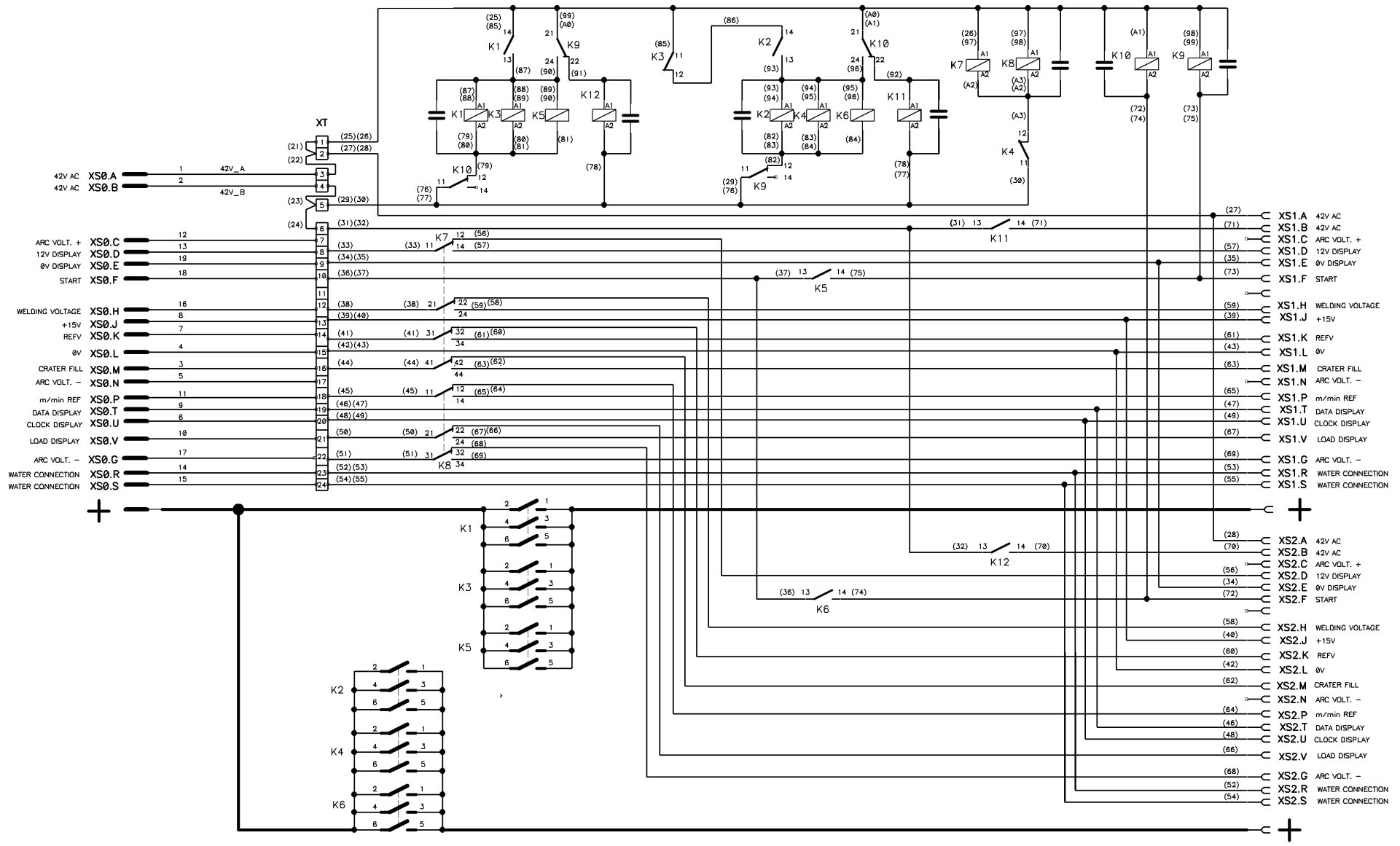


Fig. 12. Feed selector for Origo™ Mig 402c/cw, 502c/cw, 652c/cw

8 ACCESSORIES

Feed selector	0349 308 248
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<u>Part</u>	<u>Qty</u>	<u>Part No</u>	<u>Fig. No</u>
Bracket	1	0349305435	1,2,4
Bracket	1	0349305436	1,2,4
Bracket	1	0349305437	1,2,3,4
Bracket	1	0349305438	1,2,3,4
Gasket	2	0468797001	5
Support plate	2	0468796001	5
Spring pin	2	0349480394	5
Bracket	1	0349308243	5
Hexagon screw	4	0349481125	5
Plain washer	4	0349481038	5
Hexagon nut with flange	4	0349481405	5
Washer	4	0349305445	6,7,8
Distance plate	4	0349305443	6,7,8
Distance plate	2	0349305444	6
Lifting eye	2	0349308246	6,7
Hexagon screw	8	0349481136	6,7,8
Plain washer	16	0349481041	6,7,8
Spring washer	8	0349481054	6,7,8
Hexagon nut	8	0349481150	6,7,8
Feeder support	1	0349 309 788	8
Guide pin	1	0349308307	8
Water connector	1	0349 308 662	10

Optional Accessories

T-piece gas 0457 393 882

KIT – Stabilizer Origo™ Mig 0349 303 474

- Fig. No 5

Feed selector	0349 311 680
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<u>Part</u>	<u>Qty</u>	<u>Part No</u>	<u>Fig. No</u>
Bracket	1	0349305435	3
Bracket	1	0349305436	3
Bracket	1	0349480886	3
Bracket	1	0349480887	3
Gasket	2	0468797001	5
Support plate	2	0468796001	5
Spring pin	2	0349480394	5
Bracket	1	0349308243	5
Hexagon screw	4	0349481125	5
Plain washer	4	0349481038	5
Hexagon nut with flange	4	0349481405	5
Washer	4	0349305445	6,7,8
Distance plate	4	0349305443	6,7,8
Distance plate	2	0349305444	6
Lifting eye	2	0349308246	6,7
Hexagon screw	8	0349481136	6,7,8
Plain washer	16	0349481041	6,7,8
Spring washer	8	0349481054	6,7,8
Hexagon nut	8	0349481150	6,7,8
Feeder support	1	0349309788	8
Guide pin	1	0349308307	8
Water connector	1	0349308662	10

Optional Accessories

T-piece gas	0457 393 882
KIT – Stabilizer Origo™ Mig	0349 303 474

9 ORDERING NUMBERS

0349 308 248 – Feed Selector for: Origo™ Mig 410, 510, 400t, 500t, 630t
0349 311 680 – Feed Selector for: Origo™ Mig 402c/cw, 502c/cw, 652c/cw

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