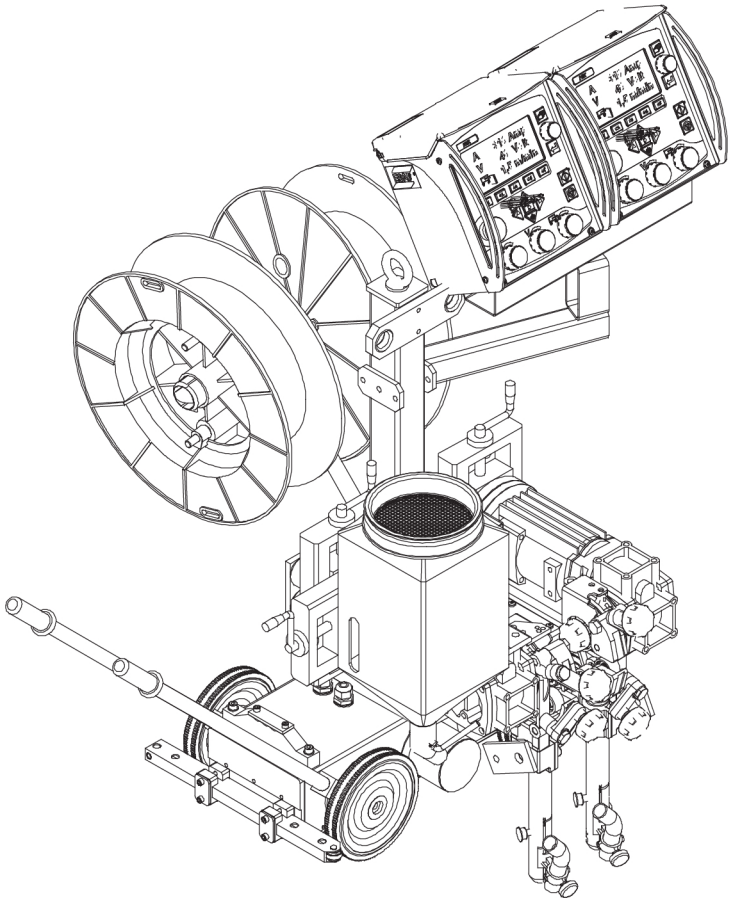
A6 Mastertrac Tandem

A6TF F2



Spare parts list

0463 649 001 GB 20261119

Valid for: serial no. 940-xxx-xxxx

Ordering number	Denomination	Type	Notes
0461 232 882	A6 Mastertrac Tandem	A6TF F2	

SPARE PARTS **4**
Automatic welding machine – A6TF F2 Mastertrac Tandem **4**
Straightener **7**
Straightener **8**
Contact jaw tube **9**
Carriage – A6TFE/TGE **10**
Flux hopper **13**
Flux valve **14**
Slide, manually operated **15**
Flux nozzle complete **16**

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SPARE PARTS

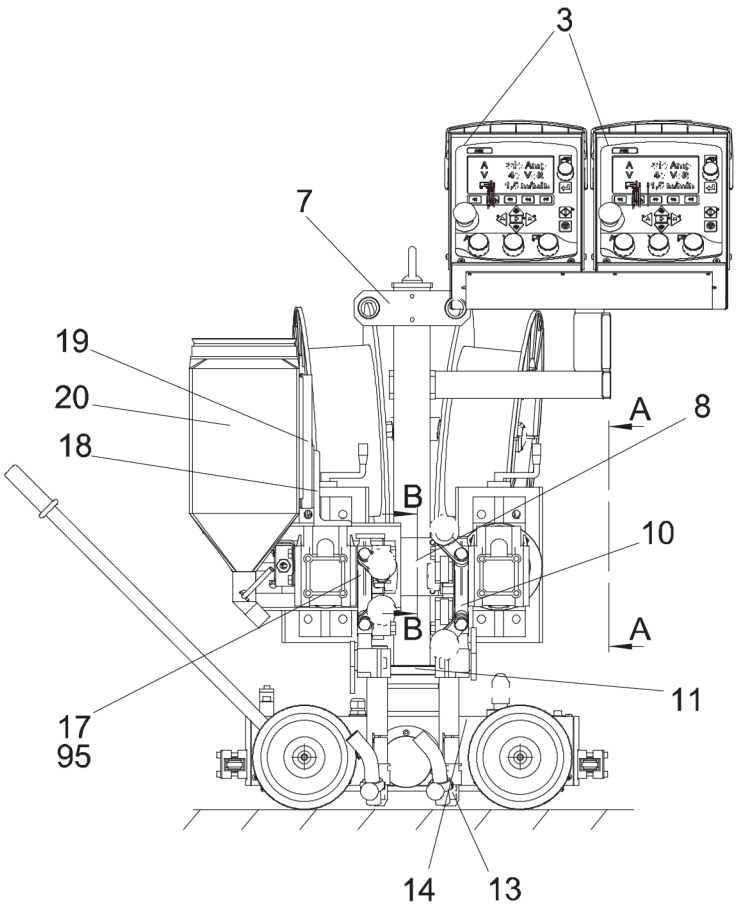
Automatic welding machine – A6TF F2 Mastertrac Tandem

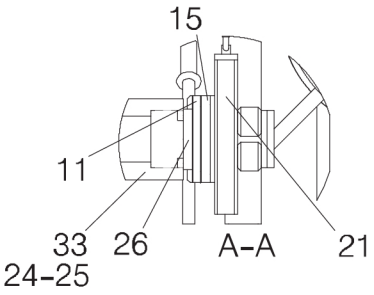
Item	Qty	Ordering no.	Denomination	Notes
		0461 232 882	**Automatic welding machine**	**A6TF F2 Mastertrac Tandem**
3	2	0460 504 880	Control box	PEK, see separate manual
6	2	0146 967 880	Brake hub	
7	1	0334 457 880	Wire guide	
8	1	0334 184 001	Plate	
10	1	0147 639 881	Wire straightener (left mounted)	D35
11	2	0334 170 001	Clamping ring	
13	2	0417 959 880	Contact jaw tube	L=220
14	1	0449 490 881	Carriage	
15	1	0334 171 001	Plate	
17	1	0147 639 880	Wire straightener (right mounted)	D35
18	1	0334 294 001	Bracket	
19	1	0148 487 880	Bracket for flux hopper	
20	1	0147 649 881	Flux hopper	10 l
21	4	0154 465 880	Manual slide	L=90
23	1	0145 063 906	Motor with gear	A6 VEC (156:1), see separate manual
24	2	0460 907 891	Motor cable	1.6 m
25	2	0218 810 183	Insulated hand wheel	
26	1	0334 172 001	Gear bracket	
27	1	0334 180 880	Reel holder	
29	1	0334 177 001	Plate	
31	8	0278 300 180	Insulator	2000 V
32	1	0334 168 881	Column	
33	1	0145 063 896	Motor with gear	A6 VEC (156:1), see separate manual
34	1	0334 297 881	Box holder	
35	1	0334 179 001	Plate	
36	1	0334 185 887	Box girder beam complete	
40	1	0153 491 001	Branching tube	
42		0443 383 001	Flux hose	D32/25
43	1	0153 299 880	Flux nozzle	
57	1	0334 709 001	Spacer	
80	2	0457 713 001	Bar	
90	2	0461 239 881	Cable (arc-voltage)	1.7 m

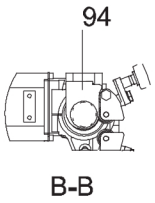
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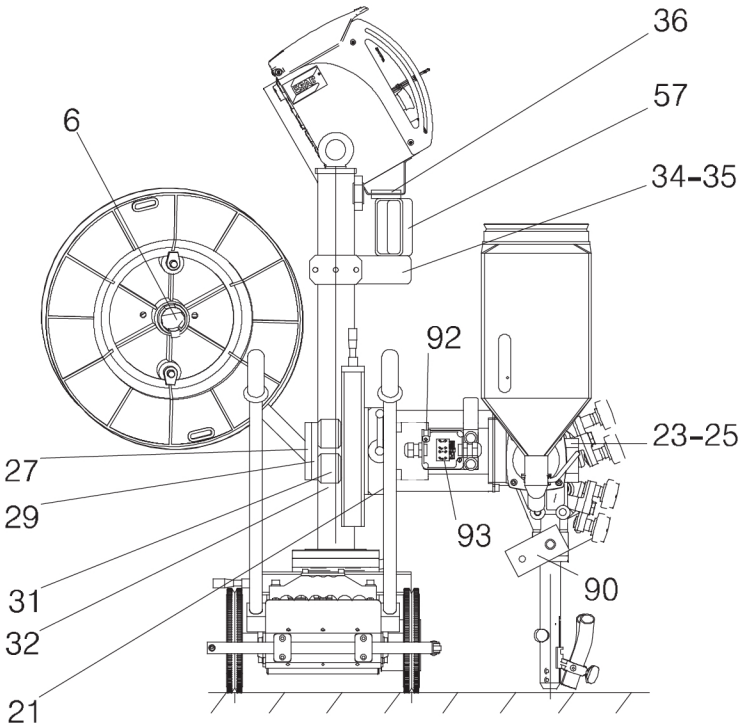
Item	Qty	Ordering no.	Denomination	Notes
92	1	0417 699 002	Clamp	
93	1	0449 498 880	Junction box complete	
94	1	0449 528 002	Protection cover, left	
95	1	0449 528 001	Protection cover, right	

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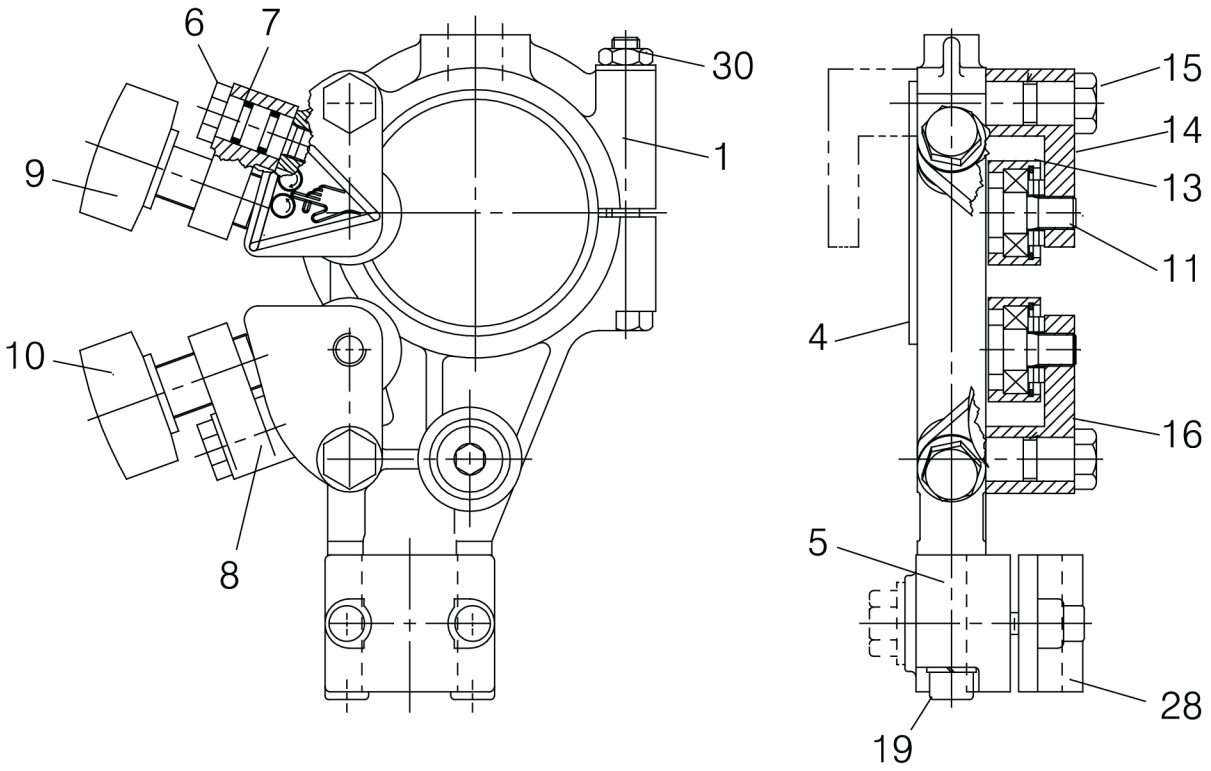

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Straightener

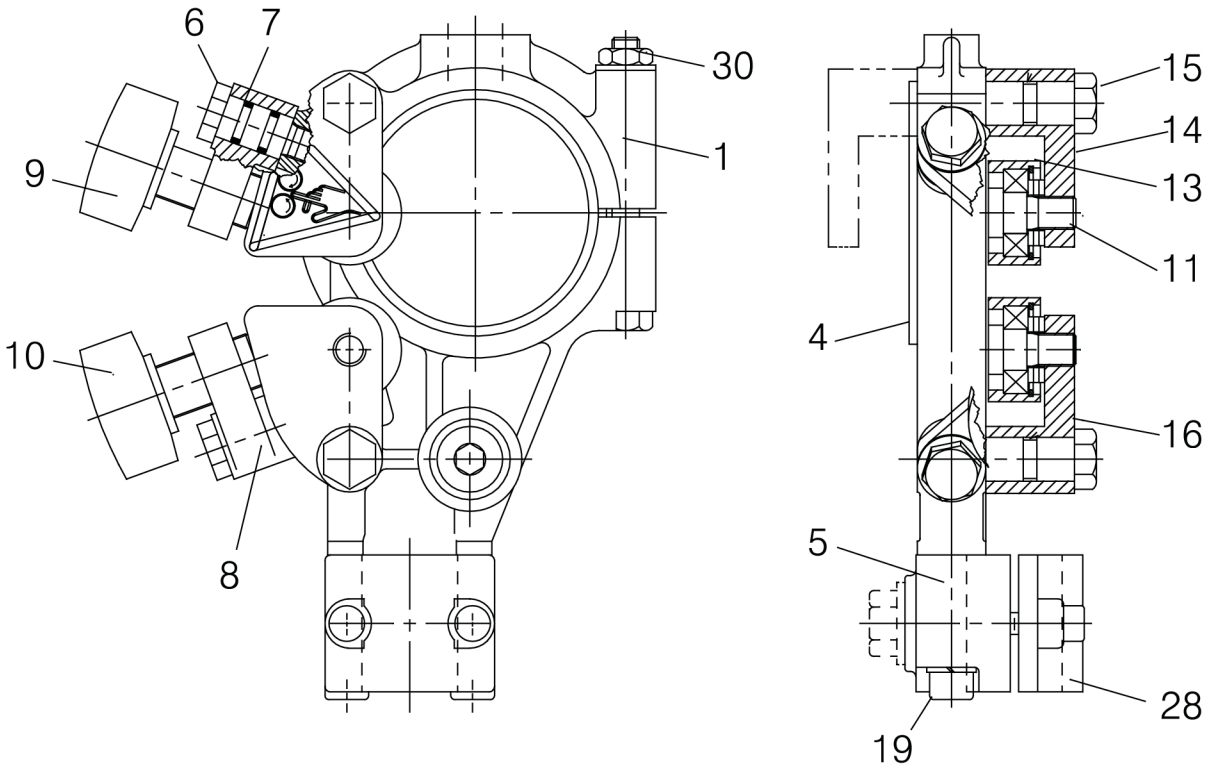
Item	Qty	Ordering no.	Denomination	Notes
		0147 639 880	**Straightener (right mounted)**	
1	1	0156 449 001	Clamp	
4	1	0215 503 601	Insulating sleeve	
5	1	0156 530 001	Clamp half	D35
6	2	0212 900 001	Spacer screw	
7	4	0215 201 209	Sealing, O-ring	D11.3×2.4
8	2	0218 400 801	Pressure roller arm	
9	1	0218 810 181	Handwheel, insulated	
10	1	0218 810 182	Handwheel, insulated	
11	3	0332 408 001	Stub shaft	
13	3	0153 148 880	Pressure roller	
14	1	0415 498 001	Pressure roller, upper	
15	2	0212 902 601	Spacer screw	
16	1	0415 499 001	Pressure roller, lower	
19	2	0219 501 013	Spring washer	D18.1/10.2
28	1	0156 531 001	Clamp half	D35
30	1	0212 601 110	Nut	M10



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Straightener

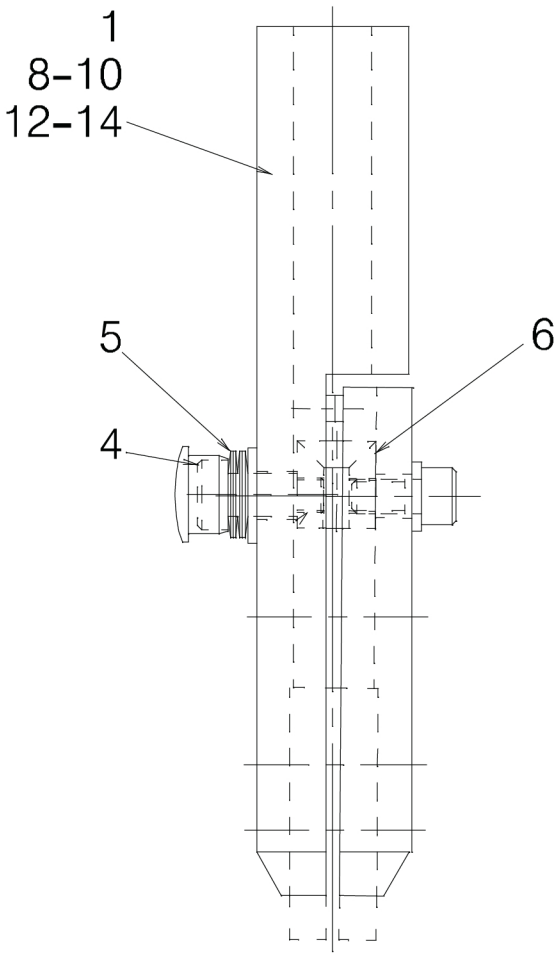
Item	Qty	Ordering no.	Denomination	Notes
		0147 639 881	**Straightener (left mounted)**	
1	1	0156 449 001	Clamp	
4	1	0215 503 601	Insulating sleeve	
5	1	0156 530 001	Clamp half	D35
6	2	0212 900 001	Spacer screw	
7	4	0215 201 209	Sealing, O-ring	D11.3×2.4
8	2	0218 400 801	Pressure roller arm	
9	1	0218 810 181	Handwheel, insulated	
10	1	0218 810 182	Handwheel, insulated	
11	3	0332 408 001	Stub shaft	
13	3	0153 148 880	Pressure roller	
14	1	0415 498 001	Pressure roller, upper	
15	2	0212 902 601	Spacer screw	
16	1	0415 499 001	Pressure roller, lower	
19	2	0219 501 013	Spring washer	D18.1/10.2
28	1	0156 531 001	Clamp half	D35
30	1	0212 601 110	Nut	M10



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Contact jaw tube

Item	Qty	Ordering no.	Denomination	Notes
		0417 959 880	**Contact jaw tube**	**L=220 mm**
1	1	0443 344 880	Contact tube	L=220 mm
4	1	0443 372 001	Fitting bolt	
5	4	0219 504 307	Cup spring	D20/10.2, T=1.1
6	1	0417 979 001	Ring	



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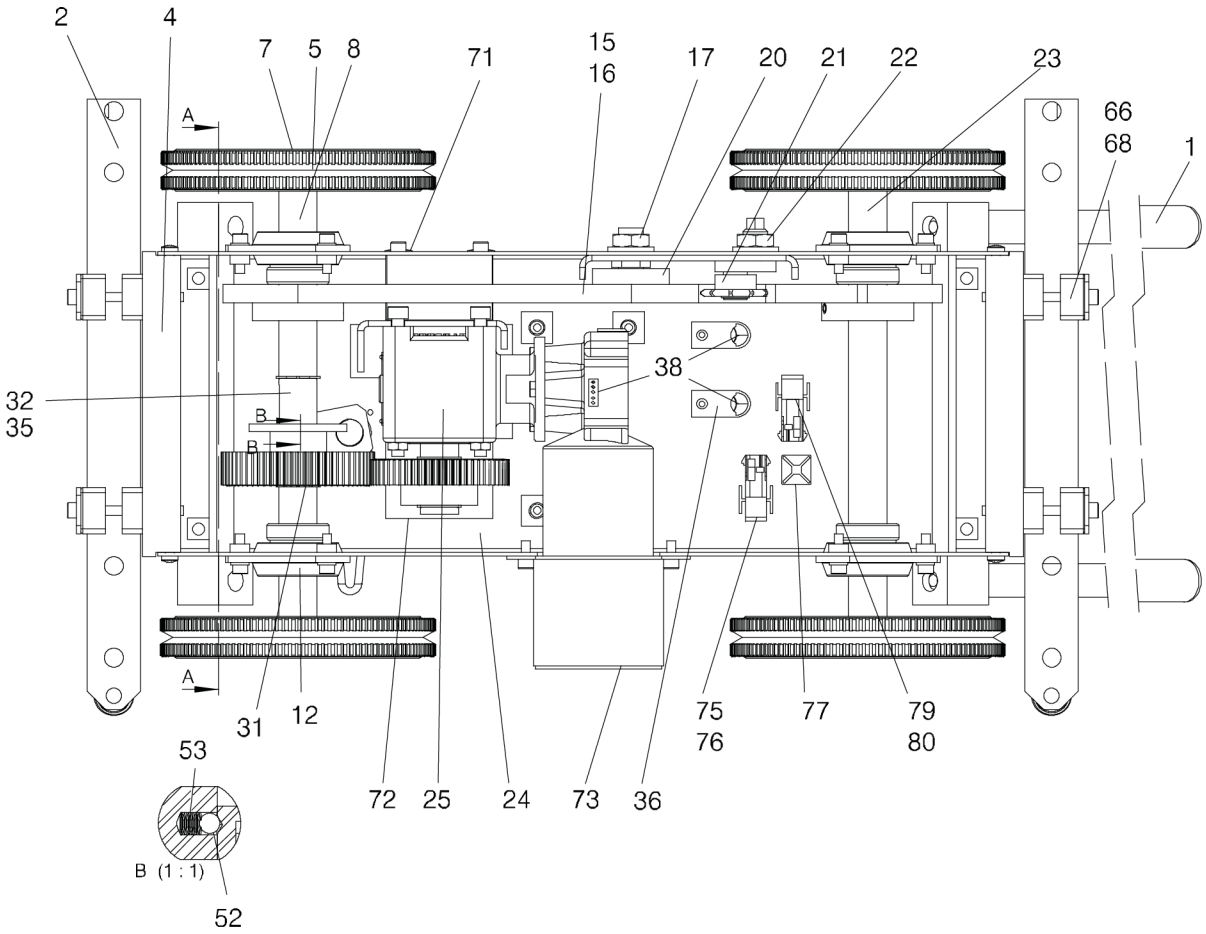
Carriage – A6TFE/TGE

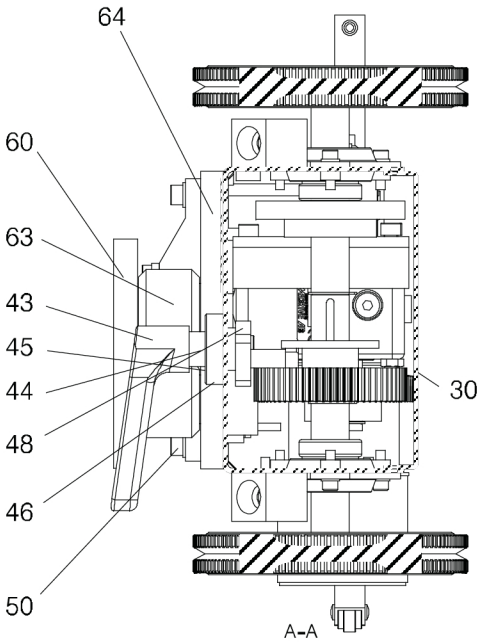
Item	Qty	Ordering no.	Denomination	Notes
		0449 490 881	**Carriage**	**A6TFE/TGE**
1	2	0334 295 880	Handle	
2	2	0449 205 880	Guide arm complete	
4	2	0334 165 880	Side plate	
5	4	0229 202 280	Wheel	
7	4	0219 501 013	Spring washer	D18.1/10.2
8	1	0334 198 880	Front shaft with sprocket	
9	1	0332 947 880	Bracket	
12	4	0334 264 001	Flange bearing unit	
15	1	0218 201 502	Chain	½"×4.88
16	1	0218 201 602	Chain lock simple	½"×4.88
17	1	0334 160 001	Stub shaft	
20	1	0334 163 880	Sprocket	
21	1	0334 162 880	Sprocket	
22	1	0334 161 001	Excenter	
23	1	0334 197 880	Rear shaft with chain wheel	
24	1	0449 480 880	Cover complete	
25	1	0449 485 881	Drive unit	
30	1	0334 167 001	Bottom plate	
31	2	0215 701 019	Circlip	D25×1.2
32	1	0334 189 001	Gear wheel	
35	1	0215 701 243	Wedge	5×5×65
36	1	0461 242 880	Pulse transducer cable	2.1 m
38	1	0461 241 880	Motor cable	1.9 m
43	1	0333 630 001	Locking arm adjustable	
44	1	0211 102 940	Roll pin	D3×28
45	1	0215 701 016	Circlip	D20
46	1	0334 196 001	Bushing	
48	1	0334 192 880	Excenter	
52	1	0221 307 001	Steel ball	7.94 mm
53	14	0219 501 101	Spring plate	D8/3.2×0.3
60	1	0334 171 001	Plate	
63	4	0278 300 180	Insulator	
64	1	0334 706 001	Plate	
66	8	0449 206 001	Clamp	
68	4	0191 498 003	Cover plate	
71	2	0192 230 107	Dummy plug	D=16
72	1	0449 487 001	Attachment	

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Item	Qty	Ordering no.	Denomination	Notes
73	1	0461 213 880	Motor attachment	
75	1	0192 784 002	Sleeve plug	2-pol.
76	2	0192 784 102	Cap	
77	1	0191 998 103	Attachment	
79	1	0192 784 001	Pin plug	2-pol.
80	2	0192 784 101	Pin	

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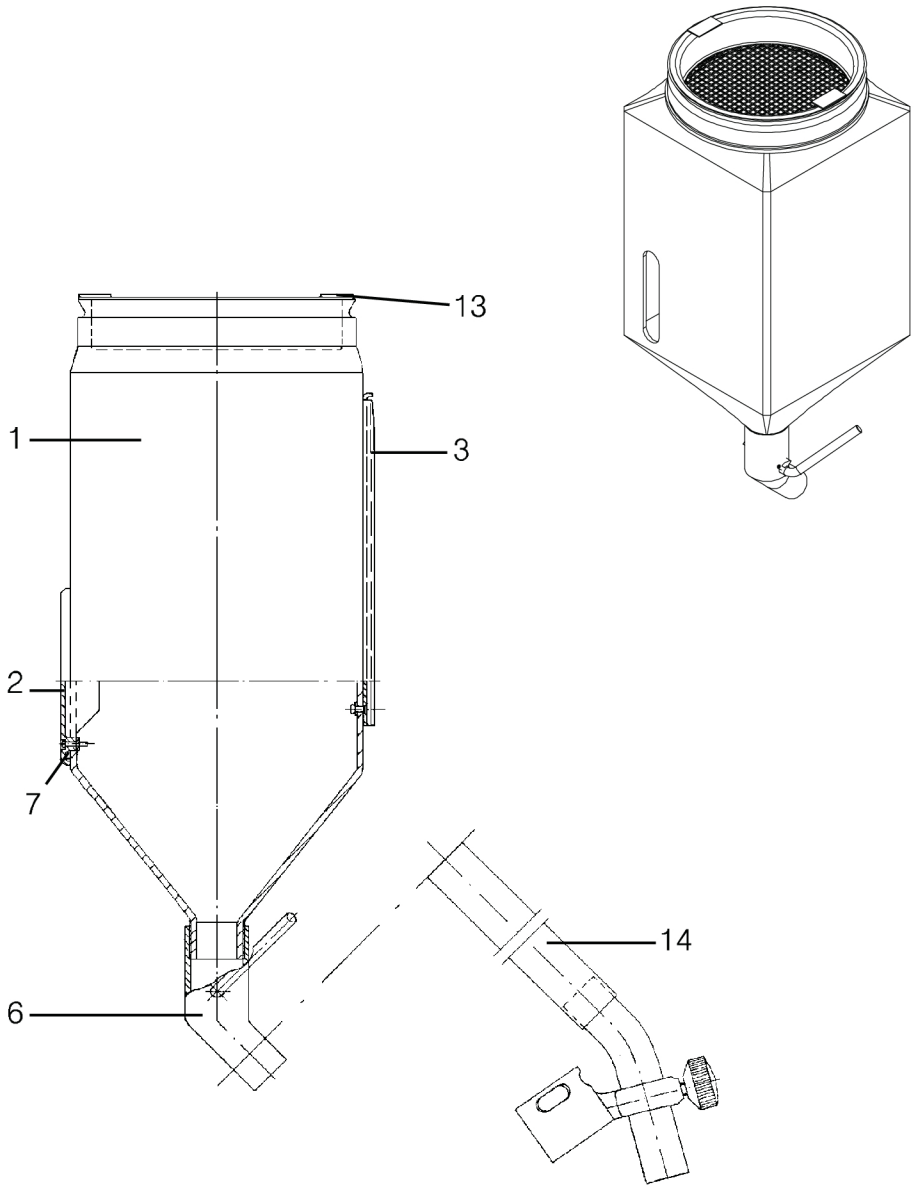

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Flux hopper

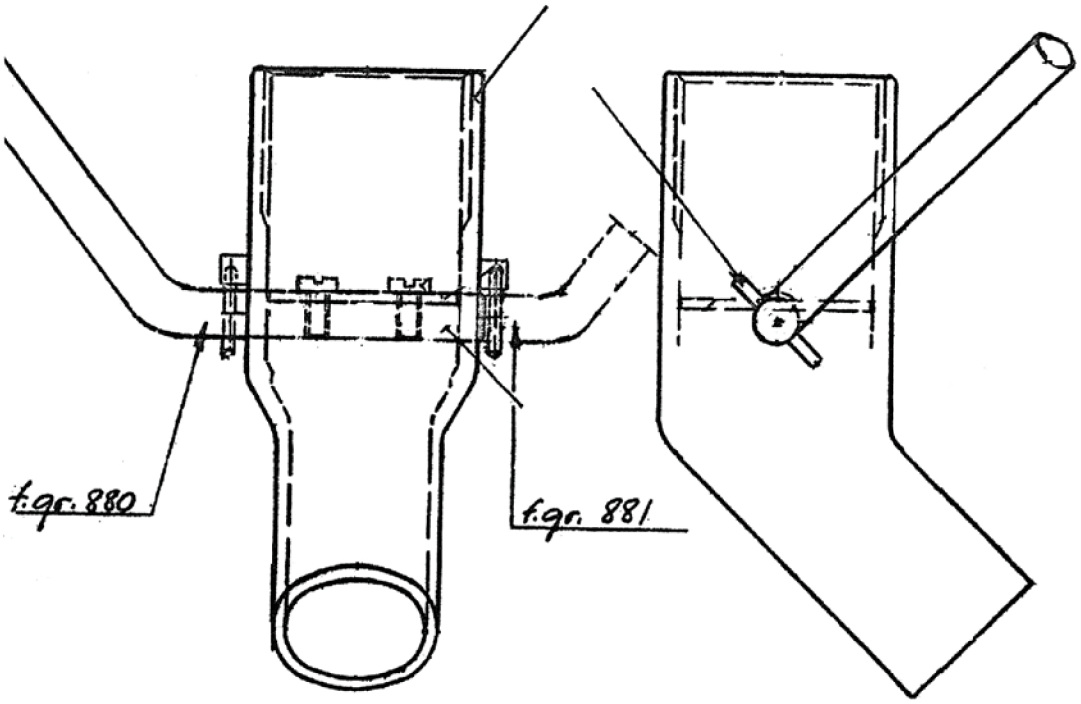
Item	Qty	Ordering no.	Denomination	Notes
		0147 649 881	**Flux hopper**	**10 l**
1	1	0154 007 001	Flux hopper	
2	1	0148 837 001	Window (A6 flux hopper)	
3	1	0147 645 001	Mounting	
6	1	0153 347 880	Flux valve	
7	1	0215 201 232	Sealing, O-ring	69.2×5.7
13	1	0020 301 780	Flux strainer	
14	1	0443 383 002	Flux hose	L=500



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Flux valve

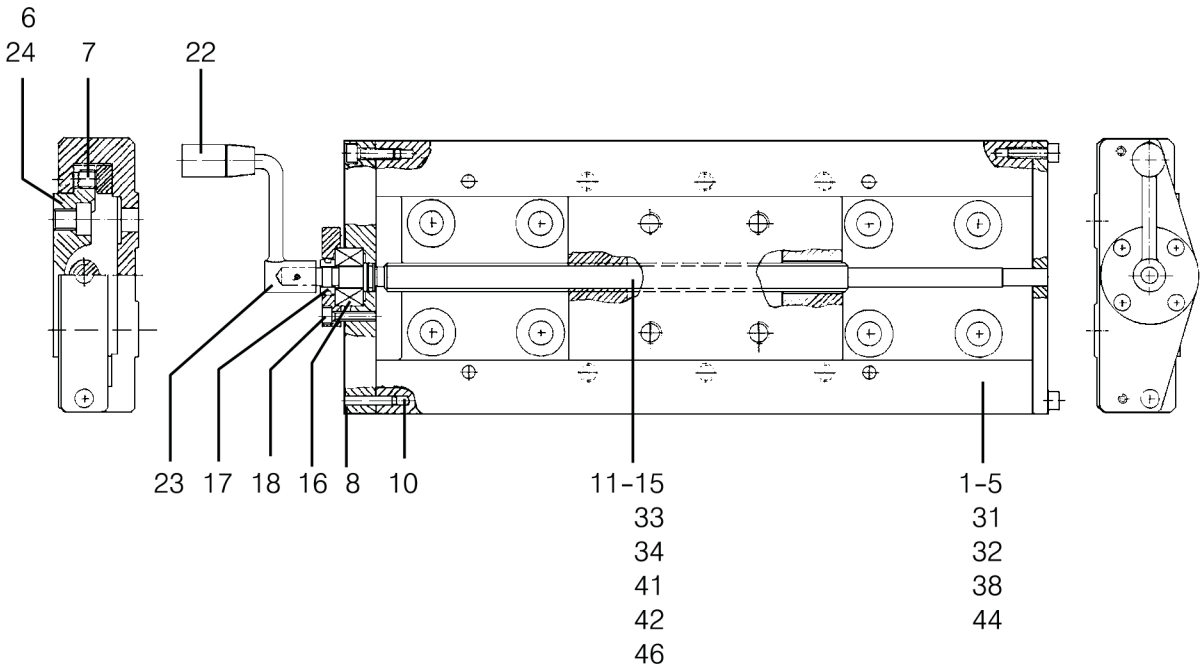
Item	Qty	Ordering no.	Denomination	Notes
		0153 347 880	**Flux valve**	
1	1	0153 348 001	Outlet	
2	1	0153 349 001	Shaft	
3	1	0211 102 938	Roll pin	D3×20



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Slide, manually operated

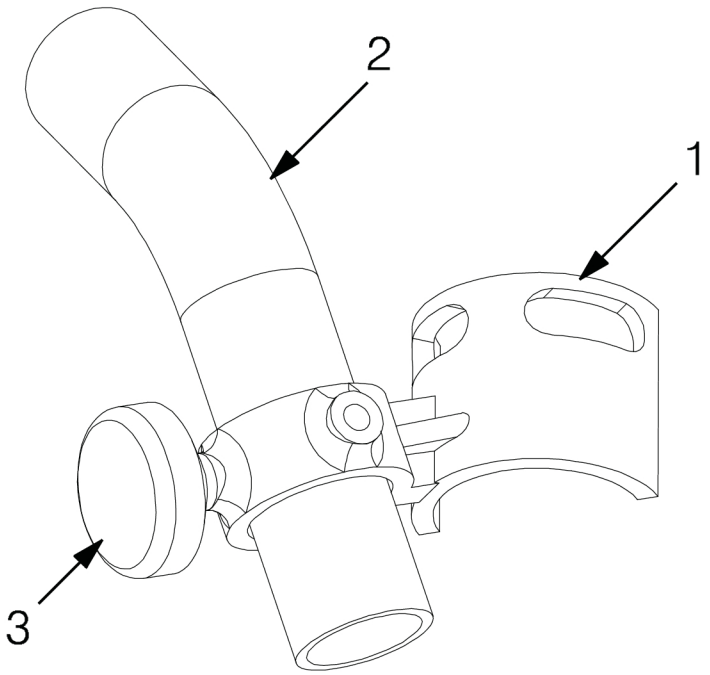
Item	Qty	Ordering no.	Denomination	Notes
		0154 465 880	**Slide, manually operated**	**L=90**
1	1	0154 464 001	Slide frame	
6	1	0154 463 880	Carriage with slide rails	
7	6	0190 509 485	Stop screw	M10×10
8	1	0154 458 001	End piece	
10	2	0211 102 957	Roll pin	D5×20
11	1	0154 461 001	Lead screw	
16	1	0190 531 201	Ball bearing	SKF 3201
17	1	0154 456 001	Lock nut	
18	1	0154 457 001	Ball bearing cap	
22	1	0334 537 001	Handle crank	
23	1	0211 102 938	Roll pin	D3×20



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Flux nozzle complete

Item	Qty	Ordering no.	Denomination	Notes
		0153 299 880	**Flux nozzle complete**	
1	1	0153 290 002	Holder for flux pipe	
2	1	0153 296 001	Flux pipe, bent	
3	1	0153 425 001	Wheel	



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