

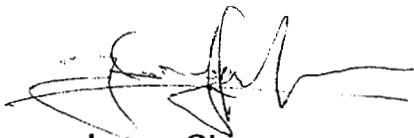
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BULLETIN #146

WELDMATIC IC II ALL MODELS**W22-0 MOTOR & 2 ROLL DRIVE REPLACEMENT**

Weldmatic IC II power source was originally supplied with a W22-0 wirefeed motor and 2 roll drive. This assembly is no longer available and the best choice for a replacement is a W27-2 wirefeed motor and 2 roll drive assembly. This assembly perform best when used in conjunction with a EURO style gun cable connector.

Please refer to the next page for instructions to convert Welmatic IC II from W22-0 to W27-2.



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QUALITY WELDING PRODUCTS, SYSTEMS AND SERVICES

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INSTRUCTION TO CONVERT IC II FROM W22 MOTOR & 2RD TO W27 MOTOR & 2 RD

To fit this assembly to an ICII, the following parts will be required. (Please refer to diagram below).

Item No.	Part No.	Description	No. Required
1	W27-2	Motor & 2 Roll Drive 60W 24V	1
2	MC11-32/2	Nylon Insulating Bush	2
3	W11-13	Motor Mounting Insulator	2
4	TC396-1	Euro Adaptor Kit	1
5	OCL8	'O' Clip $\frac{5}{16}$ "	1
6	SSHM825Z	Hex. Hd. Screw M8x25	2
7	NSHM8Z	Hex. Nut M8	2
8	WSP8Z	Plain Washer 8 Dia	4
9	WSS8Z	Spring Washer 8 Dia	2
10	SSM316W19Z	Mush. Hd. Screw $\frac{3}{16}$ " BSW x $\frac{3}{4}$ " long	2
11	NSH316WZ	Hex. Nut $\frac{3}{16}$ " BSW	2
12	WSE5Z	Ext. Star Washer $\frac{3}{16}$ " Dia	2

Fitting Procedure

1. Remove W22 Motor & 2 Roll Drive assembly and EZ fitting from ICII machine. Take care to disconnect gas hose, welding cable and gun switch wires from 2 roll drive assembly.
2. Assemble Motor & 2 Roll Drive and Euro adaptor as shown in diagram below.
3. Reconnect Gun switch wires from Euro connector to connections on PCB.
4. Reconnect welding cable to brass clamp block on Euro connector stem.
5. Reconnect gas hose from Euro connector to gas valve using 'O' Clip.
6. Fit insulators in positions shown to ensure Wirefeed motor & 2 roll drive assembly is isolated from machine panel work.

Note.

1. Front panel will need to be modified to accept Euro connector plastic housing.
2. Shelf panel may need extra holes to mount Motor & 2 Roll Drive assembly.
3. Existing Gun Cable will need modifications to suit Euro style gun connector.

