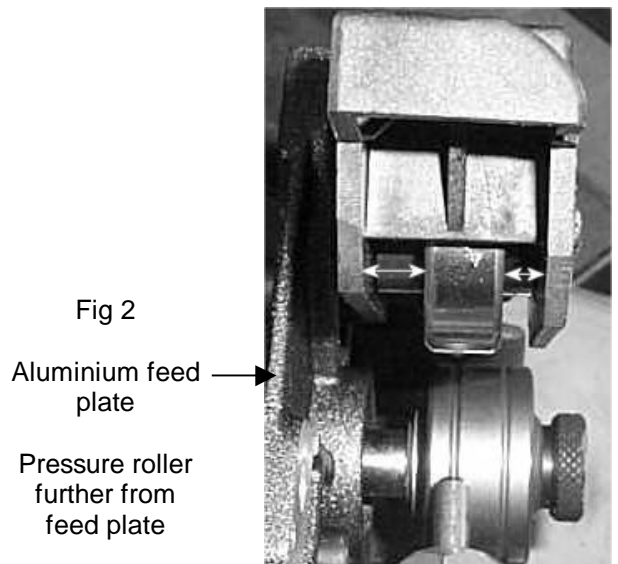
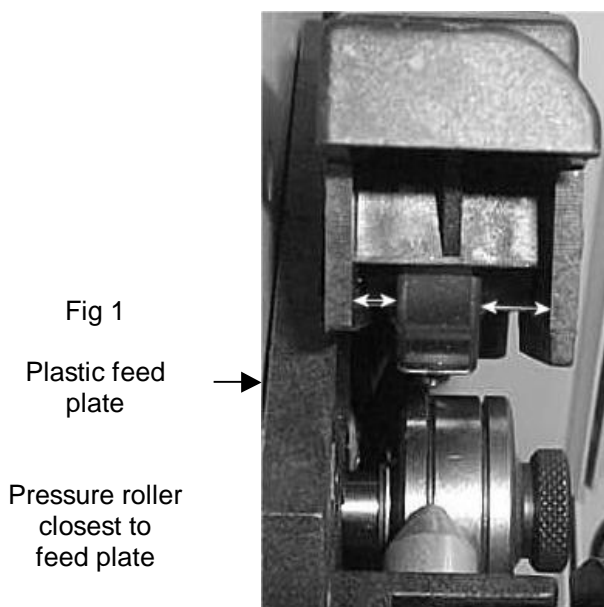


GENERAL

PRESSURE ROLLER MISALIGNMENT ON 2 ROLL DRIVE

Poor wire feed performance can result if the pressure roller is not centred over the feed roller groove. If the pressure roller runs with one edge close to the wire, it can cause varying feed pressure, resulting in wire feed problems. This can happen if the 2 spacers (one thick, & one thin) on the pressure arm assembly are incorrectly installed.

For wirefeeders with a plastic feed plate as used on CP115, CP116 and CP111, the thinner spacer is mounted closest to the feed plate so that the pressure roller is located closest to the feed plate, as in Fig 1. For wirefeeders with an aluminium feed plate as used on CP112 or W55 the pressure roller is spaced furthest from the feed plate as in Fig 2.



If you have a problem with poor wire feed on one of these wirefeed mechanisms, check if the pressure roller is centred over the drive roller groove. On some machines this can be difficult to see, and the best way may be to check for a visible line left on the pressure roller by the wire. If the spacers are incorrectly installed, swap them over as follows. See Fig 3 for reference.

1. Remove screw 1 and remove the pressure arm assembly.
2. Remove screw 2 and withdraw shaft 5.
3. Refit the pressure roller with spacers 3 and 4 fitted correctly to space the pressure roller closer to the front or rear as appropriate for the feed plate.
4. Reassemble.

QUALITY WELDING PRODUCTS, SYSTEMS AND SERVICES

The information provided in this sheet is accurate and reliable, however no warranty of accuracy or reliability is given and no responsibility arising in any other ways by errors or omissions is accepted. Any information involving mains or high voltage is intended for use by qualified electrical personnel only.

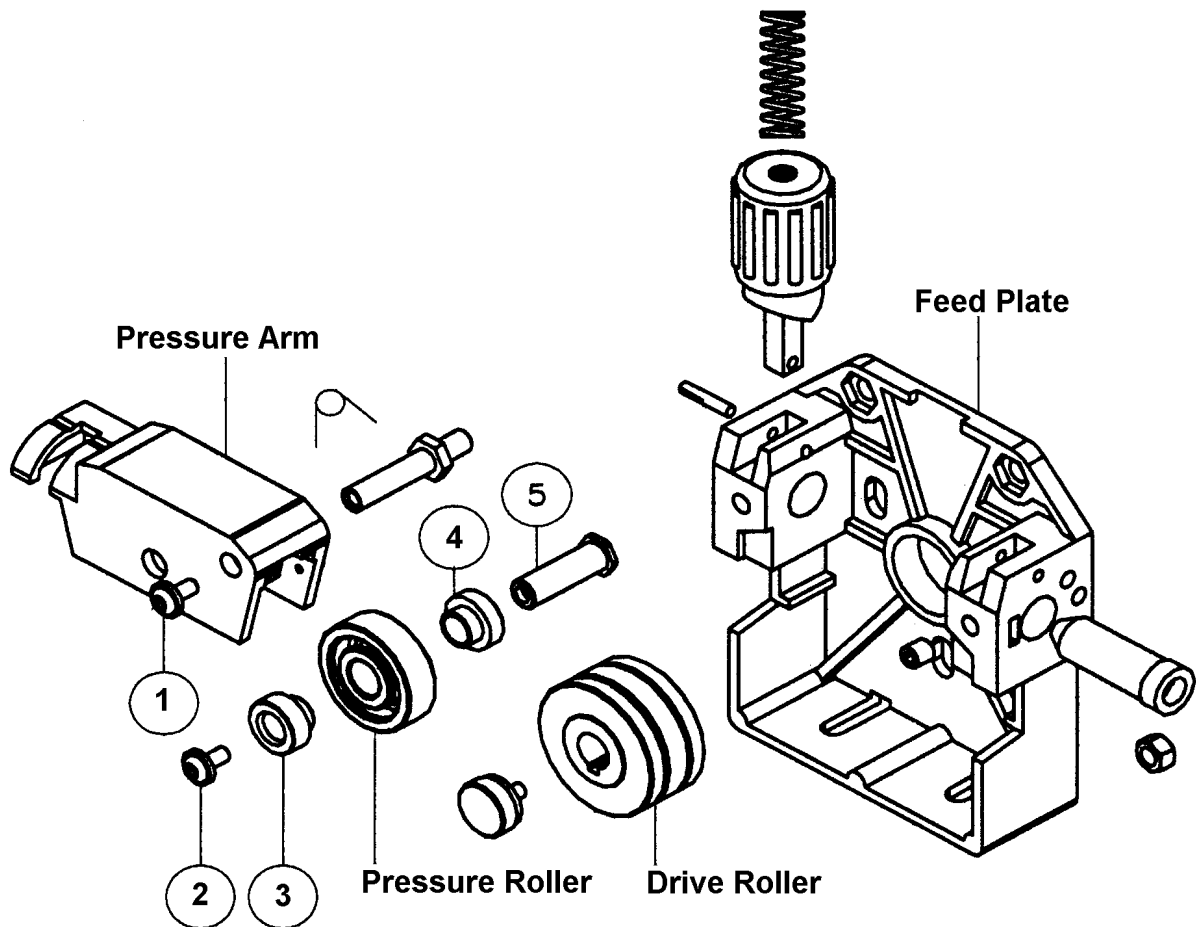


Fig 3, Wirefeed Mechanism

The pressure arm assembly, consisting of the pressure arm, pressure roller, and items 2, 3, 4 & 5, is available as a spare part, Part/No **WF001-4**. As supplied, it will suit the WF006 wirefeed mechanism (plastic feed plate) used on CP111, CP115, and CP116. It can also be used for the WF010 (aluminium feed plate) by removing the pressure roller and reversing the 2 spacers as described above.

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