

Date 09/12/11

BULLETIN # 236

## W64

### WIRE FEED SOLUTIONS

If wirefeed problems are encountered on a W64 wirefeeder, some things to check, and solutions to try are listed here. Obviously standard items such as worn/incorrectly sized feed rollers and MIG gun problems (faulty liners etc) need to be rectified as well.

#### Lack of pressure on feed rollers.

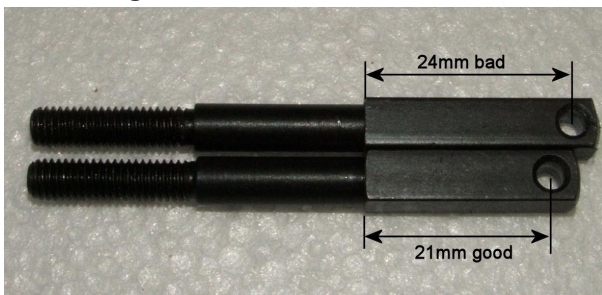
##### Pressure Spring – incorrect diameter

Ensure the pressure spring is the correct size. The correct spring has a wire diameter of 2mm. There have been some instances where a spring with wire diameter of 1.5mm has been fitted. Contact Technical Service for supplies of the correct spring.

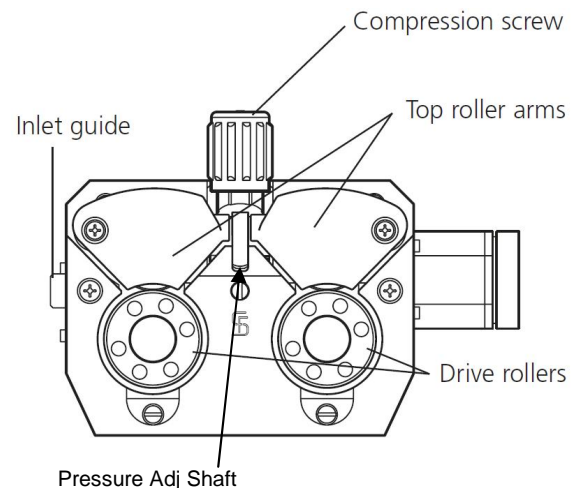
##### Pressure Spring Adjustment Shaft

The pressure adjustment shaft with the square section may be too long. It should measure 21mm from the centre of the hole to the end of the square section as below.

**Fig 1, Correct and Incorrect Shafts**

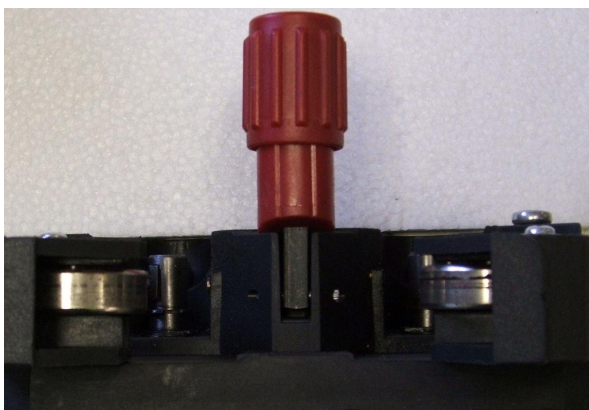


**Fig 2 Wirefeed Assembly**

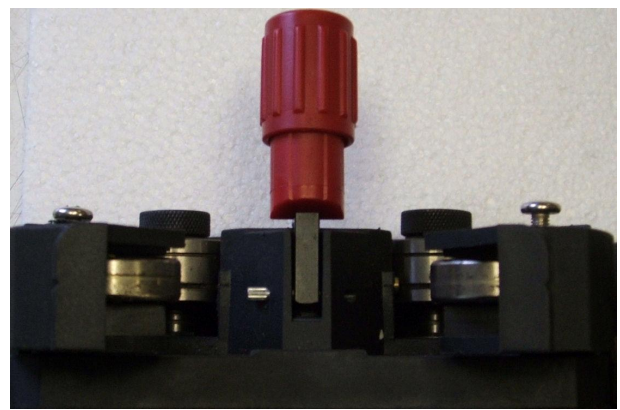


A quick way to check if this shaft is correct is to lower the shaft to the horizontal position. The red section with the graduations marked on it should be flush with the outside face of the wirefeed assy as in Fig 3. If there is clearance to the outside face as in Fig 4, this indicates that the shaft is too long.

**Fig 3, correct length shaft**



**Fig 4, shaft too long**



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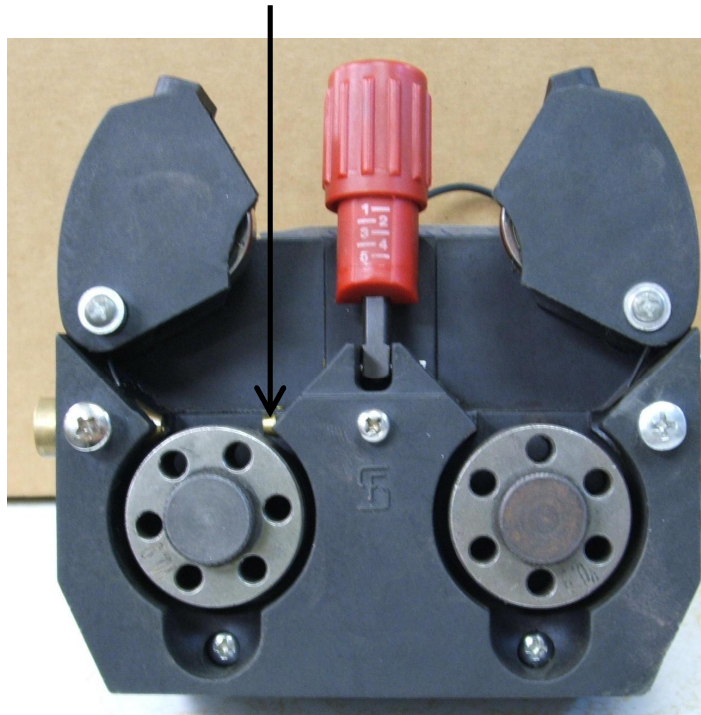
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### Intermediate Guide in Incorrect Position

If the intermediate wire guide (located between the 2 feed rollers) is not located in a central position, it may prevent the top roller housing from sitting down low enough.

Loosen the screw which locks it into position and move the guide to a central position.

Intermediate Guide is located too far to the left. It should be in the centre.



### General Wire Feed Problems

If there is a lack of pressure between top and bottom rollers, wire feed problems will result. A good way to determine if a lack of pressure is the reason for feeding problems is to close the top rollers down onto the bottom rollers with no wire between them. There should be no gap between the rollers. To gauge if there is a gap, open the rollers and then place a thin feeler gauge (or other thin material) between top and bottom rollers. If the gauge can be withdrawn easily, then there is a lack of pressure for some reason. You will then know to carefully examine the mechanism to find the cause for this lack of pressure, and can then eliminate it.

Repeat the procedure for the other set of top and bottom rollers.

Regards,

Hugh Stewart,  
Technical Service Coordinator