



Service Bulletin

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GENERAL

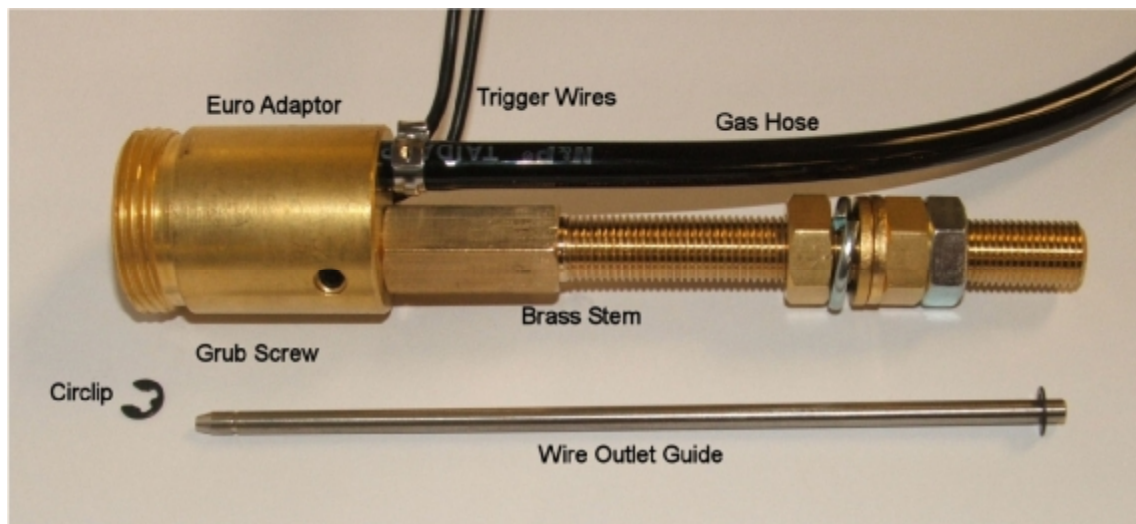
UNIVERSAL EURO ADAPTOR FOR OLDER WELDMATIC MODELS

The original euro adaptors used in early Weldmatic MIG welders are no longer available.

There is a universal euro adaptor available now as part number WF053, TORCH SOCKET EURO (UNIVERSAL) KIT which can be used to replace the complete euro adaptor assembly in these machines.

This universal adaptor can be used for internal wirefeed versions of Weldmatic models CP101, CP102, CP103, CP104, CP105, CP106, CP107, CP110, CP27. Also, wirefeeders W32 (used with CP27 and CP42), W39, W41 (Smart Feeder) and W42.

Because there are a number of different models that this universal euro adaptor can be used on, only general instructions can be given. The photo on page 2 is taken of a CP102, internal wirefeeder model, and there may be some small differences on other models. However the principle remains the same.



Directions to fit.

1. Disconnect the welding power cable, trigger wires and gas hose from the old euro adaptor.
2. Remove the old euro adaptor, complete with brass stem and wire guide.
3. Remove the plastic euro support from the outside the front of the machine.
4. To ensure that the new brass stem is properly tightened to the euro adaptor, loosen the 2.5 mm grub screw on the new euro adaptor, tighten the stem firmly into the euro adaptor, and then tighten the grub screw again.
5. Remove the nuts and washers from the new brass stem.
6. Remove the visible circlip, and withdraw the wire outlet guide. Then remove the second circlip.
7. The brass stem and wire guide will most likely need to be shortened. It is important that the following steps are carried out to ensure that the final length is correct.
8. Remove the inlet guide and feed roller from the wirefeed assembly.
9. Fit the original plastic euro support (or the new plastic euro support if using a new one) onto the new euro adaptor with brass stem.

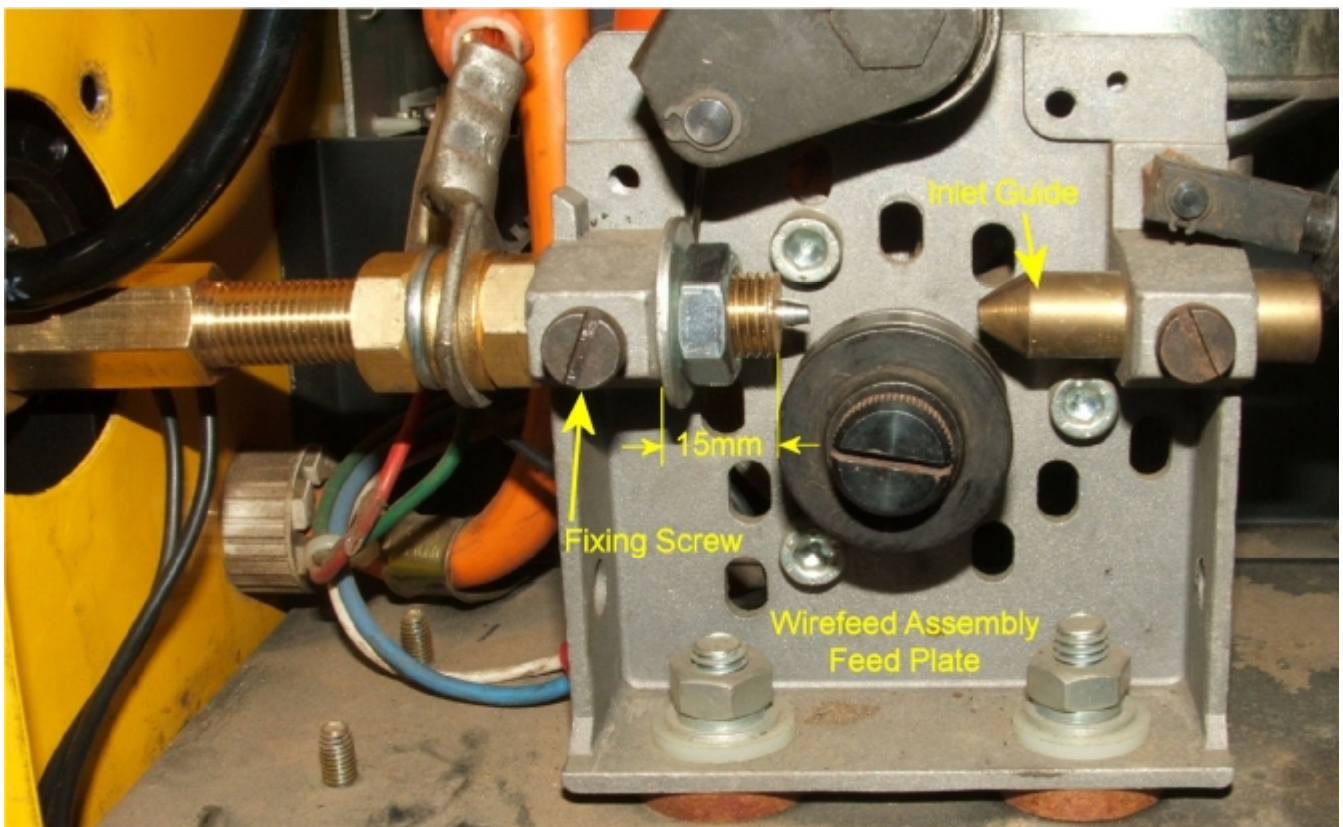
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10. Connect the euro ended MIG gun onto the new euro adaptor.
11. Fit the brass stem through the large hole in the front cover, and into the hole in the feed plate, until the plastic euro support fits snugly against the outside of the front cover.
12. Holding the stem into this position, withdraw the MIG gun by approx. 5mm to provide some clearance between the fixing nut on the MIG gun and the plastic euro support.
13. Place a mark on the thread of the brass stem approximately 15mm from the inside edge of the feed plate.
14. Disconnect the MIG gun and remove the plastic euro support.
15. Remove the euro adaptor with stem, and cut it at the mark. Remove the sharp burr from the cut edge.
16. Feed the euro adaptor with stem through the front cover, towards the feed plate. Screw the brass nut, spring washer, power cable lug, brass washer and brass nut loosely onto the stem as per photo below
17. Fit plastic euro cover and MIG gun and set the stem into the same place, leaving 5mm clearance as previously.
18. Secure the nuts with all the components in position as per photo below. Make sure the nuts are all tight.
19. Tighten the feed plate fixing screw.
20. Insert the wire outlet guide into the euro adaptor from the gun end.
21. Connect the MIG gun to the euro adaptor, and use it to push the guide into position. Ensure there is a liner inside the MIG gun when doing this, as the brass ferrule on the liner end is essential when establishing the correct wire guide length.
22. Place a mark on the wire outlet guide so that there is approx. 1-2mm of clearance between it and the feed roller. Keeping this distance as short as possible is vital when using wires that are difficult to feed such as aluminium or 0.8mm gasless wire.
23. Withdraw and cut the wire guide at this mark, and then taper the edge so it can nestle closely to the roller without touching it.
24. Insert the guide tube into the euro. If it is loose, slightly bend the guide tube. A bend of only 1-2mm will hold it in position and not affect wire feed.
25. Secure the plastic euro support to the outside of the front cover. Drill new holes if required.
26. Refit the feed roller and inlet guide.
27. Connect the new trigger wires to the existing loom. Polarity is not important.
28. Connect the new gas line to the gas valve. Use a small clamp to ensure a gas tight seal.
29. Use cable ties to ensure all wiring is secure, and safely away from moving parts.



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