



**EN**

## Retrofit option

**ON WAK TG.0003/TG.0004/TG.0009/K.0002**  
**ON WAK tigSpeed**

Wheel assembly kit

099-001356-EW501

Observe additional system documents!

08.04.2019

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# General instructions

## **WARNING**



### **Read the operating instructions!**

**The operating instructions provide an introduction to the safe use of the products.**

- Read and observe the operating instructions for all system components, especially the safety instructions and warning notices!
- Observe the accident prevention regulations and any regional regulations!
- The operating instructions must be kept at the location where the machine is operated.
- Safety and warning labels on the machine indicate any possible risks. Keep these labels clean and legible at all times.
- The machine has been constructed to state-of-the-art standards in line with any applicable regulations and industrial standards. Only trained personnel may operate, service and repair the machine.
- Technical changes due to further development in machine technology may lead to a differing welding behaviour.

**In the event of queries on installation, commissioning, operation or special conditions at the installation site, or on usage, please contact your sales partner or our customer service department on +49 2680 181-0.**

**A list of authorised sales partners can be found at [www.ewm-group.com/en/specialist-dealers](http://www.ewm-group.com/en/specialist-dealers).**

Liability relating to the operation of this equipment is restricted solely to the function of the equipment. No other form of liability, regardless of type, shall be accepted. This exclusion of liability shall be deemed accepted by the user on commissioning the equipment.

The manufacturer is unable to monitor whether or not these instructions or the conditions and methods are observed during installation, operation, usage and maintenance of the equipment.

An incorrectly performed installation can result in material damage and injure persons as a result. For this reason, we do not accept any responsibility or liability for losses, damages or costs arising from incorrect installation, improper operation or incorrect usage and maintenance or any actions connected to this in any way.

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**1 Safety instructions****1.1 For your safety****⚠ WARNING**

**Do not carry out any unauthorised repairs or modifications!**

**To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!**

**The warranty becomes null and void in the event of unauthorised interference.**

- Appoint only skilled persons for repair work (trained service personnel)!



**Risk of accidents due to non-compliance with the safety instructions!**

**Non-compliance with the safety instructions can be fatal!**

- Carefully read the safety instructions in this manual!
- Observe the accident prevention regulations and any regional regulations!
- Inform persons in the working area that they must comply with the regulations!

**⚠ CAUTION**

**Obligations of the operator!**

**The respective national directives and laws must be complied with when operating the machine!**

- Implementation of national legislation relating to framework directive 89/391/EEC on the introduction of measures to encourage improvements in the safety and health of workers at work and associated individual guidelines.
- In particular, directive 89/655/EEC concerning the minimum safety and health requirements for the use of work equipment by workers at work.
- The regulations applicable to occupational safety and accident prevention in the country concerned.
- Setting up and operating the machine as per IEC 60974.-9.
- Brief the user on safety-conscious work practices on a regular basis.
- Regularly inspect the machine as per IEC 60974.-4.

**These supplementary sheets must be used in conjunction with the appropriate standard operating instructions for the described product! These supplementary sheets expand or replace one or more chapters of the same name(s) in the standard description.**

**Read and observe the operating instructions for all system components, especially the safety instructions!**

## 2 Intended use

### 2.1 General

#### **WARNING**



##### **Hazards due to improper usage!**

The machine has been constructed to the state of the art and any regulations and standards applicable for use in industry and trade. It may only be used for the welding procedures indicated at the rating plate. Hazards may arise for persons, animals and material objects if the equipment is not used correctly. No liability is accepted for any damages arising from improper usage!

- The equipment must only be used in line with its designated purpose and by trained or expert personnel!
- Do not improperly modify or convert the equipment!

#### **CAUTION**



##### **Risk of accidents due to improperly prepared transport vehicle!**

Depending on the machine series the transport vehicle has to be adapted to mount the machine. Failing to adapt the transport vehicle can cause the machine being transported to topple and lead to injuries!

### 2.2 Special information

Transport systems ON WAK TG.0003/TG.0004/TG.0009/K.0002 and ON WAK tigSpeed are intended for:

- moving the machines and machine combinations listed,
- moving properly fixed machines and add-on parts that are correctly secured.

Any other use of the transport systems is regarded as "improper" and no liability is assumed for any damage arising therefrom.

These instructions apply only for the conversion of the following machines:

#### 2.2.1 ON WAK TG.0003/TG.0004/TG.0009/K.0002

- Picomig 185 / - 305 D3 TKG
- Picomig 355 TKM, -TKG
- Taurus 355 TKW
- Phoenix / Taurus 355 TKM
- Phoenix / Taurus 355, -405, -505 TDM
- Taurus 355, -405, -505 TDW
- Microplasma 25, -55, -105
- cool50 U40, -U42
- cool50-2 U40, -U42
- cool 50 MPW50

#### 2.2.2 ON WAK tigSpeed

- tigSpeed continuous drive 45 coldwire / hotwire
- tigSpeed oscillation drive 45 coldwire / hotwire

2.3 Application example

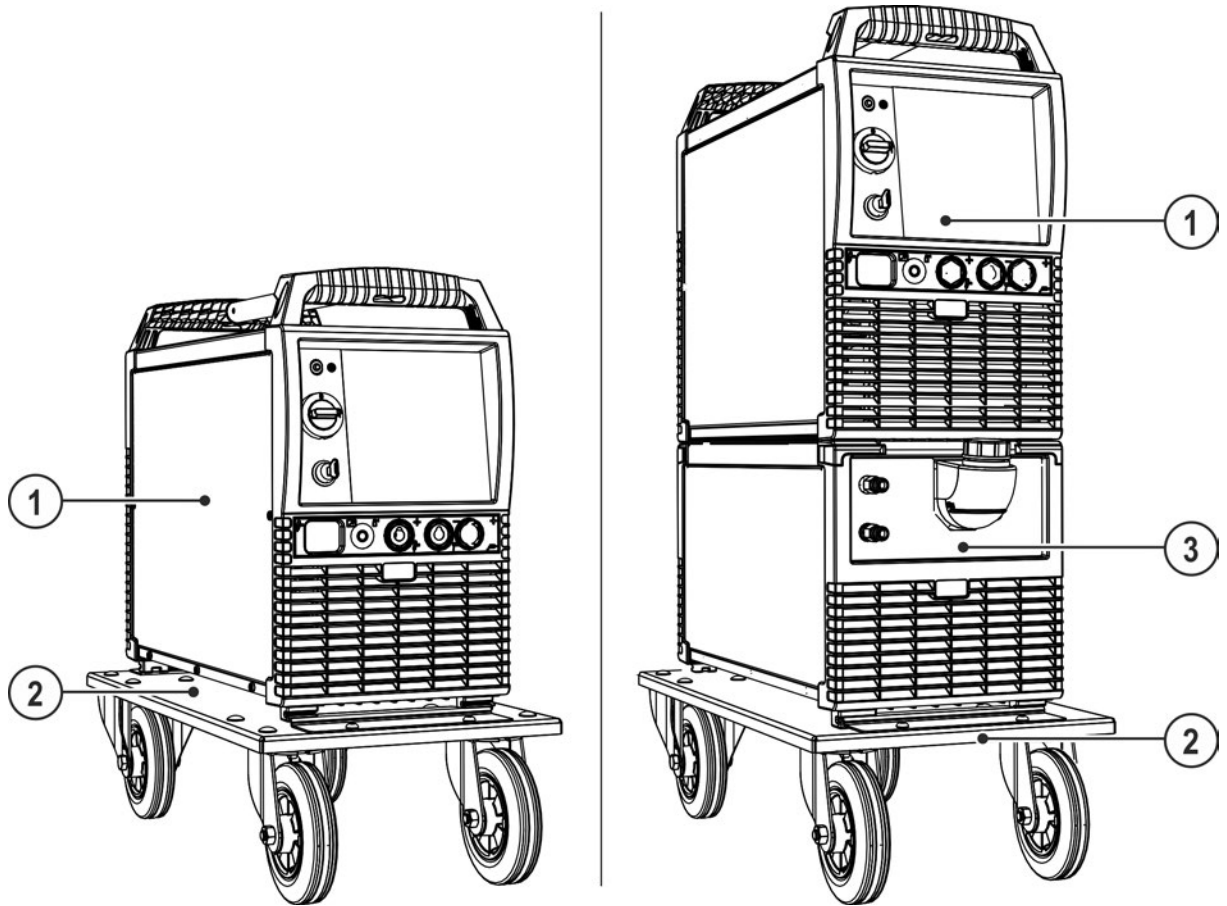


Figure 2-1

Item	Symbol	Description
1		Power source / Wire feeder
2		Transport vehicle (option)
3		Cooling unit

## 3 Machine description – quick overview

### 3.1 ON WAK TG.0003/TG.0004/TG.0009/K.0002

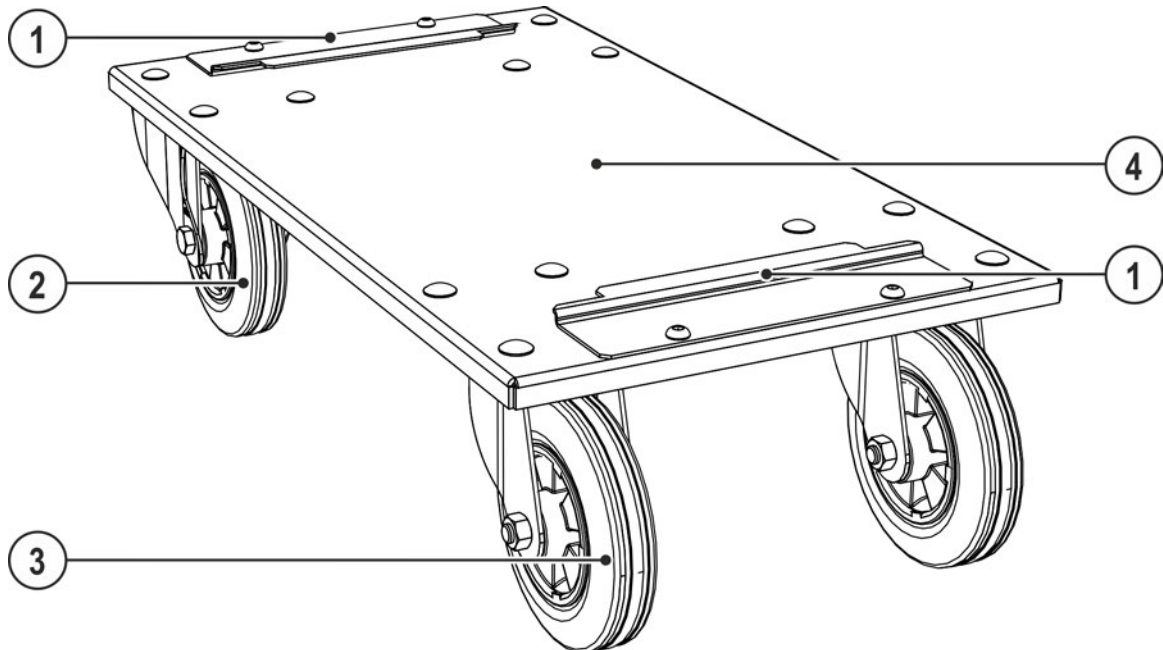


Figure 3-1

Item	Symbol	Description
1		Machine mounting attachment
2		Wheels, fixed castors
3		Wheels, guide castors
4		Machine carrier plate To support the welding machine.

## 3.2 ON WAK tigSpeed

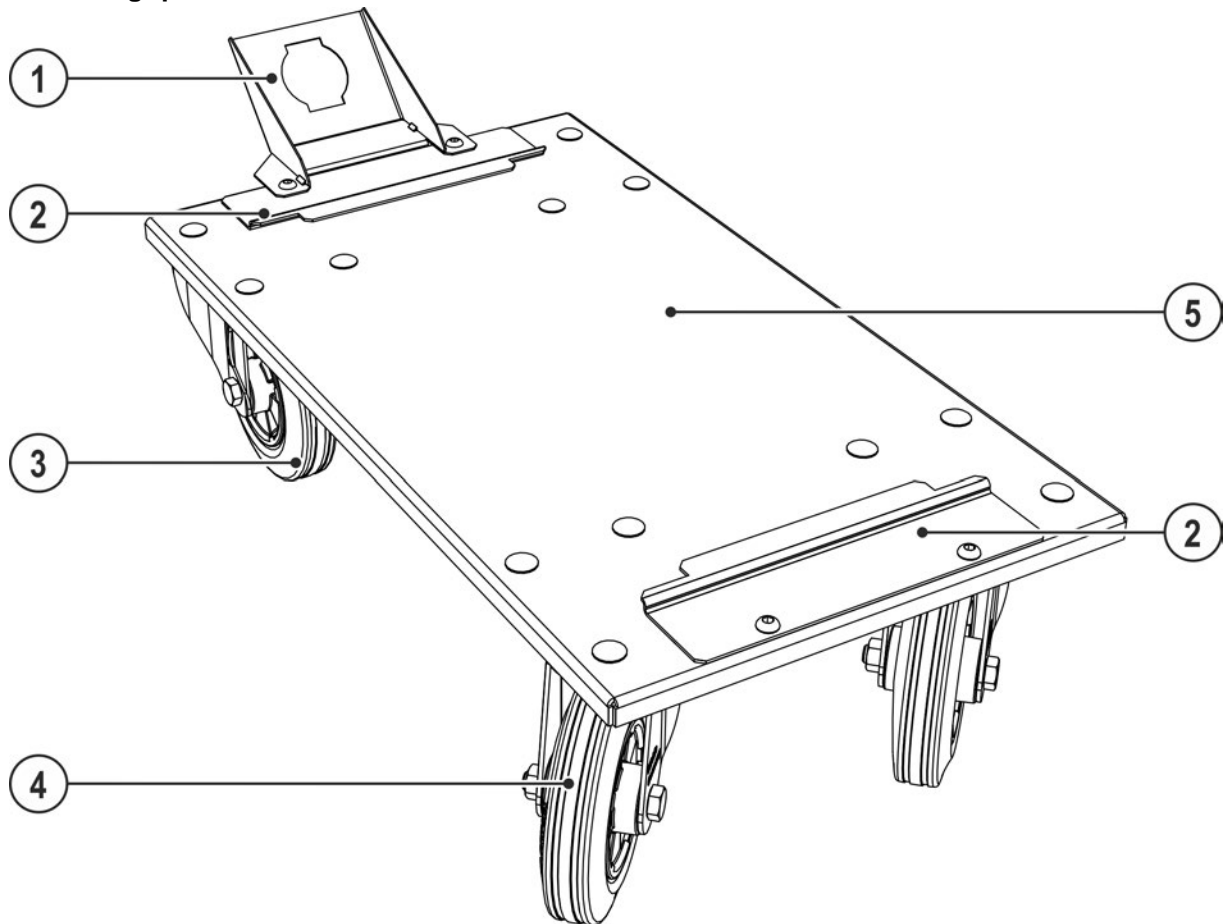


Figure 3-2

Item	Symbol	Description
1		Strain relief
2		Machine mounting attachment
3		Wheels, fixed castors
4		Wheels, guide castors
5		Machine carrier plate To support the welding machine.

## 3.2.1 Assembly

### ⚠ CAUTION



#### Improperly secured equipment!

Equipment, equipment combinations and accessories incorrectly fastened onto transport systems can tip over during transport and cause injuries!

- Only use the original parts supplied to fasten the equipment.
- Use the systems only for transporting the machines.
- Check the fixing points before each transport and at regular intervals.

## 3.3 ON WAK TG.0003/TG.0004/TG.0009/K.0002

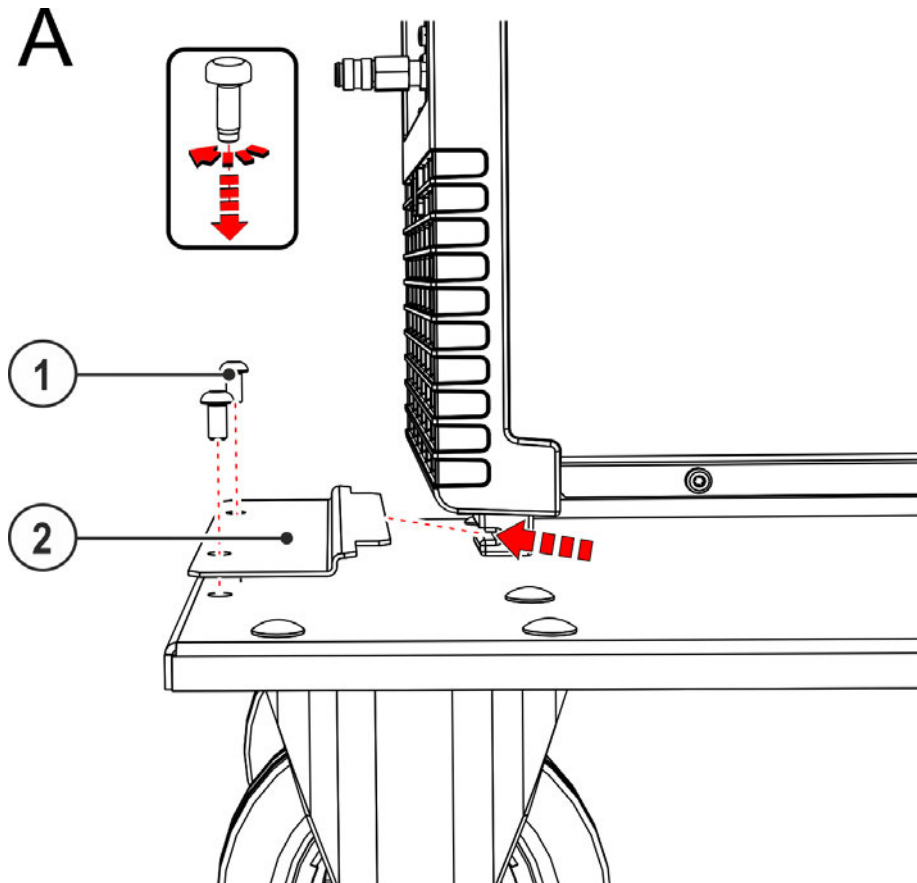


Figure 3-3



B

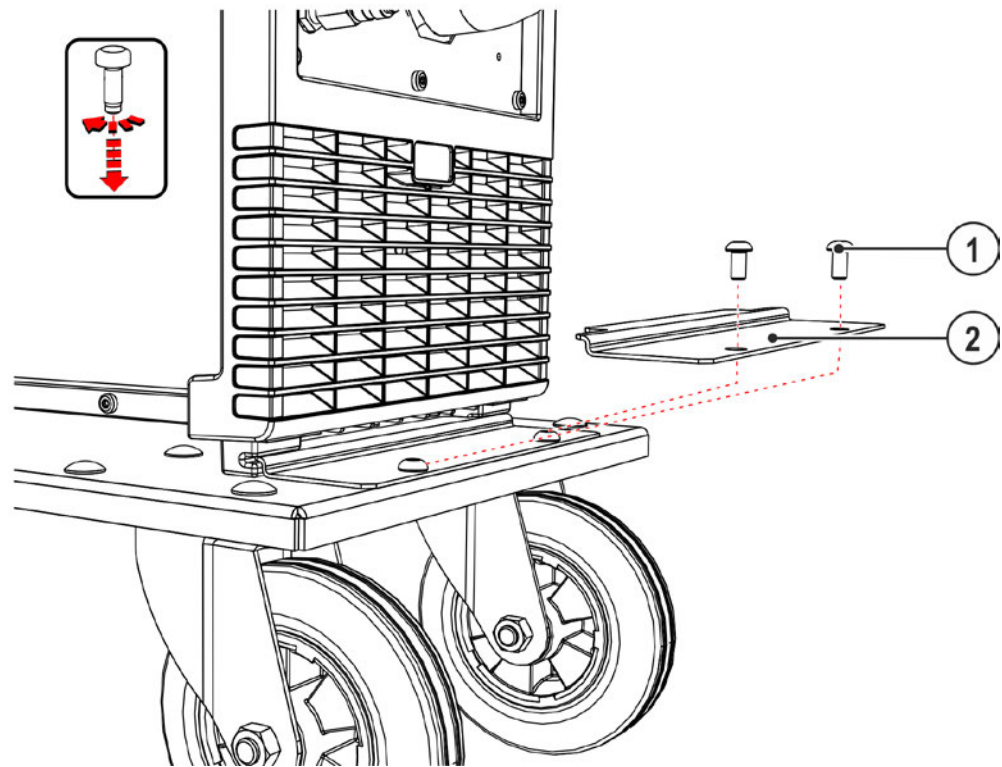


Figure 3-4

Item	Symbol	Description
1		Flat head screw
2		Machine mounting attachment

- Place and fix the machine on the carrier plate.

## 3.4 ON WAK tigSpeed

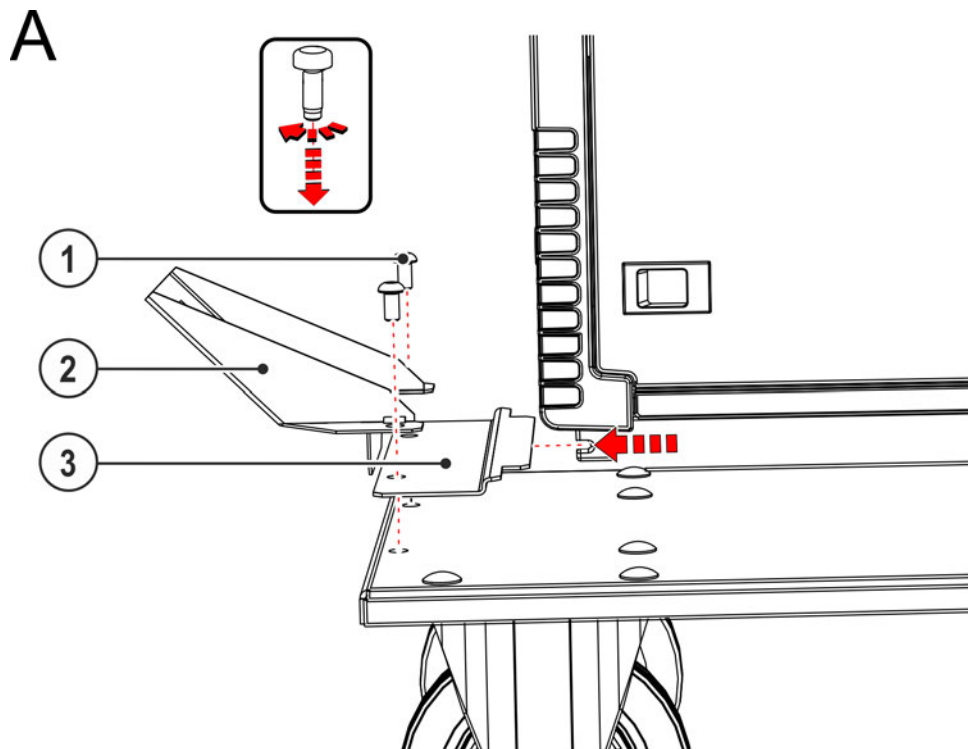


Figure 3-5

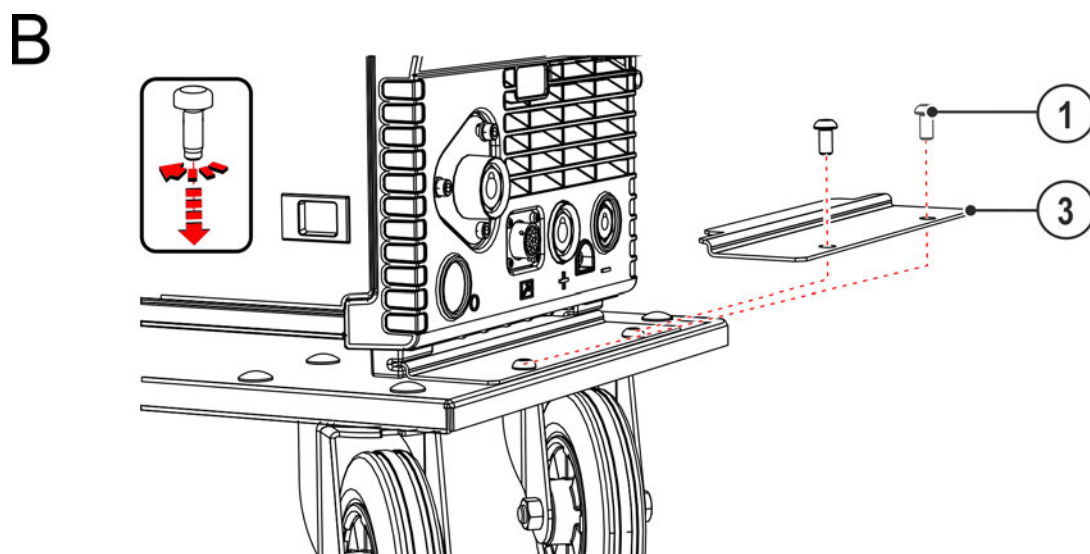


Figure 3-6

Item	Symbol	Description
1		Flat head screw
2		Strain relief
3		Machine mounting attachment

- Place and fix the machine on the carrier plate.
- Attach the strain relief with the machine mounting attachment to the carrier plate using two M8 x 16 screws.

**3.5 Final assembly**
 **WARNING**


**Danger due to failure to carry out the final inspection!**

**Parts that are incorrectly fitted or that become loose are a source of danger.**

- Check all mechanical connections to ensure that they are fitted correctly!
- Carry out the final inspection!
- Carry out the functional test!

**Keep the conversion instructions with the machine documentation!**

**When ordering spare parts, ensure that the item number and serial number of the machine are quoted!**

**4 Technical data**
**4.1.1 ON WAK TG.0003/TG.0004/TG.0009/K.0002**

<b>Dimensions (L x W x H)</b>	750 x 385 x 208 mm 25.53 x 15.16 x 8.19 inch
<b>Weight without accessories</b>	ca. 16 kg 35.27 lb
<b>Harmonised standard used</b>	IEC 60974-1

**4.1.2 ON WAK tigSpeed**

<b>Dimensions (L x W x H)</b>	864 x 385 x 276 mm 30.06 x 15.16 x 10.87 inch
<b>Weight without accessories</b>	16,4 kg 36.16 lb
<b>Harmonised standard used</b>	IEC 60974-1