

# 1 Contents

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## 2 Overview

### 2.1 For your safety



Observe the safety precautions given in the standard operating instructions.

Observe accident prevention regulations.

All conversion and retrofitting work must be performed by a qualified electrician in compliance with current VDE regulations in Germany and/or the relevant local regulations.

Disconnect from the mains before opening.

Switching off is not sufficient. Wait for 2 minutes until the capacitors have discharged.

### 2.2 Proper usage

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

- TETRIX 350 AC/DC

Descriptions of the following:

- Replace the 5-pole torch connection socket with a 12-pole torch connection socket.

### 2.3 Short description of the working steps required

- Connect adapter plate to connection socket
- Install filter PCB BTF 1
- Replace the torch connection socket
- Wire up the components

### 2.4 Re-equipment set

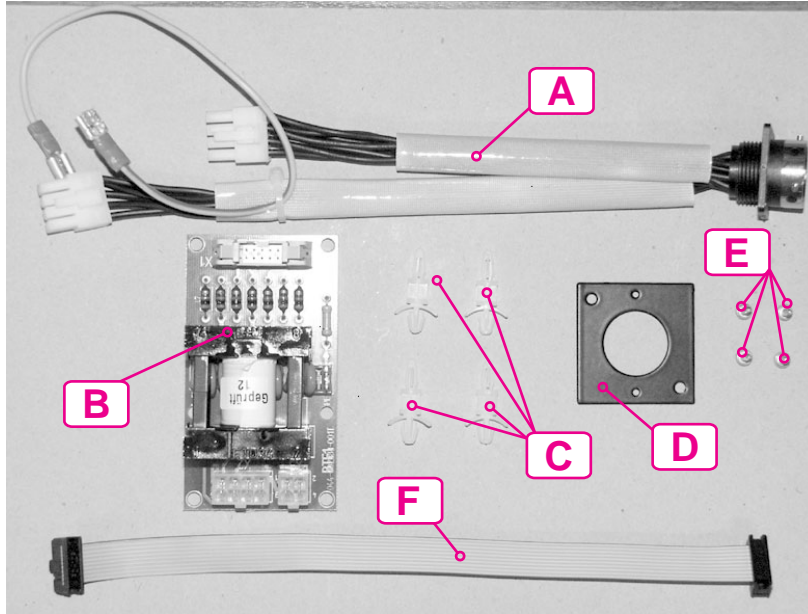


Figure 2-1

Fig.1, pos.	Designation	Item no.	Quantity
A	12-pole connection socket with cable harness	094-008113-00000	1
B	PCB BTF 1	040-000545-00010	1
C	Spacer for PCB BTF 1	064-000567-00000	4
D	Adapter plate for connection socket	094-008111-00000	1
E	Tallow-drop cross-recessed screw	094-003240-00000	4
F	Flatband cable, 10-pole	094-000114-00000	1

### 3 Conversion



The casing panels are connected using earthing cables. These must be re-connected once the assembly work is complete.

- Remove transport handle, top and right-hand machine covers.

#### 3.1 Fitting the adapter plate

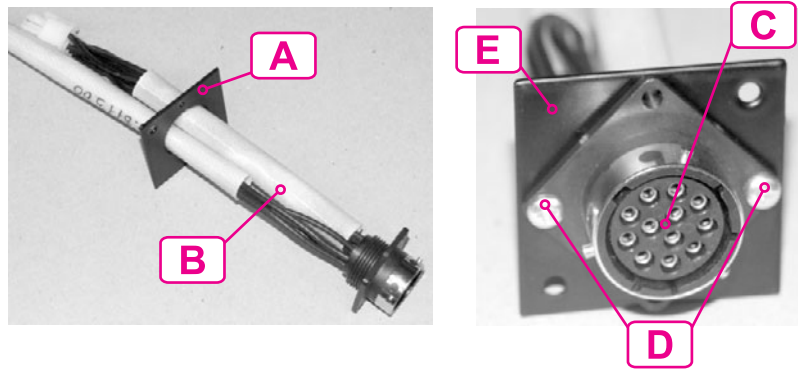


Figure 3-1

- Insert cable harness (B) of the 12-pole connection socket through the adapter plate (A)
- Screw adapter plate (E) to connection socket (C) using tapping screws (D).

#### 3.2 Installing filter PCB BTF 1

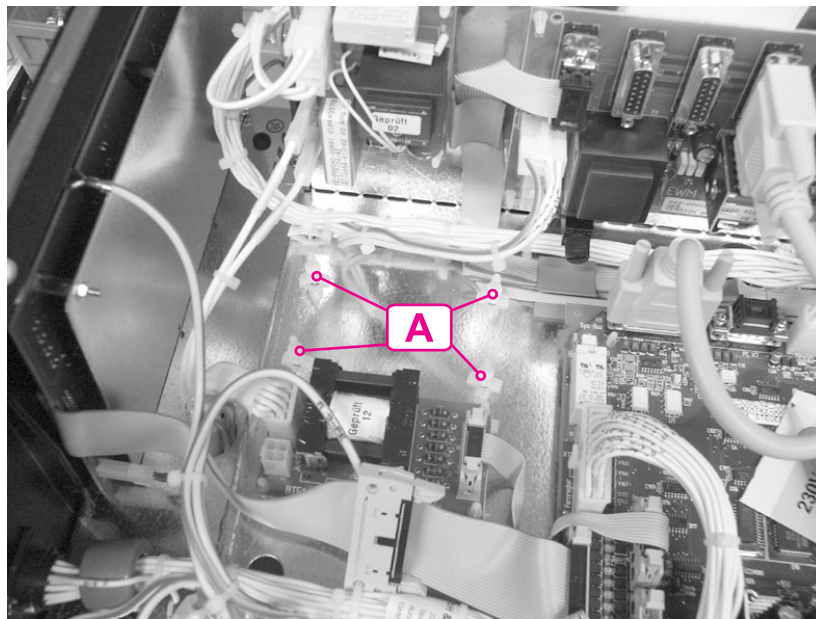


Figure 3-2

- Insert 4 spacers (A) into the existing bores in the intermediate panel, behind the machine control. You should feel the counter-hook engage.

### 3.3 Removing the torch connection socket

The images show machines with one or two torch connection sockets.

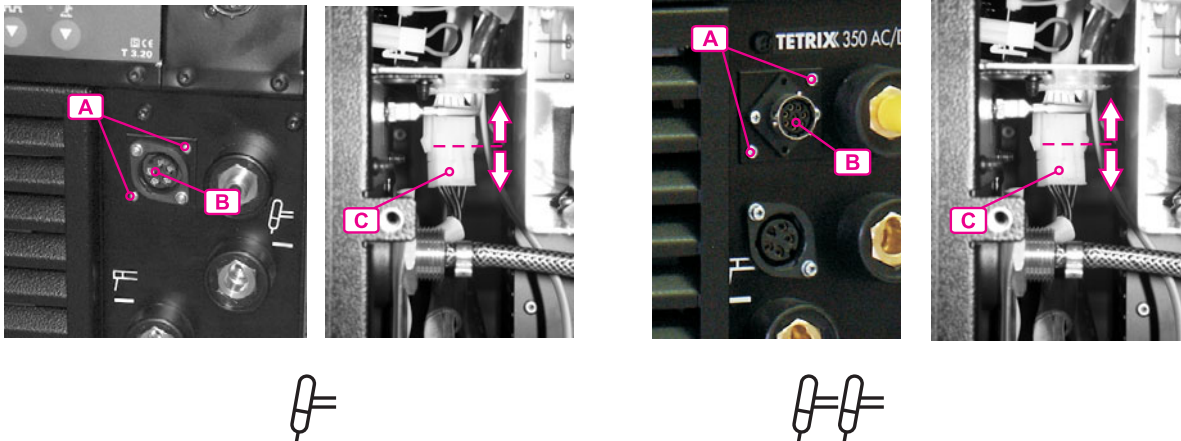


Figure 3-3

- Unscrew the tapping screws (A) on torch connection socket (B), remove the connector plug (C), take off the torch connection socket.

### 3.4 Installing the torch connection socket

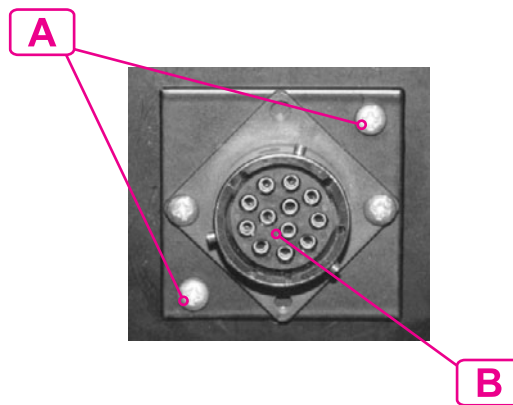


Figure 3-4

- Insert the cable harness for the 12-pole torch connection socket through the opening in the front of the casing.
- Fasten the 12-pole torch connection socket (B) using 2 tapping screws (A).

### 3.5 Wiring

The images show machines with one or two torch connection sockets.

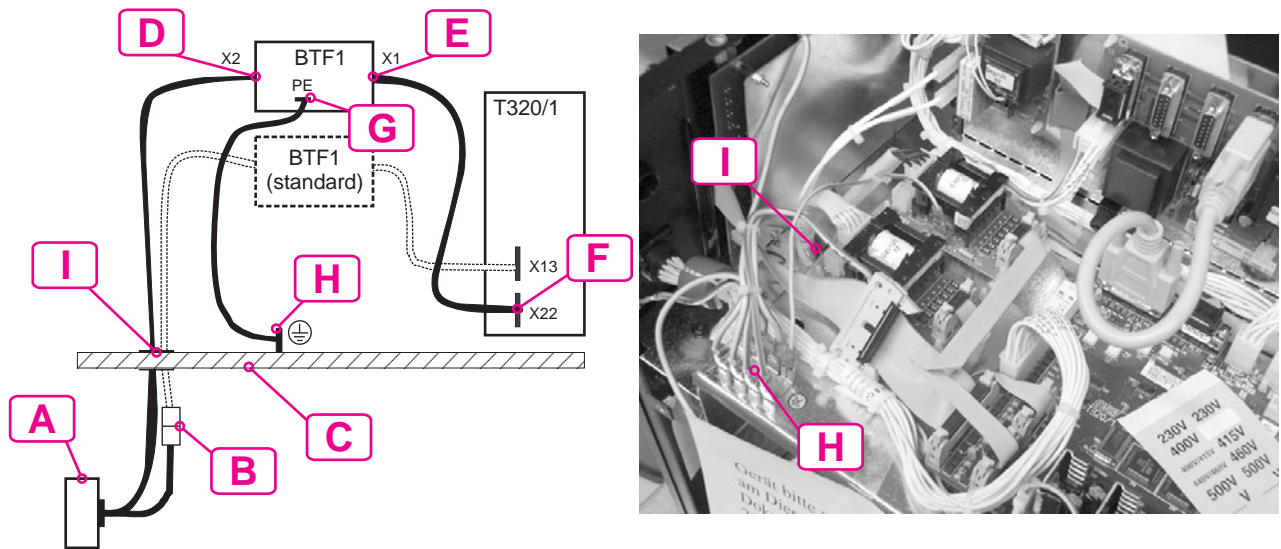


Figure 3-5

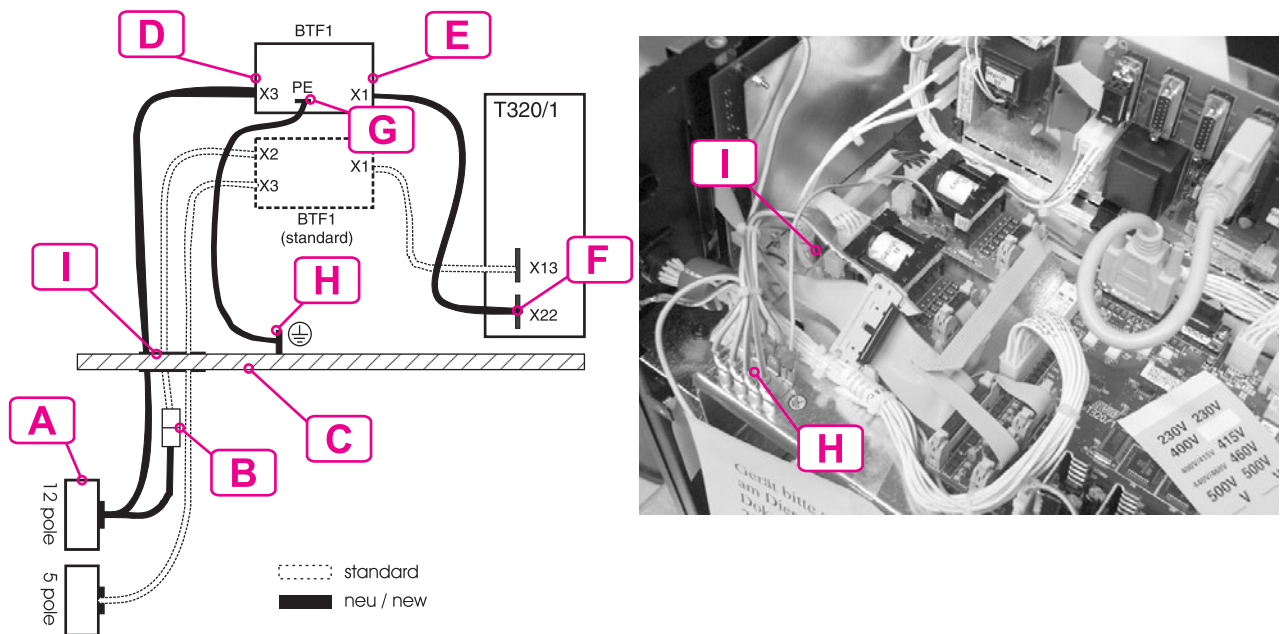


Figure 3-6

- Insert the 8-pole connector plug (short connection cable) on the 12-pole connection socket (A) onto the counter-plug (B) which should be removed first.
- Insert the 8-pole connector plug (long connection lead) through the cable bushing (I) in the intermediate casing panel (C) and insert onto PCB BTF 1, plug X2 (D).
- Fasten the earth lead and cable binder onto the long connection lead and insert onto the earthing point (G) on PCB BTF1. Insert the other side of the earth lead onto the earthing point (H).
- Use flatband cable to create a 10-pole connection between PCB BTF 1, plug X1 (E) and PCB T320/1, plug X22 (F).

## 4 Final assembly



After installation or conversion, all mechanical and electrical connections must be tested for correct installation.

No leads or tubes should be squashed or laid on sharp edges.

The casing panels are connected using earthing cables.

These must be re-connected once the assembly work is complete.



It is absolutely essential that a VDE 0544 207, BGV A2 (VBG4 so far) und BGV D1 (VBG15 so far) repetition test be performed before using the machine again.

For more detailed instructions, please see standard operating instructions for the welding machine.

- Assemble the power source unit in the reverse order.

**The machine is now ready for welding.**



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