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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.

### 2.2 Proper usage

These conversion instructions describe the retrofitting of a star handle for PHOENIX DRIVE 4 series wire feed units.

These conversion instructions apply to the following welding machines only:

- PHOENIX 401 Series

### 2.3 Re-equipment set

Pos.	Designation	Type	Item number	Quantity
1	Wire feed retaining plate	BADV553X310X20	094-001147-00004	1
2	Metal sheet cross arm	BTD588X450X19	094-011423-00000	1
3	Star handle (upper part)		094-001066-00000	1
4	Star handle (bottom part)			
5	Cup spring	M5	064-000751-00000	7
6	Self-locking hexagon nut	M5	094-001139-00000	4
7	Hexagon screw	M5 X 20mm	064-000635-00000	3
8	Spring ring	M5	064-000594-00000	3
9	Hexagon screw	M12 X 45mm	094-002147-00000	4
10	Tooth lock washer	M12	094-002065-00000	4
11	Guide castor, no lock	RAD/80X25/50	094-000180-00001	2
12	Guide castor, with lock	RAD/80X25/50	094-000180-00002	2
13	Spacer disc	AS55X18.5	094-011544-00000	4

### 3 Conversion

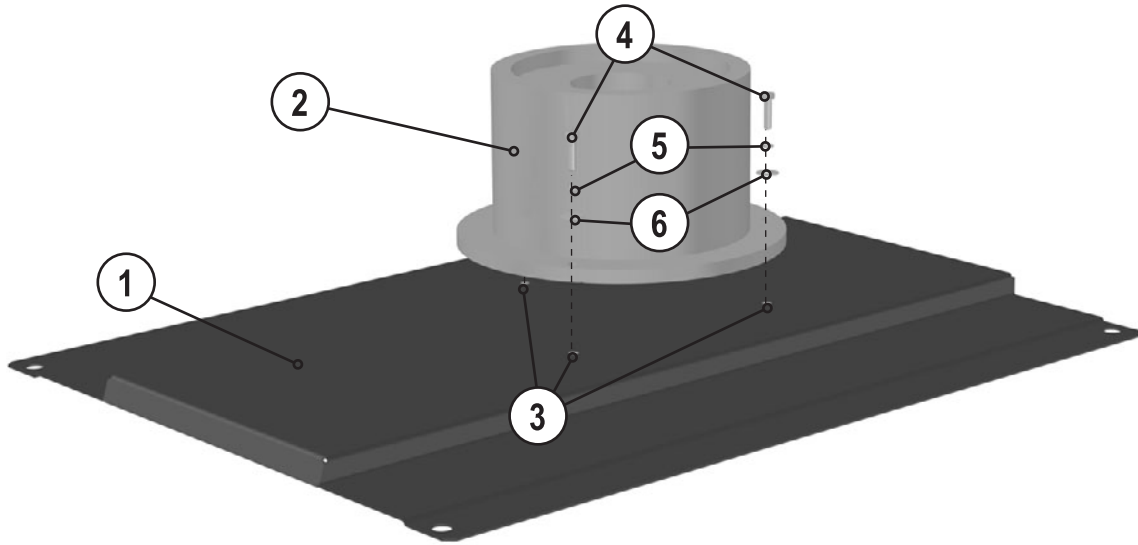


Figure 3-1

- Unscrew the lifting lugs from the welding machine.
- Place the metal sheet cross arm onto the welding machine casing cover and screw on using the lifting lugs previously removed.
- Place the star handle (bottom part) onto the metal sheet cross arm.



#### Alignment of the metal sheet cross arm

There are 3 bores on this sheet with press nuts. These press nuts are not centred on the sheet. The metal sheet cross arm must be fitted with the greater distance between the sheet edge and press nuts at the front of the welding machine.

- Fasten the star handle (bottom part) onto the metal sheet cross arm using 3 x M5 hexagon screws x 20mm, M5 spring rings and M5 cup springs with the press nuts.

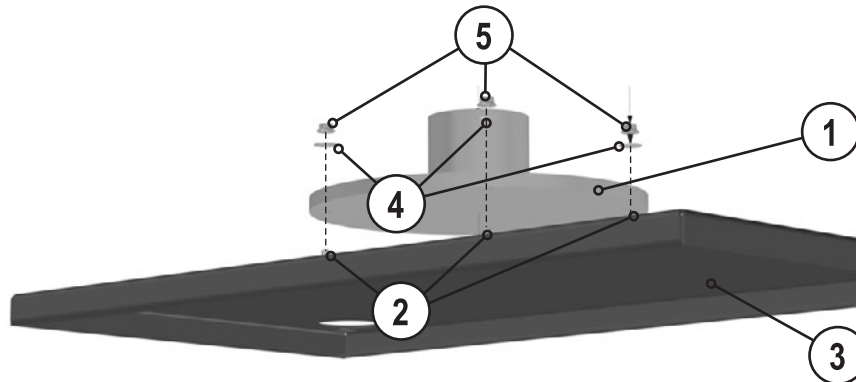


Figure 3-2

- Insert star handle (top part) into the stop pin on the wire feed retaining plate (underside).
- Screw the star handle (top part) with 4 x M5 cup springs and M5 self-locking hexagon nuts onto the underside of the wire feed retaining plate.

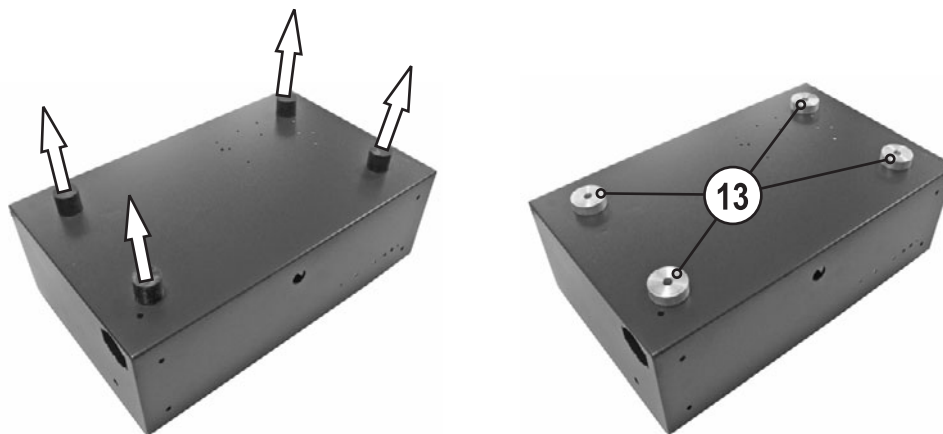


Figure 3-3

- Unscrew the rubber feet on the wire feed unit anticlockwise.
- Centre the spacers over the mounting holes with the rubber feet just unscrewed.



**The spacers are gripped on one side and must be positioned with the smooth surface on the wire feed unit.**

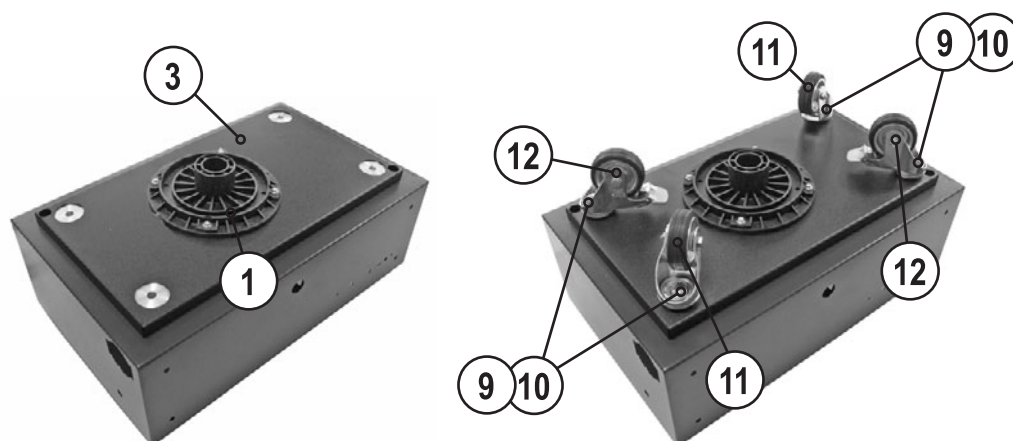


Figure 3-4

- Place the star handle (upper part) on the spacer.
- Screw the guide castors using M12 hexagon screws and M12 toothed lock washers onto the star handle (upper part), spacers and wire feed unit.



**The guide castors and locks must be fitted diagonally.**

- Insert the star handle (top part) into the star handle (bottom part).



**After installation or conversion, all mechanical connections must be checked for correct installation.**