



EN

Transport systems

Trolley 55-6
Trolley 55-6 DF

099-008825-EW501

Observe additional system documents!

12.02.2019

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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.

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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The content of this document has been prepared and reviewed with all reasonable care. The information provided is subject to change; errors excepted.

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2 For your safety

2.1 Notes on the use of these operating instructions

DANGER

Working or operating procedures which must be closely observed to prevent imminent serious and even fatal injuries.

- Safety notes include the "DANGER" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol on the edge of the page.

WARNING

Working or operating procedures which must be closely observed to prevent serious and even fatal injuries.

- Safety notes include the "WARNING" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol in the page margin.

CAUTION

Working or operating procedures which must be closely observed to prevent possible minor personal injury.

- The safety information includes the "CAUTION" keyword in its heading with a general warning symbol.
- The risk is explained using a symbol on the edge of the page.



Technical aspects which the user must observe to avoid material or equipment damage.

Instructions and lists detailing step-by-step actions for given situations can be recognised via bullet points, e.g.:

- Insert the welding current lead socket into the relevant socket and lock.

2.2 Explanation of icons

Symbol	Description	Symbol	Description
	Indicates technical aspects which the user must observe.		Activate and release / Tap / Tip
	Switch off machine		Release
	Switch on machine		Press and hold
			Switch
	Incorrect / Invalid		Turn
	Correct / Valid		Numerical value – adjustable
	Input		Signal light lights up in green
	Navigation		Signal light flashes green
	Output		Signal light lights up in red
	Time representation (e.g.: wait 4 s / actuate)		Signal light flashes red
	Interruption in the menu display (other setting options possible)		
	Tool not required/do not use		
	Tool required/use		

2.3 Part of the complete documentation

These operating instructions are part of the complete documentation and valid only in combination with all other parts of these instructions! Read and observe the operating instructions for all system components, especially the safety instructions!

The illustration shows a general example of a welding system.

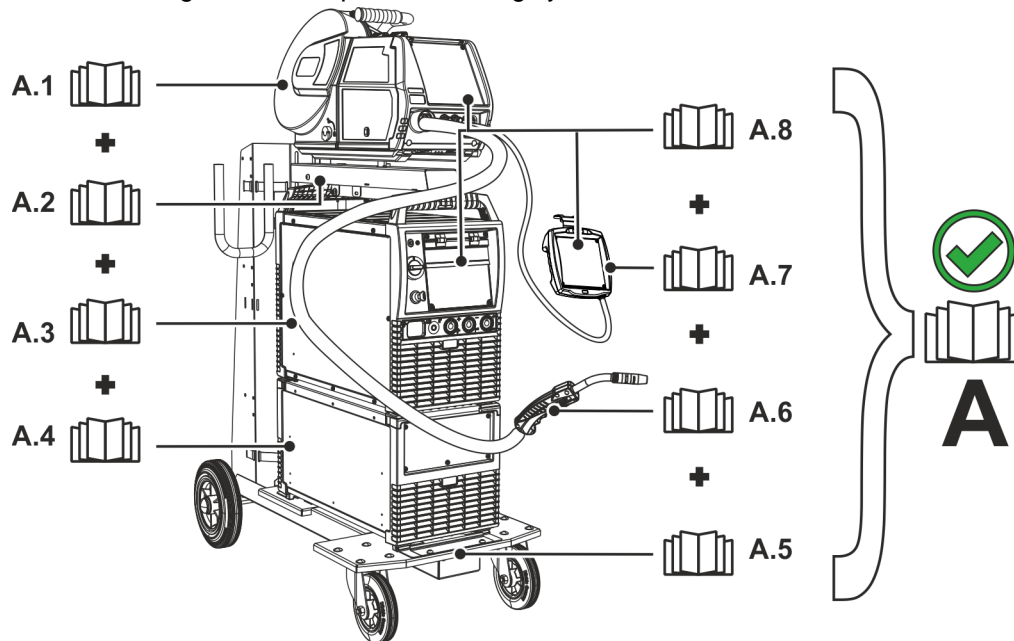


Figure 2-1

Item	Documentation
A.1	Wire feeder
A.2	Conversion instructions
A.3	Power source
A.4	Cooling unit, voltage converter, tool box etc.
A.5	Trolley
A.6	Welding torch
A.7	Remote control
A.8	Control
A	Complete documentation

3 Intended use

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!

3.1 Applications

To transport arc welding systems and process-dependent components such as shielding gas cylinders.

3.2 Use and operation solely with the following machines

- ON Case
- Cool 40, 50
- Microplasma 25, 55, 105
- Picomig 185, 355
- Tetrax 230 DC
- Tetrax 230 AC/DC
- Tetrax 300 DC Comfort 2.0 / Smart 2.0
- Tetrax 300 AC/DC Comfort 2.0 / Smart 2.0
- Phoenix 355 TKM, TKW
- Phoenix 355, 405, 505 TDM
- Taurus 355 TKW, TKM
- Taurus 355, 405, 505 TDM, TDW



For systems equipped with a wire feeder, additional options have to be retro-fitted. See the system overview for the relevant options and combinations > see 5.1 chapter.

4 Machine description – quick overview

4.1 Front view / side view from the right

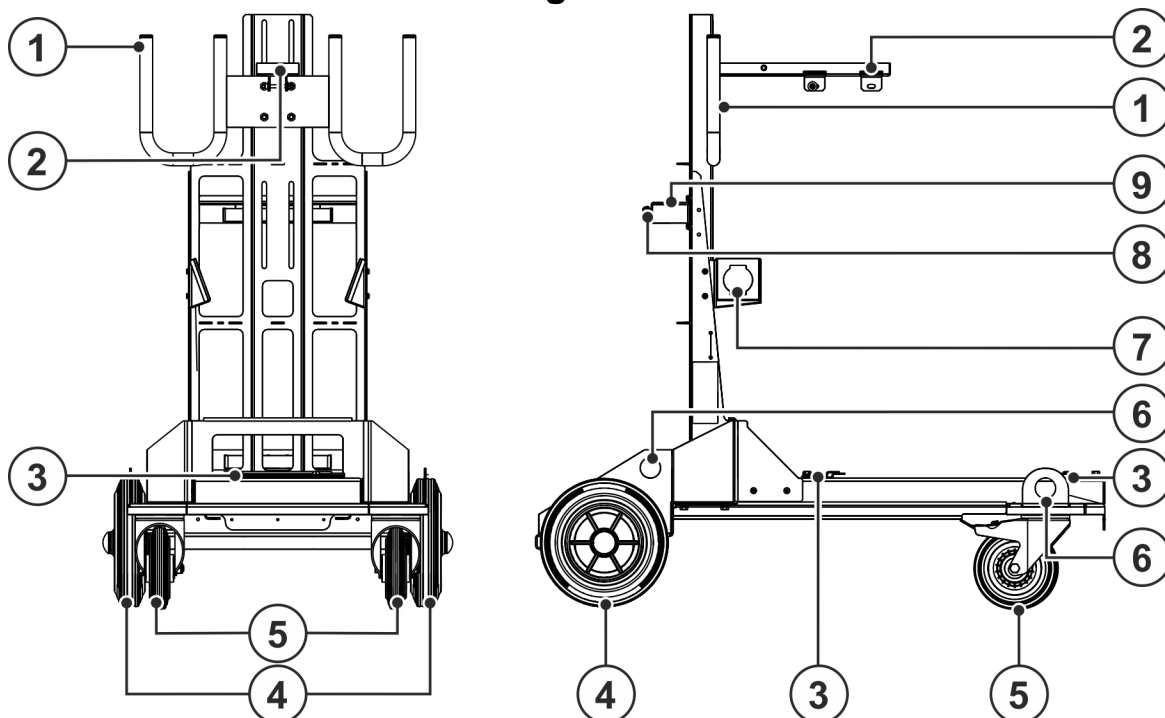


Figure 4-1

Item	Symbol	Description
1		Hose package holder
2		Hold-down fitting for welding machine
3		Machine mounting attachment
4		Transport wheel
5		Wheels, guide castors
6		Lifting lug > see 5.3.1 chapter
7		Intermediate hose package strain relief > see 5.3.2 chapter
8		Clamping belt
9		Retainer panel for gas cylinder

5 Design and function

5.1 System overview

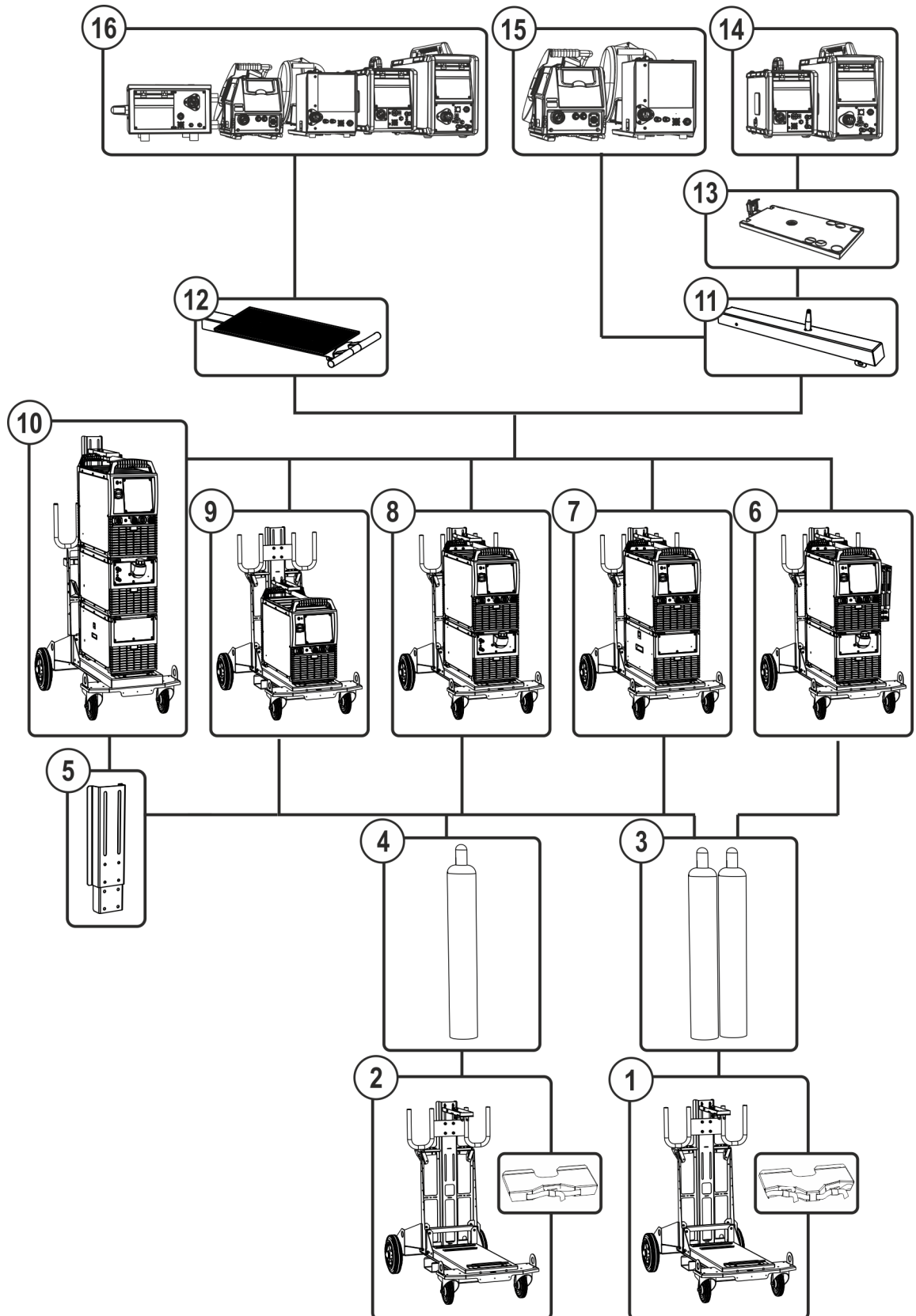


Figure 5-1

Item	Symbol	Description
1		Transport vehicle - Trolley 55-6 DF

Design and function

Installing power source or cooling module



Item	Symbol	Description
2		Transport vehicle - Trolley 55-6
3		Shielding gas cylinder
4		Shielding gas cylinder
5		Extension of the Trolley's cross arm to accommodate added modules - ON Extender 092-003507-00000
6		Transport cart - Trolley 55-6 + power source Microplasma + cooling module
7		Transport cart – Trolley 55-6 + power source + ON TC 092-002899-00000
8		Transport vehicles - Trolley 55-6 + Power source + cool
9		Transport vehicles - Trolley 55-6 + Power source
10		transport cart - Trolley 55-6 + power source + cooling module + ON TC 092- 002899-00000
11		ON TR Trolley 55-5 Cross arm and holder for wire feeder - 092-002700-00000
12		ON PS Trolley 55-5 drive 4L/4X Pivot support – 092-002712-00000
13		ON PS Trolley 55-5 drive 200/300C Pivot support – 092-002634-00000
14		Wire feeders - drive 200/300C (pivotable)
15		Wire feeders – drive 4L/4X (rotatable)
16		All wire feeders - drive

5.2 Installing power source or cooling module

⚠ CAUTION



Risk of accidents due to supply lines!

During transport, attached supply lines (mains leads, control cables, etc.) can cause risks, e.g. by causing connected machines to tip over and injure persons!

- Disconnect all supply lines before transport!



The welding machines can be mounted on the transport vehicle with or without cooling unit. When mounting a machine without cooling unit, the machine hold-down device has to be mounted in a lower position, however.

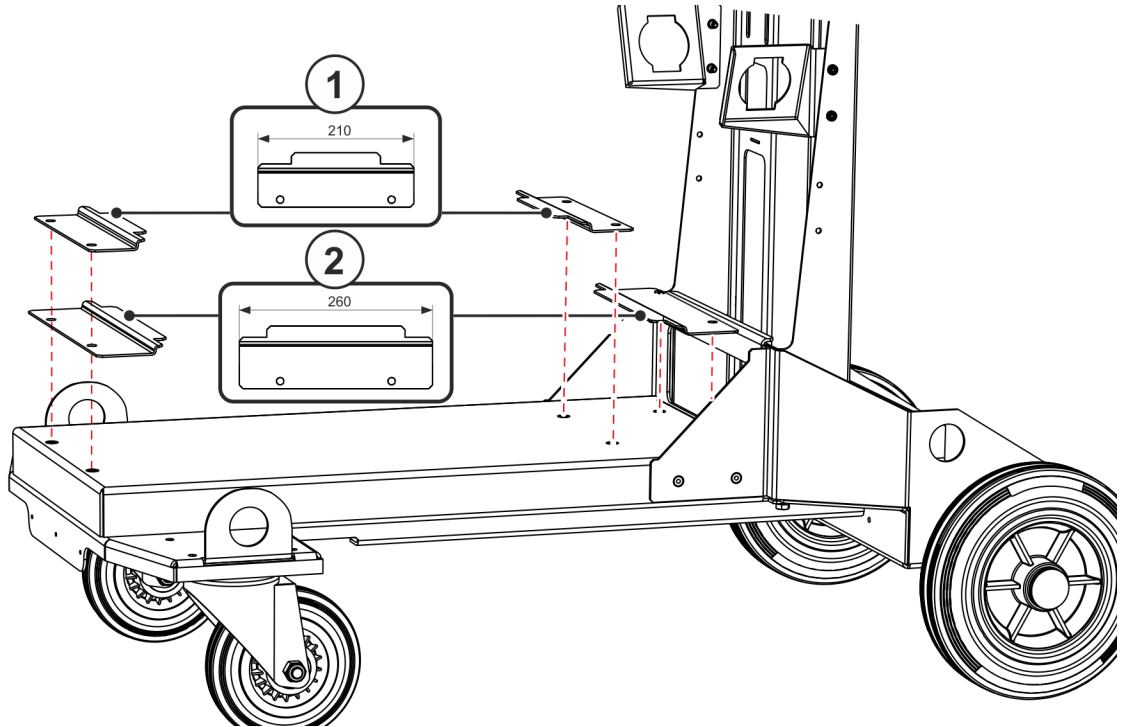


Figure 5-2

Item	Symbol	Description
1		Holding plate BK210X73X10,5
2		Holding plate BK260X84X9,5

- Unscrew the holding plates from the trolley.



Depending on the power source or cooling module to be installed, different holding plates are required at the shown positions.

Product	Holding plate
Microplasma 25, 55, 105	2
Picomig 185, 355	2
Tetrix 230, 300	1
Phoenix 355	2
Taurus 355	2
Set Taurus 505 Basic Duo Gouging	2
cool40	1
cool50	2
ON TC 55	2

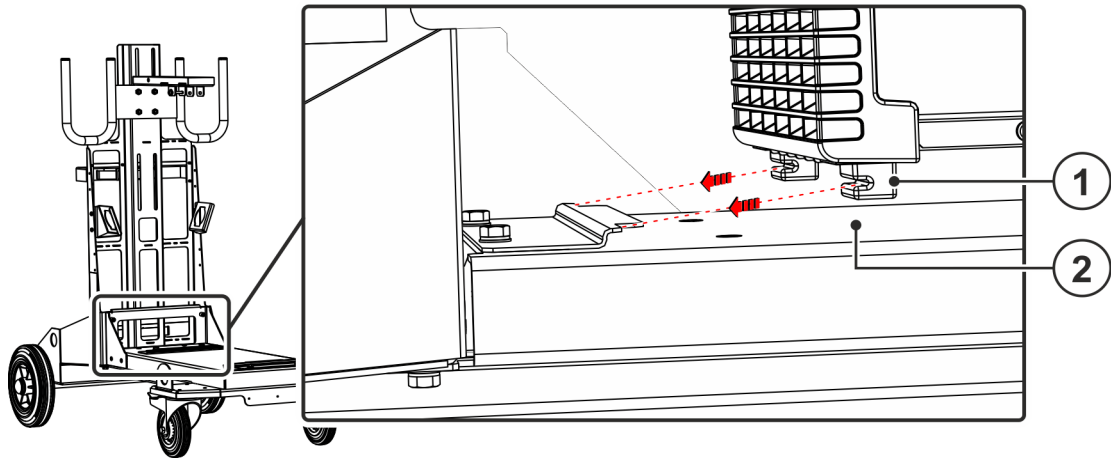


Figure 5-3

Item	Symbol	Description
1		Machine feet
2		Machine support

- Place the machine with its feet in the recesses provided.

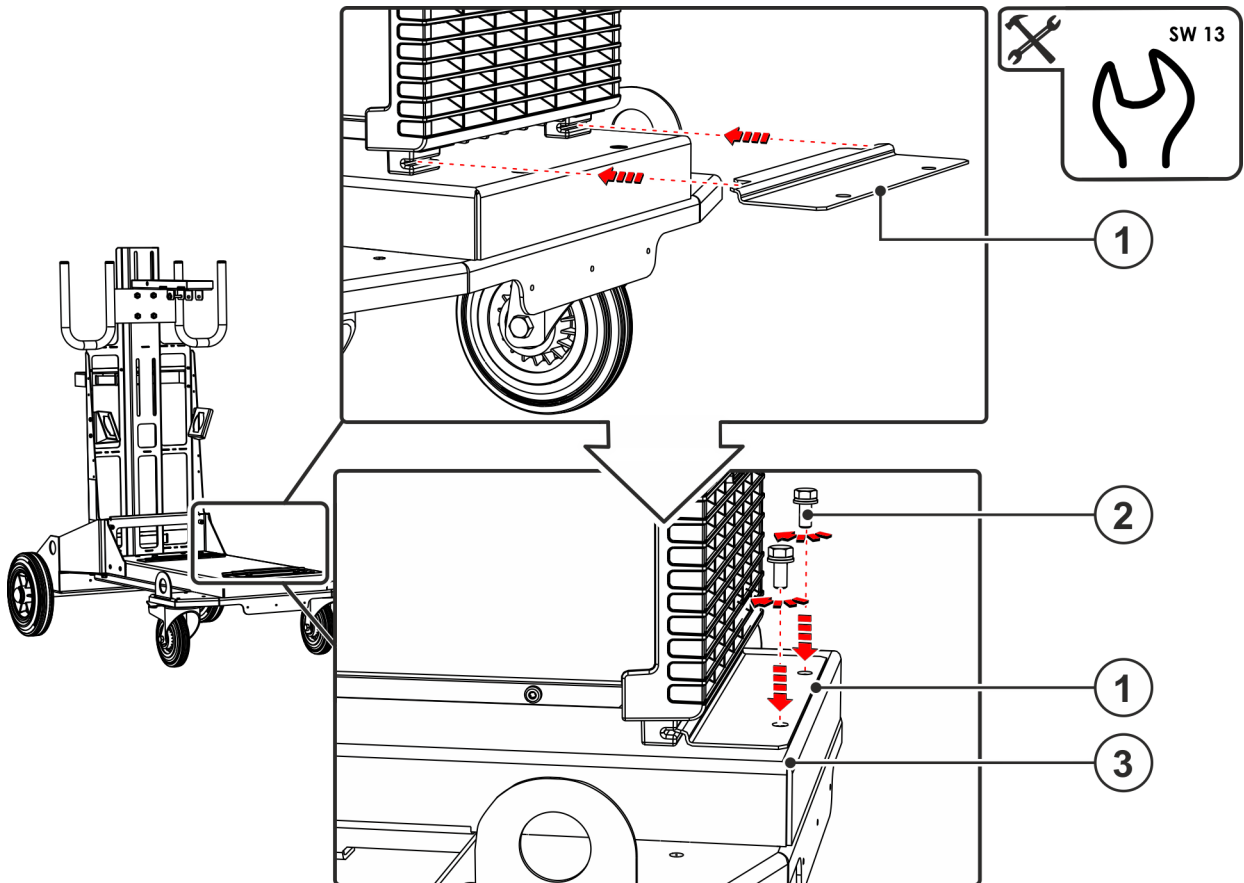


Figure 5-4

Item	Symbol	Description
1		Machine mounting attachment
2		Hexagonal screw M8 x 20
3		Machine support

- Mount the machine mounting attachment with hexagonal screws on the machine support.

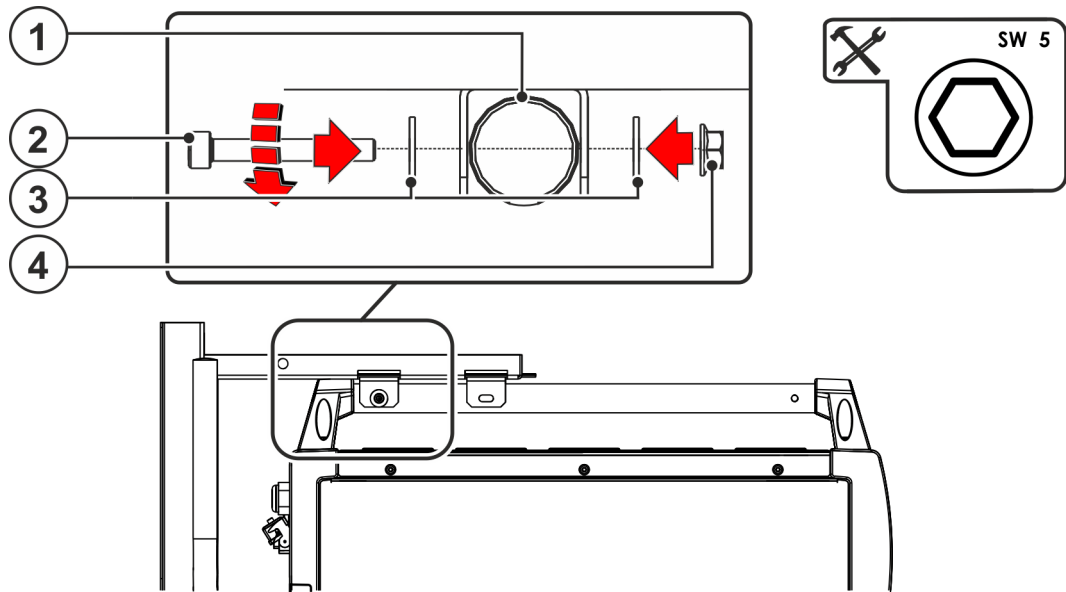


Figure 5-5

Item	Symbol	Description
1		Transport bar
2		Allen screw
3		Plain washer
4		Hexagon nut

- Mount transport bar with fastening material and wire feeder machine support.

5.3 Transport and installation

WARNING



Risk of injury when lifting by crane!

When lifting the machine by crane, persons may be severely injured by falling machines or mount-on components!

- Remove any supply lines and accessories before lifting by crane (e.g. hose package, wire spool, shielding gas cylinder, toolbox, wire feeder, remote control, etc.)!
- Avoid jerky movements!
- Properly close and lock all casing covers and protective caps before lifting by crane!
- Ensure that the load is distributed evenly! • Use chain hoists and chain slings of the same length only!
- Stay outside the danger zone underneath the machine!
- Use the correct number of hoisting equipment of the right size in the correct position! Observe the crane principle > see 5.3.1 chapter!
- Follow the regulations for occupational safety and accident prevention of the respective country!

CAUTION



Improperly secured equipment!

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

- Only used the original parts supplied to fasten the equipment.
- Use the systems only for transporting the machines > see 3.2 chapter.
- Check the fixing points before each transport and at regular intervals.

5.3.1 Craning principle

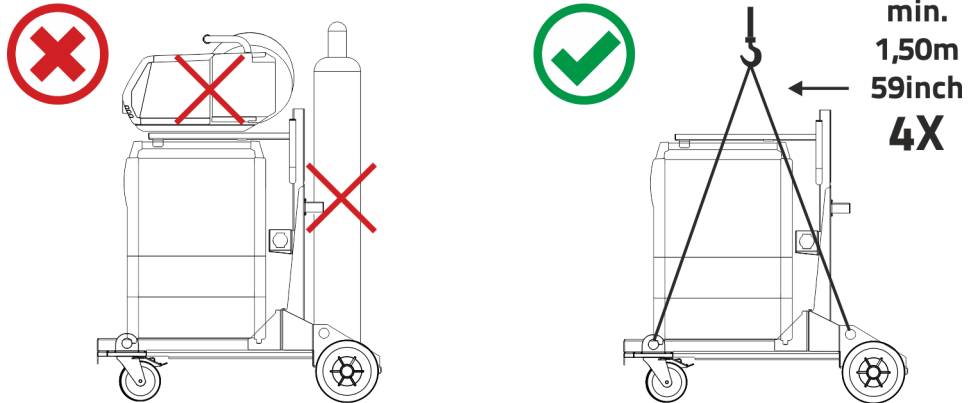


Figure 5-6

5.3.2 Intermediate hose package strain relief



Missing or incorrectly fitted strain relief!

Connection sockets or connection plugs on the machine, or the intermediate tube package, may be damaged if the strain relief is missing or incorrectly fitted. The strain relief takes the strain from cables, plugs and sockets.

5.3.2.1 Locking the strain relief

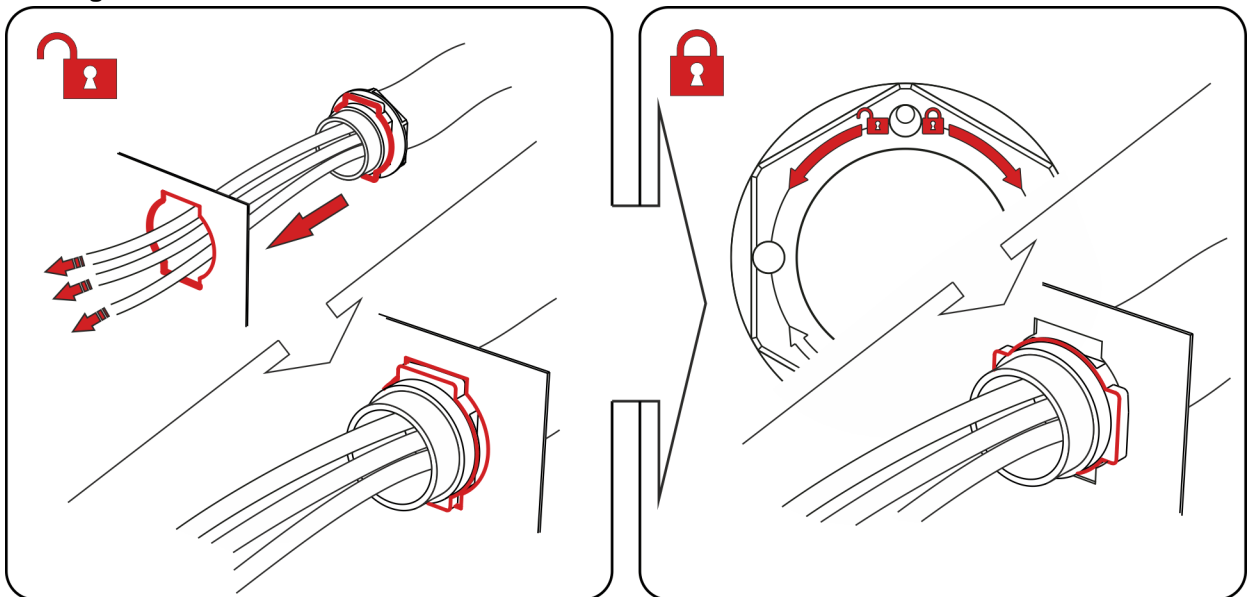


Figure 5-7

- Insert the end of the hose package through the strain relief of the hose package and lock by turning to the right.

5.4 Functional characteristics

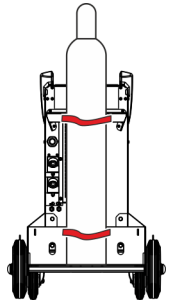
5.4.1 Securing the shielding gas cylinder

WARNING



Risk of injury due to improper handling of shielding gas cylinders! Improper handling and insufficient securing of shielding gas cylinders can cause serious injuries!

- Observe the instructions from the gas manufacturer and any relevant regulations concerning the use of compressed air!
- Lift the shielding gas cylinder onto the receptacle of the shielding gas cylinder and secure with both safety belts provided on the device as standard! Belts must be tight.
- Do not attach any element to the shielding gas cylinder valve!
- Prevent the shielding gas cylinder from heating up.



An unhindered shielding gas supply from the shielding gas cylinder to the welding torch is a fundamental requirement for optimum welding results. In addition, a blocked shielding gas supply may result in the welding torch being destroyed.

- **All shielding gas connections must be gas tight.**

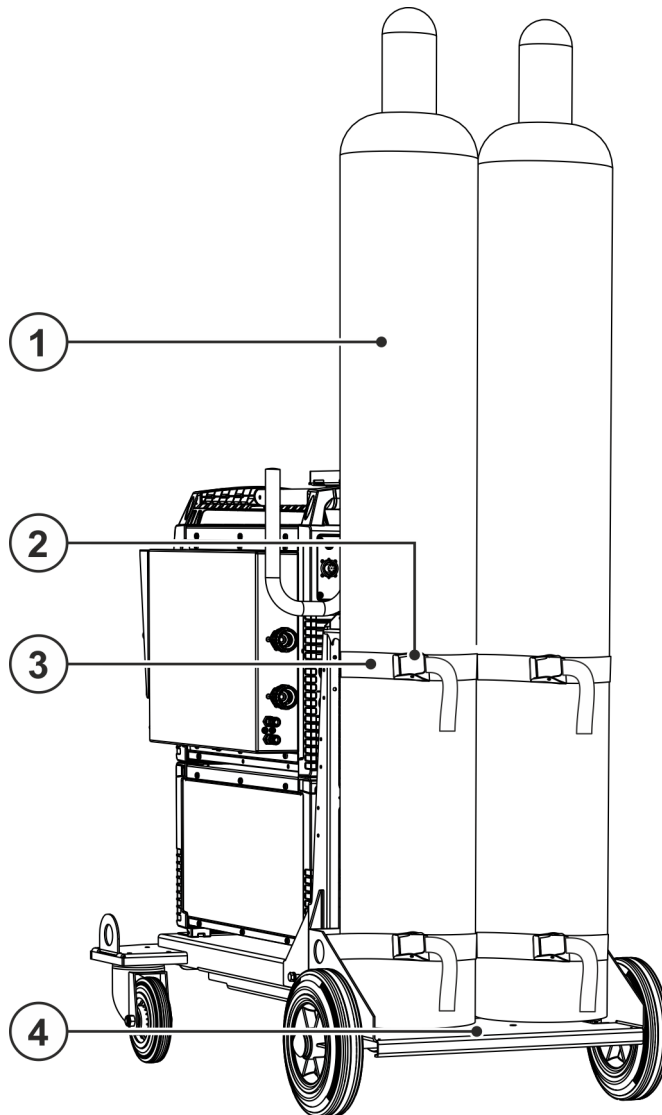


Figure 5-8

Item	Symbol	Description
1		Clamping belt

Item	Symbol	Description
2		Tension closure
3		Shielding gas cylinder holder > see 5.4.1 chapter Carrier plate for the shielding gas cylinder
4		Shielding gas cylinder

- Open the closure of the straps.
- Place shielding gas cylinder on the retainer.
- Secure shielding gas cylinder using straps.
- Fasten straps using the closure.
- Make sure the straps on the cylinder are securely fastened!

5.4.2 Using the transport system

⚠ 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 > see 3.2 chapter.
- Check the fixing points before each transport and at regular intervals.

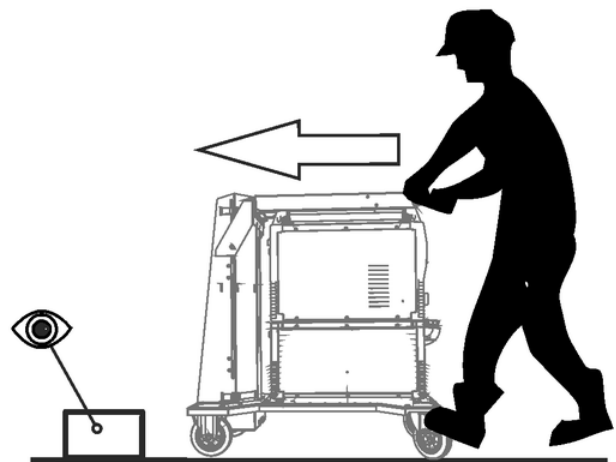
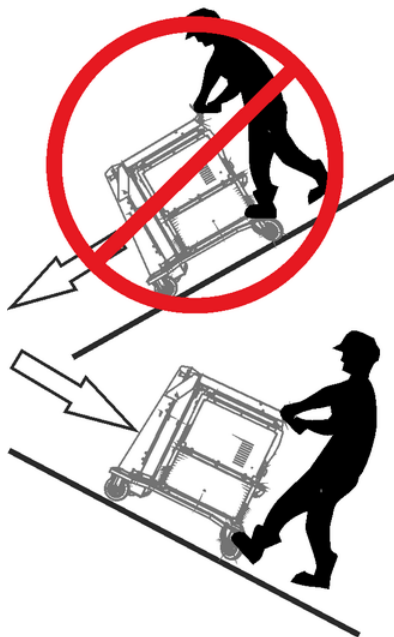


Figure 5-9

6 Maintenance, care and disposal

6.1 General

DANGER



Risk of injury due to electrical voltage after switching off!

Working on an open machine can lead to fatal injuries!

Capacitors are loaded with electrical voltage during operation. Voltage remains present for up to four minutes after the mains plug is removed.

1. Switch off machine.
2. Remove the mains plug.
3. Wait for at least 4 minutes until the capacitors have discharged!

WARNING



Incorrect maintenance, testing and repair!

Maintenance, testing and repair of the machine may only be carried out by skilled and qualified personnel. A qualified person is one who, because of his or her training, knowledge and experience, is able to recognise the dangers that can occur while testing welding power sources as well as possible subsequent damage, and who is able to implement the required safety procedures.

Observe the maintenance instructions > see 6.2 chapter.

- In the event that the provisions of one of the below-stated tests are not met, the machine must not be operated again until it has been repaired and a new test has been carried out!

Repair and maintenance work may only be performed by qualified authorised personnel; otherwise the right to claim under warranty is void. In all service matters, always consult the dealer who supplied the machine. Return deliveries of defective equipment subject to warranty may only be made through your dealer. When replacing parts, use only original spare parts. When ordering spare parts, please quote the machine type, serial number and item number of the machine, as well as the type designation and item number of the spare part.

Under the specified ambient conditions and normal working conditions this machine is essentially maintenance-free and requires just a minimum of care.

Contamination of the machine may impair service life and duty cycle. The cleaning intervals depend on the ambient conditions and the resulting contamination of the machine. The minimum interval is every six months.

6.1.1 Cleaning

- Clean the outer surfaces with a moist cloth (no aggressive cleaning agents).
- Purge the machine venting channel and cooling fins (if present) with oil- and water-free compressed air. Compressed air may overspeed and destroy the machine fans. Never direct the compressed air directly at the machine fans. Mechanically block the fans, if required.
- Check the coolant for contaminants and replace, if necessary.

6.1.2 Dirt filter

The duty cycle of the welding machine decreases as an effect of the reduced cooling air volume. The dirt filter must be removed at regular intervals and cleaned by blowing out with compressed air (depending on the level of soiling).

6.2 Maintenance work, intervals

6.2.1 Daily maintenance tasks

Visual inspection

- Mains supply lead and its strain relief
- Gas cylinder securing elements
- Check hose package and power connections for exterior damage and replace or have repaired by specialist staff as necessary!
- Gas tubes and their switching equipment (solenoid valve)
- Check that all connections and wearing parts are hand-tight and tighten if necessary.
- Check correct mounting of the wire spool.
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Other, general condition

Functional test

- Operating, message, safety and adjustment devices (Functional test)
- Welding current cables (check that they are fitted correctly and secured)
- Gas tubes and their switching equipment (solenoid valve)
- Gas cylinder securing elements
- Check correct mounting of the wire spool.
- Check that all screw and plug connections and replaceable parts are secured correctly, tighten if necessary.
- Remove any spatter.
- Clean the wire feed rollers on a regular basis (depending on the degree of soiling).

6.2.2 Monthly maintenance tasks

Visual inspection

- Casing damage (front, rear and side walls)
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Check coolant tubes and their connections for impurities

Functional test

- Selector switches, command devices, emergency stop devices, voltage reducing devices, message and control lamps
- Check that the wire guide elements (inlet nipple, wire guide tube) are fitted securely.
- Check coolant tubes and their connections for impurities
- Check and clean the welding torch. Deposits in the torch can cause short circuits and have a negative impact on the welding result, ultimately causing damage to the torch.

6.2.3 Annual test (inspection and testing during operation)

A periodic test according to IEC 60974-4 "Periodic inspection and test" has to be carried out. In addition to the regulations on testing given here, the relevant local laws and regulations must also be observed.

For more information refer to the "Warranty registration" brochure supplied and our information regarding warranty, maintenance and testing at www.ewm-group.com!

6.3 Disposing of equipment



Proper disposal!

The machine contains valuable raw materials, which should be recycled, and electronic components, which must be disposed of.

- Do not dispose of in household waste!
- Observe the local regulations regarding disposal!
- According to European provisions (Directive 2012/19/EU on Waste of Electrical and Electronic Equipment), used electric and electronic equipment may no longer be placed in unsorted municipal waste. It must be collected separately. The symbol depicting a waste container on wheels indicates that the equipment must be collected separately.
This machine has to be disposed of, or recycled, in accordance with the waste separation systems in use.
- According to German law (law governing the distribution, taking back and environmentally correct disposal of electric and electronic equipment (ElektroG)), used machines are to be placed in a collection system separate from unsorted municipal waste. The public waste management utilities (communities) have created collection points at which used equipment from private households can be disposed of free of charge.
- Information about returning used equipment or about collections can be obtained from the respective municipal administration office.
- In addition to this, returns are also possible throughout Europe via EWM sales partners.

7 Technical data**7.1 Trolley 55-6 / Trolley 55-6 DF**

	Trolley 55-6	Trolley 55-6 DF
Shielding gas cylinder support (10 l/20 l/50 l)	max. pressure: 300 bar max. height: 1640 mm (+/-20) max. diameter: 229 mm (+/-1%)	
Dimensions (L x W x H)	1114 x 678 x 1486 mm 43.9 x 26.7 x 58.5 inch	
Weight without accessories	approx. 50.4 kg approx. 111.1 lb	approx. 50.8 kg approx. 112 lb

8 Accessories

Performance-dependent accessories like torches, workpiece leads, electrode holders or intermediate hose packages are available from your authorised dealer.

8.1 General accessories

Type	Designation	Item no.
ON PS Trolley 55-5 / 55-6	Pivot support	092-002712-00000
ON PS Trolley 55-5 / 55-6 drive D200	Pivot support	092-002634-00000
ON Case	Tool box for mounting to Trolley 55-5/6	092-002899-00000
ON TR Trolley 55	Cross arm and holder for wire feeder Trolley 55-5 and Trolley 55-6	092-002700-00000
ON Extender	Extension of the cross arm of the trolley to include further modules	092-003507-00000

9 Appendix

9.1 Searching for a dealer

Sales & service partners
www.ewm-group.com/en/specialist-dealers



"More than 400 EWM sales partners worldwide"