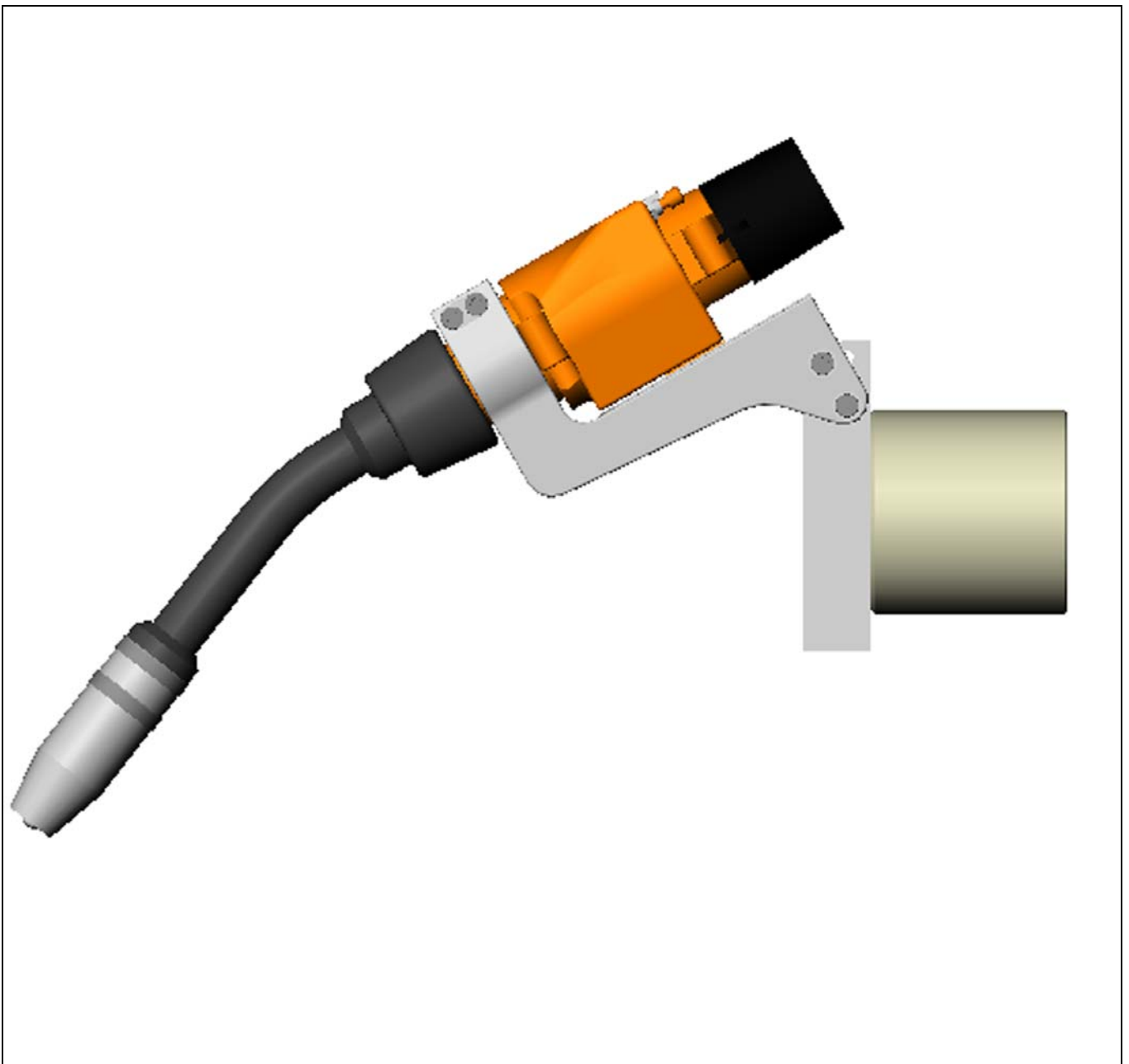


Instruction manual and Spare parts list

Welding torch PKI 250S / 250D
PKI 500S / 500D
PKI 630S / 630D
PKI 300S / 300D

504 888-102
2003-05



ABB

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ABB Automation Technology Products AB

Arc Welding & Application Equipment

S-695 82 Laxå

Sverige

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1 Technical description

The PKI welding torch is intended for mechanized gas/metal arc welding processes. It is water-cooled, and incorporates ducts for pneumatic spatter cleaning. It has a quick-connection coupling for manual exchange of torch necks. The signal cables, cooling water, gas, air and wire liner are all run in the hose bundle.

1.1 Technical data for hose bundle

The maximum load rating of the hose bundle is 500A at 100% duty cycle. The hose bundle is fitted with a pushbutton for wire feed when changing the filler wire. It is supplied with a wire liner for 1.0-1.2 mm Fe wires.

There are two designs: a single detachable and a double detachable.

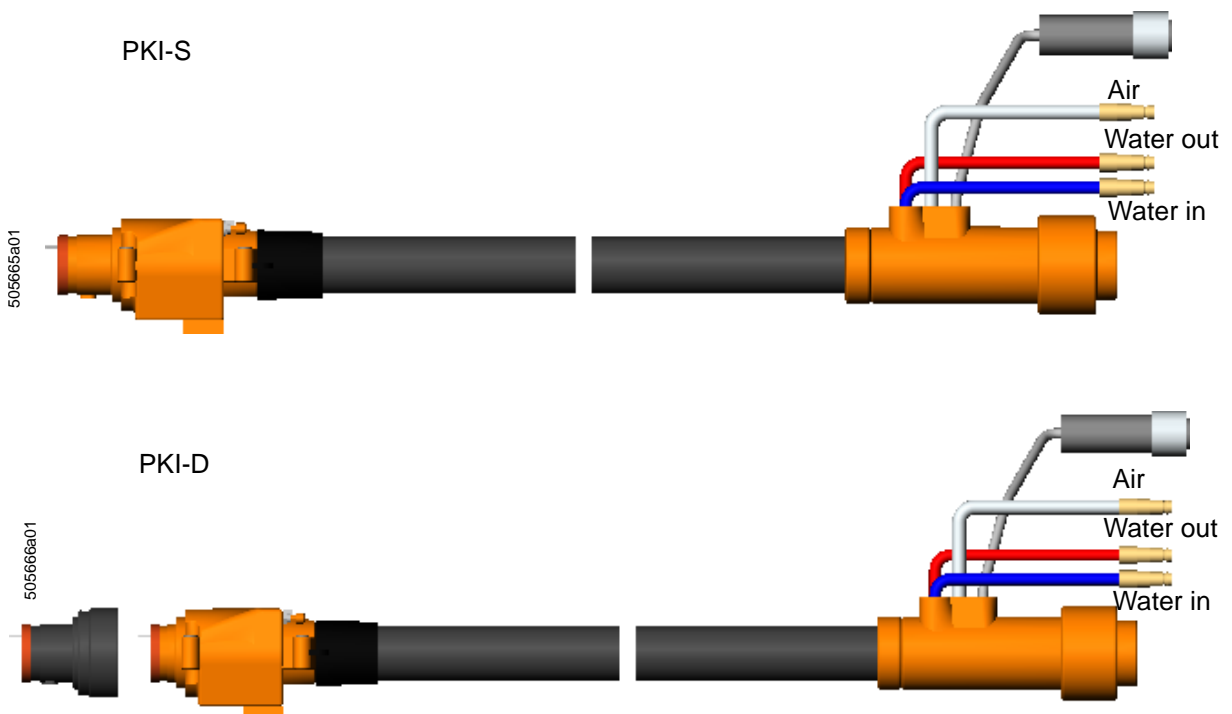
Maximum loading is limited by the type of torch neck fitted.

1.2 The PKI-S (=single) and PKI-D (=double)

This is intended for fitting on the robot arm.

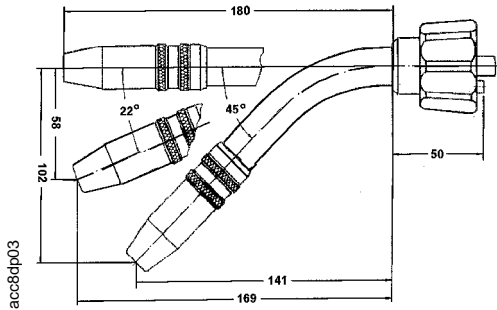
Length: 1.4 m

Connectors: EURO quick connectors for gas and filler wire
Quick connectors for water and air
12-pole electrical for control signals



1.3 Technical data: torch necks

PKI 250

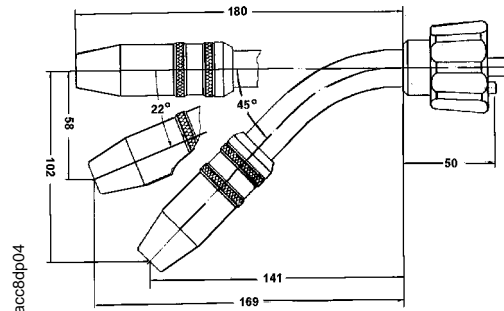


Maximum load 250 A - 100% duty cycle
 Wire diameter 0.8, 0.9, 1.0, 1.2 mm

The contact tip is secured by a clamp nut

Supplied with 12/23 gas nozzle, 68 mm long (part.no 438 533-003) and 1.0 mm contact tip (part.no 438 533-032)

PKI 500/PKI 500A (Aluminium)

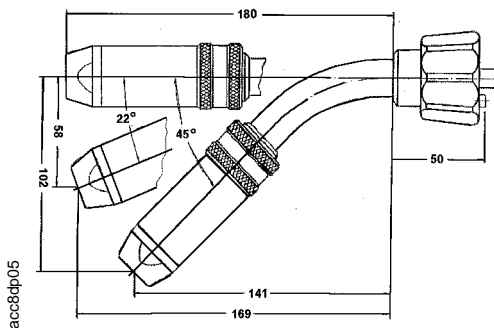


Maximum load 400 A - 100% duty cycle
 Wire diameter 0.8, 0.9, 1.0, 1.2, 1.4, 1.6 mm

The contact tip is secured by a clamp nut.
 PKI 500A; the contact tip is screwed on.

Supplied with 15/28 gas nozzle, 76 mm long (part.no 441 528-001) and 1.0 mm contact tip (part.no 441 922-003)

PKI 630

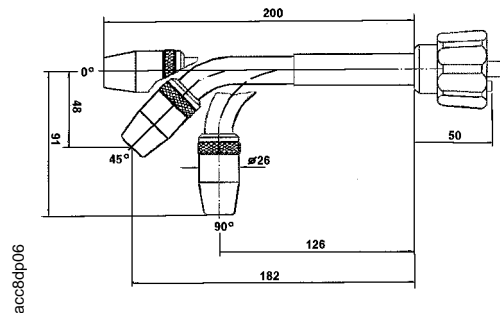


Maximum load 500 A - 100% duty cycle
 Wire diameter 1.0, 1.2, 1.4, 1.6, 2.0, 2.4 mm

The contact tip is screwed on.

Supplied with 18/34 gas nozzle, 32 mm long (part.no 438 633-002) and 1.2 mm contact tip (part.no 438 633-008)

PKI 300



Maximum load 300 A - 100% duty cycle
 Wire diameter 0.8, 0.9, 1.0, 1.2 mm

The contact tip is screwed on.

Supplied with 15/26 gas nozzle, 46 mm long (part.no 418 423-003) and 1.0 mm contact tip (part.no 418 424-003)

Maximum loading is reduced by about 25% when performing pulse welding. The factors that determine this are the particular power source being used, the work-piece being welded and the shielding gas.

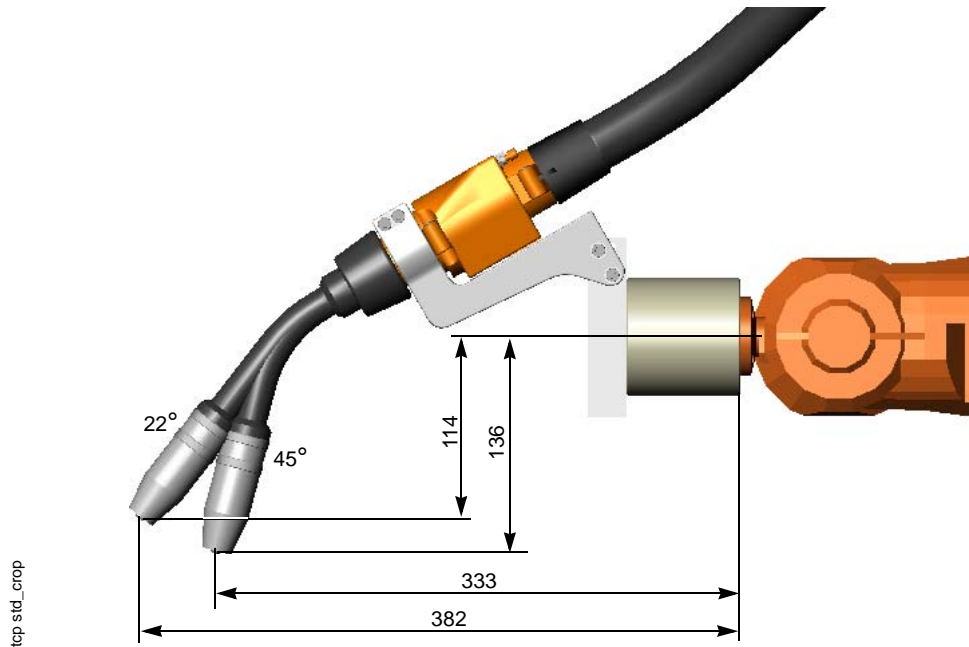
Special designs of torch necks can be supplied on request.

NB!

When deciding on the torch neck to be used, allowance must be made for the type of robot to be used.

1.4 Technical data: torch holder

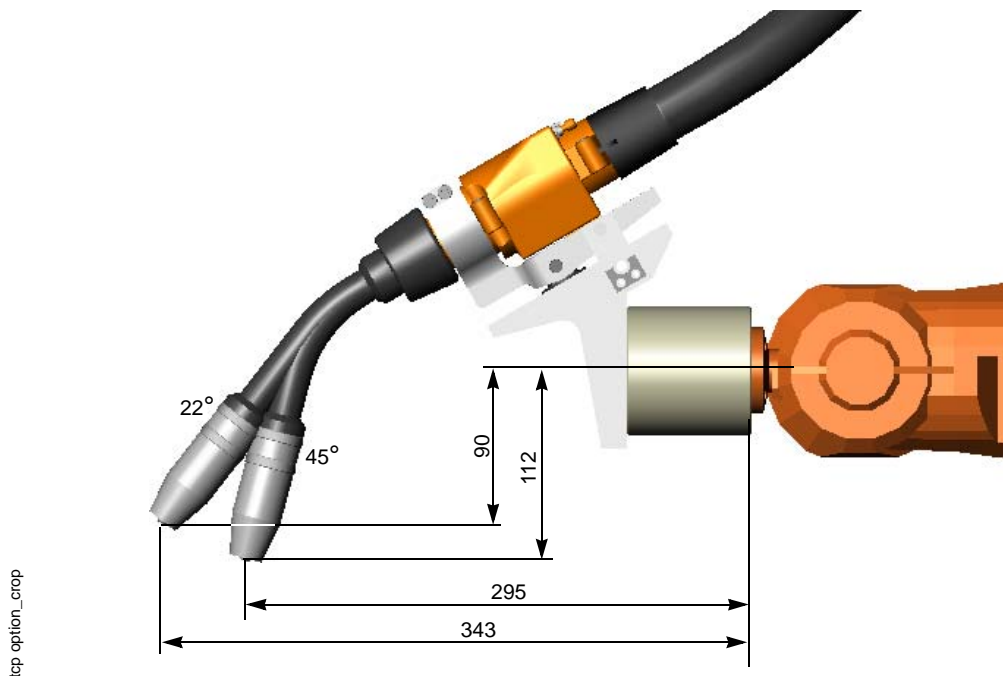
TCP measurements with the standard holder.



Optional holder for older models of the PKI welding torches consists of two parts. The lower part is fixed, carrying an adjustable upper part that allows the correct TCP to be set.

Using this solution you can attain the old TCP measurements.

Note that the dimensions shown below are approximate, and do not apply to the PKI 300.



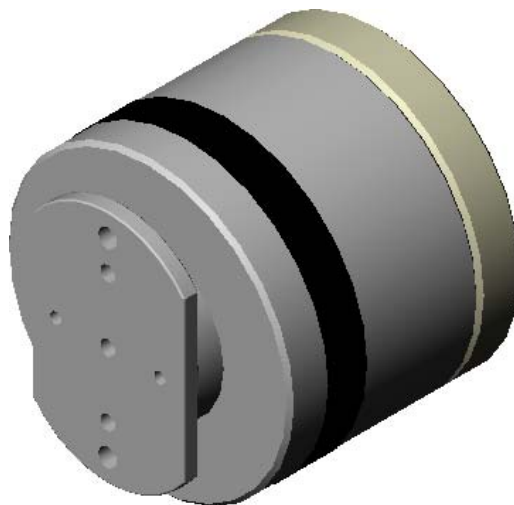
1.5 Technical data: Type 2000 and 1000 safety bracket (Option)

The mounting plate fitted to the safety switch operates the switch in all load directions, thus preventing damage to tools or welding torches. Operation of the switch causes the robot to revert to standby mode. In the event of a collision or overload, the switch senses the situation and operates in a fraction of a second.

Repetitive accuracy is high, and the switch automatically resets itself to the operating position.

1.5.1 Recommend actions in the event of a stop:

- Press the RESET button on the wire feed to activate the system.
- Change position using the programming unit, i.e. move away from the obstacle.
- Check the connectors and TCP setting.
- Restart production.



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Torsion operating torque $MT=30$ Nm
Bending operating torque $MB=20-25$ Nm

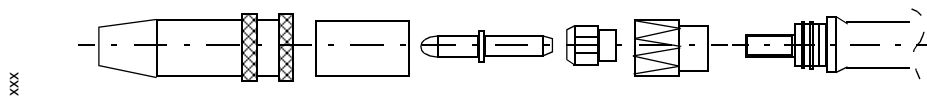
2 Service and Maintenance

Proper performance and reliability of the welding torch depend on correct use and maintenance. Use only genuine spare parts in the interest of minimum life cycle costs and maintenance of guarantee conditions.

2.1 Replacing the contact tip for:

PKI 250/500

- 1 Remove the gas nozzle and clean weld spatter off it.
- 2 Clean the internal and external threads.
- 3 Inspect the spatter protection in the gas nozzle and replace both parts if they are worn.
- 4 Remove the clamp nut, using the spanner supplied.
- 5 Remove the contact tip, the gas distributor. Replace them if worn.
- 6 Reassemble the gas distributor, the contact tip, the clamp nut and the gas nozzle with the spatter protection in the reverse order.

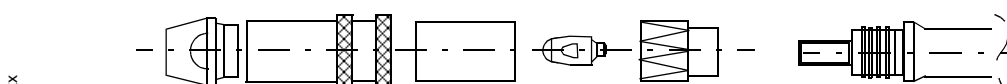
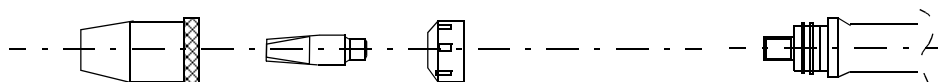


PKI 300/630

- 1 Remove the gas nozzle and cooling jacket, clean weld spatter off.
- 2 Clean the internal and external threads.
- 3 Inspect the spatter protection (PKI 630) in the gas nozzle and replace both parts if they are worn.
- 4 Remove the contact tip and the gas distributor. Replace them if worn.
- 5 Reassemble the gas distributor, the contact tip and the gas nozzle (and the cooling jacket with the spatter protection) in the reverse order.

Do not use pliers or wrenches etc. when assembling the parts.

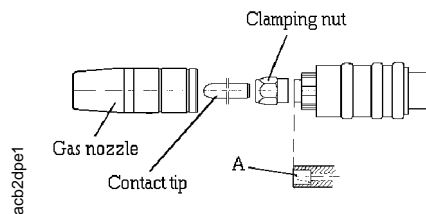
Inspect the gas nozzle and contact tip after every welding session, and replace consumable parts when they become worn.



2.2 Replacing the wire liner for:

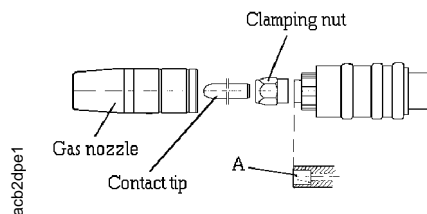
PKI 250/500

- 1 Remove from the wire feed unit:
 - For PKI-S; remove the hose bundle from the wire feed unit.
 - For PKI-D; remove the hose bundle from the wire feed unit.
- 2 Remove the gas nozzle, the clamp nut and the contact tip.
- 3 Remove the end screw in the wire liner.
- 4 Pull out the wire liner.
- 5 Remove the clamping sleeve from the wire liner.
- 6 Fit the clamping sleeve to the new wire liner, as shown in the figure.
- 7 Insert the new wire liner in the hose bundle. Refit the end screw and cut off the end of the wire liner so that it reaches the front edge of the contact tube (A). File the cut end and round it off.
- 8 Refit the contact tip and clamp nut.



PKI 300/630

- 1 Remove from the wire feed unit:
 - For PKI-S; remove the hose bundle from the wire feed unit.
 - For PKI-D; remove the hose bundle from the wire feed unit.
- 2 Remove the gas nozzle and the contact tip.
- 3 Remove the end screw in the wire liner.
- 4 Pull out the wire liner.
- 5 Remove the clamping sleeve from the wire liner.
- 6 Fit the clamping sleeve to the new wire liner, as shown in the figure.
- 7 Insert the new wire liner in the hose bundle. Refit the end screw and cut off the end of the wire liner so that it reaches the front edge of the contact tube (A). File the cut end and round it off.
- 8 Refit the contact tip and gas nozzle.



2.3 Fitting a new torch neck or straightening the torch neck

- 1 Slacken the nut (by hand) anti-clockwise, and pull out the torch neck.
- 2 Straighten the bent torch neck in the straightener.
- 3 Inspect the O-rings in the end connector and replace them if worn.
- 4 Replace the torch neck and refit the nut by hand.
- 5 Check the TCP. If necessary, correct it by adjusting the torch holder.

Do not use pliers or wrenches etc. when assembling the parts.

2.4 Visual inspection

- Inspect hoses, the support hose and support devices for signs of wear, and replace if necessary.
-

2.5 Replacing the overload switch (safety bracket - Option)

- Remove the switch by slackening the grub screw beneath the sleeve opposite the cable entry. Remove the cable clamp and pull out the switch and cable.
Fit the new switch by pressing it home to its stop position, and then tighten the screw. (The operating load is set during manufacture, and cannot be adjusted.)

3 Selection tables

3.1 Contact tips

Select the required contact tip to suite the torch neck in use from the table below. (See "Technical data: torch necks" for details of wire sizes). If the filler wire binds, e.g. when welding with high welding data using argon or mixed gas, choose a tip having a larger diameter.

Contact tips for PKI 250

Contact tips for PKI 500

Wire size			Contact tip		
ø (mm)	Ordering No.	Marking	ø (mm)	Ordering No.	Marking
0.8	438 533-030	0,8	0.8	441 922-001	0,8
0.9	438 533-031	0,9	0.9	441 922-002	0,9
1.0	438 533-032	1,0	1.0	441 922-003	1,0
1.2	438 533-033	1,2	1.2	441 922-004	1,2
			1.4	441 922-005	1,4
			1.6	441 922-006	1,6

Contact tips for PKI 500A

Wire size		Contact tip	
ø (mm)	Ordering No.	Marking	
1.0	487 107-001	1,0	
1.2	487 107-002	1,2	
1.4	487 107-003	1,4	
1.6	487 107-004	1,6	
1.8	487 107-005	1,8	

Contact tips for PKI 630

Contact tips for PKI 300

Wire size			Contact tip		
ø (mm)	Ordering No.	Marking	ø (mm)	Ordering No.	Marking
1.0	438 633-006	1,0	0.8	418 424-001	0,8
1.2	438 633-007	1,2	0.9	418 424-002	0,9
1.4	438 633-008	1,4	1.0	418 424-003	1,0
1.6	438 633-009	1,6	1.2	418 424-004	1,2
2.0	438 633-010	2,0			
2.4	438 633-016	2,4			

3.2 Wire liners

Select the required wire liner from the table below. If the filler wire binds, choose a wire liner having a larger diameter.

Wire liner				Wire
Type	Ordering No.	Diameter (mm)	Length (m)	Diameter (mm)
steel	413 005-001	1.5	3,26	Fe 0.8-0.9
	413 005-002	1.5	2,26	
	413 005-007	1.5	1,7	
	413 005-017	1.5	50	
steel	413 005-003	1.8	3,26	Fe 1.0-1.2
	413 005-004	1.8	2,26	
	413 005-008	1.8	1,7	
	413 005-018	1.8	30	
steel	413 005-005	2.2	3,26	Fe 1.4-1.6
	413 005-006	2.2	2,26	
	413 005-009	2.2	1,7	
	413 005-019	2.2	30	
steel	413 005-023	2.4	30	Fe 1.8-2.0 Cored wire 1.4-1.6
steel	413 005-024	2.9	25	Fe 2.2-2.4
teflon	441 130-003	1.5	3,26	Al 0.8-1.0
teflon	441 130-004	2.2	3,26	Al 1.2-1.4
polyamid	441 130-009	3.0	3,26	Al 1.6

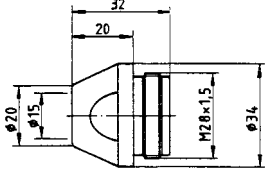
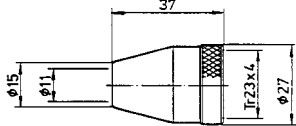
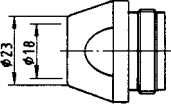
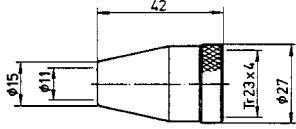
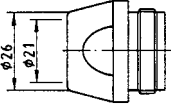
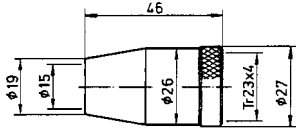
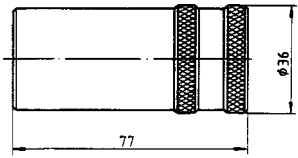
3.3 Gas nozzles

The table below shows the range of gas nozzles available for each torch neck. Select the appropriate gas nozzle depending on factors such as the welding process, accessibility etc.

Changing the gas nozzle also requires the cleaning tools to be changed when using mechanical spatter cleaning.

Ordering no.	Gas nozzle	Ordering no.	Gas nozzle
	PKI 250		PKI 500
438533-002		441528-003	
438533-003		441528-004	
438533-004		441528-001	
438533-001		441528-002	
438533-005		441528-006	
438533-006		441528-007	
	acc8tp01	441528-005	
			acc8tp02

Welding torch PKI
Selection tables

Ordering no.	Gas nozzle	Ordering no.	Gas nozzle
438633-001	<p style="text-align: center;">PKI 630</p> 	418423-001	<p style="text-align: center;">PKI 300</p> 
438633-002		418423-002	
438633-003		418423-003	
<p style="text-align: center;">Cooling sleeve 438633-004</p>	 <p style="text-align: center;">acc8tp03</p>		<p style="text-align: center;">acc8tp04</p>

4 Reservdelsförteckning/Spare Parts List

Reservdelar beställs genom ABB Automation Technology Products AB. Vid beställning var vänlig uppge typ och tillverkningsnummer samt benämningar och beställningsnummer enligt reservdelsförteckningen.

Rätt till ändring av specifikationer utan avisering förbehålles.

*Spare parts are to be ordered from ABB Automation Technology Products AB.
Kindly indicate type of unit, serial number, denominations and ordering number
according to the spare parts list.*

Rights to reserved to alter specifications without notice.

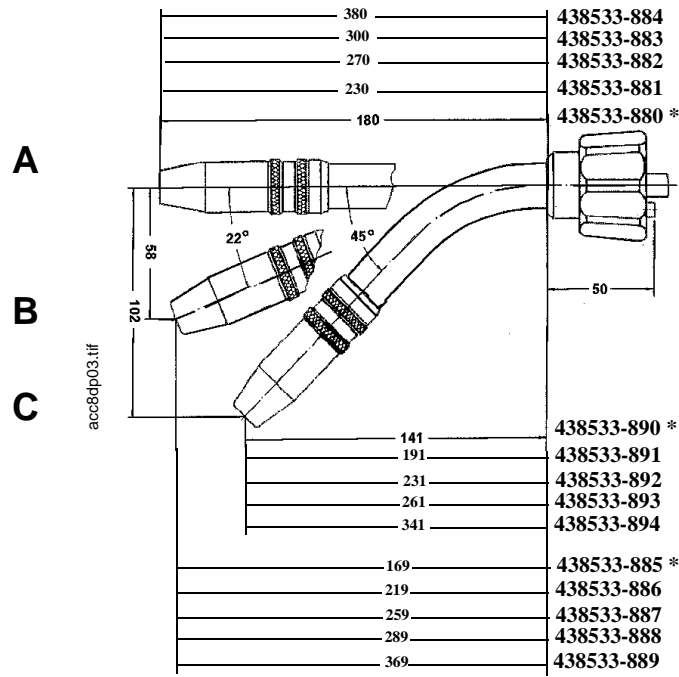
Reservdelsförteckning/Spare Parts List

Positionsnummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkingar Remarks
A		438 533-880	PKI 250 Kontaktodon, kompl.	PKI 250 Torch neck, compl.	0°
B		438 533-885	Kontaktodon, kompl.	Torch neck, compl.	22°
C		438 533-890	Kontaktodon, kompl.	Torch neck, compl.	45°
1	x	438 533-001	Gaskåpa	Gas nozzle	11/20 L=68
		438 533-002	Gaskåpa	Gas nozzle	9/23 L=68
		438 533-003 ^a	Gaskåpa	Gas nozzle	12/23 L=68
		438 533-004	Gaskåpa	Gas nozzle	12/23 L=63
		438 533-005	Gaskåpa	Gas nozzle	12/20 L=63
		438 533-006	Gaskåpa	Gas nozzle	15/23 L=68
2		438 533-020	Sprutskydd	Spatter protection	
3	x	438 533-030	Kontaktmunstycke	Contact tip	0,8 mm
		438 533-031	Kontaktmunstycke	Contact tip	0,9 mm
		438 533-032	Kontaktmunstycke	Contact tip	1,0 mm
		438 533-033	Kontaktmunstycke	Contact tip	1,2 mm
4		438 533-040	Spännmutter	Clamp nut	
5		438 533-100	Gasfördelare	Gas distributor	
6		438 533-110	O-ring sats	Set of o-rings	
7		505 791-001	Kontaktskruv	Connecting piece	
		501 910-880	Kontaktodon, kompl. För HELIX	Torch neck, compl. For HELIX	22°
		501 910-001	Kontaktodon	Contact device	
		501 910-002	Adapter	Adapter	

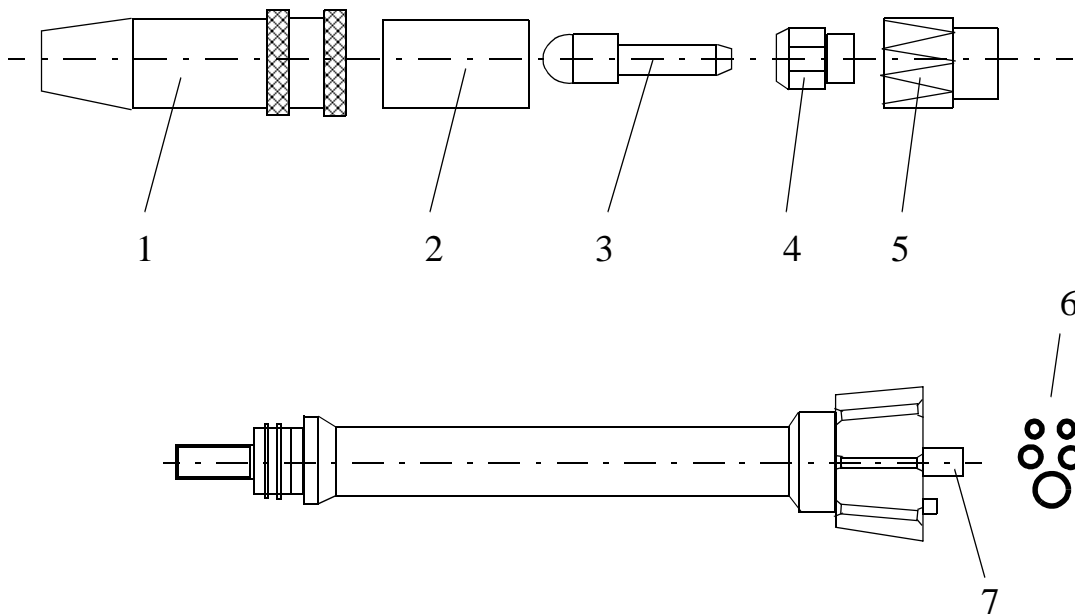
a. Standard; vid köp av komplett kontaktodon

a. Included as standard with complete torch neck

PKI 250



Standardmodeller markerade med *
 Standard models marked with *



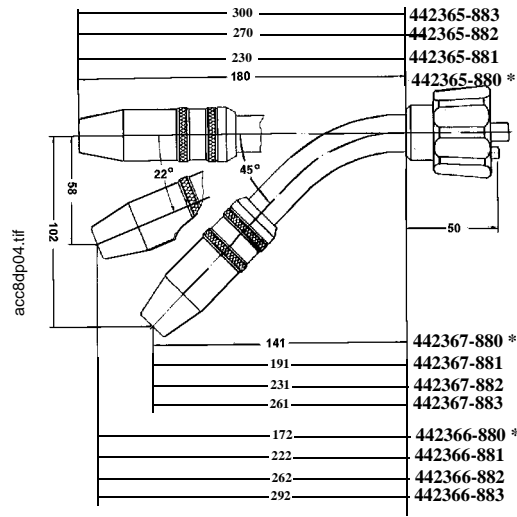
Reservdelsförteckning/Spare Parts List

Positions- nummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkingar Remarks
A		442 365-880	PKI 500 Kontaktidon, kompl.	PKI 500 Torch neck, compl.	0°
B		442 366-880	Kontaktidon, kompl.	Torch neck, compl.	22°
C		442 367-880	Kontaktidon, kompl.	Torch neck, compl.	45°
1	*	441 528-001 ^a	Gaskåpa	Gas nozzle	15/28 L=76
		441 528-002	Gaskåpa	Gas nozzle	15/28 L=71
		441 528-003	Gaskåpa	Gas nozzle	13/28 L=76
		441 528-004	Gaskåpa	Gas nozzle	13/28 L=71
		441 528-005	Gaskåpa	Gas nozzle	18/28 L=76
		441 528-006	Gaskåpa	Gas nozzle	15/24 L=76
		441 528-007	Gaskåpa	Gas nozzle	15/24 L=71
2		441 530-001	Sprutskydd	Spatter protection	
		441 530-002	Sprutskydd	Spatter protection	
3		412 992-001	Gasfördelare	Gas distributor	
		412 992-003	Gasfördelare	Gas distributor	
4	*	441 922-001	Kontaktmunstycke	Contact tip	0,8 mm
		441 922-002	Kontaktmunstycke	Contact tip	0,9 mm
		441 922-003	Kontaktmunstycke	Contact tip	1,0 mm
		441 922-004	Kontaktmunstycke	Contact tip	1,2 mm
		441 922-005	Kontaktmunstycke	Contact tip	1,4 mm
		441 922-006	Kontaktmunstycke	Contact tip	1,6 mm
5		412 988-001	Spännmutter	Clamp nut	
		441 142-001	Nyckelsats för spänn- mutter	Key kit for clamp nut	
6		438 533-110	O-ring sats	Set of o-rings	
7		505 791-001	Kontaktskruv	Connecting piece	

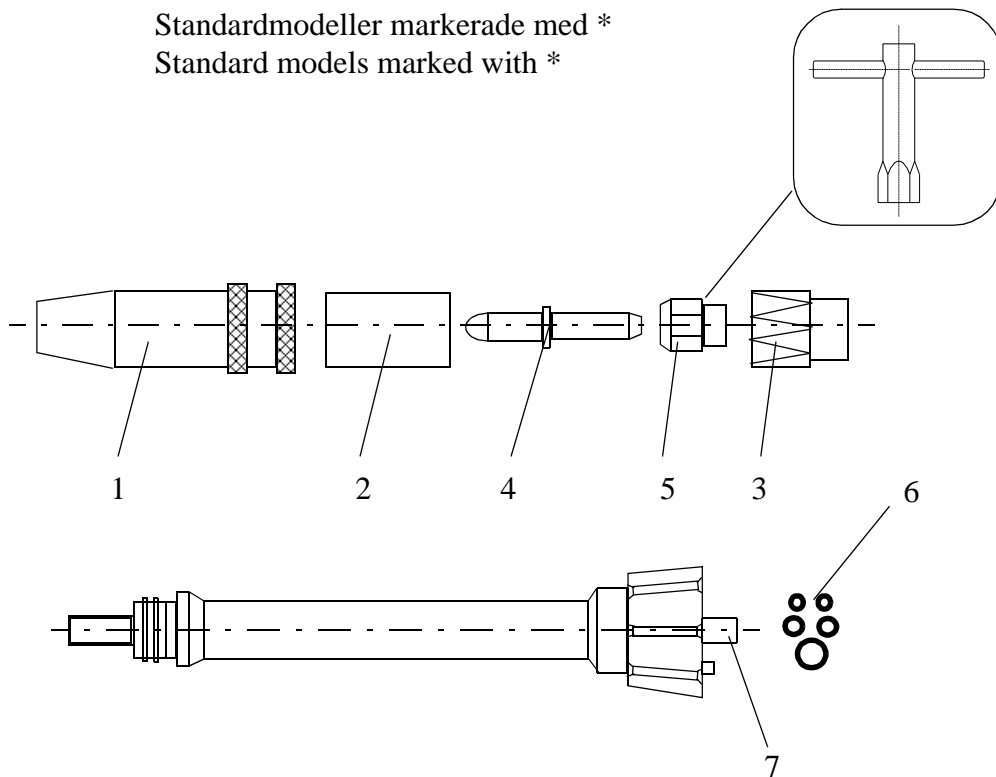
a. Standard; vid köp av komplett kontaktidon

a. Included as standard with complete torch neck

PKI 500



Standardmodeller markerade med *
 Standard models marked with *



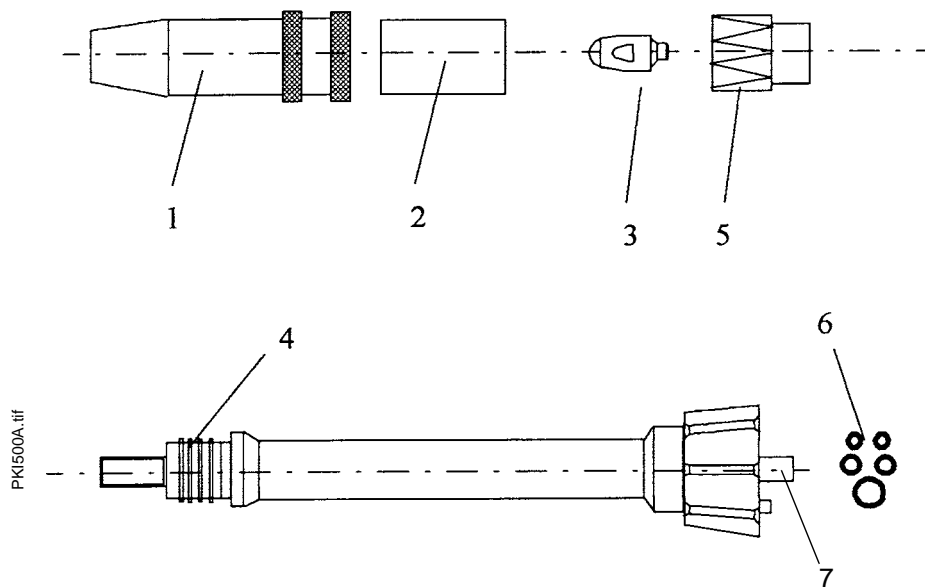
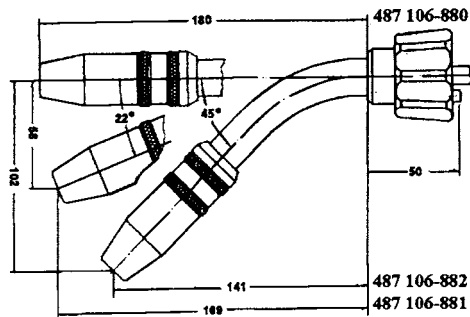
Reservdelsförteckning/Spare Parts List

Positionsnummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkingar Remarks
A		487 106-880	PKI 500A Kontaktidon, kompl.	PKI 500A Torch neck, compl.	0°
B		487 106-881	Kontaktidon, kompl.	Torch neck, compl.	22°
C		487 106-882	Kontaktidon, kompl.	Torch neck, compl.	45°
1	*	441 528-001 ^a	Gaskåpa	Gas nozzle	15/28 L=76
		441 528-002	Gaskåpa	Gas nozzle	15/28 L=71
		441 528-003	Gaskåpa	Gas nozzle	13/28 L=76
		441 528-004	Gaskåpa	Gas nozzle	13/28 L=71
		441 528-005	Gaskåpa	Gas nozzle	18/28 L=76
		441 528-006	Gaskåpa	Gas nozzle	15/24 L=76
		441 528-007	Gaskåpa	Gas nozzle	15/24 L=71
2		441 530-001	Sprutskydd	Spatter protection	
3	*	487 107-001	Kontaktmunstycke	Contact tip	1,0 mm
		487 107-002	Kontaktmunstycke	Contact tip	1,2 mm
		487 107-003	Kontaktmunstycke	Contact tip	1,4 mm
		487 107-004	Kontaktmunstycke	Contact tip	1,6 mm
		487 107-005	Kontaktmunstycke	Contact tip	1,8 mm
		487 107-006	Kontaktmunstycke	Contact tip	0,8 mm
4		487 109-001	O-ring	O ring	
5		487 108-001	Gasfördelare	Gas distributor	
6		438 533-110	O-ring sats	Set of o-rings	
7		505 791-001	Kontaktskruv	Connecting piece	

a. Standard; vid köp av komplett kontaktidon

a. Included as standard with complete torch neck

PKI 500A (Aluminium)



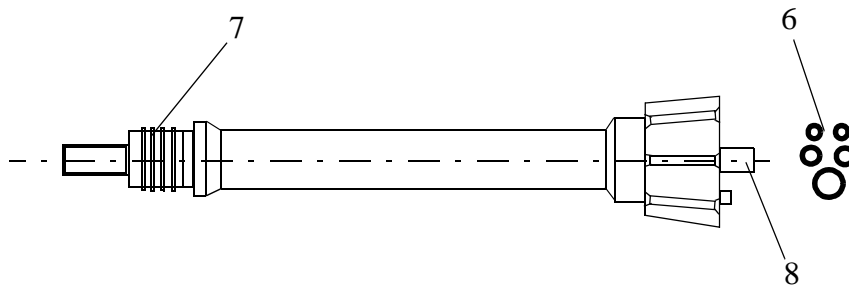
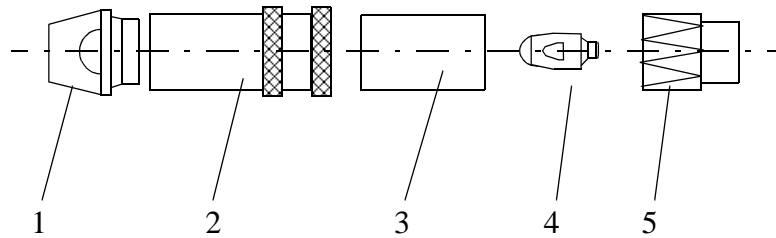
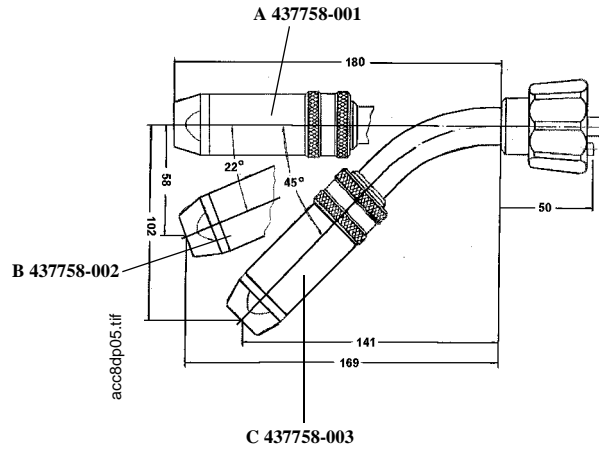
Reservdelsförteckning/Spare Parts List

Positionsnummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkningar Remarks
A		437 758-001	PKI 630 Kontakt don, kompl.	PKI 630 Torch neck, compl.	0°
B		437 758-002	Kontakt don, kompl.	Torch neck, compl.	22°
C		437 758-003	Kontakt don, kompl.	Torch neck, compl.	45°
1		438 633-001	Gaskåpa	Gas nozzle	15/34 L=32
	*	438 633-002	Gaskåpa	Gas nozzle	18/34 L=32
		438 633-003 ^a	Gaskåpa	Gas nozzle	21/34 L=32
2		438 633-004	Kylmantel	Cooling jacket	L=77
3		441 530-001	Sprutskydd	Spatter protection	
4		438 633-006	Kontaktmunstycke	Contact tip	1,0 mm
	*	438 633-007	Kontaktmunstycke	Contact tip	1,2 mm
		438 633-008	Kontaktmunstycke	Contact tip	1,4 mm
		438 633-009	Kontaktmunstycke	Contact tip	1,6 mm
		438 633-010	Kontaktmunstycke	Contact tip	2,0 mm
		438 633-016	Kontaktmunstycke	Contact tip	2,4 mm
5		438 633-011	Gasfördelare	Gas distributor	
6		438 533-110	O-ringsats	Set of o-rings	
7		438 633-017	O-ringsats	Set of o-rings	
8		505 791-001	Kontaktskruv	Connecting piece	

a. Standard; vid köp av komplett kontakt don

a. Included as standard with complete torch neck

PKI 630



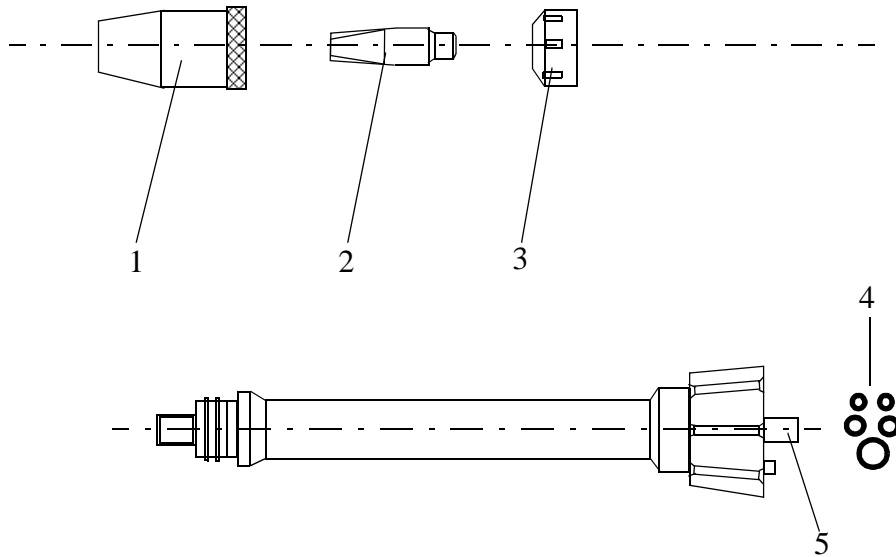
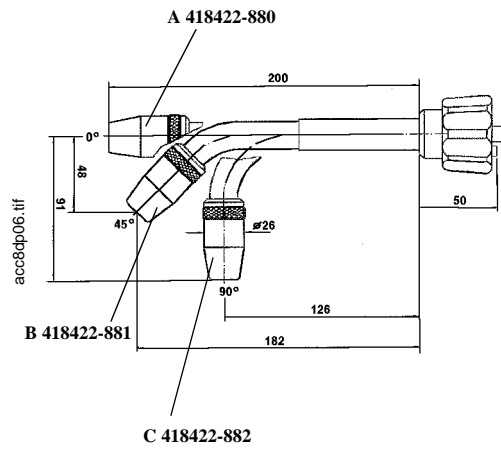
Reservdelsförteckning/Spare Parts List

Positions- nummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkingar Remarks
A		418 422-880	PKI 300 Kontaktton, kompl.	PKI 300 Torch neck, compl.	0°
B		418 422-881	Kontaktton, kompl.	Torch neck, compl.	45°
C		418 422-882	Kontaktton, kompl.	Torch neck, compl.	90°
1		418 423-001	Gaskåpa	Gas nozzle	11/26 L=37
	*	418 423-002	Gaskåpa	Gas nozzle	11/26 L=42
	*	418 423-003 ^a	Gaskåpa	Gas nozzle	15/26 L=46
2		418 424-001	Kontaktmunstycke	Contact tip	0,8 mm
	*	418 424-002	Kontaktmunstycke	Contact tip	0,9 mm
	*	418 424-003	Kontaktmunstycke	Contact tip	1,0 mm
	*	418 424-004	Kontaktmunstycke	Contact tip	1,2 mm
3		418 425-001	Gasfördelare	Gas distributor	
4		438 533-110	O-ring sats	Set of o-rings	
5		505 791-001	Kontaktskruv	Connecting piece	

a. Standard; vid köp av komplett kontaktton

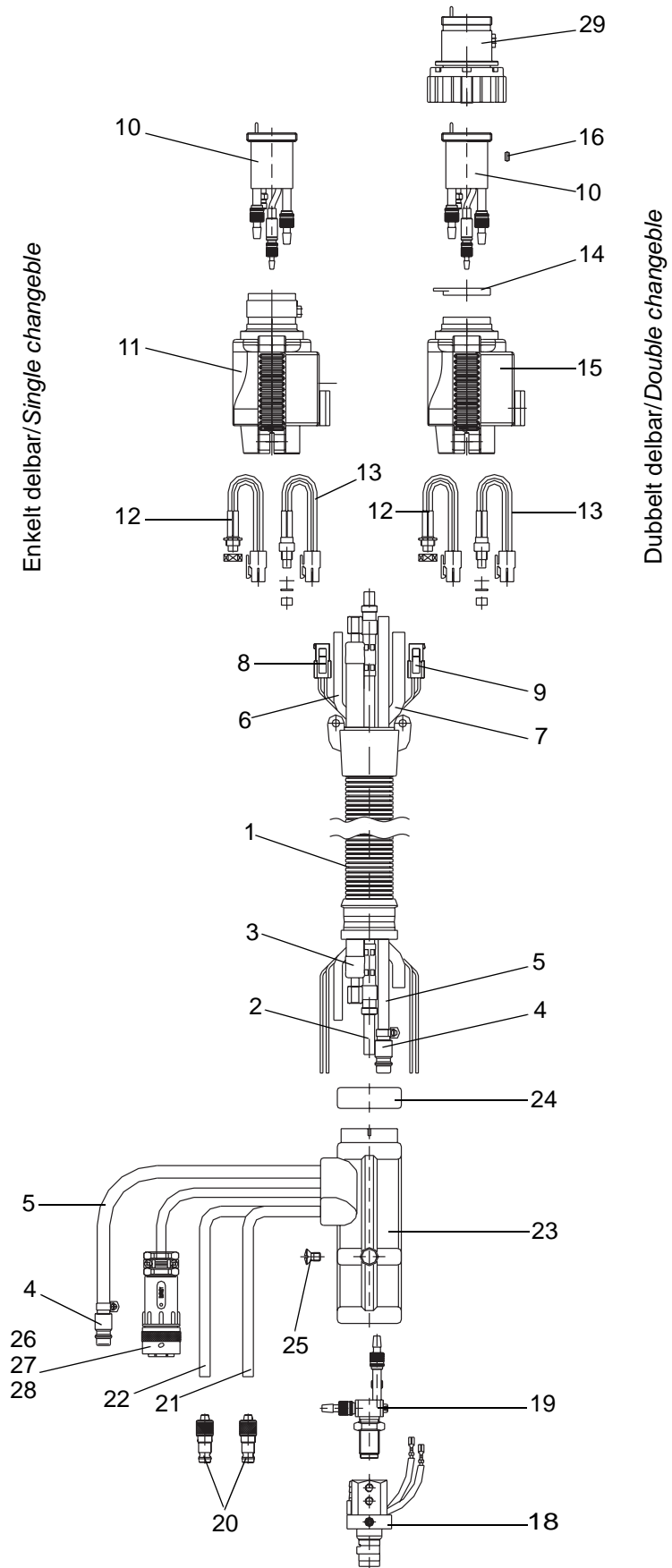
a. Included as standard with complete torch neck

PKI 300



Reservdelsförteckning/Spare Parts List

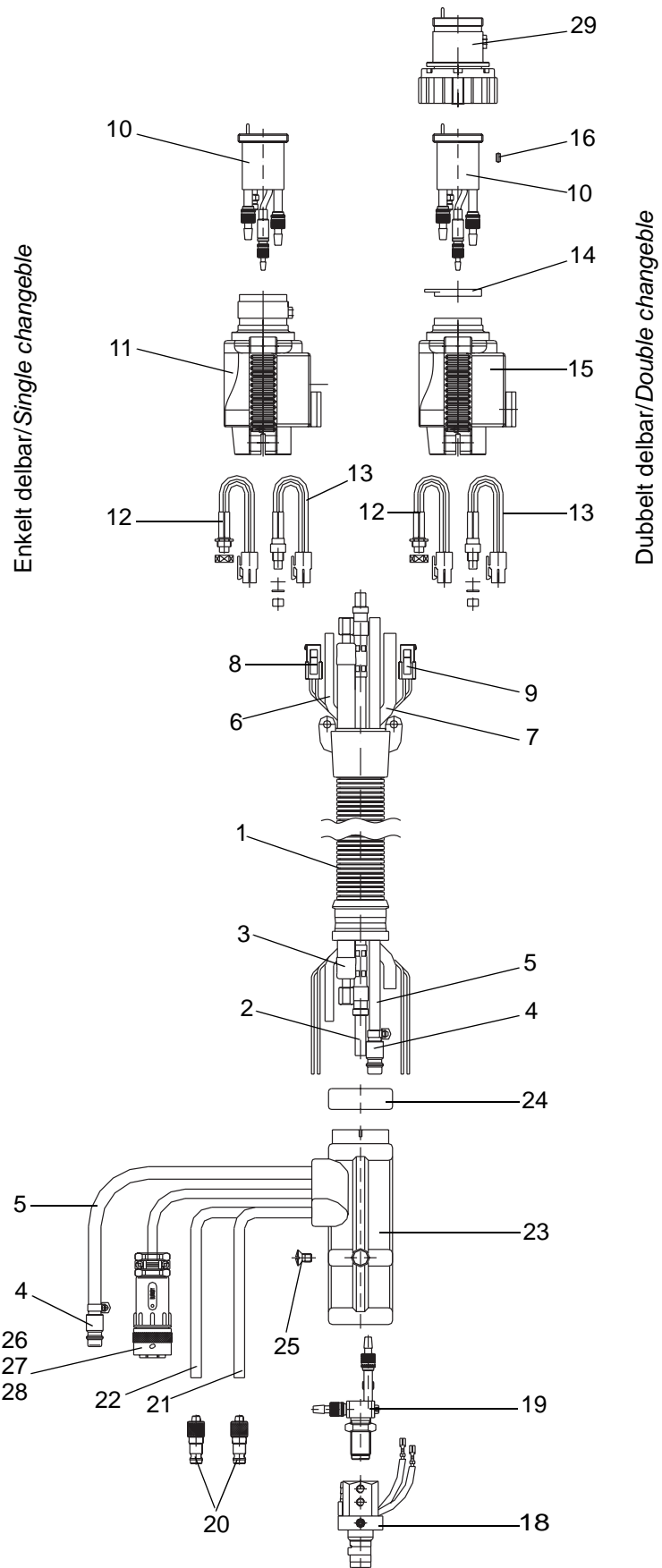
Positionsnummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkningar Remarks
A		505 665-880	PKI-S EURO Slangpaket	PKI-S EURO Hose bundle	Single L=1400
B		505 666-880	PKI-D EURO Slangpaket	PKI-D EURO Hose bundle	Double L=1400
1		505 792-001	Ytterhölje	Cover	
2		505 792-002	Trådledarslang	Wire liner hose	
3		505 792-003	Ström- o vattenkabel	Current/water cable	
4		505 792-004	Nippel	Nipple	
5		505 792-005	Tryckluftslang	Air pressure hose	
6		505 792-006	Gasslang	Gas hose	
7		505 792-007	Vattenslang	Water hose	
8		505 792-008	Styrkabel svart	Cable black	
9		505 792-009	Styrkabel blå	Cable blue	
10		505 794-001	Anslutningskropp	Attachment body	
11		505 794-002	Pistolhus	Torch housing	A
12		505 794-003	Tryckknapp	Push-button	
13		505 794-004	Kontakt	Contact	
14		505 794-005	Stödring	Support ring	B
15		505 794-006	Pistolhus	Torch housing	B
16		505 794-007	Kil	Parallel key	B
18		505 793-001	Kontaktinsats	Attachement body	
19		505 793-002	Vattenanslutning	Water connector	
20		412 996-001	Insticksnippel	Plug-in nipple	
21		412 997-001	Anslutningsslang, röd	Hose, red	
22		412 997-002	Anslutningsslang, blå	Hose, blue	
23		501 340-001	Kontaktus	Contact housing	
24		501 342-001	Låsring	Locking ring	
25		501 343-001	Fästskruv	Mounting screw	
26		323 942-003	Stiftpropp	Pin plug	12-pol
27		323 943-103	Dragavlastning	Tractionrelieving device	12-pol
28		323 945-001	Kontaktstift	Contact pin	
29		505 666-002	Anslutningskropp	Attachment body	B



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Reservdelsförteckning/Spare Parts List

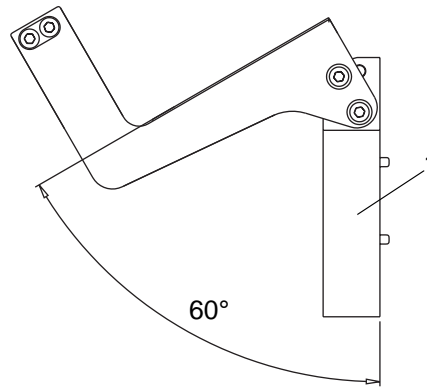
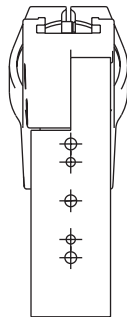
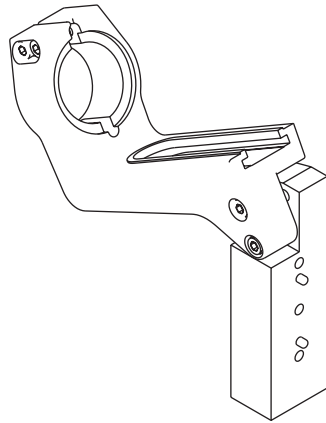
Positionsnummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkingar Remarks
30		413 005-001	Elektroddedare i stål Elektroddedare	Wire liner in steel Wire liner	Ø 1.5, L=3260
		413 005-002	Elektroddedare	Wire liner	Ø 1.5, L=2260
		413 005-003	Elektroddedare	Wire liner	Ø 1.8, L=3260
		413 005-004	Elektroddedare	Wire liner	Ø 1.8, L=2260
		413 005-005	Elektroddedare	Wire liner	Ø 2.2, L=3260
		413 005-006	Elektroddedare	Wire liner	Ø 2.2, L=2260
		413 005-017	Elektroddedare	Wire liner	Ø 1.5, L=50
		413 005-018	Elektroddedare	Wire liner	Ø 1.8, L=30
		413 005-019	Elektroddedare	Wire liner	Ø 2.2, L=30
			Elektroddedare i plast	Wire liner in plastique	
		441 130-003	Elektroddedare	Wire liner	Ø 1.6, L=3260
		441 130-004	Elektroddedare	Wire liner	Ø 2.2, L=3260
		441 130-	Elektroddedare	Wire liner	



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Reservdelsförteckning/Spare Parts List

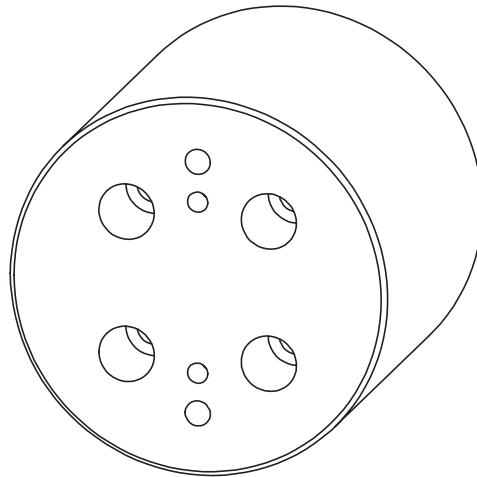
Positionsnummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkingar Remarks
1		505 667-880 505 667-001	Kontakttonshållare, kompl. Pistolhållare	Torch support, compl. Torch support	PHF 100



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Svetspistol/Welding gun PKI
Reservdelsförteckning/Spare Parts List

Positions- nummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkingar Remarks
		505 002-880	Isolationspuck		

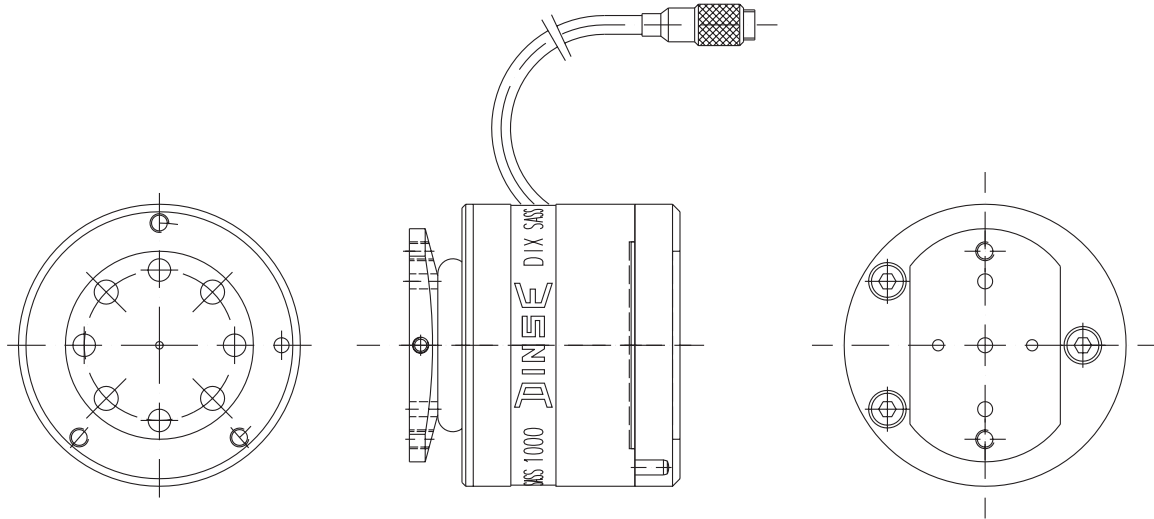


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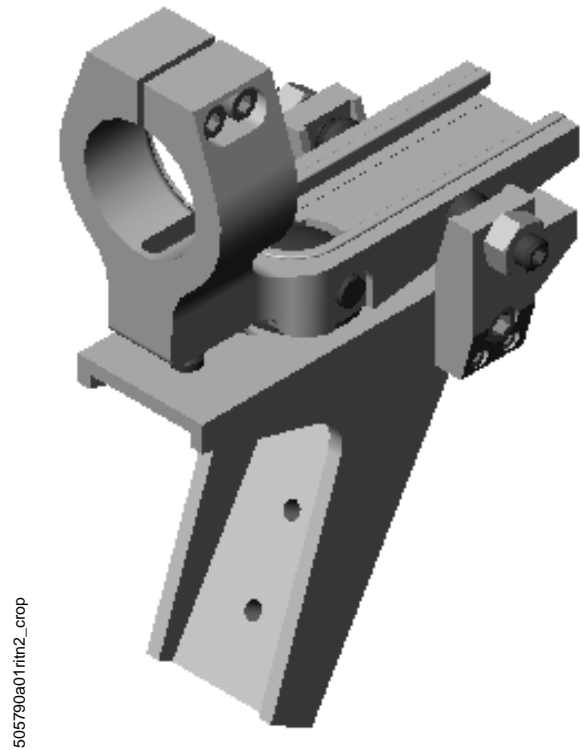
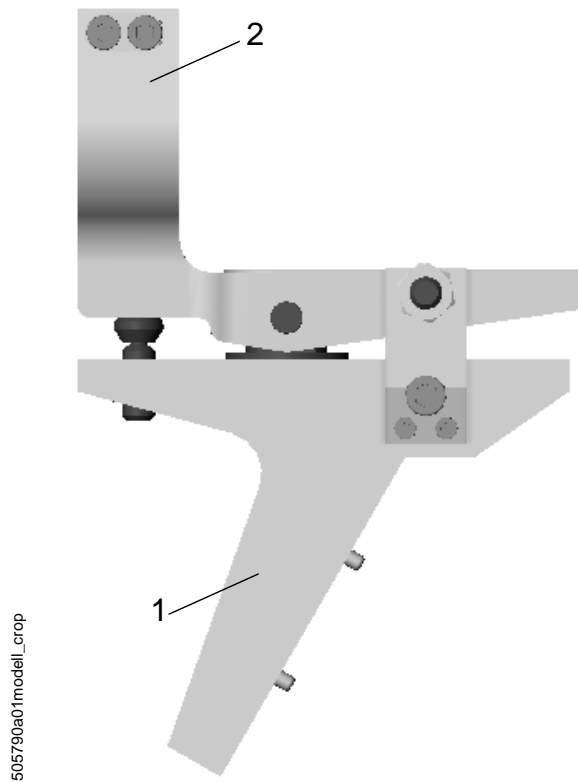
Reservdelsförteckning/Spare Parts List

Positionsnummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkingar Remarks
		500 377-880	OPTION Brytfäste, kompl.	OPTION Safety bracket, compl.	1000

500377b01



Positionsnummer Position number	Antal Quantity	Beställningsnummer Ordering number	Benämning	Denomination	Anmärkningar Remarks
		505 790-880	OPTION Kontaktdonshållare, kompl.	OPTION Torch holder, compl.	
1		505 790-001	Bygel	Clamp	
2		505 790-002	Hållare	Holder	



Svetspistol/Welding gun PKI

Reservdelsförteckning/Spare Parts List

