

SPEEDTEC® 180C & 200C

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Spare Parts

SP50268 / SP50585 REV12
12/2024

ASSEMBLY PAGE NAME			Machine Assembly	Machine Assembly	Wire Drive Assembly	Euro Socket Assembly	Miscellaneous Items	
CODE NO.:	K NO.:	FIGURE NO.:	A	B	C	C	-	
50268	K14098-1	SPEEDTEC® 180C	1	1	1	1	1	
50585	K14099-1	SPEEDTEC® 200C	2	2	2	2	2	

*items highlighted in bold are recommended spare parts

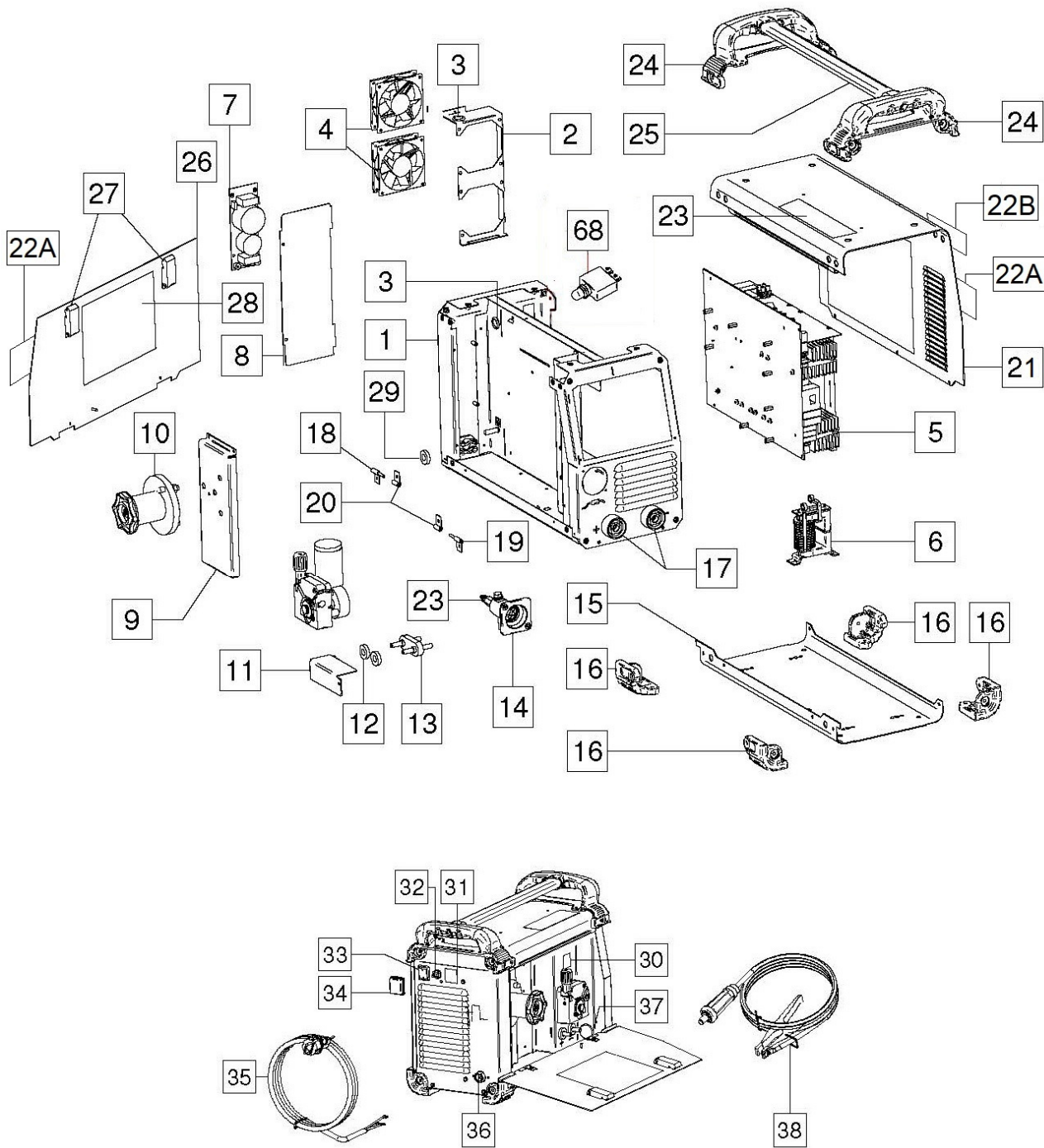
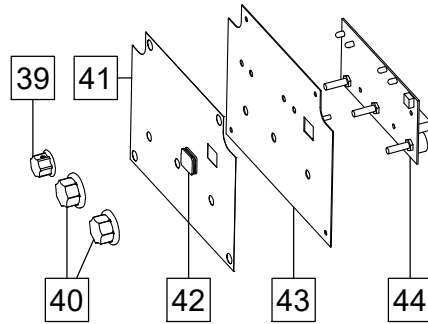


Figure A.

Figure A: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
1	RACK	R-3019-296-1/08R	1	X	-					
1	RACK	R-3019-296-4/08R	1	-	X					
2	COVER	R-1019-292-2/08R	1	X	X					
3	RUBBER CABLE BUSH	1373-182-002R	2	X	X					
4	FAN	1111-311-082R	2	X	X					
5	P.C. BOARD	R-6042-064-1R	1	X	-					
	P.C. BOARD	R-6042-064-6R	1	-	X					
6	CHOCKE	R-4034-148-1R	1	X	X					
7	FILTER EMI	Y030-1R	1	X	X					
8	COVER	R-1019-336-1/08R	1	X	X					
9	SUPPORT	R-1019-297-1/08R	1	X	X					
10	REEL HUB COMPLETE	0744-000-247R	1	X	X					
11	COVER	R-1019-338-1/08R	1	X	X					
12	INSULATOR RING	D-1869-007-3R	2	X	X					
13	TERMINAL BLOCK X4	1361-599-328R	1	X	X					
14	EURO SLEEVE	0646-231-005R	1	X	X					
15	COVER	R-3019-299-1/02R	1	X	X					
16	CORNER CAP	W95X1147R	4	X	X					
17	SOCKET X2, X3	C-2986-001-2R	2	X	X					
18	HINGLE AND AXLE	D-3574-011-3/02R	1	X	X					
19	HINGLE AND AXLE	D-3574-011-4/02R	1	X	X					
20	HINGLE	D-3574-007-1/33R	2	X	X					
21	COVER	R-1012-563-1/02R	1	X	X					
21A	LABEL LINCOLN	R-000-087-1R	2	-	X					
21B	LABEL SPEEDTEC® 200C	R-0010-444-1R	1	-	X					
22	STICKER (WIRING DIAGRAM)	R-0010-488-1R	1	X	-					
	STICKER (WIRING DIAGRAM)	R-0010-488-2R	1	-	X					
23	STICKER	2719-107-728R	1	X	X					
24	HANDLES	W95X1146R	2	X	X					
25	CENTRAL HANDLE	W92X0228-7R	1	X	X					
26	LEFT SIDE PANEL	R-1019-341-1R	1	X	-					
26	LEFT SIDE PANEL	R-3016-030-1/02R	1	-	X					
27	LOCK	0654-610-004R	2	X	X					
28	STICKER (WELDING PARAMETERS)	R-0010-492-1R	1	X	-					
29	FERRITE CORE	W5600005R	1	X	X					
30	STICKER	2719-107-732R	1	X	X					
31	STICKER (GAS)	2719-107-733R	1	X	X					
32	GAS SOLENOID	0972-423-040R	1	X	X					
33	SWITCH	1115-270-019R	1	X	X					
34	BLACK FRAME SHIELD	1115-299-073R	1	X	X					
35	POWER LEAD	R-0010-435-1R	1	X	X					
36	CABLE RELIEF	1361-599-674R	1	X	X					
37	RUBBER CABLE BUSH	1361-599-198R	1	X	X					
38	WORK LEAD	R-5041-277-1R	1	X	X					
68	THERMAL CIRCUIT	1115-299-033R	1	-	X					

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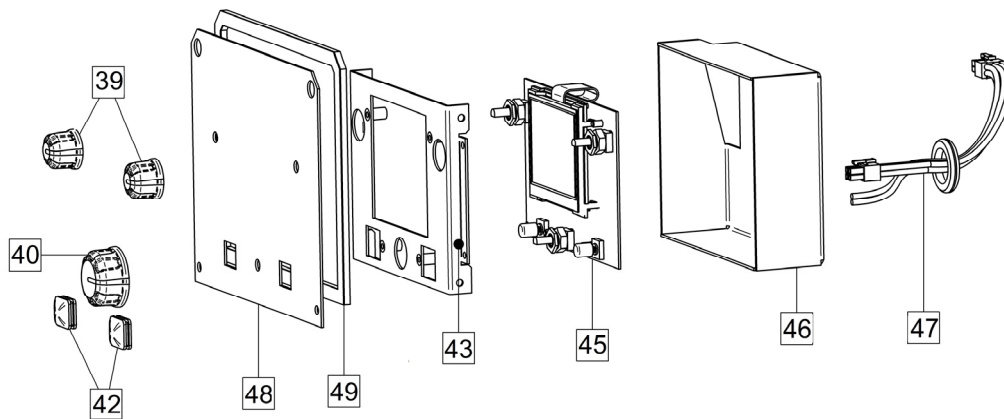


Figure B.

Figure B: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
39	KNOB	9ST13639-3	1	X	-					
39	KNOB	9SM22778-1	2	-	X					
40	KNOBS	9SS18425-1	2	X	-					
40	KNOB	9SM22778-2	1	-	X					
41	STICKER	R-0010-443-1R	1	X	-					
41	STICKER	R-0010-444-1R	1	-	X					
42	RUBBER BUTTOM	1373-182-005R	1	X	-					
42	RUBBER BUTTOM	1373-182-005R	2	-	X					
43	FRONT PANEL	R-3019-268-1/08R	1	X	-					
43	FRONT PANEL	R-3019-269-1/08R	1	-	X					
44	P.C. BOARD	Y031-1R	1	X	-					
45	P.C. BOARD COMPLETE	R-6042-063-1R	1	-	X					
	DISPLAY	0942-172-001R								
46	COVER	R-1019-302-1/08R	1	-	X					
47	WIRING HARNESS	R-5041-250-3R	1	-	X					
48	PANEL	R-0010-724-1R	1	-	X					
49	FRONT PANEL GASKET	R-0010-838-1R	1	-	X					

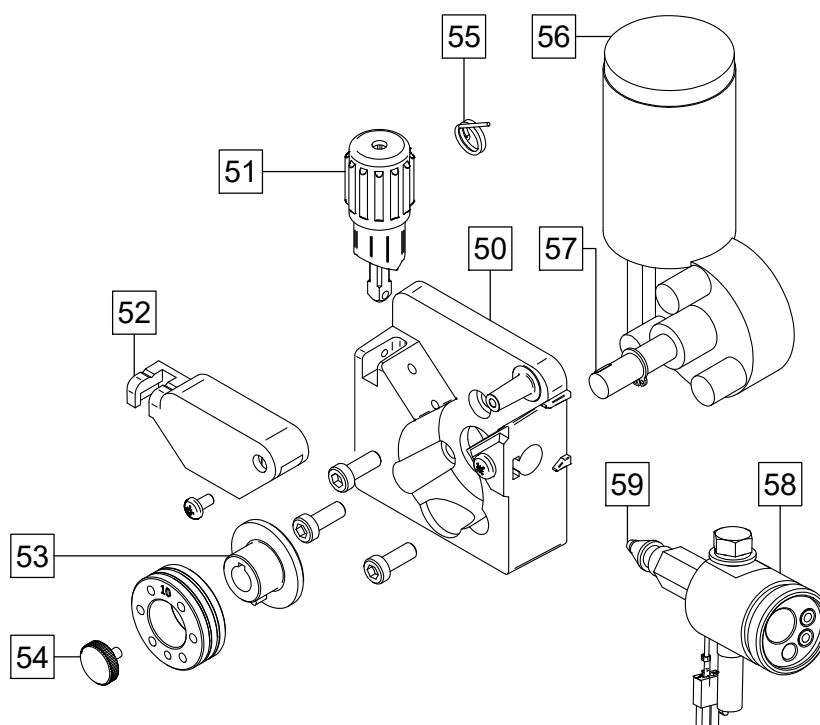


Figure C.

Figure C: Wire Drive Assembly & Euro Socket Assembly

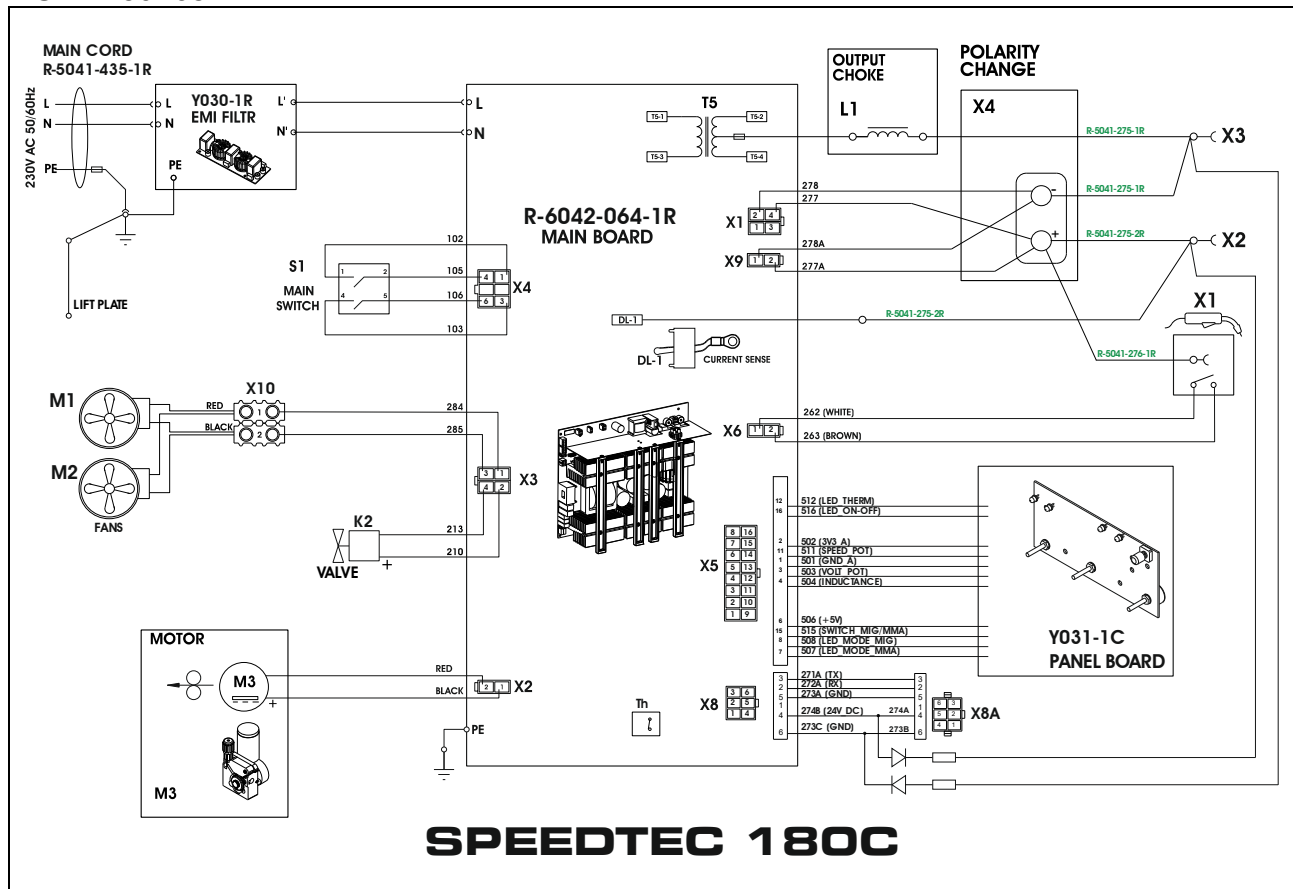
Item	Description	Part Number	QTY	1	2	3	4	5	6	7
	WIRE DRIVE ASSEMBLY	0744-000-246R	1	X	X					
50	FEED PLATE	0744-000-248R	1	X	X					
51	FIXING ARM COMPL.	0646-233-015R	1	X	X					
52	PRESSURE ARM COMPL	0744-000-249R	1	X	X					
53	DRIVE ROLL ADAPTER	0744-000-250R	1	X	X					
54	FIXING CAP	0744-000-251R	1	X	X					
55	SPRING PRESSURE ARM	0744-000-252R	1	X	X					
56	MOTOR	0744-000-253R	1	X	X					
57	WOODROF KEY	0646-231-102R	1	X	X					
58	EURO SOCKET	R-8040-294-1R	1	X	X					
59	OUTLET GUIDE	R-2010-017-1R	1	X	X					

Miscellaneous Items (not shown in figure A, B, C)

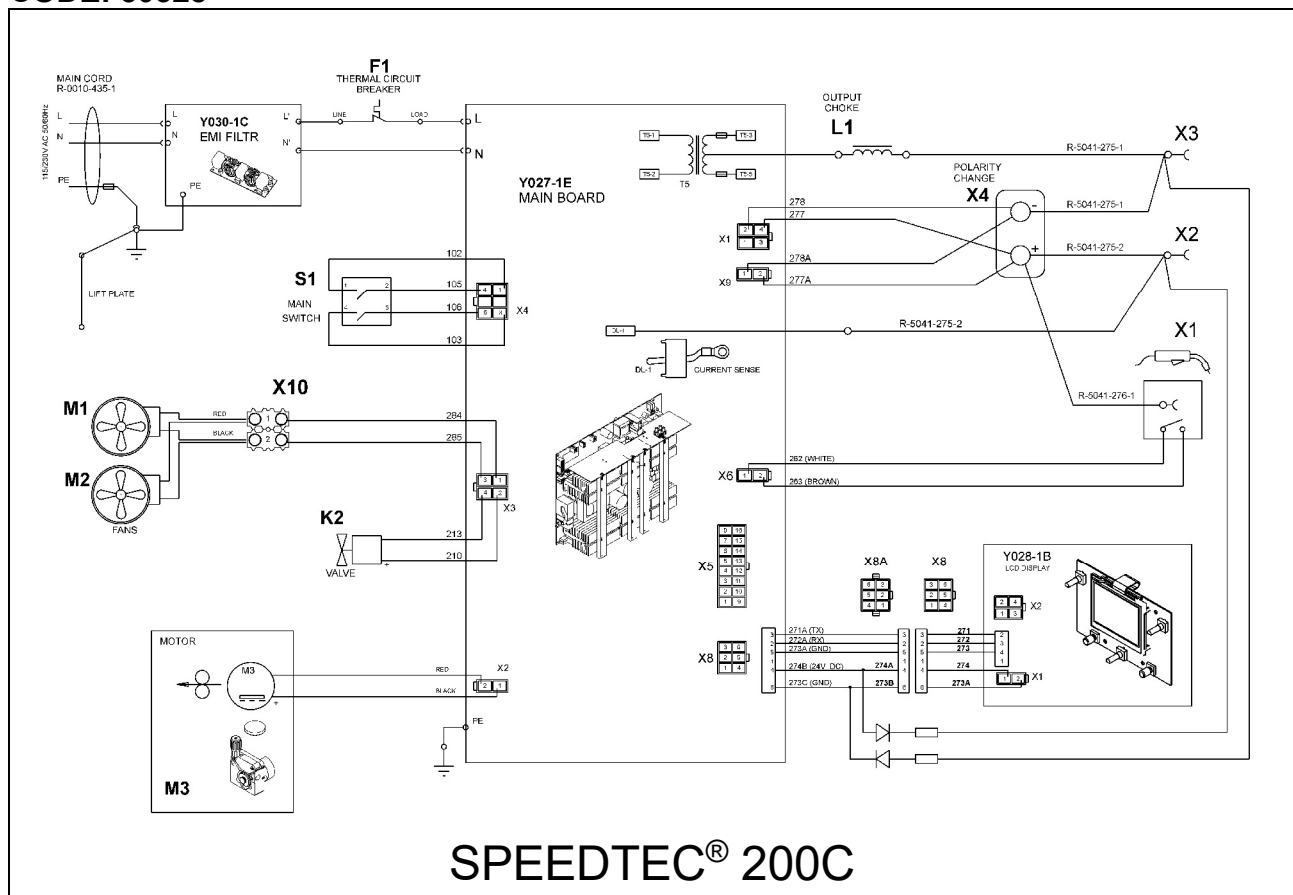
Item	Description	Part Number	QTY	1	2	3	4	5	6	7
60	WIRING HARNESS	R-5041-250-1R	1	X	X					
61	GROUNG WIRE	R-5041-250-6R	1	X	X					
62	WIRING HARNESS	R-5041-250-8R	1	X	X					
63	WIRE	R-5041-275-1R	1	X	X					
64	WIRE	R-5041-275-2R	1	X	X					
65	WIRE	R-5041-276-1R	1	X	X					
66	VRD HARNESS	R-5041-290-1R	1	X	X					
67	WIRE	R-5041-401-1R	1	-	X					

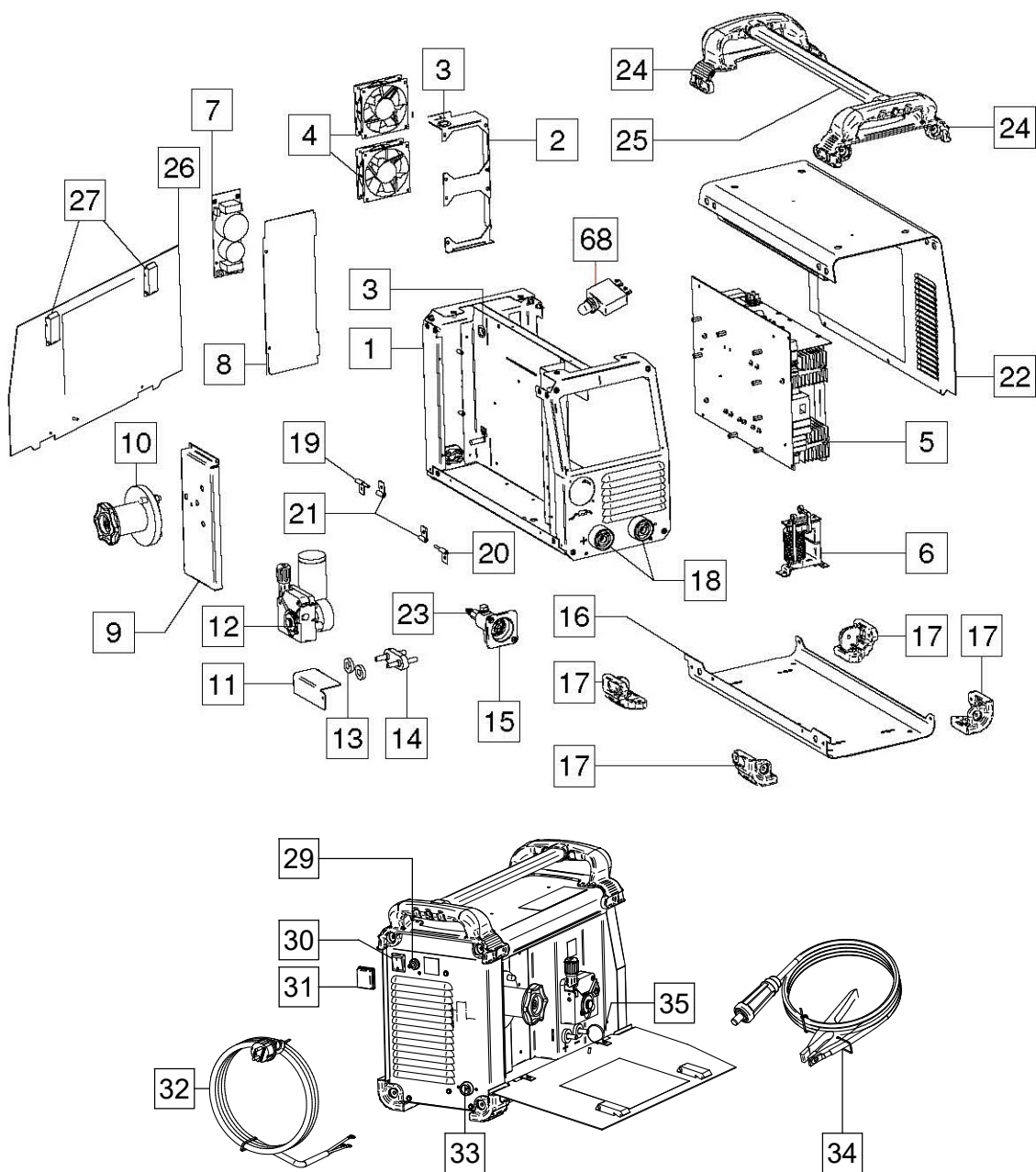
Electrical Schematic

CODE: 50268

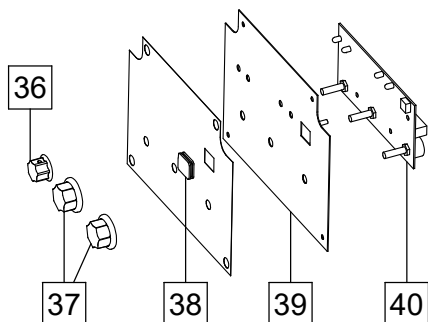


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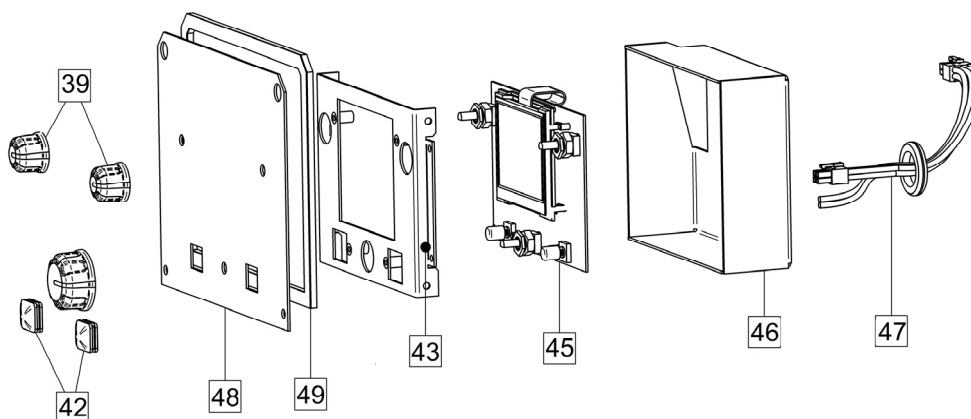




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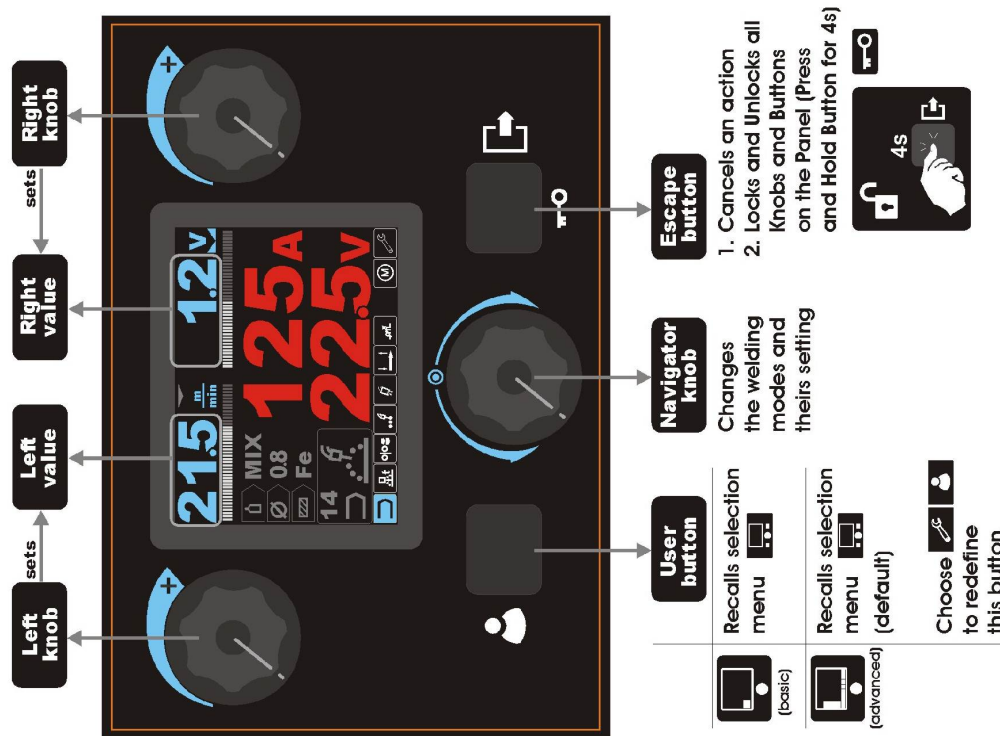
Description	Ref.	Recycle				ST				
		Fe	Al	Cu	Brass	Boards	Plastics	Liquid Cristal	External Electric Cables	Capacitors
RACK	1	X								
COVER	2,	X								
COVER	8, 11, 16, 22, 45		X							
LOCK	27						X			
LEFT SIDE PANEL	26		X							
FAN	4			X			X			
HINGLE	19, 20, 21	X								
P.C. BOARDS	5, 7, 40					X				
P.C. BOARD	44					X		X		
WIRE REEL SPINDLE	10	X					X			
SUPPORT	9	X								
EURO SOCKET	23				X					
EURO SLEEVE	15						X			
SOCKET	18	X		X			X			
SWITCHES	30	X			X					
BLACK FLAME SHIELD	31						X			
KNOB	36, 37						X			
BUTTON	42						X			
GAS SOLENOID	29	X		X	X					

INSULATOR RING	13						X			
WIRE FEEDER	12	X		X			X			
TERMINAL BLOCK	14				X		X			
POWER LEAD	32			X	X		X			
CORNER CAP	17						X			
HANDLE	24						X			
HANDLE	25		X							
WORK LEAD	34								X	
RUBBER CABLE BUSH	3, 35						X			
CABLE RELIEF	33						X			
CHOKE	6	X		X			X			
FRONT PANEL	39, 43	X		X						
FRONT PANEL GASKET	49						X			
PANEL	48						X			
WIRING HARNESS	46								X	
THERMAL CIRCUIT	68	X			X		X			

Quick Guide

QUICK GUIDE I

	Select Welding Process		SMAW (MMA) Welding		Basic menu
	Burnback		GMAW (MIG/MAG) Manual Welding		Brightness Level
	Run-in WFS		FCAW-S - Self-shielded Manual Welding		View Software and Hardware Version Information
	Preweld Time		GMAW (MIG/MAG) Synergic Welding		User Button
	Postflow Time		Select Process by Number		Cancel an Action
	Inductance		Select Gas		Switch On Output Voltage (TIG/MMA only)
	Spot Welding Setting		Select Wire Type (material)		Switch Off Output Voltage (TIG/MMA only)
	Spot Timer		Select Wire Size (diameter)		Unlock panel
	Switch off Spot Welding		Select Function of Gun Trigger (2-Step/4-Step)		Unlock Panel by Code
	2-Step		Configuration and Set-up		Hot Start
	4-Step		Lock/Unlock Panel		Arc Force
	Memory		Lock Panel		Adjust Voltage
	Save a Memory		Lock Panel by Code		Welding Material Thickness
	Recall a Memory (user memory)		Recall Factory Setting		Welding Current
	Clear a Memory		Select Menu (basic/advanced)		Wire Feeder Speed (WFS)
	GTAW (TIG) Welding		Advanced Menu		



QUICK GUIDE II BASIC MENU



Synergic Table 1.0

Material	Wire	Process	Gas
		MMA	
		TIG	
		MIG	
		FCAW-S	
Fe	1.0	MIG syner	CO ₂
Fe	1.0	MIG syner	MIX1
Fe	0.8	MIG syner	CO ₂
Fe	0.8	MIG syner	MIX1
Fe	0.6	MIG syner	CO ₂
Fe	0.6	MIG syner	MIX1
SS	1.0	MIG syner	MIX2
SS	0.8	MIG syner	MIX2
AlSi	1.0	MIG syner	Ar
AlMg	1.0	MIG syner	Ar
MIX1 - CO ₂ /Ar (18/82)			
MIX2 - CO ₂ /Ar (2/98)			

