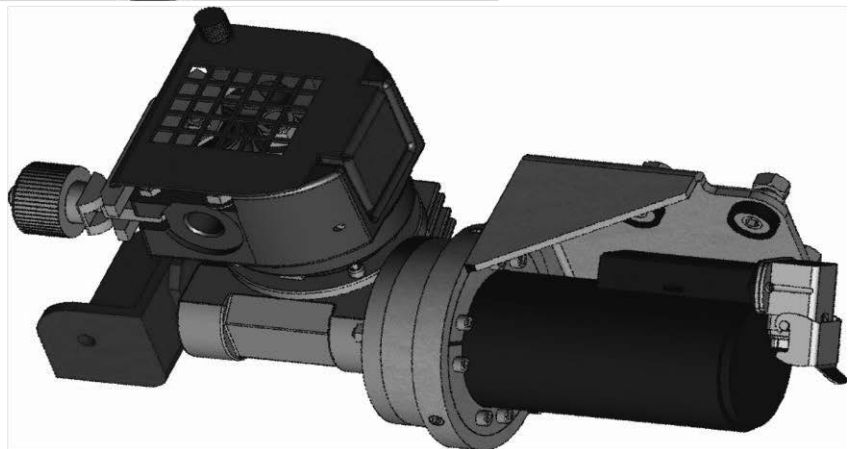
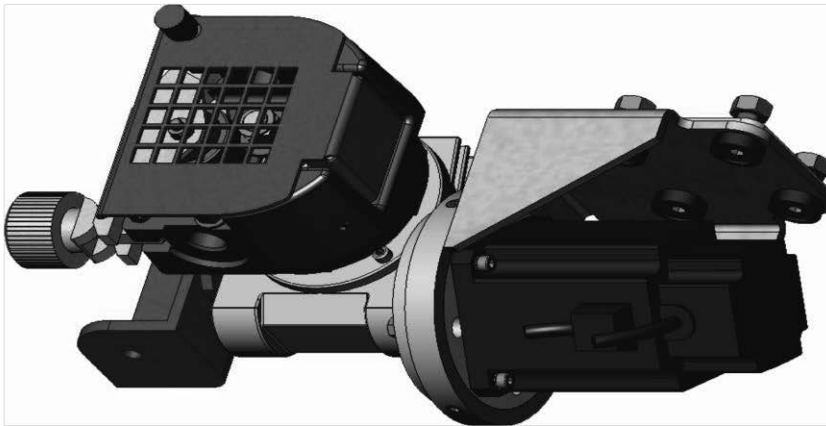


# WIRE FEED UNIT DX7

N° W000315118 - W000315119  
9109 6982 - 9109 6983



EDITION: EN  
REVISION: G  
DATE: 11-2018

Instructions for use

REF. :8695 5235

*Original instructions*

Thank you very much for the trust you have shown by choosing this piece of equipment. It will give you trouble-free service if it is used and maintained as recommended.

Its design, component specifications and manufacturing are in accordance with applicable European directives.

Please refer to the CE declaration enclosed to identify the directives applicable to it.

The manufacturer shall not be liable for any combination of parts not recommended by it.

For your safety, please follow the non-limitative list of recommendations and obligations, a large part of which are included in the Labour Code.

Please inform your supplier if you find any error in this instruction manual.

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# REVISIONS

**REVISION B** **08/05**

DESIGNATION	PAGE
Complete update	

**REVISION C** **05/06**

DESIGNATION	PAGE
To change logos	-

**REVISION D** **06/07**

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Reference change	11

**REVISION E** **10/08**

DESIGNATION	PAGE
Complete update + spareparts newoffer	-

**REVISION F** **10/09**

DESIGNATION	PAGE
Update 3A	

**REVISION G** **11/18**

DESIGNATION	PAGE
To change logos	

## SAFETY INSTRUCTIONS

For general safety instructions, please refer to the specific manual supplied with the equipment.



### AIRBORNE NOISE

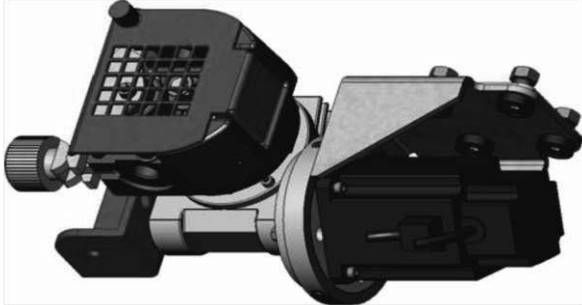
Please refer to the specific manual supplied with the equipment.



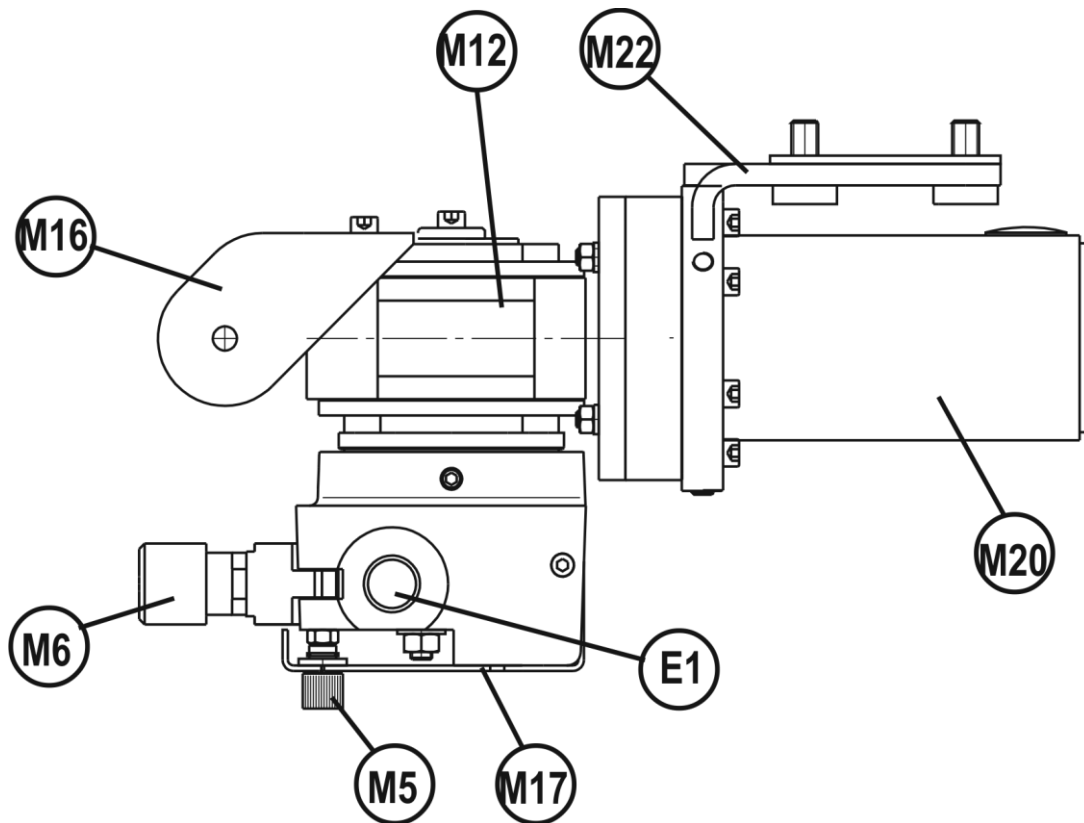
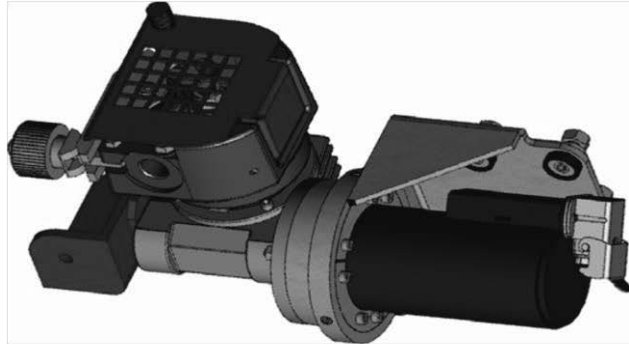
Because the motor, reducing gear and plate all have the same potential (welding +), the metal parts must not touch the feed assembly.

**DESCRIPTION**

**VERSION DX7 3A**



**VERSION DX7**



## 1 - FUNCTION OF DX7

The **DX7** plate gear motor unit feeds electrode wire for automatic flux welding equipment.

## 2 - VERSIONS

	<b><u>DX7</u></b>	<b><u>DX7 3A</u></b>
4,2 m/mn SUBMERGED ARC	W000315118	9109 6982
15 m/mn MIG or MAG	W000315119	9109 6983

## 3 - DESCRIPTION

Grease-lubricated gear motor M12 is made up of a wheel and a worm.

The gear motor unit assembly has a fixing plate (M22) with four insulated screws to prevent arcing with the welding current.

The assembly also has two flange systems to orient the wire output in two planes in relation to the fastening for optimised locating on the machines.

The plate has a shaft for two rollers that feed the electrode wire; the shaft may have three rollers for two-wire applications.

The lock roller can be locked with the help of knob M6. Inlet E1 and the outlet from the plate are symmetrical, with a  $\varnothing$  of 18 mm. The fixing of the wire feed (A.S) or the torch (MIG/MAG) is achieved by a tangent buffer.

Cover M17 guards the operator and can be opened with button M5.

Support tab M16 is provided to fix the powder container in the submerged arc version.

## 4 - SPECIFICATIONS

### VERSION DX7

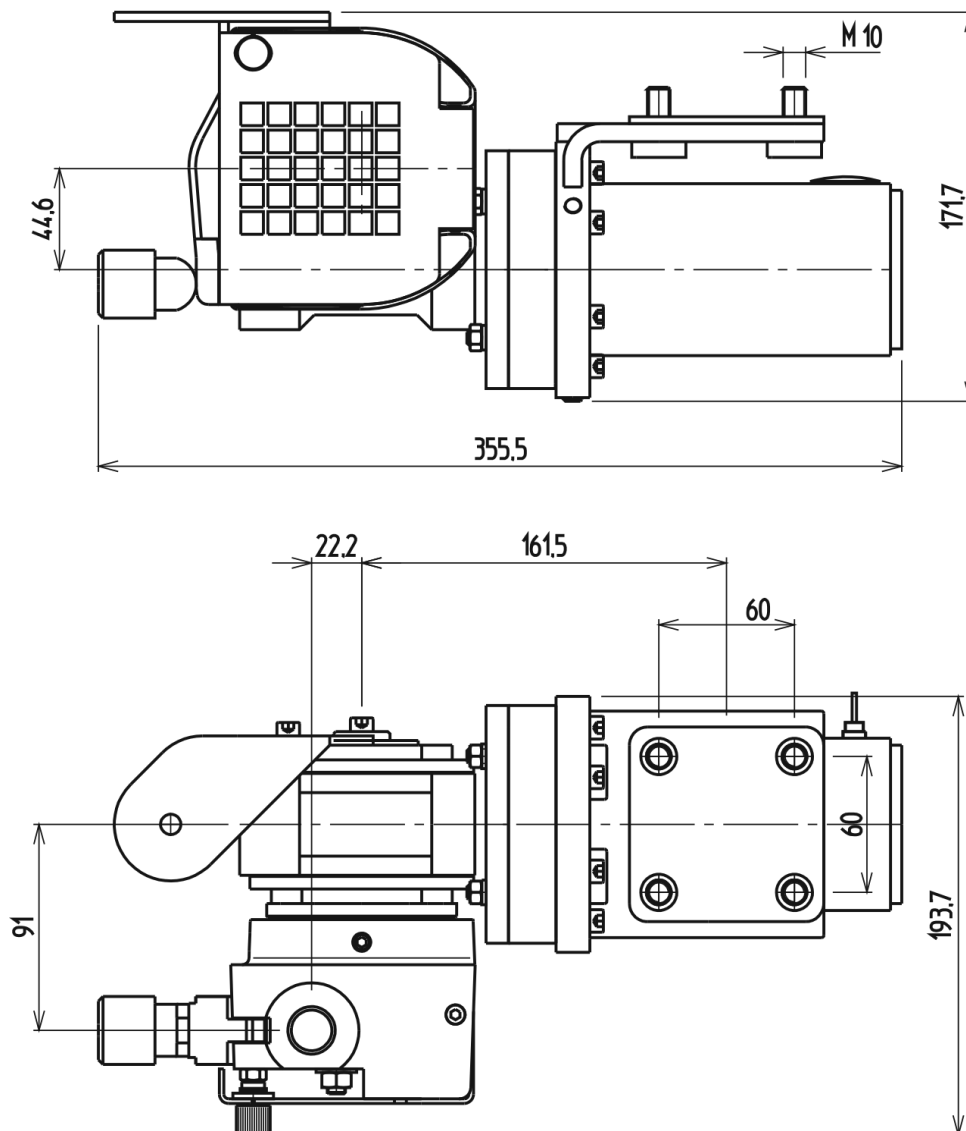
- Power supply voltage 42 VDC
- I average current consumption under charge 5 Amperes
- Max. current consumption → max. admissible 5.5 Amperes
- Power supply cable section 2 x 2.5 mm<sup>2</sup>.

Tacho-generator 7 V/1000 rpm motor.

The motor must be powered by a **MOTOVAR MV 20** variable speed unit,  
part no. 9109 6220

The feed speed range with a **MOTOVAR MV 20** unit is from 0.17 to 4.20 m/mm with the W000315118 model and 0.6 to 15 m/mm with the W000315119 model.

The wire feed rollers are not part of unit **DX7**





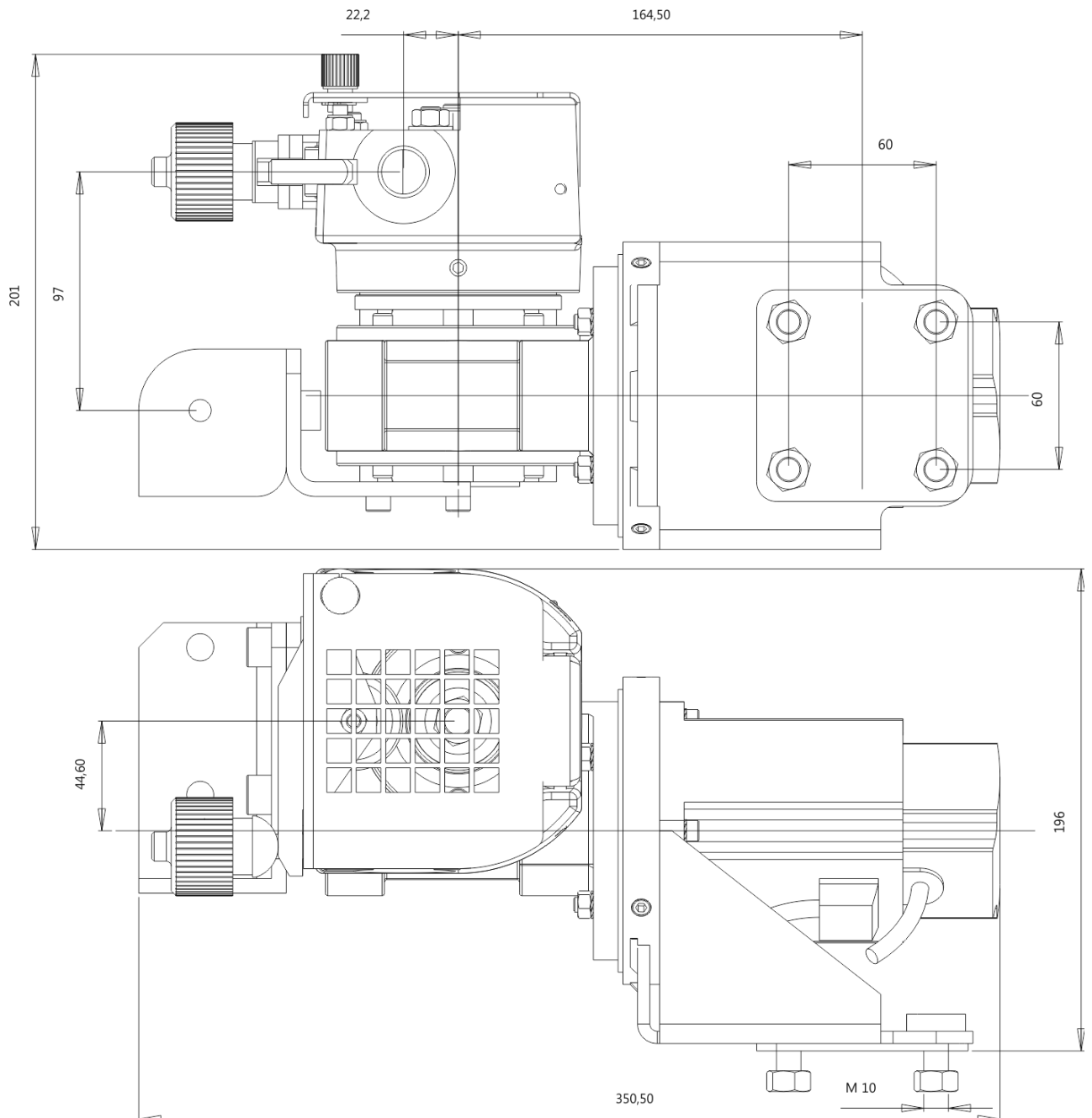
**VERSION DX7 3A**

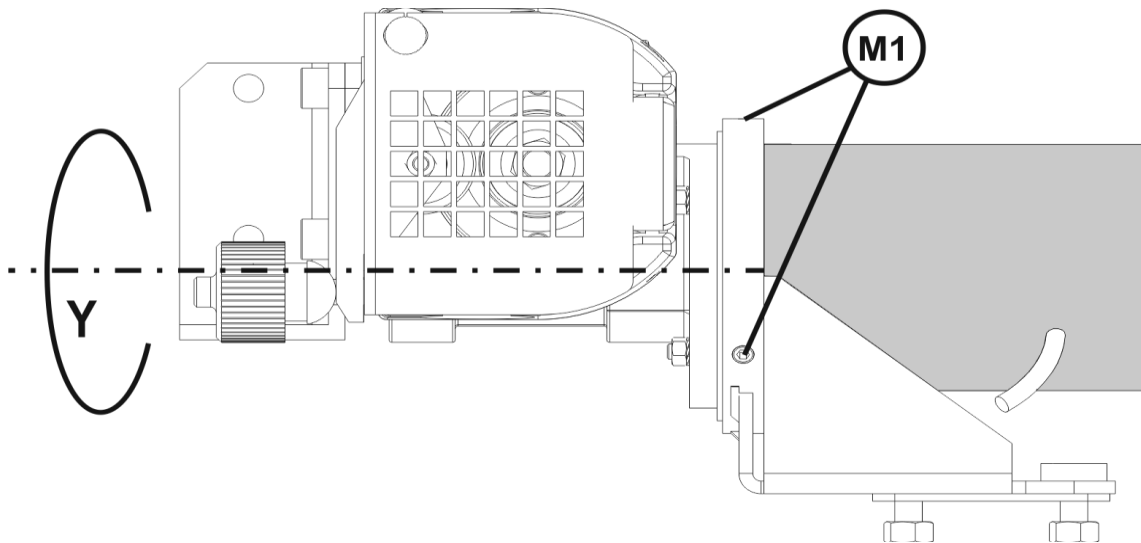
Motor Brushless 500W 48V DC

The motor must be powered by a **MOTORPACK** variable speed unit,  
part no. 9530 7802

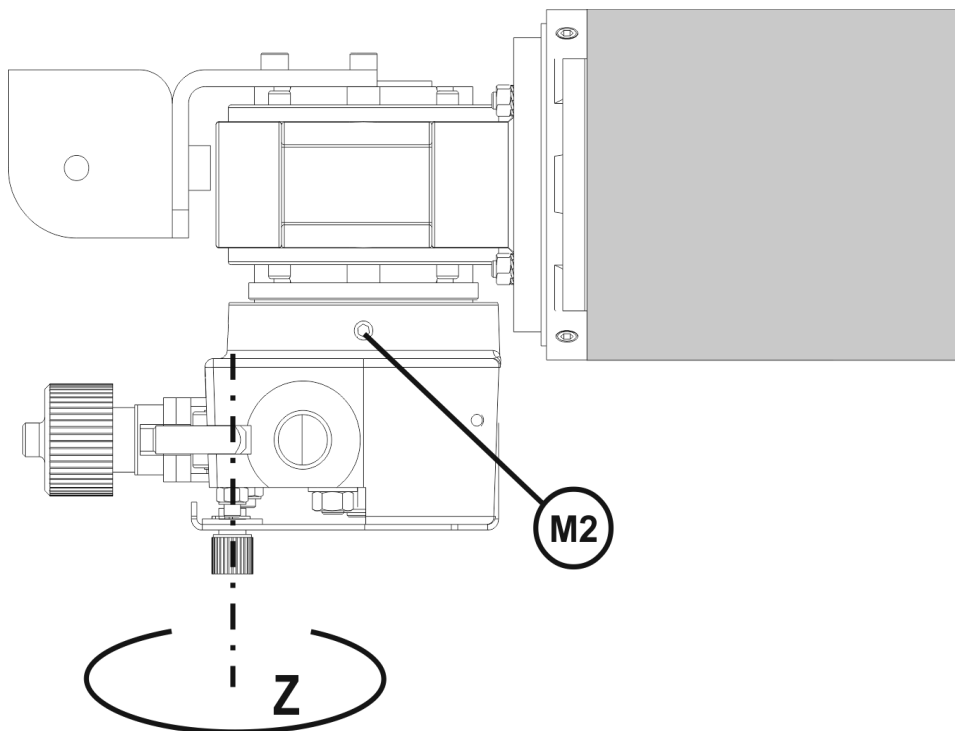
The feed speed range with a **MOTOVAR MV 20** unit is from  
0.17 to 4.20 m/mm with the 9109 6982 model and  
0.6 to 15 m/mm with the 9109 6983 model.

The wire feed rollers are not part of unit **DX7**



**HEAD ORIENTATION**

The assembly can be turned along Y by unfastening the eight screws (M1)



The head can be turned along Z by unfastening the three screws (M2)

## USE

### STARTING UP

Fix the gear motor assembly on the machine with four M10 screws with a centre distance of 60mm (do not forget the insulating plate).

- Open the guard cover.
- Assemble the wire guide on the plate entry side and the torch (MIG-MAG) or wire feed (A.S) on the plate exit side.
- Fit the rollers onto the shaft and lock with the nut and washer.
- Feed the wire in the plate and fasten it with the lock roller plate using the knob.
- Close the guard cover.

### ELECTRICAL CONNECTIONS

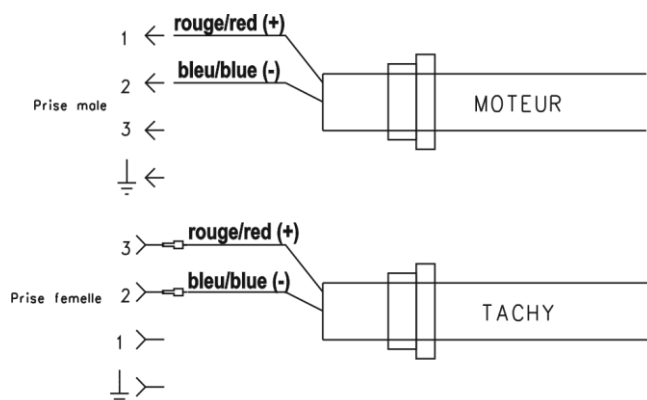
#### Sanyo Motor connections:

Connect the power supply cable to the male connector.

#### Tacho-generator connections:

Connect the cable to the female connector.

Check the motor rotation direction. If needed, reverse the two motor power supply conductors and the two tacho conductors.




#### 3A Motor connections:

See plan 9530 9202.

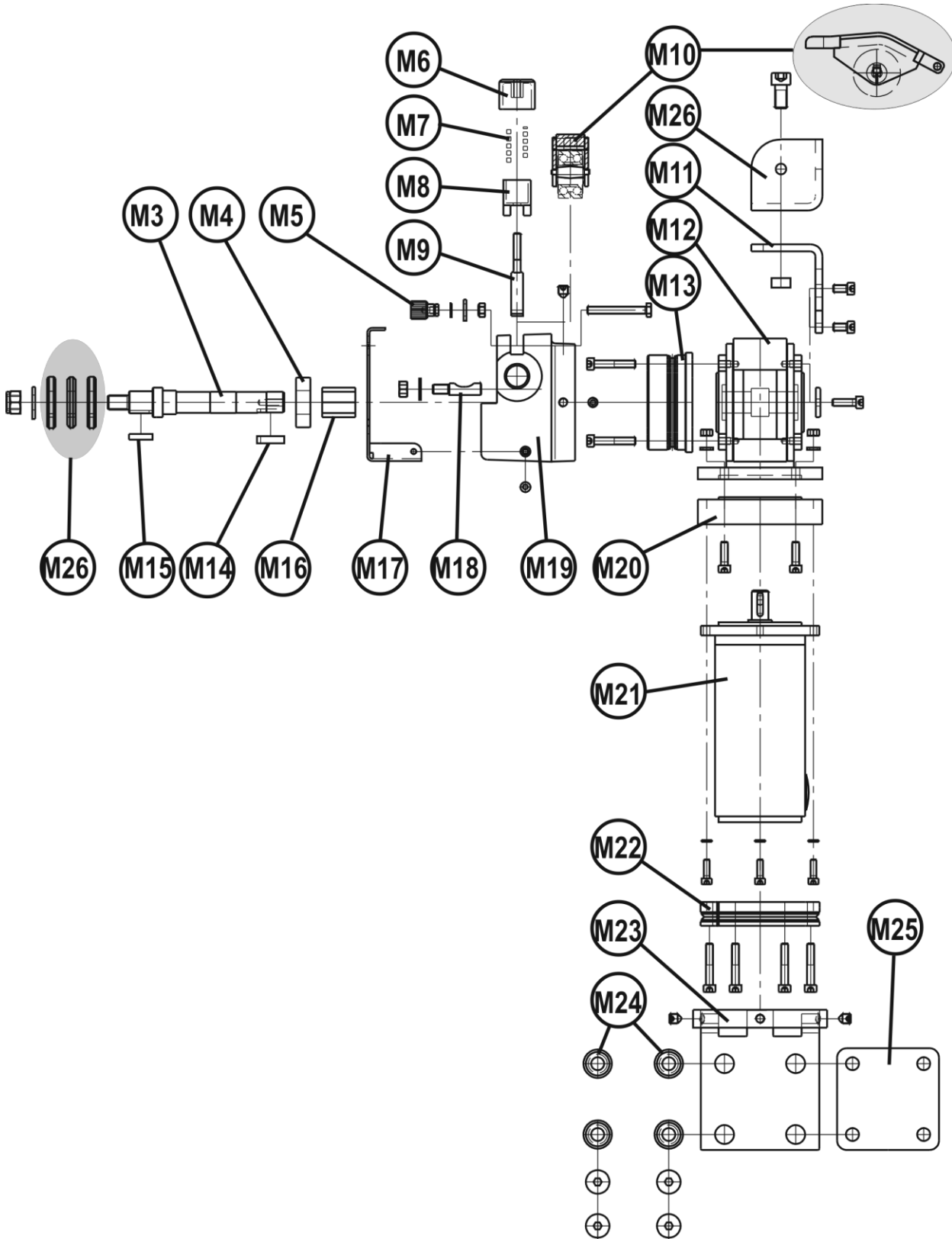


Because the motor, gear motor and plate all have the same potential (welding +), the metal parts must not touch the feed unit.

# SPARE PARTS

 In order to avoid errors when supplying spare parts, we recommend that you send us a copy of the page with the list of parts duly completed. Please specify in the Order column the number of parts desired and indicate the type and the serial number of your equipment.


## VERSION DX7



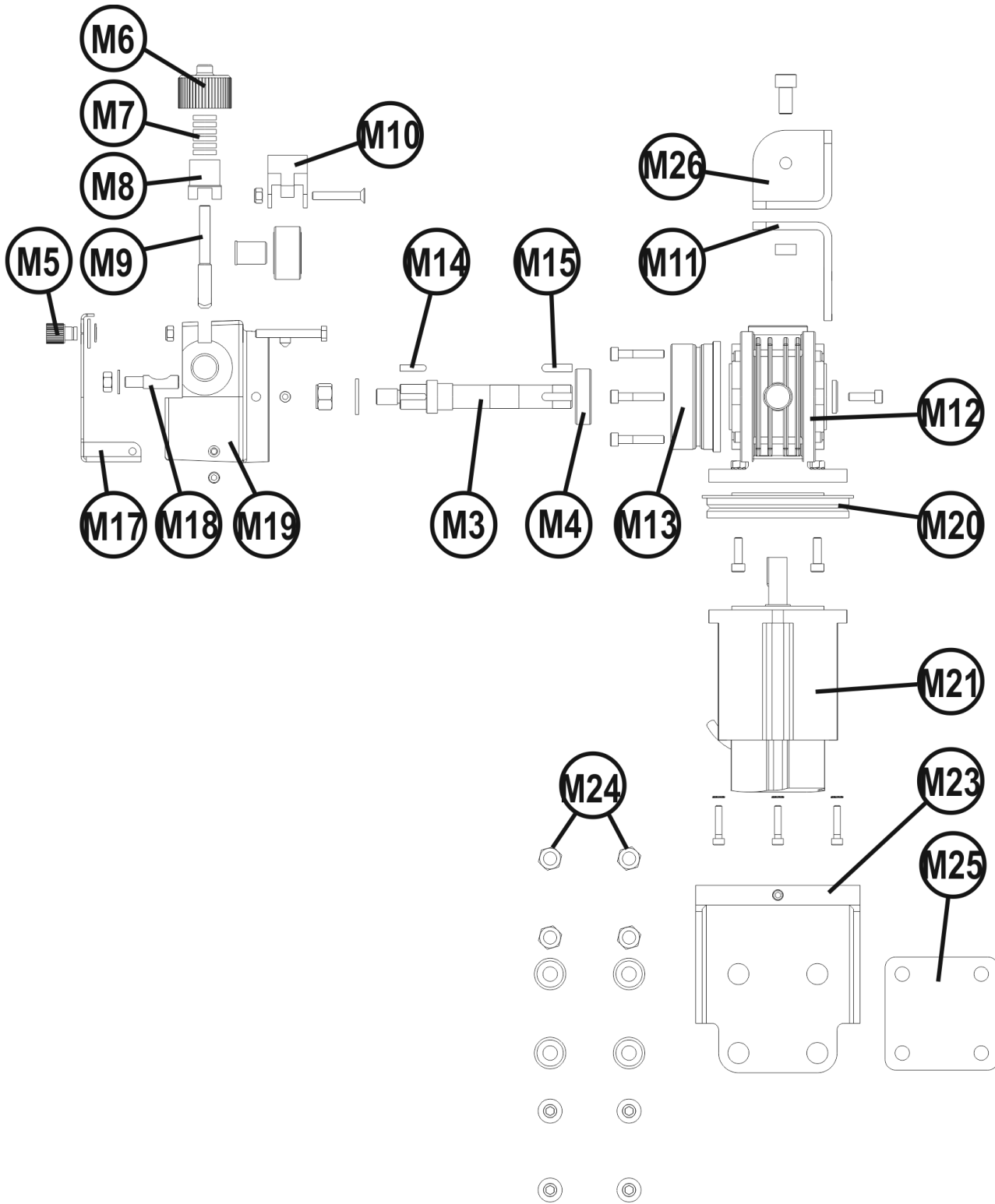
✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
3	9109 6166			Feed plate shaft
4	.620 0429			20/40/12 6004 2RS bearing
5	9109 6146			Knob
6	9109 6149			Adjusting ring
7	.620 0371			Pressure spring
8	9109 6148			Adjusting end piece
9	9109 6147			Adjusting rod
10	W000269309	✓		Plate with pressure roller
11	9109 6296			Flux container support
26	9109 6297			Flux container support
12				Reducing gear
	W000269311	✓		VF44 P71 B14 R1/35 <b>for 4.2 m/min version</b>
	W000269312	✓		VF44 P71 B14 R1/10 <b>for 15 m/min version</b>
13	9109 6153			Plate hub
14	.620 1649			6/6/23 key
15	9109 4326			3/16 key
16	9109 6167			Spacer ring
17	9109 6154			Cover
18	9109 6156			Tangent buffer
19	9109 6152			<b>DX7</b> plate
20	9109 6157			Motor spacer flange
21	W000269310	✓		GMP <b>DX7</b> motor with tacho-generator
22	9109 6159			Rotation flange
23	9109 6158			Turning support
24	9109 4327			Insulation for M10 screw
25	9109 4324			Fixing support insulation
				<i>NOT INCLUDED IN THE UNIT</i>
	W000237608	✓		Set of 2 rollers for one Ø 1,6 à Ø 2,4
	W000237609	✓		Set of 2 rollers for one Ø 3,2 à Ø 5
	9109 6175			Set of 2 rollers for one Ø 1,6 à Ø 2,4
	9109 6176			Set of 2 rollers for one Ø 3,2 à Ø 5
	W000234765	✓		Set of 3 rollers for two 1,2 / 2,4 mm

➤ For parts order, give the quantity required and put the number of your machine in the box below.

	TYPE:
	Number:

VERSION DX7 3A



✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
3	9109 6166			Feed plate shaft
4	.620 0429			20/40/12 6004 2RS bearing
5	9109 6146			Knob
6	9109 6149			Adjusting ring
7	.620 0371			Pressure spring
8	9109 6148			Adjusting end piece
9	9109 6147			Adjusting rod
10	W000269309	✓		Plate with pressure roller
11	9109 6296			Flux container support
26	9109 6297			Flux container support
12				Reducing gear
	W000269311	✓		VF44 P71 B14 R1/35 <b><u>for 4.2 m/min version</u></b>
	W000269312	✓		VF44 P71 B14 R1/10 <b><u>for 15 m/min version</u></b>
13	9109 6153			Plate hub
14	.620 1649			6/6/23 key
15	9109 4326			3/16 key
16	9109 6167			Spacer ring
17	9109 6154			Cover
18	9109 6156			Tangent buffer
19	9109 6152			DX7 plate
20	9109 6157			Motor spacer flange
21	9530 0070			3A motor 500W
23	9109 6158			Turning support
24	9109 4327			Insulation for M10 screw
25	9109 4324			Fixing support insulation
				<i><u>NOT INCLUDED IN THE UNIT</u></i>
	W000237608	✓		Set of 2 rollers for one Ø 1,6 à Ø 2,4
	W000237609	✓		Set of 2 rollers for one Ø 3,2 à Ø 5
	9109 6175			Set of 2 rollers for one Ø 1,6 à Ø 2,4
	9109 6176			Set of 2 rollers for one Ø 3,2 à Ø 5
	W000234765	✓		Set of 3 rollers for two 1,2 / 2,4 mm

➤ For parts order, give the quantity required and put the number of your machine in the box below.

CE Type <input type="text"/> Matricule <input type="text"/>	TYPE:
	Number:

