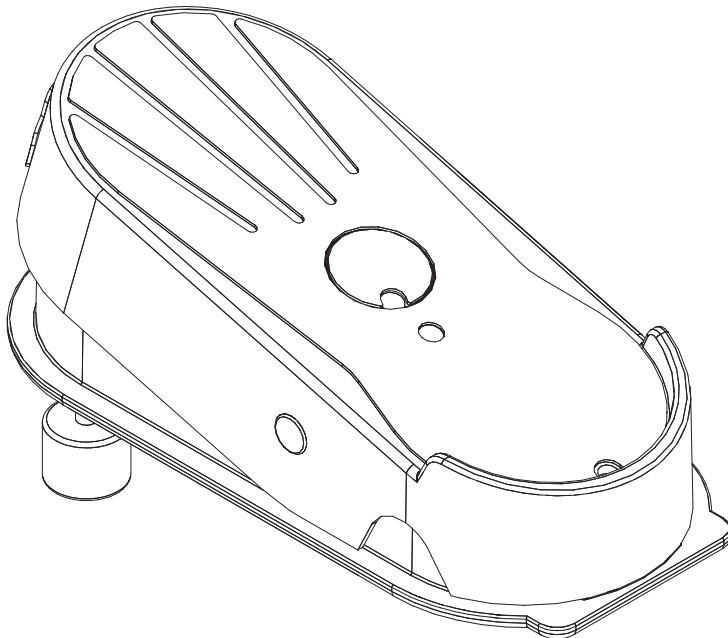


## Operator's Manual

# WIRELESS TIG FOOT PEDAL



For use with machines having Code Numbers:  
**11946, 12158, 12159**



**Register your machine:**  
[www.lincolnelectric.com/registration](http://www.lincolnelectric.com/registration)

**Authorized Service and Distributor Locator:**  
[www.lincolnelectric.com/locator](http://www.lincolnelectric.com/locator)

### Save for future reference

Date Purchased

Code: (ex: 10859)

Serial: (ex: U1060512345)

# THANK YOU FOR SELECTING A QUALITY PRODUCT BY LINCOLN ELECTRIC.

## PLEASE EXAMINE CARTON AND EQUIPMENT FOR DAMAGE IMMEDIATELY

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

## SAFETY DEPENDS ON YOU

Lincoln arc welding and cutting equipment is designed and built with safety in mind. However, your overall safety can be increased by proper installation ... and thoughtful operation on your part. **DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT READING THIS MANUAL AND THE SAFETY PRECAUTIONS CONTAINED THROUGHOUT.** And, most importantly, think before you act and be careful.

### **WARNING**

This statement appears where the information must be followed exactly to avoid serious personal injury or loss of life.

### **CAUTION**

This statement appears where the information must be followed to avoid minor personal injury or damage to this equipment.



## KEEP YOUR HEAD OUT OF THE FUMES.

**DON'T** get too close to the arc. Use corrective lenses if necessary to stay a reasonable distance away from the arc.

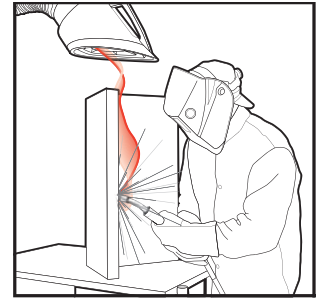
**READ** and obey the Safety Data Sheet (SDS) and the warning label that appears on all containers of welding materials.

**USE ENOUGH VENTILATION** or exhaust at the arc, or both, to keep the fumes and gases from your breathing zone and the general area.

**IN A LARGE ROOM OR OUTDOORS**, natural ventilation may be adequate if you keep your head out of the fumes (See below).

**USE NATURAL DRAFTS** or fans to keep the fumes away from your face.

If you develop unusual symptoms, see your supervisor. Perhaps the welding atmosphere and ventilation system should be checked.



## WEAR CORRECT EYE, EAR & BODY PROTECTION

**PROTECT** your eyes and face with welding helmet properly fitted and with proper grade of filter plate (See ANSI Z49.1).

**PROTECT** your body from welding spatter and arc flash with protective clothing including woolen clothing, flame-proof apron and gloves, leather leggings, and high boots.

**PROTECT** others from splatter, flash, and glare with protective screens or barriers.

**IN SOME AREAS**, protection from noise may be appropriate.

**BE SURE** protective equipment is in good condition.

Also, wear safety glasses in work area **AT ALL TIMES.**



## SPECIAL SITUATIONS

**DO NOT WELD OR CUT** containers or materials which previously had been in contact with hazardous substances unless they are properly cleaned. This is extremely dangerous.

**DO NOT WELD OR CUT** painted or plated parts unless special precautions with ventilation have been taken. They can release highly toxic fumes or gases.

## Additional precautionary measures

**PROTECT** compressed gas cylinders from excessive heat, mechanical shocks, and arcs; fasten cylinders so they cannot fall.

**BE SURE** cylinders are never grounded or part of an electrical circuit.

**REMOVE** all potential fire hazards from welding area.

**ALWAYS HAVE FIRE FIGHTING EQUIPMENT READY FOR IMMEDIATE USE AND KNOW HOW TO USE IT.**



## SECTION A: WARNINGS



### CALIFORNIA PROPOSITION 65 WARNINGS



**WARNING:** Breathing diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects, or other reproductive harm.

- Always start and operate the engine in a well-ventilated area.
- If in an exposed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system.
- Do not idle the engine except as necessary.

For more information go to [www.P65warnings.ca.gov/diesel](http://www.P65warnings.ca.gov/diesel)

**WARNING:** This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code § 25249.5 *et seq.*)



**WARNING:** Cancer and Reproductive Harm  
[www.P65warnings.ca.gov](http://www.P65warnings.ca.gov)

**ARC WELDING CAN BE HAZARDOUS. PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS SHOULD CONSULT WITH THEIR DOCTOR BEFORE OPERATING.**

Read and understand the following safety highlights. For additional safety information, it is strongly recommended that you purchase a copy of "Safety in Welding & Cutting - ANSI Standard Z49.1" from the American Welding Society, P.O. Box 351040, Miami, Florida 33135 or CSA Standard W117.2-1974. A Free copy of "Arc Welding Safety" booklet E205 is available from the Lincoln Electric Company, 22801 St. Clair Avenue, Cleveland, Ohio 44117-1199.

**BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.**



### FOR ENGINE POWERED EQUIPMENT.

- 1.a. Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.
- 1.b. Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.
- 1.c. Do not add the fuel near an open flame welding arc or when the engine is running. Stop the engine and allow it to cool before refueling to prevent spilled fuel from vaporizing on contact



with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.

- 1.d. Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.
- 1.e. In some cases it may be necessary to remove safety guards to perform required maintenance. Remove guards only when necessary and replace them when the maintenance requiring their removal is complete. Always use the greatest care when working near moving parts.
- 1.f. Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.
- 1.g. To prevent accidentally starting gasoline engines while turning the engine or welding generator during maintenance work, disconnect the spark plug wires, distributor cap or magneto wire as appropriate.
- 1.h. To avoid scalding, do not remove the radiator pressure cap when the engine is hot.



### ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS



- 2.a. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines
- 2.b. EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.
- 2.c. Exposure to EMF fields in welding may have other health effects which are now not known.
- 2.d. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:
  - 2.d.1. Route the electrode and work cables together - Secure them with tape when possible.
  - 2.d.2. Never coil the electrode lead around your body.
  - 2.d.3. Do not place your body between the electrode and work cables. If the electrode cable is on your right side, the work cable should also be on your right side.
  - 2.d.4. Connect the work cable to the workpiece as close as possible to the area being welded.
  - 2.d.5. Do not work next to welding power source.



## ELECTRIC SHOCK CAN KILL.



- 3.a. The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.
- 3.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.

**In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying, if there is a high risk of unavoidable or accidental contact with the workpiece or ground) use the following equipment:**

- Semiautomatic DC Constant Voltage (Wire) Welder.
  - DC Manual (Stick) Welder.
  - AC Welder with Reduced Voltage Control.
- 3.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically “hot”.
  - 3.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.
  - 3.e. Ground the work or metal to be welded to a good electrical (earth) ground.
  - 3.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.
  - 3.g. Never dip the electrode in water for cooling.
  - 3.h. Never simultaneously touch electrically “hot” parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.
  - 3.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.
  - 3.j. Also see Items 6.c. and 8.



## ARC RAYS CAN BURN.



- 4.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87.1 standards.
- 4.b. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- 4.c. Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.



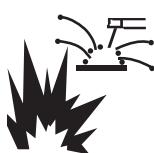
## FUMES AND GASES CAN BE DANGEROUS.



- 5.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. **When welding hardfacing (see instructions on container or SDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and within applicable OSHA PEL and ACGIH TLV limits using local exhaust or mechanical ventilation unless exposure assessments indicate otherwise. In confined spaces or in some circumstances, outdoors, a respirator may also be required. Additional precautions are also required when welding on galvanized steel.**
- 5.b. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.
- 5.c. Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- 5.d. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.
- 5.e. Read and understand the manufacturer’s instructions for this equipment and the consumables to be used, including the Safety Data Sheet (SDS) and follow your employer’s safety practices. SDS forms are available from your welding distributor or from the manufacturer.
- 5.f. Also see item 1.b.



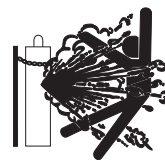
## WELDING AND CUTTING SPARKS CAN CAUSE FIRE OR EXPLOSION.



- 6.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.
- 6.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to "Safety in Welding and Cutting" (ANSI Standard Z49.1) and the operating information for the equipment being used.
- 6.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- 6.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).
- 6.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- 6.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
- 6.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.
- 6.h. Also see item 1.c.
- 6.i. Read and follow NFPA 51B "Standard for Fire Prevention During Welding, Cutting and Other Hot Work", available from NFPA, 1 Batterymarch Park, PO box 9101, Quincy, MA 022690-9101.
- 6.j. Do not use a welding power source for pipe thawing.



## CYLINDER MAY EXPLODE IF DAMAGED.



- 7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.
- 7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- 7.c. Cylinders should be located:
  - Away from areas where they may be struck or subjected to physical damage.
  - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- 7.d. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder.
- 7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- 7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
- 7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders," available from the Compressed Gas Association, 14501 George Carter Way Chantilly, VA 20151.



## FOR ELECTRICALLY POWERED EQUIPMENT.



- 8.a. Turn off input power using the disconnect switch at the fuse box before working on the equipment.
- 8.b. Install equipment in accordance with the U.S. National Electrical Code, all local codes and the manufacturer's recommendations.
- 8.c. Ground the equipment in accordance with the U.S. National Electrical Code and the manufacturer's recommendations.

**Refer to**  
**<http://www.lincolnelectric.com/safety>**  
**for additional safety information.**

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Pairing the Pedal/Receiver .....	B-3
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<b>Trouble Shooting</b> .....	<b>Section E-1</b>
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# GENERAL DESCRIPTION

The Wireless TIG Foot pedal provides precision arc control along with the freedom and flexibility of a wireless device. Extremely easy-to-use, the system can be set up and configured within seconds.

The rugged housing will stand up in the toughest welding environments and the anti-slip pads will ensure that the pedal stays exactly where you want it to. Extension legs are included to provide optimal comfort in a range of welding positions and can be offset to allow the pedal to be used on uneven surfaces.

LED's on the receiver provide feedback to the operator including output state, remaining battery life and communication strength. A built-in calibration routine provides a greater control over the arc and ensures consistent performance and response weld after weld.

## INDIVIDUAL COMPONENTS

K3550-1 (Transmitter only)
Code 12158
FCC ID: OUR_XBEE
K3551-1 (Receiver only)
Code 12159
FCC ID: OUR_XBEE

The Wireless TIG Foot Pedal is compatible with the following power sources:

Square Wave™ TIG 175  
 Invertec® V160-T  
 Invertec® V205-T DC  
 Invertec® V205-T AC/DC  
 Invertec® V311-T AC/DC  
 Precision TIG® 225  
 Precision TIG® 275  
 Precision TIG® 375  
 Invertec® V350 PRO  
 Flextec™ 450  
 Flextec™ 650  
 PowerWave® C300(1)  
 PowerWave® S350(1,2)  
 PowerWave® S500(1,2)

(1) Requires K2909-1 (12-pin to 6-pin Adapter)

(2) Requires K3001-2 (S-Series User Interface Kit)

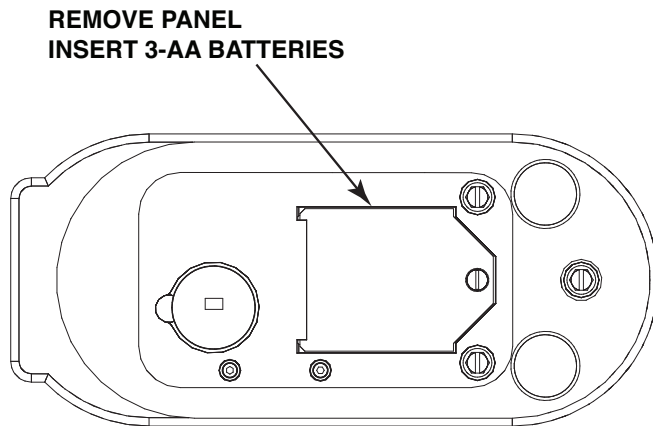


**ASSEMBLY AND OPERATION**

**Pedal:**

Out of the box, remove the panel on the bottom side of the pedal and insert 3-AA batteries. Two non-skid leveling legs are included for optional height adjustments.

**FIGURE A.1**



When the pedal is depressed, the remaining two LEDs will turn on.

“OUTPUT ON” (center):

This LED indicates that the trigger circuit has been closed. If connected to a power source, the output will be enabled.

“BATTERY” (left):

This LED indicates the strength of the battery. It changes from GREEN (OK), to YELLOW, to RED (critical) as the batteries in the pedal are depleted. Depending on the setting of the receiver DIP SWITCH, it can also illuminate BLUE (see Diagnostic Mode).

**Receiver:**

Connect one end of the 15VDC power supply to the receiver cable assembly; and the other end into a 115 VAC receptacle. The ‘ON’ LED will illuminate. The receiver is designed to be magnetically affixed to any steel surface.

The pedal is already in Control Mode and ready to weld. (See figure A.2)

**FIGURE A.2**





**CHANNEL SELECTION**

In addition to being properly paired, the pedal and receiver must be set to the same channel in order for communication to take place. The **rotary DIP SWITCH** sets which of the 16 channels within the 2.4GHz band the system will communicate on. If multiple systems are operating within the same vicinity, it is recommended that each is operated on its own channel to improve performance.

It is important to note that each pedal is factory programmed with a unique ID. A receiver is programmed to respond **ONLY** to the pedal in which it is paired.

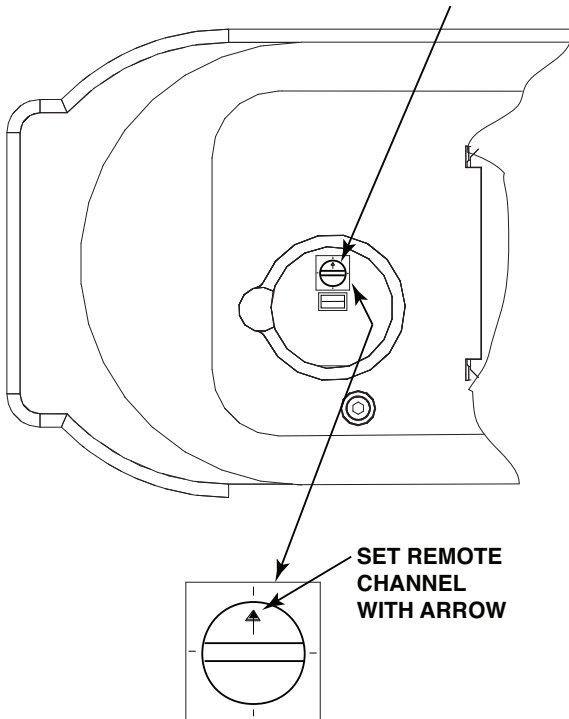
**Selecting Channel (Pedal):**

(See figure A.3)

1. Remove the plug cover on the bottom of the pedal.
2. With a small screw driver, select the **desired channel**.
3. See selecting channels on the receiver.

**FIGURE A.3**

**PLUG COVER REMOVED  
INSERT SMALL SCREW  
DRIVER TO SET DESIRED CHANNEL.**



**SET REMOTE  
CHANNEL  
WITH ARROW**

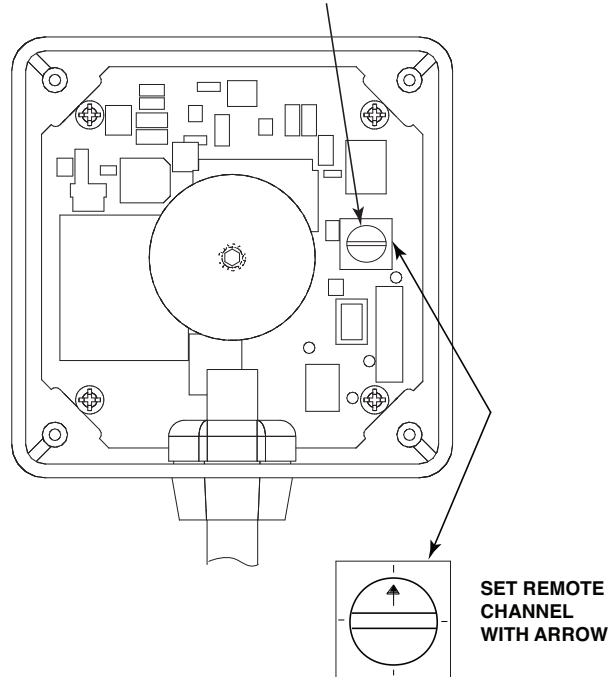
**Selecting Channel (Receiver):**

(See figure A.4)

1. Remove the 4 screws on the back of the receiver and remove the cover.
2. With a small screw driver, select the **desired channel**.
3. After channels have been set to the same **desired channel**, see next step Pairing the Pedal/Receiver.

**FIGURE A.4**

**BACK COVER REMOVED  
INSERT SMALL SCREW  
DRIVER TO SET DESIRED CHANNEL.**



**SET REMOTE  
CHANNEL  
WITH ARROW**

### PAIRING THE PEDAL/RECEIVER

The pairing procedure establishes a communication link between the pedal and receiver which is maintained until this procedure is repeated (systems remained paired even if power is removed). Pairing also allows multiple pedals to communicate with the same receiver (though not simultaneously).

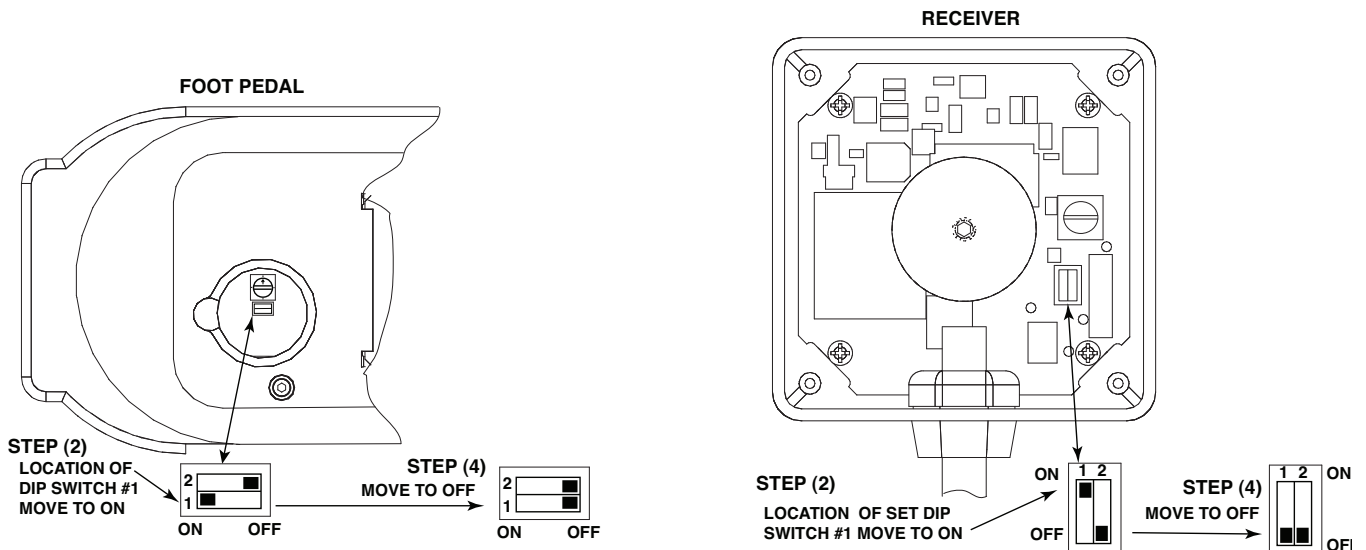
Normal operation requires that the systems are placed in Control Mode (**DIP SWITCHES #1** is set to the “OFF” position on both the pedal and receiver). To pair a different pedal, place the system into Configure Mode.

#### Pairing in Configure Mode:

(See figure A.5)

1. Ensure that power is applied to both the pedal and receiver.
2. Set **DIP SWITCHES #1** on both the pedal and receiver to “ON”.
3. Fully depress the pedal for 2 seconds, then release.
4. Set **DIP SWITCHES #1** on both the pedal and receiver back to “OFF”.
5. Replace plug button/cover.

FIGURE A.5



**CALIBRATION:**

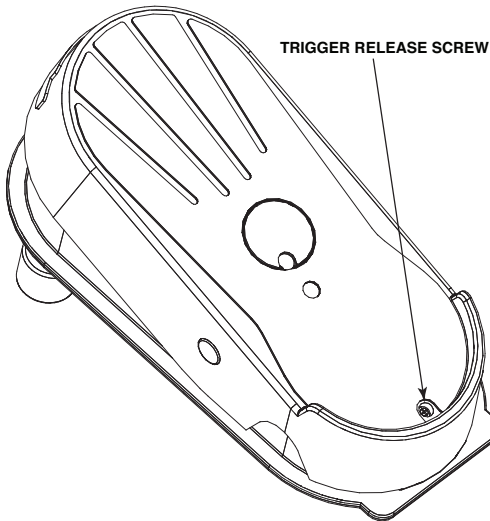
There are two parameters that can be calibrated: the Trigger Release Screw and MAX Pedal Stroke.

**Trigger Release Screw**

(See figure A.6)

This screw determines the response of the pedal. It should be set so that it engages the internal on/off switch (enabling output) when the pedal is at rest, and disengages the on/off switch when the pedal is depressed.

**FIGURE A.6**



**MAX Pedal Stroke**

Extreme impact and/or part replacement procedures can affect the optimal position of the pot and thus the ability to reach the maximum welding set point. The Max Pedal Stroke parameter aligns the maximum depressed position of the pedal to the maximum set output of the machine.

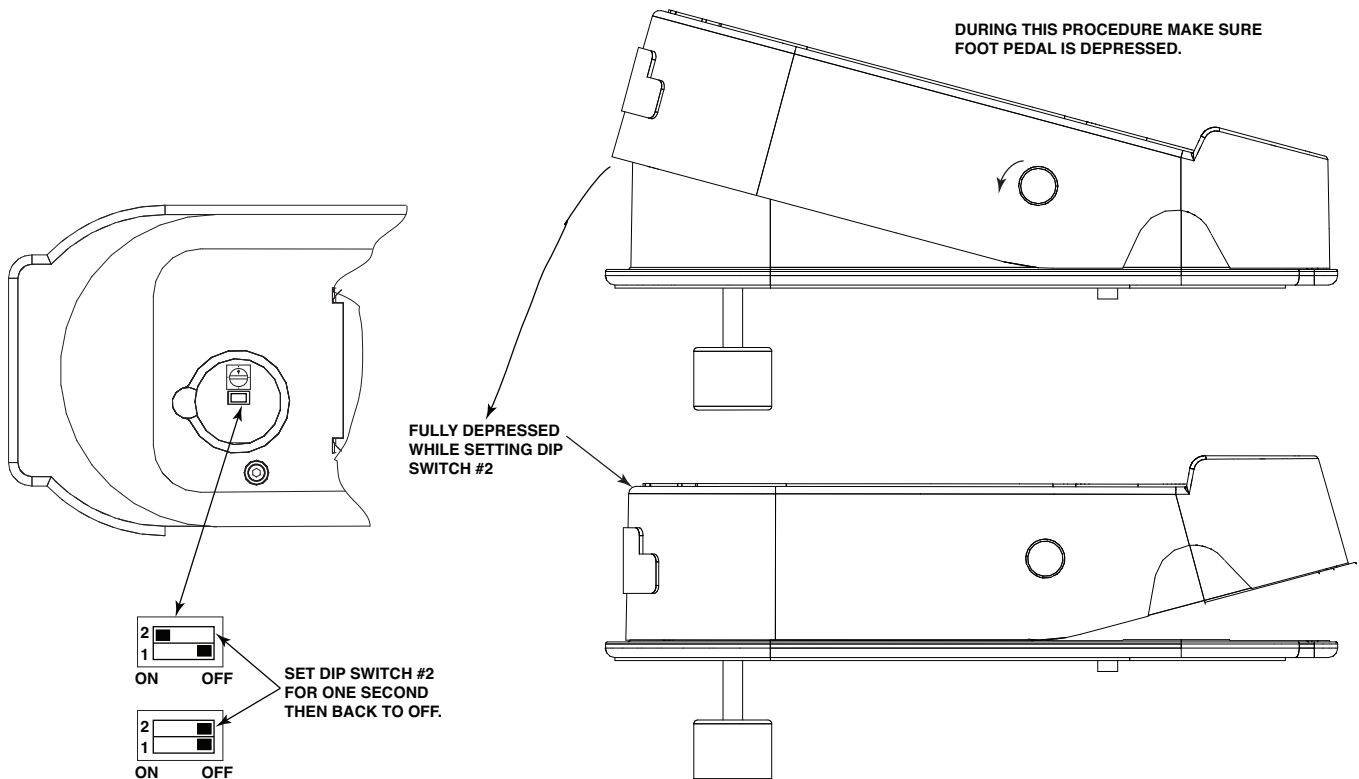
**Setting the Max Stroke:**

(See figure A.7)

1. Remove the plug cover on the bottom of the pedal.
2. With the pedal fully depressed, set **DIP SWITCH #2** into the "ON" position for 1 second, and then back into the "OFF" position.
3. Release the pedal.
4. Replace the plug cover.

**Note:** This entire procedure should be completed with the pedal fully depressed. The position of the pedal when the switch is thrown will be equated to the maximum current set point.

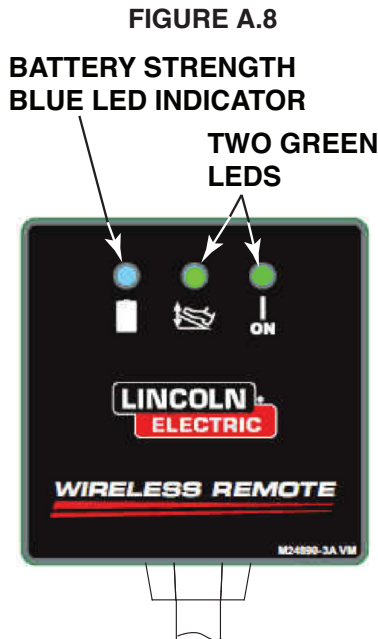
**FIGURE A.7**



### DIAGNOSTIC MODE

The system’s range is maximized with a clear line of sight to the power source. Other factors such as heavy RF activity within the pedal’s vicinity can also affect performance.

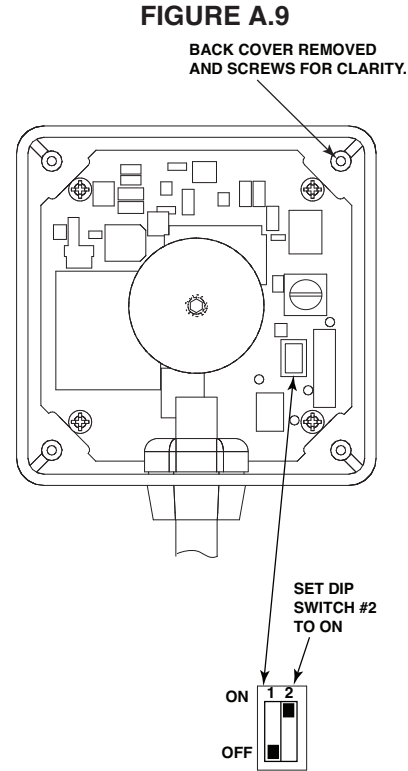
The diagnostic mode will provide a qualitative analysis of the system’s communication. In this mode, the battery strength indicator will change to illuminate BLUE, and blink at a rate of 20 times per second to indicate uninterrupted communication. An intermittent blinking rate would suggest a heavily congested environment, or that the pedal and receiver are approaching their maximum operating distance. (See figure A.8)



### Entering Diagnostic Mode:

(See figure A.9)

1. Remove the 4 screws on the back of the receiver and remove the cover.
2. Set DIP SWITCH #2 on the receiver board to “ON.”
3. Replace cover.



### DIP SWITCH FUNCTIONS

Each pedal and receiver has a 2 position dip switch and a 16 position rotary dip switch. The functionality of each is as follows:

#### PRINTED CIRCUIT BOARD

Mode of Operation	Pedal Dip Switches		Receiver Dip Switches		Details/Function
	#1	#2	#1	#2	
Control	off	off	off	off	Normal Transmission
Diagnostic	off	off	off	on	Communication strength metric
Configure	on	x	on	x	Pairing Procedure
Calibration	x	on	x	x	Set/Clear dip at maximum stroke

X-Don't care

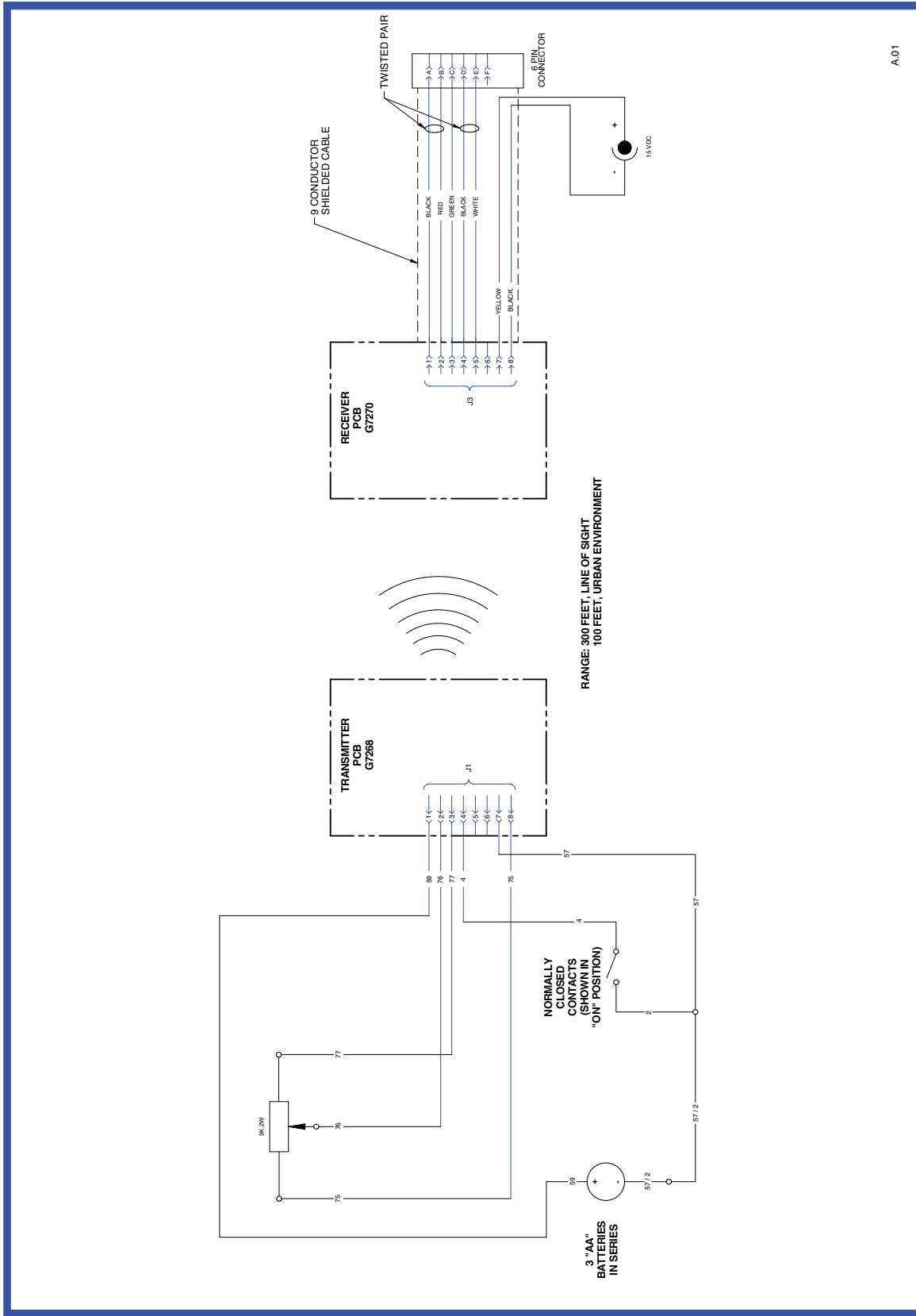
Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
The machine does not respond when the pedal is engaged.	<ol style="list-style-type: none"> <li>1. The battery power is too low.</li> <li>2. The pedal and receiver are not set to the same channel.</li> <li>3. The pedal and receiver are not paired.</li> <li>4. The Max Stroke is not set properly.</li> <li>5. The system needs to be reset.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace the batteries in the pedal.</li> <li>2. Adjust the rotary switches to a matching channel.</li> <li>3. Follow procedure for pairing the system.</li> <li>4. Follow procedure for setting the max pedal stroke.</li> <li>5. Cycle power by removing/re-inserting a battery within the pedal.</li> </ol>
Arc does not stay initiated.	<ol style="list-style-type: none"> <li>1. High Frequency interference is present.</li> <li>2. Heavy RF activity within the vicinity.</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-route the TIG torch away from the receiver. Cycle power to the receiver.</li> <li>2. Switch to a different channel using the rotary switch. This may be the case when using multiple wireless pedal systems in close proximity.</li> </ol>
The output of the machine stays on.	<ol style="list-style-type: none"> <li>1. The Trigger Release screw is not set properly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten the Trigger Release screw fully into the pedal.</li> </ol>

**⚠ CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

# WIRELESS FOOT PEDAL WIRING DIAGRAM



L16343

**NOTE:** This diagram is for reference only. It may not be accurate for all machines covered by this manual. The specific diagram for a particular code is pasted inside the machine on one of the enclosure panels. If the diagram is illegible, write to the Service Department for a replacement. Give the equipment code number.

**PARTS LIST FOR**

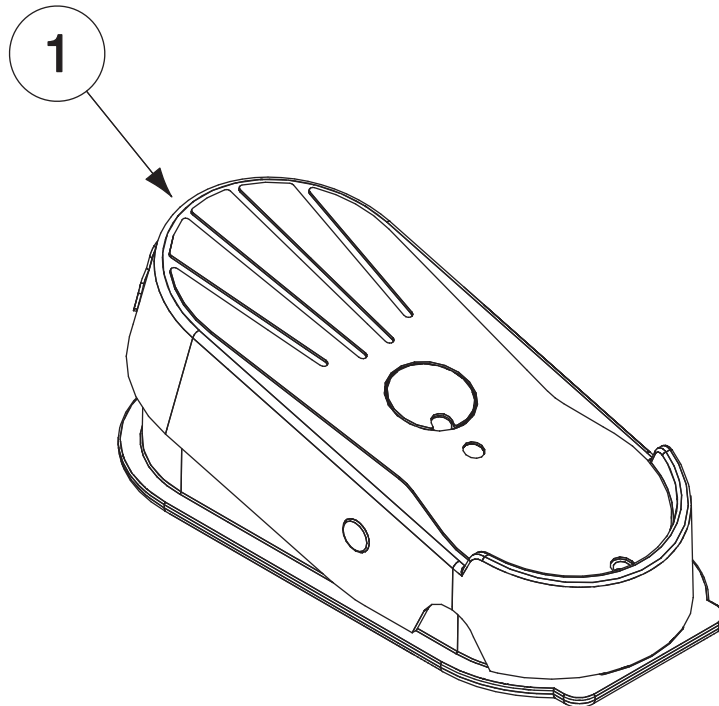
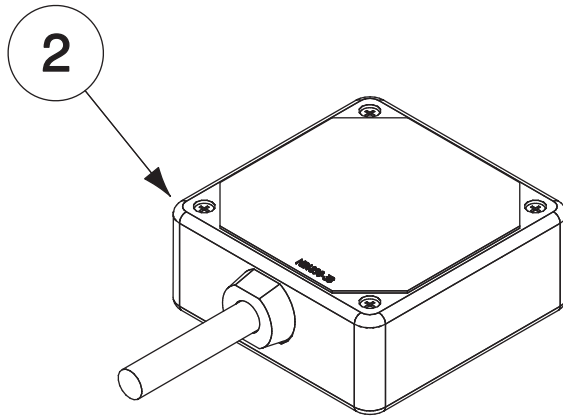
**Wireless TIG Foot Pedal**

WIRELESS TIG FOOT PEDAL





# ILLUSTRATION OF SUB-ASSEMBLIES





# Indicates a change this printing.

Use only the parts marked "x" in the column under the heading number called for in the model index page.

DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
Switching Power Supply	M24889	1	X								
Leveling Foot	S29511	2	X								



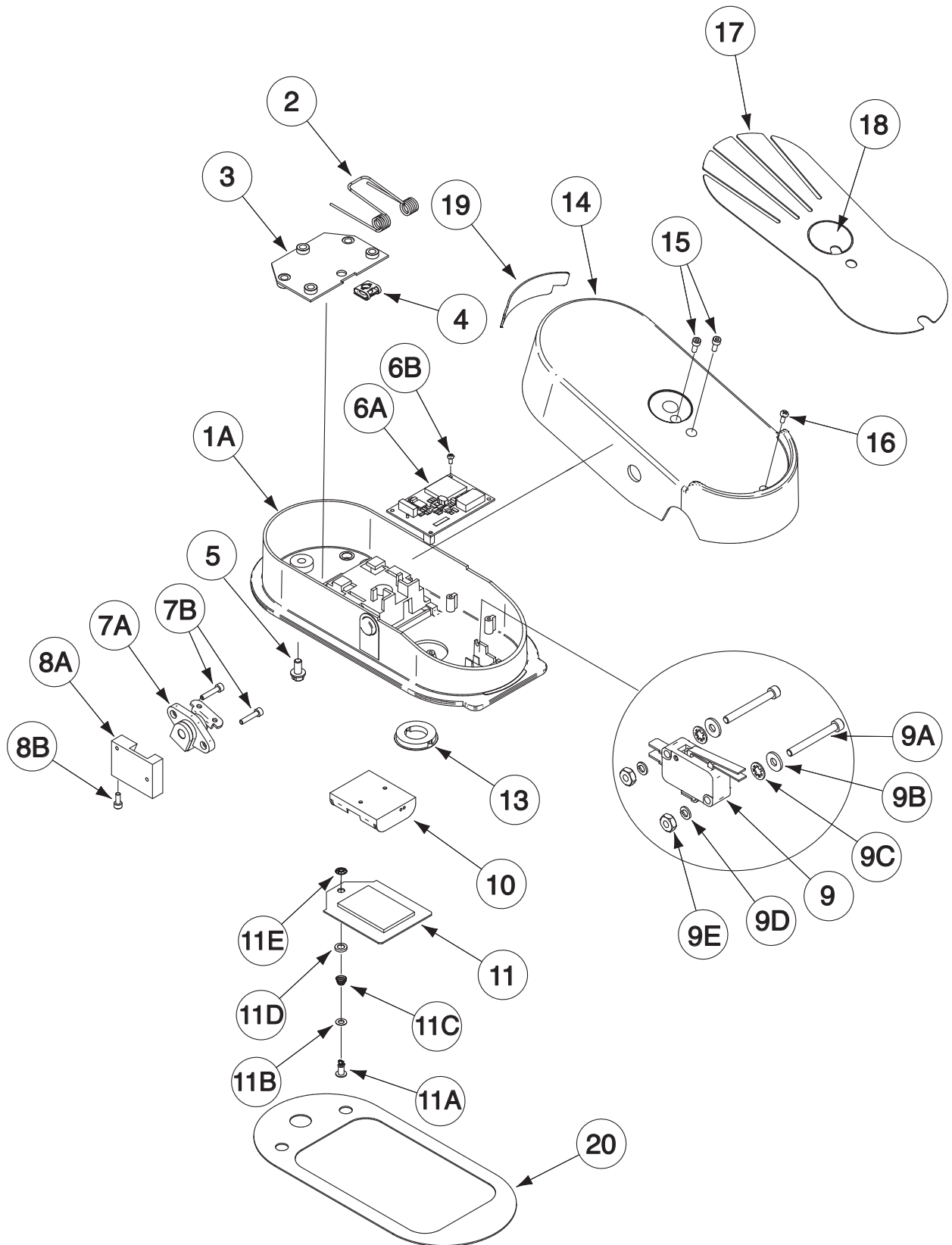
# NOTES

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WIRELESS TIG FOOT PEDAL



# Foot Pedal Assembly



WIRELESS TIG FOOT PEDAL

Oct-13



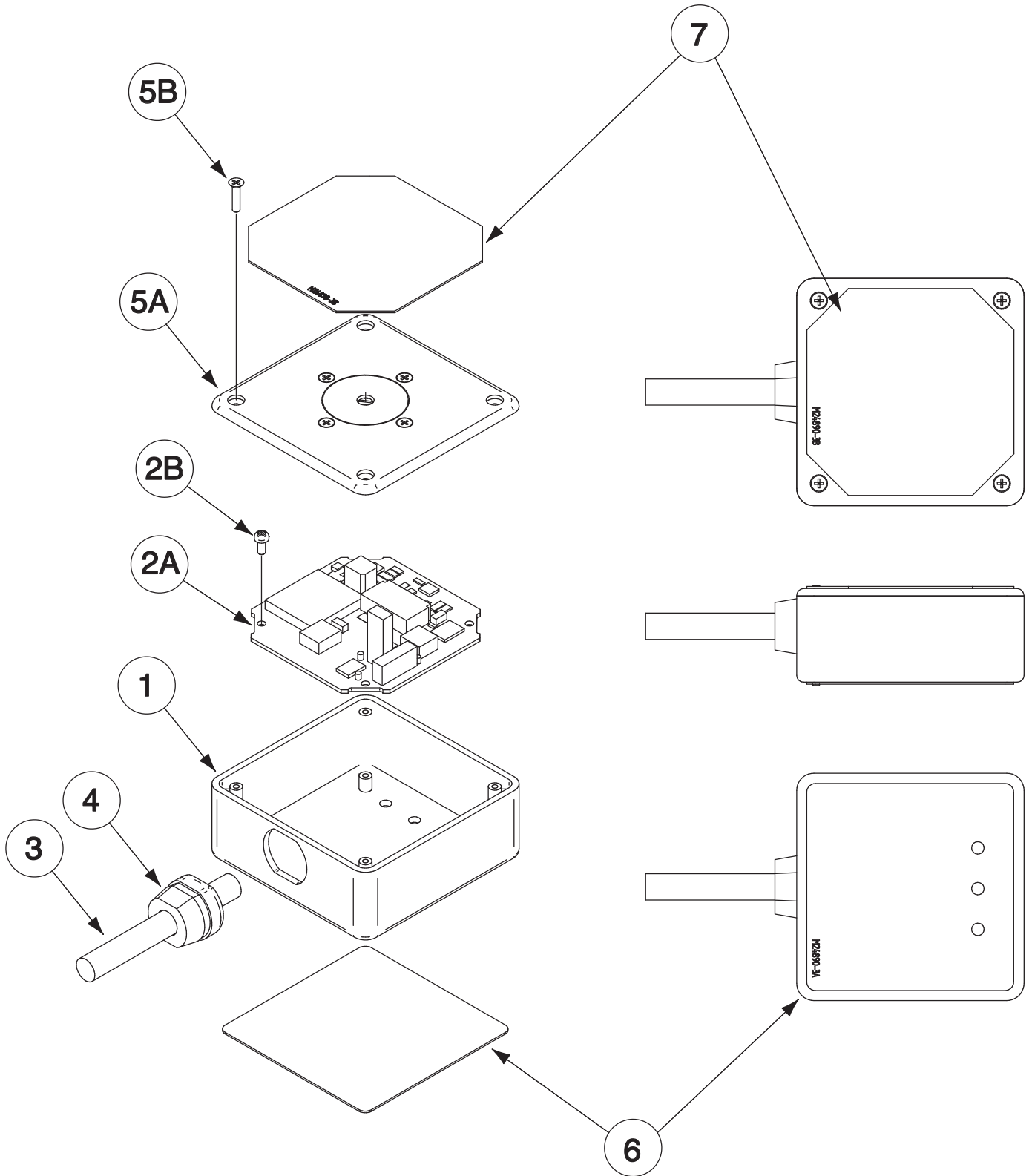
# Indicates a change this printing.

Use only the parts marked "x" in the column under the heading number called for in the model index page.

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1A	Foot Pedal Assembly (G7380), Includes: Pedal Bottom	K3127-1 G7328	1 1	X X								
2	Spring	M22906-1	1	X								
3	Foot Bracket, Toe	S29290-1	1	X								
4	Receptacle	S24820-1	1	X								
5	Thread Cutting Screw	S9225-8	3	X								
6A	P.C. Board Assembly	G7268-[ ]	1	X								
6B	Self Tapping Screw	S8025-124	3	X								
7	Harness Assembly, Includes:	M24145	1	X								
7A	Acceleration Module	<b>NSS</b>	1	X								
7B	M4 x 0.7 x 20 Metric Socket Head Cap Screw	T14731-74	2	X								
7C	Lock Washer (Not Shown)	T4291-A	2	X								
8A	Mounting Block	S29503	1	X								
8B	M4 x 0.7 x 10 Metric Socket Head Cap Screw	T14731-63	2	X								
8C	Lock Washer	T4291-A	2	X								
9	SPDT Micro Switch	S29526	1	X								
9A	#4-40 x 1.00 SHCS	T9447-126	2	X								
9B	Plain Washer	S9262-39	2	X								
9C	Internal Shake Lock Washer	T9695-2	2	X								
9D	Lock Washer	T4291-B	2	X								
9E	#4-40 HN	CF000002	2	X								
10	Plastic Battery Holder	S29522-1	1	X								
11	Battery Cover & Insulation Assembly	S29823	1	X								
11A	Quarter Turn Stud	S24815-1	1	X								
11B	Sealing Washer	S24816-1	1	X								
11C	Ejector Spring	S24817-1	1	X								
11D	Nylon Wear Washer	S24818-1	1	X								
11E	Retainer	S24819-1	1	X								
13	Plug Button	T10397-10	1	X								
14	Pedal Top	G7329	1	X								
15	M4 x 0.7 x 10 Metric Socket Head Cap Screw	T14731-63	2	X								
16	Self Tapping Screw	S8025-96	1	X								
17	Foot Pedal Decal (Top) (M24890-1A) (Part of M24890-1)	<b>NSS</b>	1	X								
18	Plug Decal (M24890-1B) (Part of M24890-1)	<b>NSS</b>	1	X								
19	LECO Logo Decal	S27368-8	1	X								
20	Foot Pedal Decal (Bottom) (M24890-1C) (Part of M24890-1)	<b>NSS</b>	1	X								



# Receiver Assembly





# Indicates a change this printing.

Use only the parts marked "x" in the column under the heading number called for in the model index page.

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1	Receiver Assembly (L16342), Includes: Receiver Enclosure	K3351-1	1	X								
		<b>NSS</b>	1	X								
2A	Receiver P.C. Board Assembly	G7270-[ ]	1	X								
2B	Self Tapping Screw	S8025-121	4	X								
3	Connector & Lead Assembly	S18081-8	1	X								
4	Lead Grommet	T9274-3	1	X								
5A	Enclosure Cover & Magnet Assembly	M24887	1	X								
5B	Self Tapping Screw	S8025-124	4	X								
6	Receiver Nameplate (M24890-3A) (Part of M24890-3)	<b>NSS</b>	1	X								
7	Receiver Nameplate (M24890-3B) (Part of M24890-3)	<b>NSS</b>	1	X								



			
<b>WARNING</b>	<ul style="list-style-type: none"> <li>Do not touch electrically live parts or electrode with skin or wet clothing.</li> <li>Insulate yourself from work and ground.</li> </ul>	<ul style="list-style-type: none"> <li>Keep flammable materials away.</li> </ul>	<ul style="list-style-type: none"> <li>Wear eye, ear and body protection.</li> </ul>
Spanish <b>AVISO DE PRECAUCION</b>	<ul style="list-style-type: none"> <li>No toque las partes o los electrodos bajo carga con la piel o ropa mojada.</li> <li>Aíslese del trabajo y de la tierra.</li> </ul>	<ul style="list-style-type: none"> <li>Mantenga el material combustible fuera del área de trabajo.</li> </ul>	<ul style="list-style-type: none"> <li>Protéjase los ojos, los oídos y el cuerpo.</li> </ul>
French <b>ATTENTION</b>	<ul style="list-style-type: none"> <li>Ne laissez ni la peau ni des vêtements mouillés entrer en contact avec des pièces sous tension.</li> <li>Isolez-vous du travail et de la terre.</li> </ul>	<ul style="list-style-type: none"> <li>Gardez à l'écart de tout matériel inflammable.</li> </ul>	<ul style="list-style-type: none"> <li>Protégez vos yeux, vos oreilles et votre corps.</li> </ul>
German <b>WARNUNG</b>	<ul style="list-style-type: none"> <li>Berühren Sie keine stromführenden Teile oder Elektroden mit Ihrem Körper oder feuchter Kleidung!</li> <li>Isolieren Sie sich von den Elektroden und dem Erdboden!</li> </ul>	<ul style="list-style-type: none"> <li>Entfernen Sie brennbares Material!</li> </ul>	<ul style="list-style-type: none"> <li>Tragen Sie Augen-, Ohren- und Körperschutz!</li> </ul>
Portuguese <b>ATENÇÃO</b>	<ul style="list-style-type: none"> <li>Não toque partes elétricas e electrodos com a pele ou roupa molhada.</li> <li>Isole-se da peça e terra.</li> </ul>	<ul style="list-style-type: none"> <li>Mantenha inflamáveis bem guardados.</li> </ul>	<ul style="list-style-type: none"> <li>Use proteção para a vista, ouvido e corpo.</li> </ul>
Japanese <b>注意事項</b>	<ul style="list-style-type: none"> <li>通電中の電気部品、又は溶材にヒブやぬれた布で触れないこと。</li> <li>施工物やアースから身体が絶縁されている様にして下さい。</li> </ul>	<ul style="list-style-type: none"> <li>燃えやすいものの側での溶接作業は絶対にしてはなりません。</li> </ul>	<ul style="list-style-type: none"> <li>目、耳及び身体に保護具をして下さい。</li> </ul>
Chinese <b>警告</b>	<ul style="list-style-type: none"> <li>皮肤或湿衣物切勿接触带电部件及焊条。</li> <li>使你自已与地面和工件绝缘。</li> </ul>	<ul style="list-style-type: none"> <li>把一切易燃物品移离工作场所。</li> </ul>	<ul style="list-style-type: none"> <li>佩戴眼、耳及身体劳动保护用具。</li> </ul>
Korean <b>위험</b>	<ul style="list-style-type: none"> <li>전도체나 용접봉을 젖은 헝겍 또는 피부로 절대 접촉치 마십시오.</li> <li>모재와 접지를 접촉치 마십시오.</li> </ul>	<ul style="list-style-type: none"> <li>인화성 물질을 접근시키지 마십시오.</li> </ul>	<ul style="list-style-type: none"> <li>눈, 귀와 몸에 보호장구를 착용하십시오.</li> </ul>
Arabic <b>تحذير</b>	<ul style="list-style-type: none"> <li>لا تلمس الاجزاء التي يسري فيها التيار الكهربائي أو الألكترود بجسدك أو بالملابس المبللة بالماء.</li> <li>ضع عازلا على جسمك خلال العمل.</li> </ul>	<ul style="list-style-type: none"> <li>ضع المواد القابلة للاشتعال في مكان بعيد.</li> </ul>	<ul style="list-style-type: none"> <li>ضع أدوات وملابس واقية على عينيك وأذنيك وجسمك.</li> </ul>

**READ AND UNDERSTAND THE MANUFACTURER'S INSTRUCTION FOR THIS EQUIPMENT AND THE CONSUMABLES TO BE USED AND FOLLOW YOUR EMPLOYER'S SAFETY PRACTICES.**

**SE RECOMIENDA LEER Y ENTENDER LAS INSTRUCCIONES DEL FABRICANTE PARA EL USO DE ESTE EQUIPO Y LOS CONSUMIBLES QUE VA A UTILIZAR, SIGA LAS MEDIDAS DE SEGURIDAD DE SU SUPERVISOR.**

**LISEZ ET COMPRENEZ LES INSTRUCTIONS DU FABRICANT EN CE QUI REGARDE CET EQUIPMENT ET LES PRODUITS A ETRE EMPLOYES ET SUIVEZ LES PROCEDURES DE SECURITE DE VOTRE EMPLOYEUR.**

**LESEN SIE UND BEFOLGEN SIE DIE BETRIEBSANLEITUNG DER ANLAGE UND DEN ELEKTRODENEINSATZ DES HERSTELLERS. DIE UNFALLVERHÜTUNGSVORSCHRIFTEN DES ARBEITGEBERS SIND EBENFALLS ZU BEACHTEN.**

			
<ul style="list-style-type: none"> <li>● Keep your head out of fumes.</li> <li>● Use ventilation or exhaust to remove fumes from breathing zone.</li> </ul>	<ul style="list-style-type: none"> <li>● Turn power off before servicing.</li> </ul>	<ul style="list-style-type: none"> <li>● Do not operate with panel open or guards off.</li> </ul>	<b>WARNING</b>
<ul style="list-style-type: none"> <li>● Los humos fuera de la zona de respiración.</li> <li>● Mantenga la cabeza fuera de los humos. Utilice ventilación o aspiración para gases.</li> </ul>	<ul style="list-style-type: none"> <li>● Desconectar el cable de alimentación de poder de la máquina antes de iniciar cualquier servicio.</li> </ul>	<ul style="list-style-type: none"> <li>● No operar con panel abierto o guardas quitadas.</li> </ul>	Spanish <b>AVISO DE PRECAUCION</b>
<ul style="list-style-type: none"> <li>● Gardez la tête à l'écart des fumées.</li> <li>● Utilisez un ventilateur ou un aspirateur pour ôter les fumées des zones de travail.</li> </ul>	<ul style="list-style-type: none"> <li>● Débranchez le courant avant l'entretien.</li> </ul>	<ul style="list-style-type: none"> <li>● N'opérez pas avec les panneaux ouverts ou avec les dispositifs de protection enlevés.</li> </ul>	French <b>ATTENTION</b>
<ul style="list-style-type: none"> <li>● Vermeiden Sie das Einatmen von Schweißrauch!</li> <li>● Sorgen Sie für gute Be- und Entlüftung des Arbeitsplatzes!</li> </ul>	<ul style="list-style-type: none"> <li>● Strom vor Wartungsarbeiten abschalten! (Netzstrom völlig öffnen; Maschine anhalten!)</li> </ul>	<ul style="list-style-type: none"> <li>● Anlage nie ohne Schutzgehäuse oder Innenschutzverkleidung in Betrieb setzen!</li> </ul>	German <b>WARNUNG</b>
<ul style="list-style-type: none"> <li>● Mantenha seu rosto da fumaça.</li> <li>● Use ventilação e exaustão para remover fumo da zona respiratória.</li> </ul>	<ul style="list-style-type: none"> <li>● Não opere com as tampas removidas.</li> <li>● Desligue a corrente antes de fazer serviço.</li> <li>● Não toque as partes elétricas nuas.</li> </ul>	<ul style="list-style-type: none"> <li>● Mantenha-se afastado das partes moventes.</li> <li>● Não opere com os painéis abertos ou guardas removidas.</li> </ul>	Portuguese <b>ATENÇÃO</b>
<ul style="list-style-type: none"> <li>● ヒュームから頭を離すようにして下さい。</li> <li>● 換気や排煙に十分留意して下さい。</li> </ul>	<ul style="list-style-type: none"> <li>● メンテナンス・サービスに取りかかる際には、まず電源スイッチを必ず切して下さい。</li> </ul>	<ul style="list-style-type: none"> <li>● パネルやカバーを取り外したままで機械操作をしないで下さい。</li> </ul>	Japanese <b>注意事項</b>
<ul style="list-style-type: none"> <li>● 頭部遠離煙霧。</li> <li>● 在呼吸區使用通風或排風器除煙。</li> </ul>	<ul style="list-style-type: none"> <li>● 維修前切斷電源。</li> </ul>	<ul style="list-style-type: none"> <li>● 儀表板打開或沒有安全罩時不準作業。</li> </ul>	Chinese <b>警告</b>
<ul style="list-style-type: none"> <li>● 얼굴로부터 용접가스를 멀리하십시오.</li> <li>● 호흡지역으로부터 용접가스를 제거하기 위해 가스제거기나 통풍기를 사용하십시오.</li> </ul>	<ul style="list-style-type: none"> <li>● 보수전에 전원을 차단하십시오.</li> </ul>	<ul style="list-style-type: none"> <li>● 판넬이 열린 상태로 작동치 마십시오.</li> </ul>	Korean <b>위험</b>
<ul style="list-style-type: none"> <li>● ابعد رأسك بعيداً عن الدخان.</li> <li>● استعمل التهوية أو جهاز ضغط الدخان للخارج لكي تبعد الدخان عن المنطقة التي تتنفس فيها.</li> </ul>	<ul style="list-style-type: none"> <li>● اقطع التيار الكهربائي قبل القيام بأية صيانة.</li> </ul>	<ul style="list-style-type: none"> <li>● لا تشغيل هذا الجهاز اذا كانت الاغطية الحديدية الواقية ليست عليه.</li> </ul>	Arabic <b>تحذير</b>

**LEIA E COMPREENDA AS INSTRUÇÕES DO FABRICANTE PARA ESTE EQUIPAMENTO E AS PARTES DE USO, E SIGA AS PRÁTICAS DE SEGURANÇA DO EMPREGADOR.**

使う機械や溶材のメーカーの指示書をよく読み、まず理解して下さい。そして貴社の安全規定に従って下さい。

請詳細閱讀並理解製造廠提供的說明以及應該使用的銀焊材料，並請遵守貴方的有關勞動保護規定。

이 제품에 동봉된 작업지침서를 숙지하시고 귀사의 작업자 안전수칙을 준수하시기 바랍니다.

اقرأ بتمعن وافهم تعليمات المصنع المنتج لهذه المعدات والمواد قبل استعمالها واتبع تعليمات الوقاية لصاحب العمل.

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