

CENTURY MFG. COMPANY



**Spoolgun & Control Module
Installation Instructions**

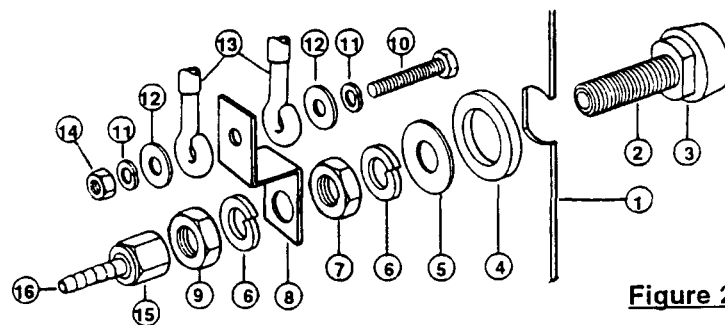
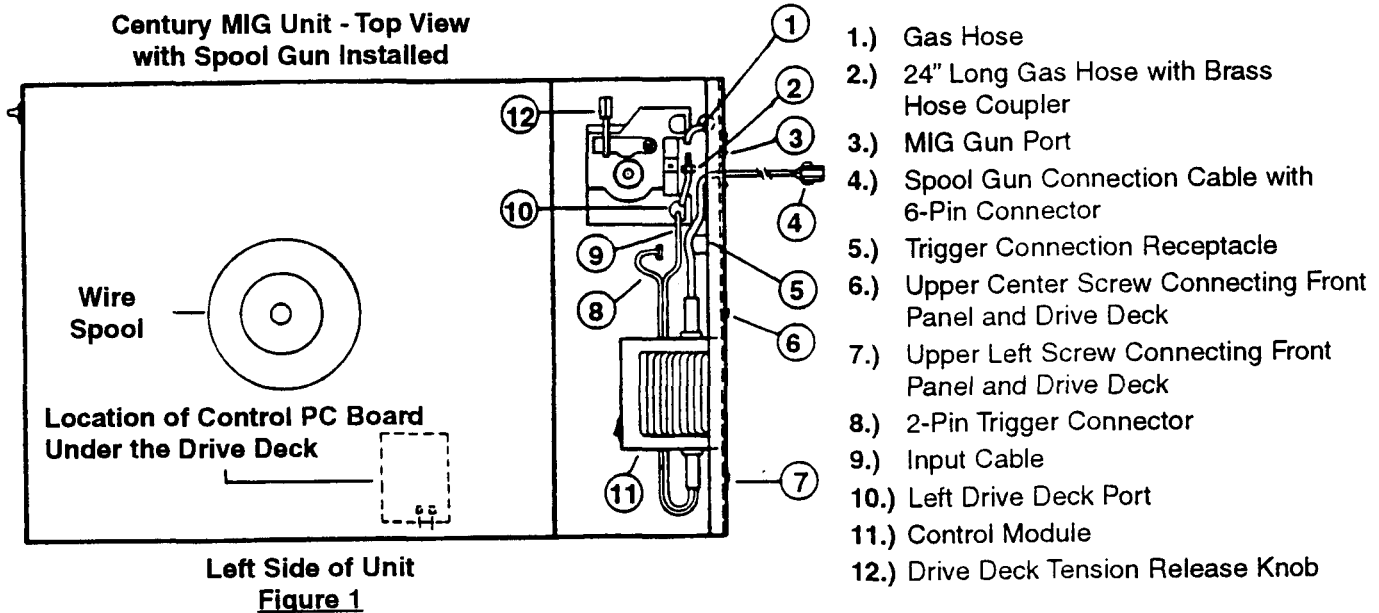
For 160 Amp and 225 Amp Wirefeed Welders Only

**BEFORE ATTEMPTING TO INSTALL THE SPOOLGUN
CONTROL MODULE, DISCONNECT ALL INPUT ELECTRICAL
POWER TO THE MIG UNIT**

Order Spool gun Parts from Welder Repair - 800-925-7741

A.) THE NEW CURRENT CONDUCTOR CONNECTOR

- 1.) Remove the left side panel of the MIG unit. (See Figure 1).
- 2.) Locate where the welding current conductors (solid transformer wires) are attached to the positive (DC+) terminal stud. (See Figure 2).
- 3.) Remove the bolted connection from the end of the positive terminal stud. (Save parts for later use). (See Figure 2).
- 4.) Remove the 9/16" nut from the end of the positive terminal stud. (See Figure 2).
- 5.) Remove the positive terminal stud from front panel of the welder. (See Figure 2).
- 6.) Remove black receptacle nut from positive terminal stud. (See Figure 2).
- 7.) Screw the black receptacle nut on the end with the larger opening of the kit's positive terminal stud. (See Figure 2). **NOTE: The spoolgun plug only fits into the larger opening of the positive terminal stud.**



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| <ol style="list-style-type: none"> 1.) Front Panel 2.) Positive Terminal Stud 3.) Black Receptacle Stud 4.) Black Insulating Washer 5.) 9/16" Flat Washer 6.) 9/16" Lock Washer (2) 7.) 9/16" Brass Nut 8.) Conductor Strap 9.) 9/16" Nut | <ol style="list-style-type: none"> 10.) 1/4" Bolt 11.) 1/4" Lock Washer 12.) 1/4" Flat Washer (2) 13.) Welding Current Conductors
(Solid Transformer Wires) 14.) 1/4" Nut 15.) Brass Fitting Nut 16.) Brass Hose Fitting
(Shown Inside the Brass Fitting nut) |
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NOTE: The Spool Gun Plug only fits into the larger opening of the positive terminal stud. Be sure that the black receptacle nut is on the end with the larger opening.

Spool Gun and Control Module need to be installed by qualified personnel.

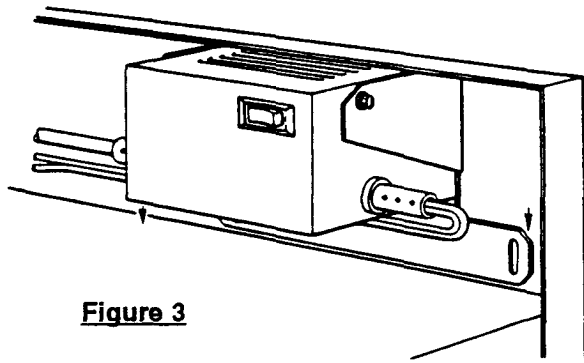


Figure 3

- 8.) Place the new positive terminal through the front panel, and fasten in place using, in order: black insulating washer, 9/16" flat washer, 9/16" lock washer, and the 9/16" brass nut. (See Figure 2). Be sure this is a tight connection.
- 9.) Attach the conductor strap to the positive terminal stud using a 9/16" lock washer and 9/16" nut. (See Figure 2). Be sure this is a tight connection.
- 10.) Connect the welding current conductors (Solid Transformer Wires) to the upper part of the conductor strap using the previously removed 1/4" bolt and 1/4" washer, and the installation kit's 1/4" nut and 1/4" lock washer. (See Figure 2). Be sure this is a tight connection.
- 11.) Insert the brass hose fitting in the brass fitting nut, and screw the brass fitting nut on the positive terminal stud. (See Figure 2). Be sure this is a tight connection.

NOTE: At this point you should have an extra flat washer and the old positive terminal stud which are not needed

B.) THE CONTROL MODULE CONNECTION

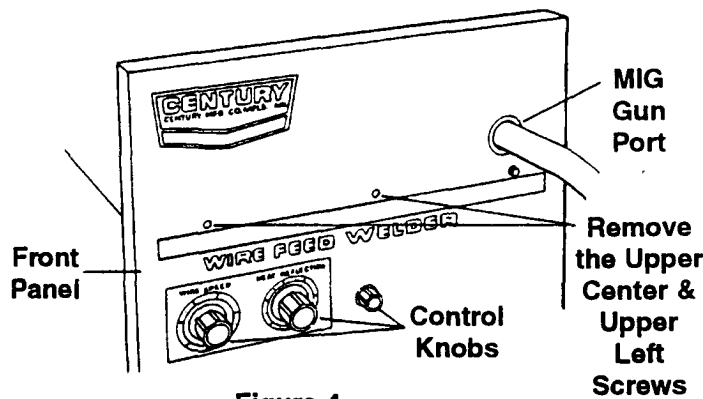


Figure 4

- 1.) Remove the upper left screw and the upper center screw which attach the front panel to the drive deck. (See Figures 1 & 4).
- 2.) Place the control module against the front panel such that the tabs on the control module are down toward the deck. (See Figure 3).
- 3.) Bend the black/red cables under the control module and between the dimples on the bottom of the control module. (See Figure 3).
- 4.) Slide the tabs on the control module between the front panel and the drive deck such that the slots on the tabs are aligned with the holes in the front panel. **NOTE:** The black/red cables should move freely below the control module.

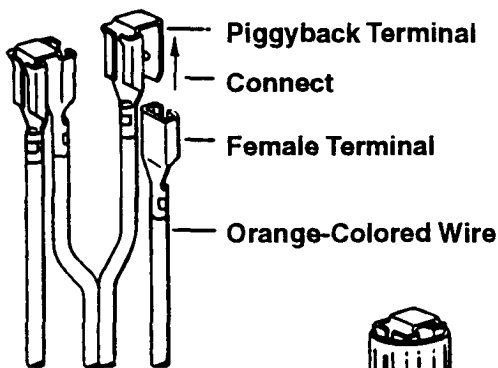


Figure 5

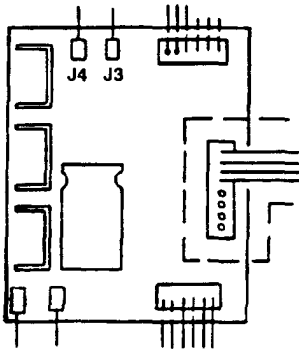


Figure 6

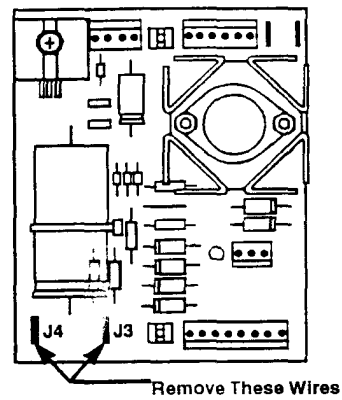
- 5.) Screw the upper left screw and the upper center screw back into the front panel.
- 6.) Disconnect the MIG gun and remove it from the MIG gun port in the front panel.
- 7.) Slide the spool gun connection cable (Gray Cable) through the MIG gun port. (See Figure 1).
- 8.) Slide the MIG gun back through the hole while holding the spool gun connection cable against the side of the port.
- 9.) Reconnect the MIG gun.
- 10.) Push the input cable through the left drive deck port. (See Figure 1, Item 10). **NOTE:** The input cable has 2 piggyback connectors on its ends.
- 11.) Locate the control PC board. (See Figure 1 & 7).

How a connection should look after heat shrink sleeve is applied

Spool Gun and Control Module need to be installed by qualified personnel.



Control Circuit Board A
Figure 7



Control Circuit Board B
Figure 8

- 12.) Locate the orange wires from J3 and J4 on the PC Board A or as indicated on PC Board B, and disconnect them from the control PC Board.
- 13.) Connect each orange wire to one of the piggyback connectors. (See Figure 5).
- 14.) Slide a heat shrink sleeve over the end of each piggyback connector and the orange wires connector. (See Figure 6).
- 15.) Use a heat gun or hair dryer to heat and shrink the heat shrink sleeve in place.
- 16.) Reconnect the piggybacked terminals to J3 and J4 on control PC Board A or as indicated on PC Board B.

C.) THE SHIELDING GAS CONNECTION

- 1.) Slide one end of the kit's 24" long hose over the brass hose fitting connected to the positive terminal stud. Be sure that this is a tight connection.
- 2.) Push the other end of the hose up through the left drive deck port.
- 3.) Slide the 3/16" diameter end of the brass hose coupler into the end of the kit's hose. Be sure that this is a tight connection.
- 4.) Tie the hose to the input cable with a twist tie to prevent hose from sliding back through the left drive deck port.

D.) PREPARING TO WELD WITH THE SPOOLGUN (ALUMINUM WIRE)

- 1.) Disconnect the trigger connection of the MIG gun.
- 2.) Connect the control module's trigger connection to the trigger connection receptacle. (See Figure 1).
- 3.) Remove the gas hose from the MIG gun and connect it to the 1/4" diameter end of the brass hose coupler.
NOTE: If hose is pushed on more than three barbs, it may be difficult to move hose back to the MIG gun at a later time.
- 4.) Mate the 6-pin control receptacle of the spool gun with the 6-pin plug of the control module control cable.
- 5.) Plug the spool gun plug into the positive (DC+) receptacle on the front of the MIG unit.
- 6.) Plug the ground cable plug into the negative (DC-) terminal.
- 7.) Convert the shielding gas to Argon. **NOTE: When using steel wire, check owners manual for appropriate shielding gas.**
- 8.) Turn the Wire Feed control knob to its minimum setting.
- 9.) Release tension from the drive roller so that no pressure is being applied to the MIG unit's drive roller. (See Figure 1).
- 10.) Turn the spool gun control module switch on. The spool gun is now connected. When you are ready to use the MIG gun again, follow step E.

E.) RECONNECTING THE MIG GUN

- 1.) Turn the spool gun control module switch off.
- 2.) Disconnect the trigger connection of the spool gun.
- 3.) Connect the MIG gun's trigger connection.
- 4.) Reapply tension to the drive roller.
- 5.) Disconnect the 6-pin plug from the 6-pin receptacle.
- 6.) Reconnect ground clamp and ground cable to appropriate jacks.
- 7.) Convert to appropriate shielding gas.

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