

**Note:** Teflon tape must be used to make the item 6, gas hose assembly to item 5, robot gas connector and to the wire feeder.

## Step 7

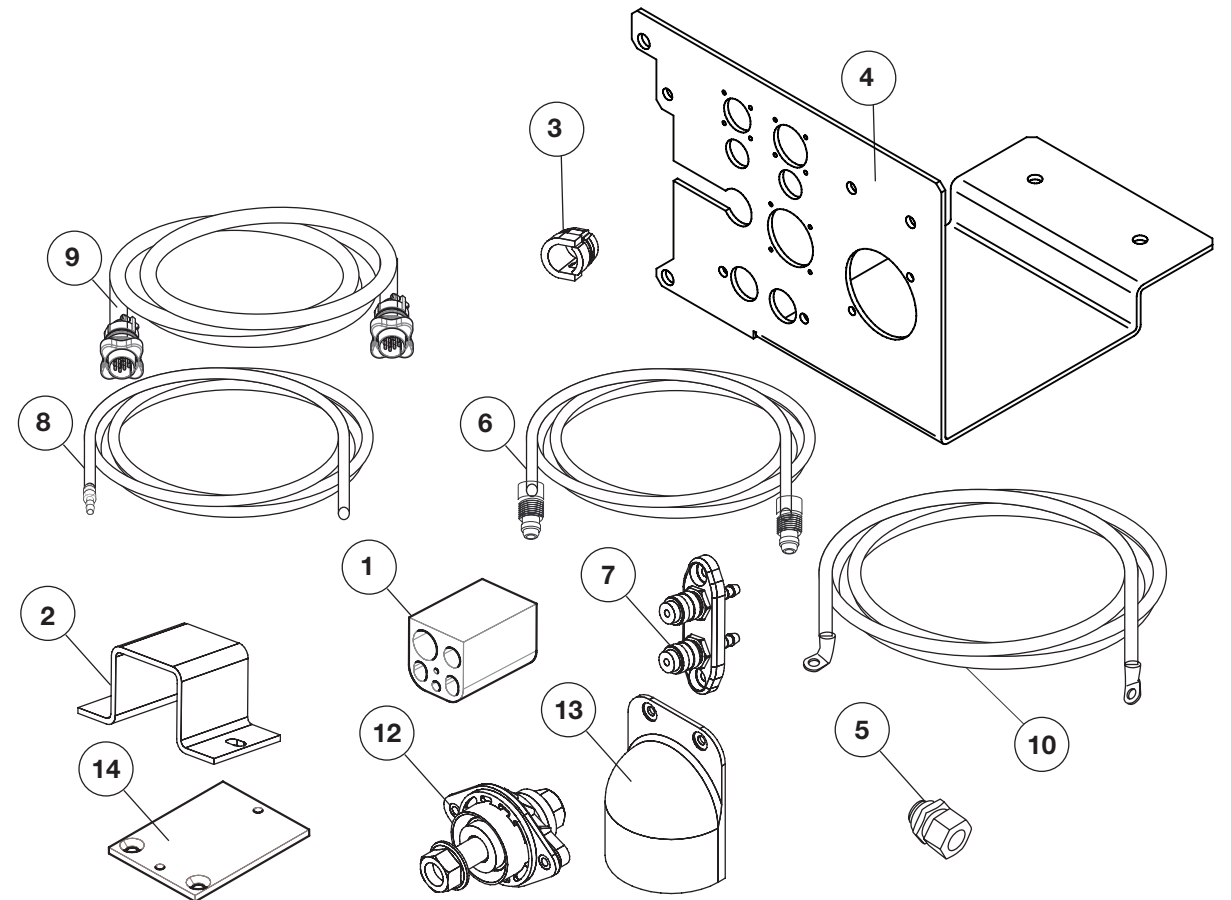
With Hardware J – Examine and bundle the cables and hoses to provide enough clearance from any interference during robot movement.

Tighten all screws and nuts.

Periodically, check the screws and nuts to make sure that they are tightened; and the cables and hoses are not damaged.

Hardware Kit Packages		K4251-MA1440-A & K4251- MA2010-A	
DESCRIPTION	CONTENTS		QTY
Hardware B (item 9 to item 4)	M3x10 Screws		12
Hardware C (item 7 to item 4 and wire feeder)	M4x15 bolt		4
	M4 lock washer		4
	M4 flat washer		8
	M4 nut		4
	Water Hose Clamp		4
Hardware D (item 12 &13 to item 4)	M4x25 bolt		2
	M4 nut		2
	M4 flat washer		2
	M5x16 bolt		2
	M5 nut		2
	M5 flat washer		4
	G 1/2 Bolt		1
	G 1/2 flat washer		2
Hardware E (item 2 to robot)	G 1/2 Nut		1
	M6x20 bolt		8
	M6 flat washer		10
	M6 spring washer		10
	M6x14 flat phillips head screw		2
Hardware G	M6x10 bolt		2
	M8x25 bolt		5
	M8 spring washer		10
	M8 flat washer		10
Hardware J	M8 nut		5
	Black Zip Tie		10
	M5x16 bolt		2
Hardware K (item 4 to Robot base)	M5 spring washer		2
	M5 flat washer		2
	M8x20 bolt		4
Hardware L	M8 spring washer		4
	M8 flat washer		4
	M8 nut		4
Hardware M (For AutoDrive S/SA feeder to feeder bracket, and feeder bracket to arm)	#8-32 x .375 Phillips Pan Head Screw		6
	M4 Oversized Washer		6
	M6 X 1.0 X 12 mm SHCS		4
	M6 lock washer		4
	M8 X 1.25 X 12 mm SHCS		4
	M8 lock washer		4

Select your arm:		K4251-MA1440-A		K4251-MA2010-A	
Item	Description	Part Number	Qty	Part Number	Qty
1	RUBBER CABLE HOLDER	S31678	4	S31678	4
2	CABLE HOLDER BRACKET, TOP	M25431-1	4	M25431-1	4
3	LEAD GROMMET	S27052-2	1	S27052-2	1
4	BULK HEAD BRACKET, B	L16629-18	1	L16629-18	1
5	GAS FITTING	S30266-8	1	S30266-8	1
6	GAS HOSE, UPPER ARM 0.8 M	S30266-22	1	S30266-22	1
7	WATER CONNECTION KIT	S31896	1	S31896	1
8	WATER HOSE [ 3.9M ] - Red & Blue	E4823-19	1	E4823-19	1
9	CONTROL CABLE	M25431-11[3.4M]	1	M25431-12[3.7M]	1
10	POWER CABLE WITH 60 DEGREE BEND	M25439-11[3.5M]	1	M25439-12[3.8M]	1
11	HARDWARE KIT	S30266-21	1	S30266-21	1
12	OUTPUT STUDS	S16656-5	1	S16656-5	1
13	OUTPUT STUDS COVER	M20007	2	M20007	2
14	3rd Axis Cable Holder Bracke, Bottom	L16629-19	1	L16629-19	1



# WARNING



**ELECTRIC SHOCK CAN KILL**

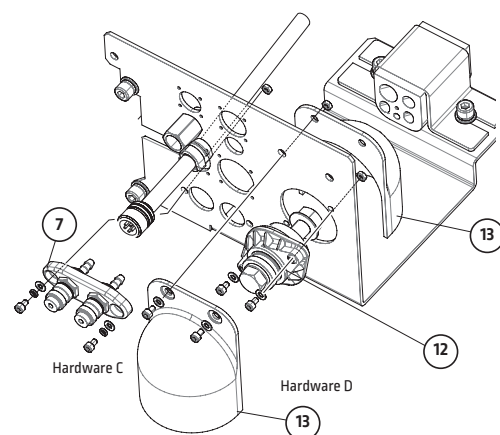


Turn off power to arm and feeder before installing dress out kit. Verify that power is not available to wirefeeder. Only qualified personnel should install Dress Out Kit.

## Step 1

With 1/2 Hardware C – Install item 7 (water connection kit) to item 4 (bulk head bracket B). Trim excess water tubes, if necessary and connect the hoses with connectors.

With Hardware D – Connect the end of the power cable with 60° bend to item 13.

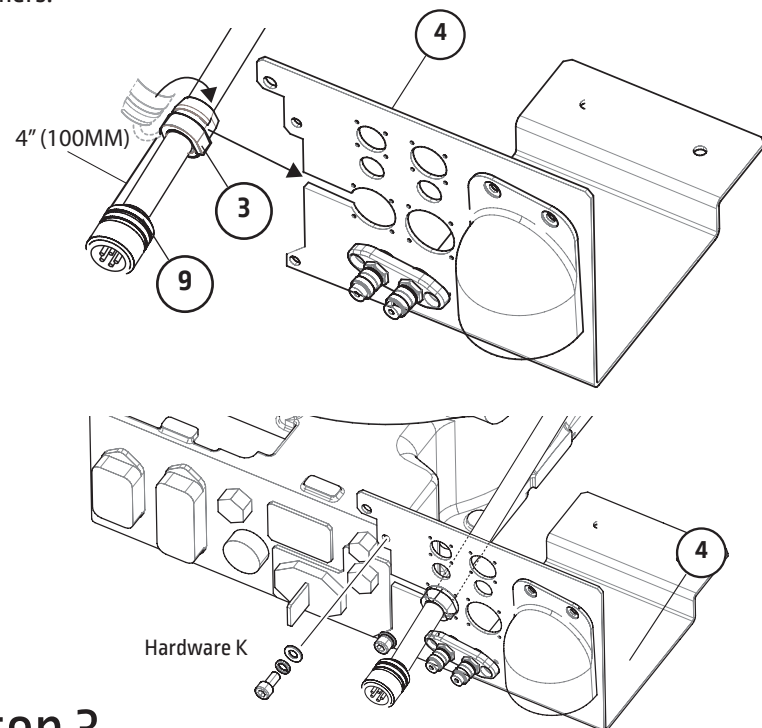


## Step 2

Peel off the masking tape, if it is still on Item 4, Bulk Head Bracket B, to provide good ground connection. With Hardware D and reference to Step 6 drawing, install the output stud, cover, water and gas hardware on the item 4 on bench first.

With Item 3 grommet, anchor Item 9 control cable to Item 4 Bulk Head Bracket B, by slipping the control cable thru the slot on the side of the bracket and clamp the cable using grommet from four inch (100mm) away from connector.

With Hardware K – Install Item 4 to the base of the robot. If any bolts are present, remove them and use the supplied bolts, lock washers and plain washers.



## Step 3

Refer to AutoDrive SA/S Instruction manual to install torch and goose neck through the robot arm.

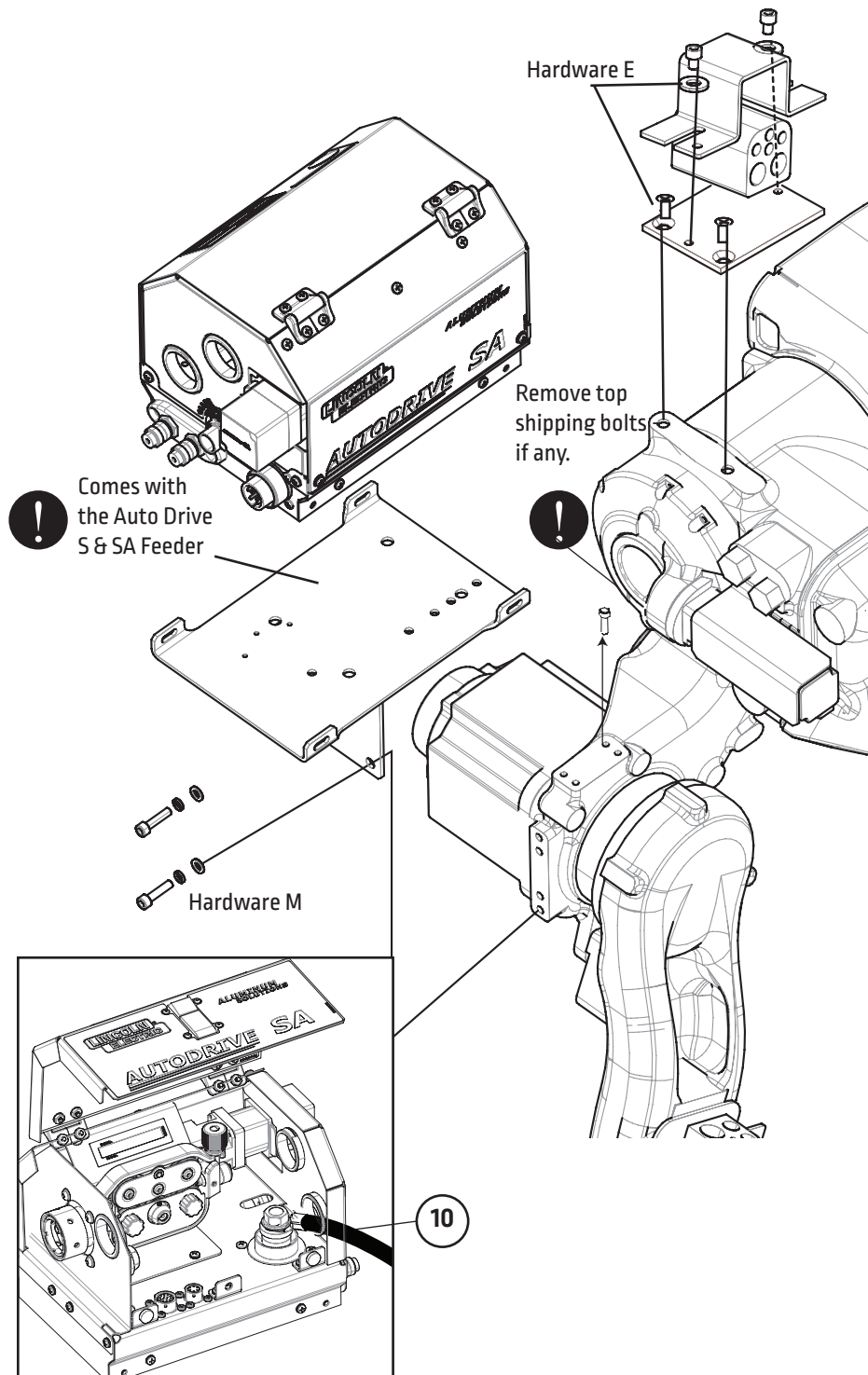
## Step 4

Remove top shipping bolts, if any.

With Hardware M – Mount feeder bracket (comes with the feeder package) to the robot. See illustrations below.

Refer to AutoDrive SA/S instruction manual for connection between the torch and feeder. Connect the flat end of Item 10 (power cable) to inside the feeder with hardware in the feeder. Route the power cable to exit through the back of the feeder.

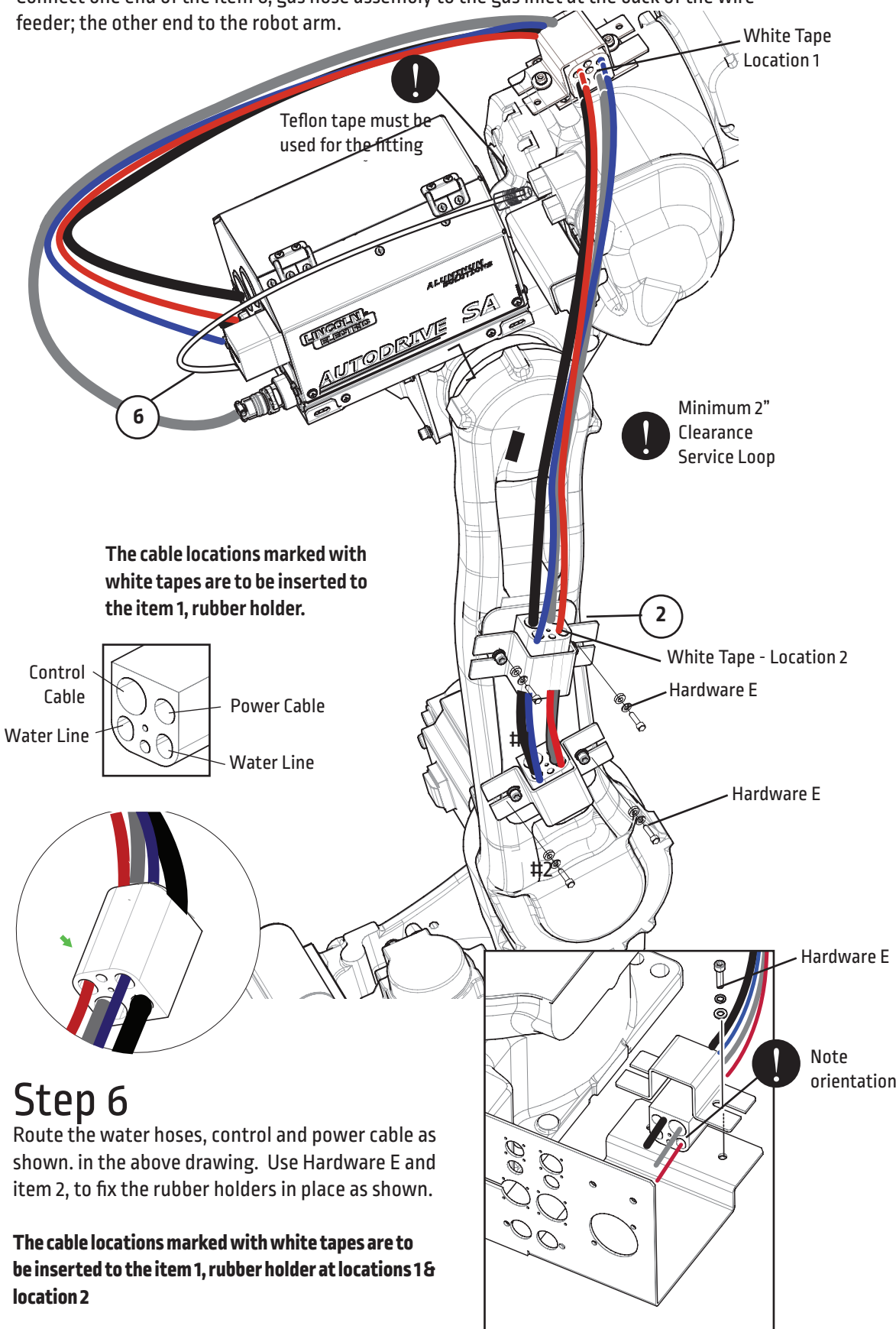
Connect male fitting of item 8 water lines (blue and red) to the water connection inlets at the back of the wire feeder. Connect item 9, the control cable to the back of the feeder.



## Step 5

Orient the power cable and the control cable toward the robot arm. Locate and bundle the cables and hoses with the rubber holders and brackets, so that they can freely move with the robot's motion.

Connect one end of the item 6, gas hose assembly to the gas inlet at the back of the wire feeder; the other end to the robot arm.



## Step 6

Route the water hoses, control and power cable as shown. in the above drawing. Use Hardware E and item 2, to fix the rubber holders in place as shown.

The cable locations marked with white tapes are to be inserted to the item 1, rubber holder at locations 1 & location 2