

MANUAL NO: 1U30022
1U30033



OWNER'S MANUAL
FOR
WIRE FEEDER

MODEL: CM-7402 1U30022
CMW-742 1U30033

DO NOT DESTROY

IMPORTANT: Read and understand the entire contents of this manual, with special emphasis on the safety material throughout the manual, before installing, operating, or maintaining this equipment. This equipment and this manual are for use only by persons trained and experienced in the safety operation of welding equipment. Do not allow untrained persons to install, operate or maintain this equipment. Contact your distributor if you do not fully understand this manual.

DAIHEN Corporation WELDING PRODUCTS DIVISION

December4, 2012

Upon contact, advise MODEL and MANUAL NO.

Notice : Machine export to Europe

This product does not meet the requirements specified in the EC Directives which are the EU safety ordinance that was enforced starting on January 1, 1995. Please make sure that this product is not allowed to bring into the EU after January 1, 1995 as it is.

The same restriction is also applied to any country which has signed the EEA accord.


Please ask us before attempting to relocate or resell this product to or in any EU member country or any other country which has signed the EEA accord.

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1. SAFETY INFORMATION

The following safety alert symbols and signal words are used throughout this manual to identify various hazards and special instructions.


 WARNING	WARNING gives information regarding possible personal injury or loss of life.
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 CAUTION	CAUTION refers to minor personal injury or possible equipment damage.
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2. ARC WELDING SAFETY PRECAUTIONS


 WARNING	
ARC WELDING can be hazardous.	
<ul style="list-style-type: none">● PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. Be sure to:<ul style="list-style-type: none">• Keep children away.• Keep pacemaker wearers away until consulting a doctor.● Read and understand the summarized safety information given below and the original principal information that will be found in the PRINCIPAL SAFETY STANDARDS.● Have only trained and experienced persons perform installation, operation, and maintenance of this equipment.● Use only well maintained equipment. Repair or replace damaged parts at once.	
ARC WELDING is safe when precautions are taken.	


2. ARC WELDING SAFETY PRECAUTIONS (continued)

	ELECTRIC SHOCK can kill.
<p>Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuits are electrically live whenever the output is on. The power line and internal circuits of this equipment are also live when the line disconnect switch is on. When arc welding all metal components in the torch and work circuits are electrically live.</p> <ul style="list-style-type: none">● Do not touch live electrical parts.● Wear dry insulating gloves and other body protection that are free of holes.● Insulate yourself from work and ground using dry insulating mats or covers.● Be sure to disconnect the line disconnect switch before installing, changing torch parts or maintaining this equipment.● Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.● Keep all panels and covers of this equipment securely in place.● Do not use worn, damaged, undersized, or poorly spliced cables.● Do not touch electrode and any metal object if POWER switch is ON.● Do not wrap cables around your body.● When the wire feeder is not in use or the work is interrupted for a long time, shut off the power of all units.● Blow dry air to parts periodically to remove dust and dirt.	

	ARC RAYS can burn eyes and skin: FLYING SPARKS AND HOT METAL can cause injury. NOISE can damage hearing.
<p>Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin.</p> <p>Noise from some arc welding can damage hearing.</p> <ul style="list-style-type: none">● Wear face shield with a proper shade of filter (See ANSI Z 49.1 listed in PRINCIPAL SAFETY STANDARDS) to protect your face and eyes when welding or watching a welder work.● Wear approved safety goggles. Side shields recommended.● Use protective screens or barriers to protect others from flash and glare: warn others not to look at the arc.● Wear protective clothing made from durable, flame-resistant material (wool and leather) and foot protection.● Use approved earplugs or earmuffs if noise level is high. <p>Chipping and grinding can cause flying metal. As welds cool, they can throw off slag.</p> <ul style="list-style-type: none">● Wear approved face shield or safety goggles. Side shields recommended.● Wear proper body protection to protect skin.	

2. ARC WELDING SAFETY PRECAUTIONS (continued)

	WELDING can cause fire and explosion.
<p>Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, spatter, hot base metal, and hot equipment can cause fire and explosion. Accidental contact of electrode or welding wire to metal object can cause sparks, overheating, or fire.</p> <ul style="list-style-type: none">● Protect yourself and others from flying sparks and hot metals.● Do not weld where flying sparks can strike flammable material.● Remove all flammables within 10m (33ft) of the welding arc. If this is not possible, tightly, cover them with approved covers.● Be alert that welding sparks and hot metals from welding can easily pass through cracks and openings into adjacent areas.● Watch for fire, and keep a fire extinguisher nearby.● Be aware that welding on a ceiling, floor, bulkhead, or partition can ignite a hidden fire.● Do not weld on closed containers such as tanks or drums.● Connect base metal side cable as close to the welding area as possible to prevent the welding current from traveling along unknown paths and causing electric shock and fire hazards.● Remove stick electrode from holder or cut off welding wire at contact tip when not in use.● Does not use the welding power source for other than arc welding.● Wear oil-free protective garments such as leather gloves, a heavy shirt, cuffless trousers, boots, and a cap.● A loose cable connection can cause sparks and excessive heating.● Tighten all cable connections.● When there is an electrical connection between a work piece and the frame of wire feeder or the wire reel stand, are may be generated and cause damage by a fire if the wire contacts the frame or the work piece.	

	FUMES AND GASES can be hazardous to your health.
<p>Arc welding produce fumes and gases. Breathing these fumes and gases can be hazardous to your health.</p> <ul style="list-style-type: none">● Keep your head out of the fumes. Do not breathe the fumes.● Ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.● If ventilation is poor, use an approved air-supplied respirator.● Read the Material Safety Data Sheets (MSDS) and the manufacturer's instructions on metals, consumables, coatings, and cleaners.● Do not weld or cut in locations near degreasing, cleaning, or spraying operations. The heat and arc rays can react with vapors to form highly toxic and irritating gases.● Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Shielding gases used for welding can displace air causing injury or death. Be sure the breathing air is safe.	

2. ARC WELDING SAFETY PRECAUTIONS (continued)



CYLINDER can explode if damaged.

A shielding gas cylinder contains high-pressure gas. If damaged, a cylinder can explode.

Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Use only correct shielding gas cylinders, gas regulator, hoses, and fittings designed for the specific application; maintain them in good condition.
- Protect compressed gas cylinders from excessive heat, mechanical shock, and arcs.
- Keep the cylinder upright and securely chained to a stationary support or a rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuit.
- Never touch cylinder with welding electrode.
- Read and follow instructions on compressed gas cylinders, associated equipment, and the CGA publication P-1 listed in **PRINCIPAL SAFETY STANDARDS**.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when gas cylinder is in use or connected for use.
- Do not disassemble or repair the gas regulator except for the person authorized by the manufacturer of them.

WARNING

Be sure to observe the followings for preventing physical injuries, a fire and electric shock.

Handling of plastic parts

Front cover is made of polycarbonate.

Make sure to observe the following notice.


- Do not apply external force and a shock to front cover. Otherwise it maybe broken and in trouble.
- Polycarbonate can endure wiping off with water and alcohol in general but using at a sticking place with an organic solvent, chemicals, cutting oil and atmosphere such as composition oil, it gives bad influence to polycarbonate and it causes a crack (breaking) and a strength down.


If abnormality was discovered such as crack on the front cover, stop operating immediately and ask to repair and change.

WARNING

- Do not alter or remodel our products.
- You may get injured or have your equipment damaged because of fire, failure or malfunction caused by altering or remodeling the product.
- The warranty does not cover any altered or remodeled products.

2. ARC WELDING SAFETY PRECAUTIONS (continued)

	Rotating parts may cause injuries. Be sure to observe the following.
<p>If hands, fingers, hair or clothes are put near the fan's rotating parts or wire feeder's feed roll, injuries may occur.</p> <ul style="list-style-type: none">● Do not use this equipment if the case and the cover are removed.● When the case is removed for maintenance/inspection and repair, certified or experienced operators must perform the work. Erect a fence, etc. around this equipment to keep others away from it.● Before touching rotating parts for maintenance, inspection and repair, shut off the welding power.● Do not put hands, fingers, hair or clothes near the rotating fans or wire feed roll.	

	ARC WELDING work areas are potentially hazardous.
<p>FALLING or MOVING machine can cause serious injury.</p> <ul style="list-style-type: none">● When hanging the welding power source by a crane, do not use the carrying handle.● Put the welding power source and wire feeder solidly on a flat surface.● Do not pull the welding power source across a floor laid with cables and hoses.● Do not put wire feeder on the welding power source.● Do not put the welding power source and wire feeder where they will pit or fall. <p>WELDING WIRE can cause puncture wounds.</p> <ul style="list-style-type: none">● Do not press gun trigger until instructed to do so.● Do not point gun toward any part of the body, other people, or any metal when threading welding wire.	

PRINCIPAL SAFETY STANDARDS

Arc welding equipment – Installation and use, Technical Specification IEC 62081, from International Electro technical Commission

Arc welding equipment Part 1: Welding power sources IEC 60974-1, from International Electro technical Commission

Safety in Welding and Cutting, ANSI Standard Z49.1, from American Welding Society.

Safety and Health Standards, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office.

Recommended Practices for Plasma Arc Cutting, American Welding Society Standard AWS C5.2, from American Welding Society.

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, American Welding Society Standard AWS F4.1, from American Welding Society.

National Electrical Code, NFPA Standard 70, from National Fire Protection Association.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association.

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales.

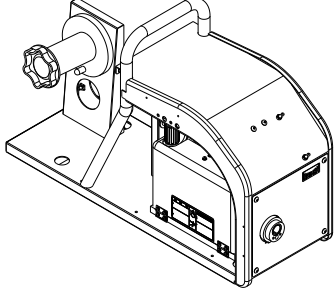
Safe Practices For Occupation And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute.

Cutting And Welding Processes, NFPA Standard 51B, from National Fire Protection Association.

NOTE: The codes listed above may be improved or eliminated. Always refer to the updated codes.

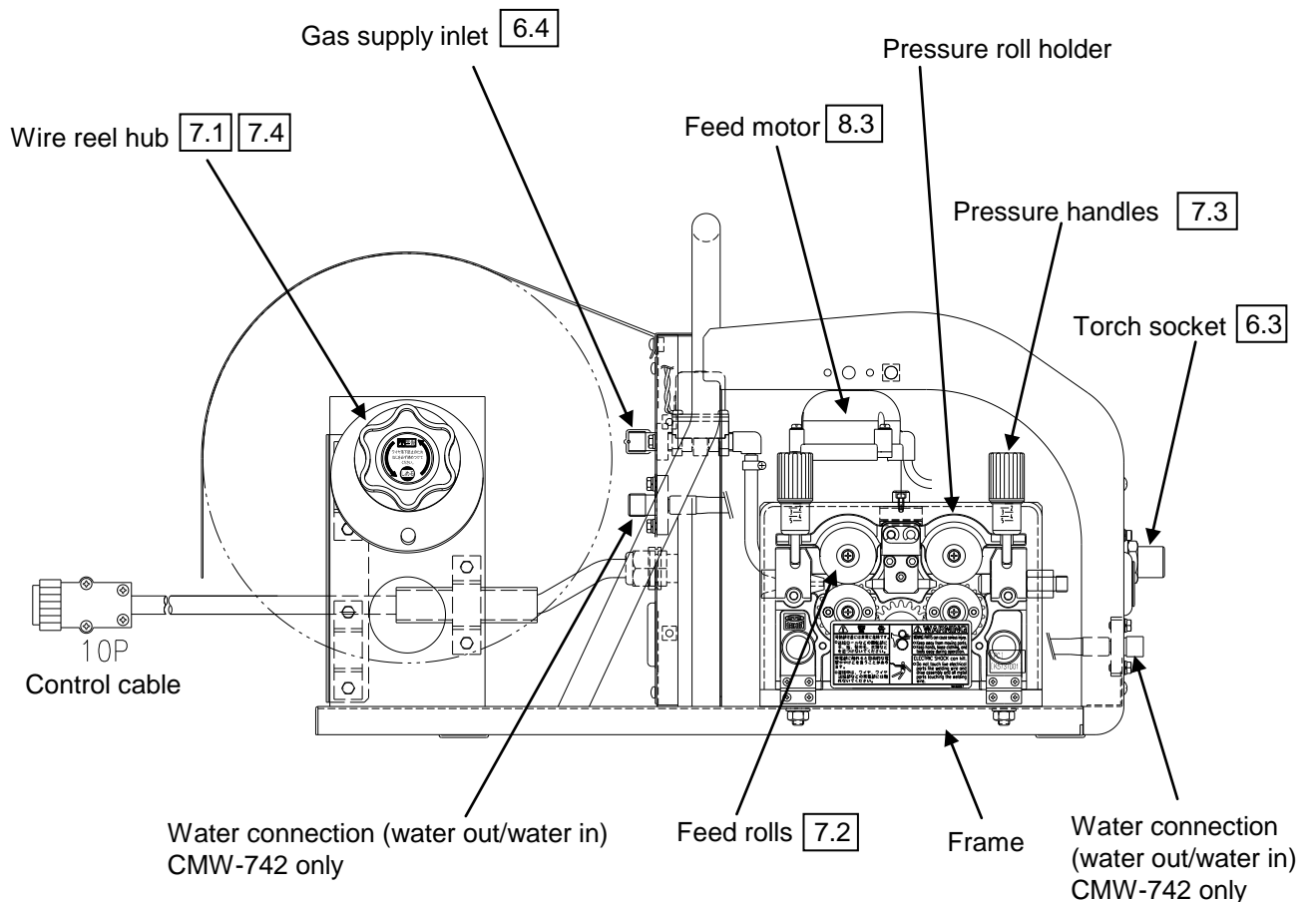
3. CHECKING OF QUANTITY OF THE ACCESSORIES

Check the quantity of parts when opening the package.

Wire feeder		Accessory			
	No.	Description	Specification	Quantity	
				CM-7402	CMW-742
	①	Gas hose (3m)	K5430A00	1	1
	②	Hose cover	U1997C03	1	1
	③	Hose cover	U30033L01	—	1
	④	Water hose	U2879J00	—	2
	⑤	Label	NK9071	1	1
⑥	MANUAL	4-1-076	1	1	




4. NAMES OF PARTS

Refer to the section indicated in □ for details.







5. CARRYING AND INSTALLING OF THE WIRE FEEDER

5.1 Transportation

 WARNING	
Observe the following to avoid damage to the wire feeder or physical injury when carrying the equipment.	
	<ul style="list-style-type: none"> ● Do not touch the charging parts inside or outside the wire feeder. ● Disconnect the wire feeder from the welding power source by turning off the line disconnect switch in the power box to avoid an electric shock before carrying the equipment.
	<ul style="list-style-type: none"> ● Be sure to detach the wire reel from the wire feeder before lifting the equipment to the high places by a crane.

5.2 Installation

 WARNING	
When installing the wire feeder, follow the instructions below to avoid occurrence of fires during welding and physical damage by fume gas.	
	<ul style="list-style-type: none"> ● Do not place the welding machine near combustible materials and flammable gas. ● Remove combustible materials to prevent dross coming into contact with combustible objects. If that not possible, cover them with noncombustible covers.
	<ul style="list-style-type: none"> ● To avoid gas poisoning and danger of suffocation, wear a gas mask or adequately ventilate when using the welding machine in the place regulated by a local law. ● To prevent disorder or poisoning caused by fume, wear a gas mask or weld at a partial exhaust facility approved by the local regulation. ● Adequately ventilate or wear a gas mask when using the welding machine in a tank, a boiler, a hold of a ship, because heavier gas such as carbon dioxide or argon gases are drifting there. ● When using the welding machine at a narrow space, comply with a trained supervisor's directions. And be sure to wear a gas mask. ● Do not operate the welding machine near the place where degreasing, cleansing, and spraying are performed. Otherwise, poisonous gas may be generated. ● Be sure to wear a gas mask or adequately ventilate when welding a coating steel plate. (Poisonous gas and fume may be generated.) ● Do not place the welding power source, wire feeder, torch, and control cable (including the extension cable) in an area where the equipment can become wet.

 CAUTION	
Follow the instructions below when selecting an installation place for the wire feeder.	
<ul style="list-style-type: none"> ● Do not install in areas exposed to direct sunlight and rain. ● Do not place the welding power source, wire feeder, torch, and control cable (including the extension cable) in an area where the equipment can become wet. ● Install the wire feeder in the place where is altitude below 1,000m and the ambient temperature is between -10 °C and +40 °C (+14 °F and +104 °F). ● Install a wind shield to protect arc from wind. ● Fix the gas cylinder to a stand specifically made for gas cylinders. 	

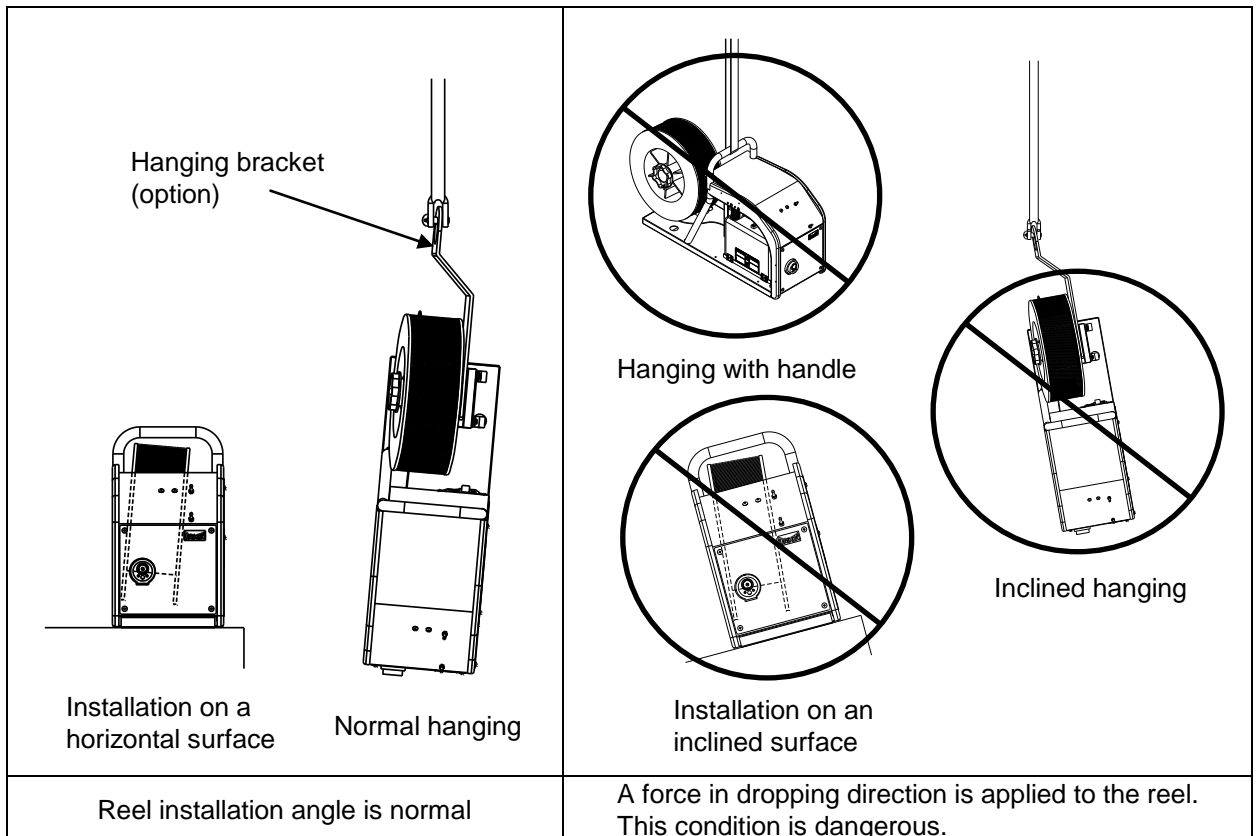
5. CARRYING AND INSTALLING OF THE WIRE FEEDER(continued)





WARNING

When using the wire feeder at a high place or in hung condition, observe the following precautions to prevent serious personal injury due to fallen wire feeder or wire reel.

- For hanging the wire feeder, use a metal hanger structured to prevent falling and hang the wire feeder in a safe and secure manner.
- When hanging the wire feeder, use the hanging bracket (optional bracket of part number U30022Z00).
- Do not hang the wire feeder using the handle of the wire feeder as shown in the diagram below.
- Do not install or hang the wire feeder in a posture, resulting in falling of the reel as shown in the diagram below.
- When installing the wire feeder at a high place, be sure to install and secure it on a horizontal surface.



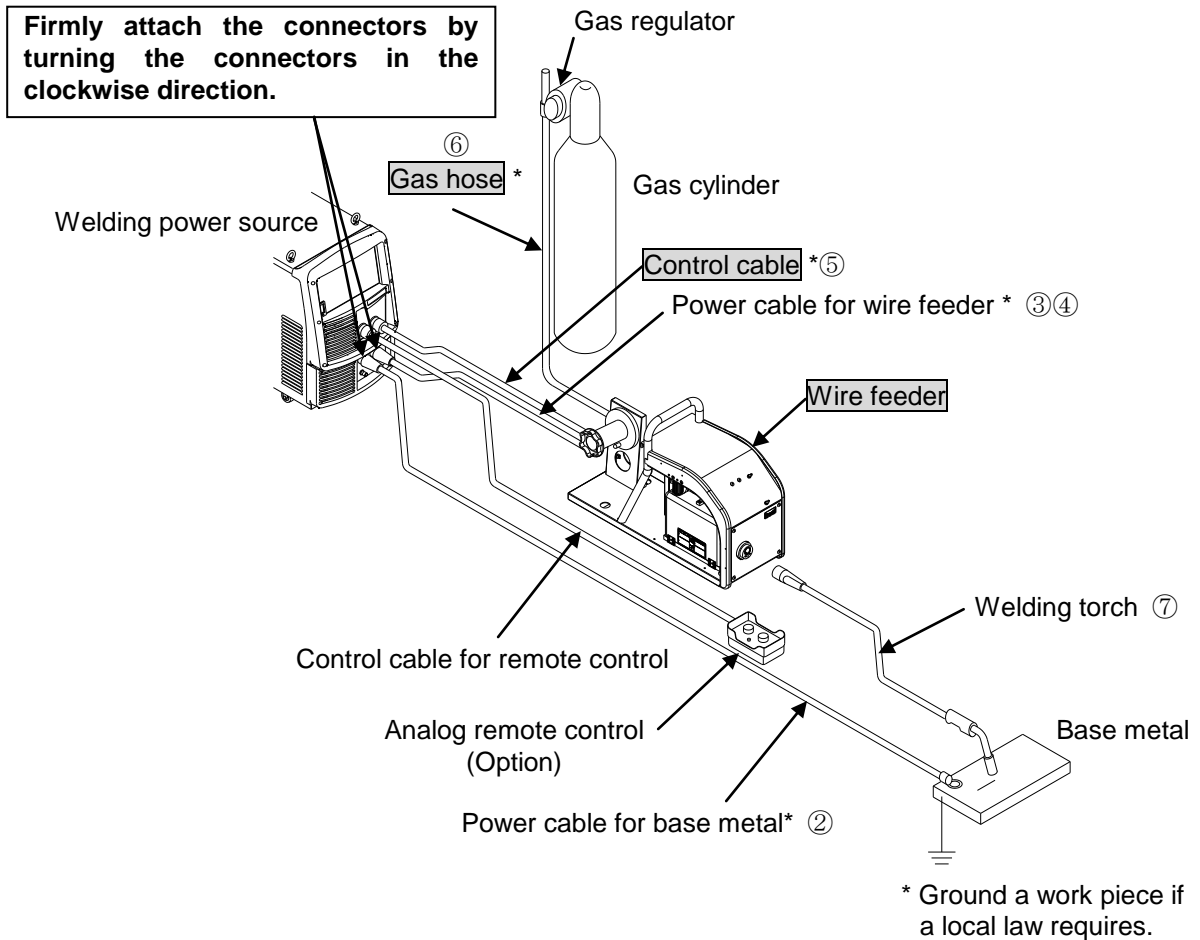
6. CONNECTION PROCEDURE


 CAUTION	
	Follow the instructions below to avoid electric shock.
<p>Do not touch live electrical parts, as this may cause in fatal shock and severe burns.</p> <ul style="list-style-type: none">● Do not touch live electrical parts of the welding machine.● Have a qualified electric engineer ground the case of the welding power source and the base metal or jig electrically connected, following a local law.● Disconnect the wire feeder from the welding power source by turning off the line disconnect switch in the power box to avoid an electric shock before grounding the welding power source or base metal and connecting the cables or hoses.● Do not use a cable with lack of capacity or a damaged cable.● Tighten and insulate the connections of cables.● Firmly attach the cover of the welding machine after connection of the cables.● Do not place the welding power source, wire feeder, torch, and control cable (including the extension cable) in an area where the equipment can become wet.● Insulate connected part of the bolt and the nut with the insulating tape surely after it tightens enough.	

6. CONNECTION PROCEDURE(continued)

6.1 Connection to the Welding Power Source and to the Gas regulator

- For air cooling torch (CM-7402)



NOTE: Standard composition consists of the parts indicated in . Preparation of the parts except the standard composition is required to use the wire feeder.

*Available in 5m, 10m, 15m, and 20m. (Control cable and Gas hose)

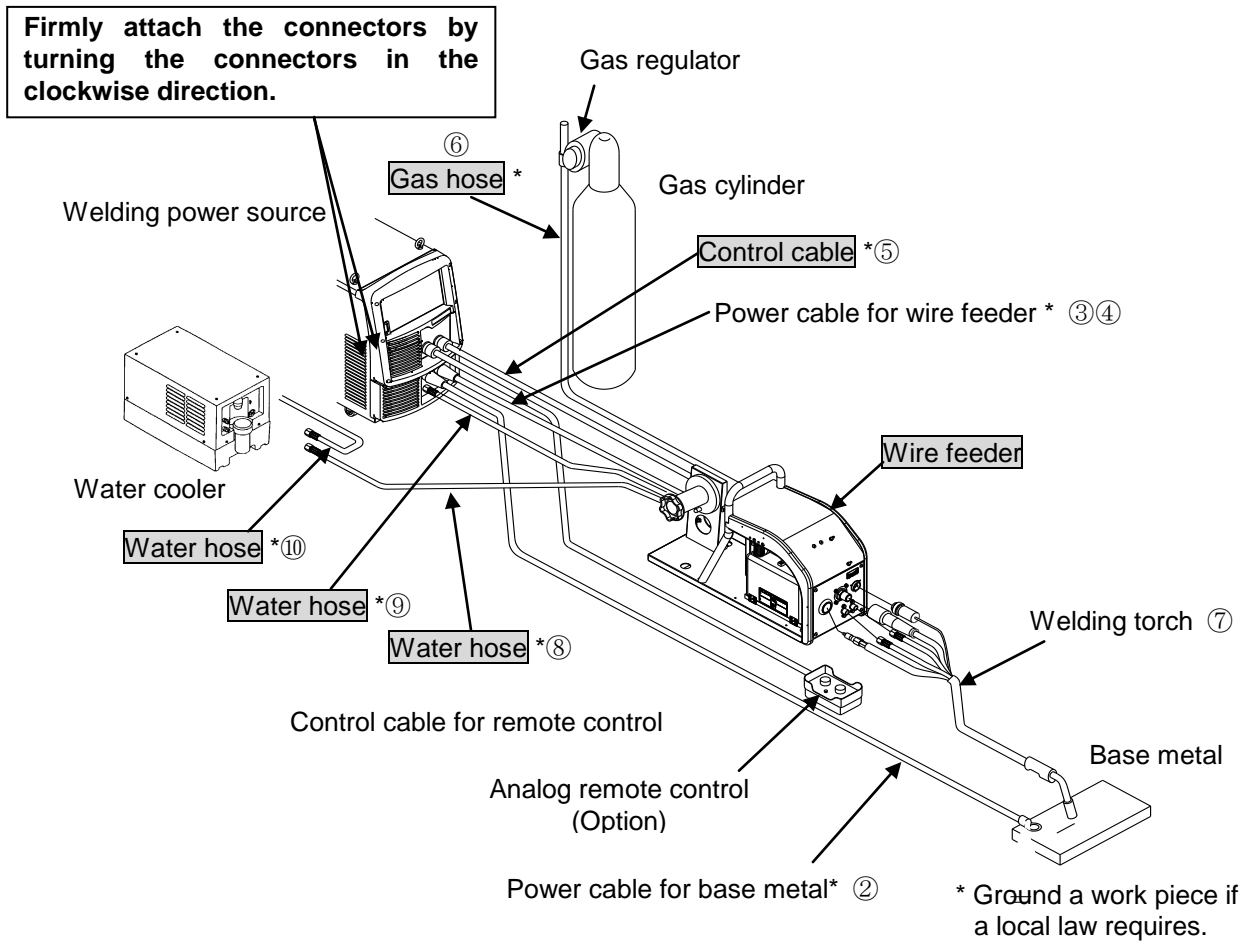
Available in 2m, 7m, 12m, 17m and 22m. (Power cable)

Follow the steps below for the connection of the welding power source and the wire feeder.

1. Ground the base metal (if required by local laws or codes).
2. Connect the power cable for base metal between the negative output terminal and the base metal.
3. Attach the power cable for wire feeder to the positive output terminal.
4. After removing the right-side plate of the wire feeder, attach the power cable for wire feeder to the power terminal block. (refer 6.2 for details)
5. Connect the control cable for the wire feeder (10P) into the wire feeder socket on the welding power source.
6. Attach the gas hose to the gas supply inlet on the back side of the wire feeder. (refer 6.4 for details)
7. Connect the welding torch to the wire feeder. (refer 6.3 for details)

6. CONNECTION PROCEDURE(continued)

- For air cooling torch (CMW-742)



NOTE: Standard composition consists of the parts indicated in . Preparation of the parts except the standard composition is required to use the wire feeder.


*Available in 5m, 10m, 15m, and 20m.


Follow the steps below for the connection of the welding power source and the wire feeder.

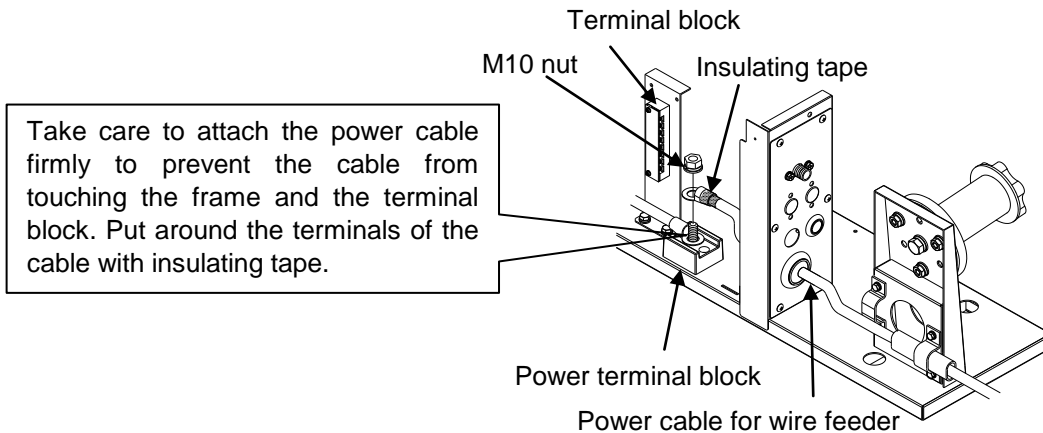
1. Ground the base metal (if required by local laws or codes).
2. Connect the power cable for base metal between the negative output terminal and the base metal.
3. Attach the power cable for wire feeder to the positive output terminal.
4. After removing the right-side plate of the wire feeder, attach the power cable for wire feeder to the power terminal block. (refer 6.2 for details)
5. Connect the control cable for the wire feeder (10P) into the wire feeder socket on the welding power source.
6. Attach the gas hose to the gas supply inlet on the back side of the wire feeder. (refer 6.4 for details)
7. Connect the welding torch to the wire feeder. (refer 6.3 for details)
8. Connect the water hose to water connection (water out) of the wire feeder back side, and to water connection (water in) of the water cooler.
9. Connect the water hose to water connection (water in) of the wire feeder back side, and to water connection (water out) of the front side of the welding power source.
10. Connect the water hose to water connection (water out) of the water cooler, and to water connection (water in) of the back side of the welding power source.

6. CONNECTION PROCEDURE(continued)


6.2 Connecting of the Power Cable for Wire Feeder

 WARNING
<p>Touching live electrical parts may cause in fatal electric shock and severe burns.</p> <ul style="list-style-type: none"> ● Do not touch live electrical parts of the welding machine. ● Have a qualified electric engineer ground the case of the welding power source and the base metal or jig electrically connected in accordance with a local law. ● Disconnect the wire feeder from the welding power source by turning off the line disconnect switch in the power box to avoid an electric shock before the welding power source or base metal and connecting the cables or hoses. ● After connecting the cables, cover the power source with the cover or case. ● When using the welding machine in such a humid environment as construction site, on the steel plate, or on steel structure, install a leakage breaker.

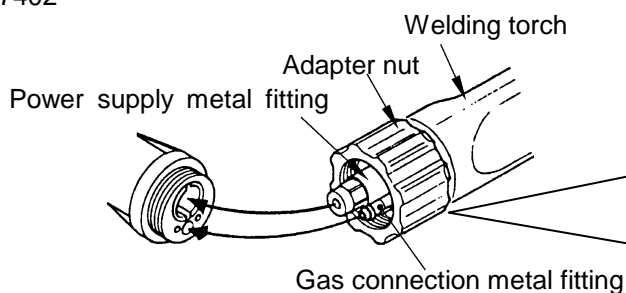
 CAUTION								
<p>● Use the proper power cable that matches the welding current.</p> <table border="1" style="margin-left: auto; margin-right: auto; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">Applicable current (Rated current)</th> <th style="text-align: center;">Cable thickness</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">200 A</td> <td style="text-align: center;">38mm² or more</td> </tr> <tr> <td style="text-align: center;">350 A*</td> <td style="text-align: center;">60mm² or more</td> </tr> <tr> <td style="text-align: center;">500 A</td> <td style="text-align: center;">80mm² or more</td> </tr> </tbody> </table> <p>When performing pulse welding using the welding power source with 350 A applicable current and a 17m or more cable, use the thicker cable by one rank.</p>	Applicable current (Rated current)	Cable thickness	200 A	38mm ² or more	350 A*	60mm ² or more	500 A	80mm ² or more
Applicable current (Rated current)	Cable thickness							
200 A	38mm ² or more							
350 A*	60mm ² or more							
500 A	80mm ² or more							



6.3 Connecting of the Welding Torch

 CAUTION
<p>● Ensure that the torch connector is firmly attached. If the connector is not fully inserted, there may be a risk of fire, burns, and product damage.</p>

• For CM-7402

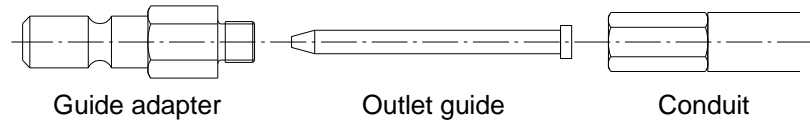


Before connecting a wire feeder to a welding torch, make sure that the feed metal and gas connection metal are inserted into the welding torch until restricted and that the adapter nut is properly inserted into the welding torch. (Forcible insertion of the adapter nut may cause in damage to the threads of the metals.)

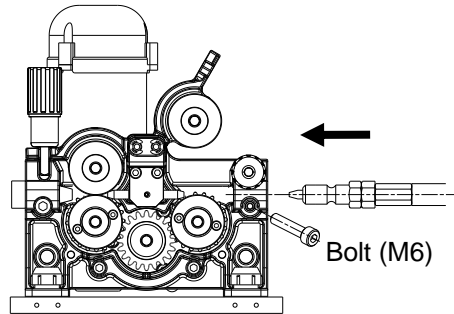
6. CONNECTION PROCEDURE(continued)

• For CMW-742

(1) After removing guide adapter from the wire feeder, insert the outlet guide into the guide adapter. Then attach this to the torch conduit. Use the suitable outlet guide for using wire size.



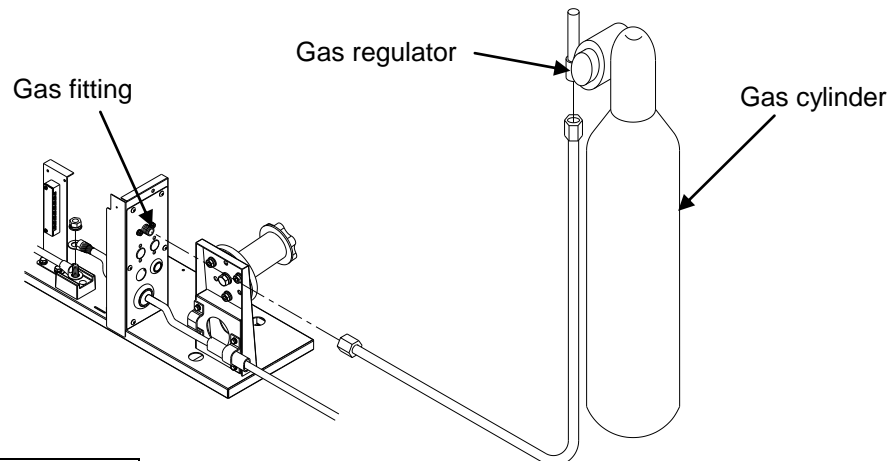
(2) Insert the guide adapter into the place where it was, and fasten it with bolt.



6.4 Connecting of the Gas Hose

! WARNING	
	<ul style="list-style-type: none"> ● You may suffer from danger of suffocation caused by lack of oxygen when shield gas keeps drifting in a closed place. Be sure to turn off the shield gas at the main when the welding power source is not in use.

! WARNING	
<ul style="list-style-type: none"> ● Be sure to connect the gas hose after fixing to the stand, as physical injuries may cause from falling down of gas cylinder. ● Attach a proper gas regulator to the gas cylinder. Failure to observe the demand may cause in physical injuries. The gas regulator for high pressure gas must be used. 	



How to Make Gas Connection

1. Firmly connect the gas hose to the gas supply inlet located on the rear side of the wire feeder.
2. Mount the gas regulator on the gas cylinder by tightening the nut for attaching the gas cylinder .
3. Connect the gas hose to the gas supply outlet on the gas regulator.

NOTE: Firmly tighten the nuts using a monkey wrench, etc. to connect the gas hose and gas regulator.

7. WELDING PREPERATION

7.1 Fitting of Wire

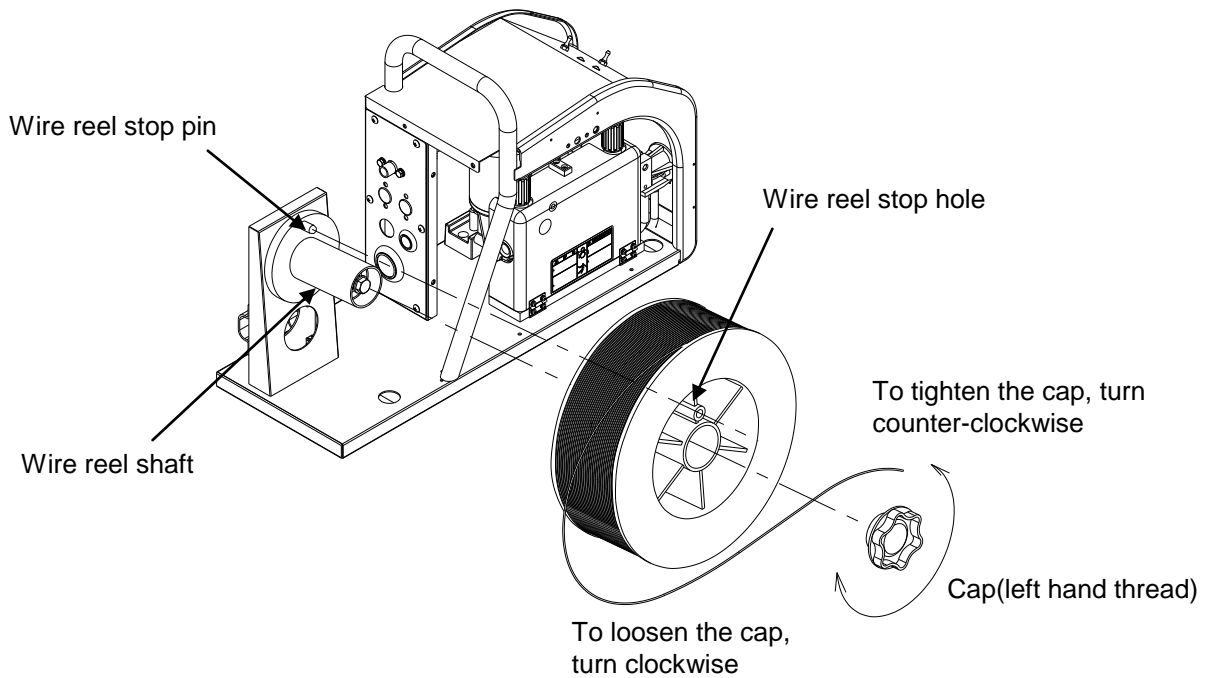
WARNING

- When the wire is set on the wire reel shaft, fully tighten the cap to prevent falling.
- In case a breakage, crack or deformation is found in the wire reel shaft or cap, do not use but replace it.

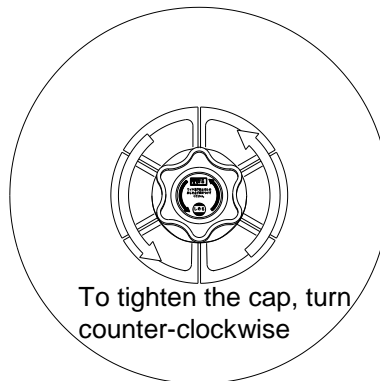
Fitting of Wire

1. Turn the cap clockwise to loosen it.
2. Detach the cap from the wire reel shaft.
3. Mount the wire reel on the wire reel shaft.

NOTE: When installing the wire reel shaft, be sure to insert the stopper pin of the wire reel shaft into the wire reel stopper pin hole.

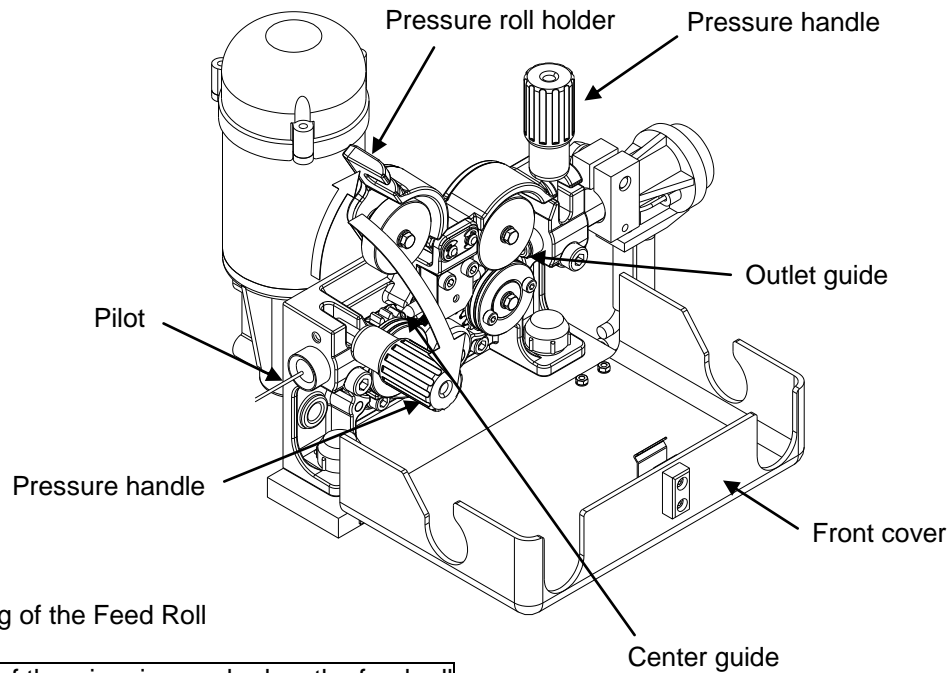


4. Turn the cap counter-clockwise to tighten it.



7. WELDING PREPERATION(continued)

5. Open the front cover.
6. Bring down the pressure handle, then raise the pressure roll holder.
7. After pulling out the wire, thread it from the pilot to outlet guide through the center guide.
8. Return the pressure reel holder first, the pressure handle.
9. Close the front cover.



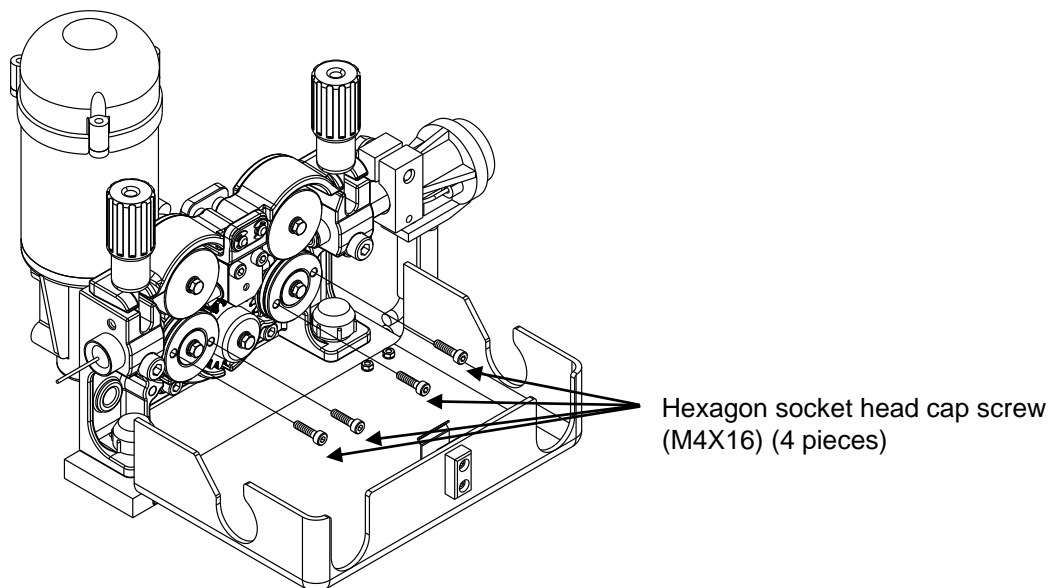
7.2 Mounting of the Feed Roll

Confirming of the wire size marked on the feed roll

1. Use the proper feed roll for the wire size.
2. The feed roll of ϕ 1.2 wire size is mounted.

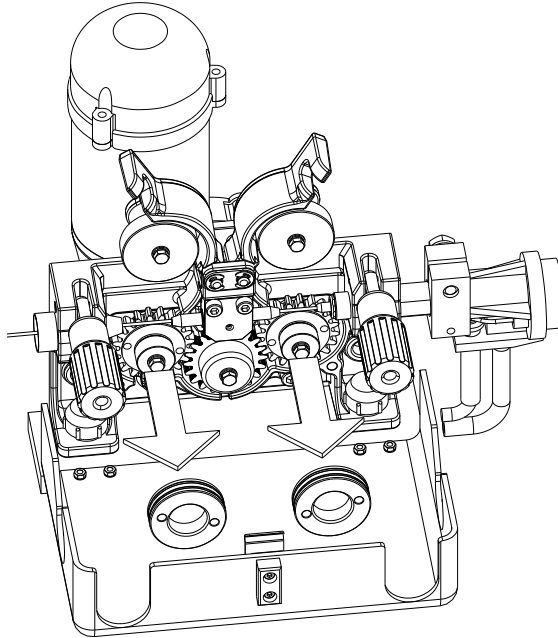
Replacing of the feed roll

1. Open the front cover.
2. Remove the hexagon socket head cap screw (M4x16) (2 pieces per roll) fixing the feeder roll.

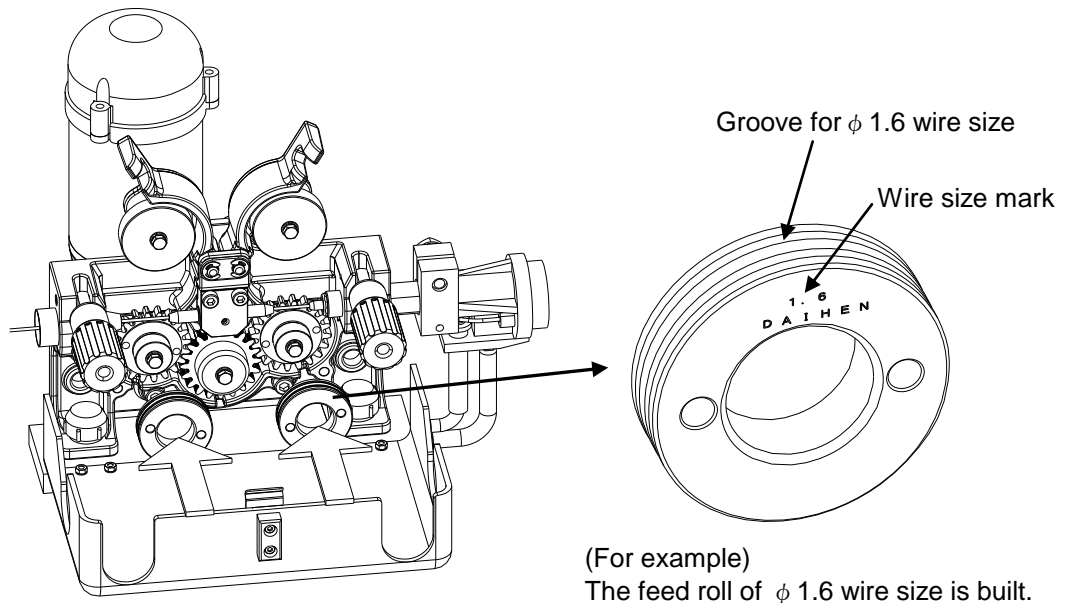


7. WELDING PREPERATION(continued)

3. Bring down the pressure handle, then raise the pressure roll holder.
4. Separate the feed roll from the wire feeder by pulling out the feed roll toward you.



5. Mount the feed roll, with the wire size marked on the wire feeder facing out.



6. Tighten the hexagon socket head cap screw (M4X16) (2 pieces per roll) to fix the feeder roll.
7. Close the front cover.

7. WELDING PREPERATION(continued)


7.3 Adjusting of the wire pressure

Set to the proper wire pressure for the wire type by turning the pressure handle.
The numeral on the pressure scale set with the right pressure handle should be correspond to the one set with the left pressure handle.

Recommended wire pressure adjustment		
Wire diameter	Wire pressure scale	
	Solid wire	Flux cored wire
ϕ 1.6, ϕ 2.0	4 ~ 5	3 ~ 4
ϕ 1.2, ϕ 1.4	3 ~ 4	2 ~ 3
ϕ 0.9, ϕ 1.0	2 ~ 3	
ϕ 0.8	1 ~ 2	

7.4 Adjusting of the wire reel hub

After performing inching operation, take care to adjust the brake of the wire reel hub to prevent the wire from going too slack. The bake has been properly adjusted before shipment. Therefore, readjustment of the brake is not required for welding in standard welding conditions.

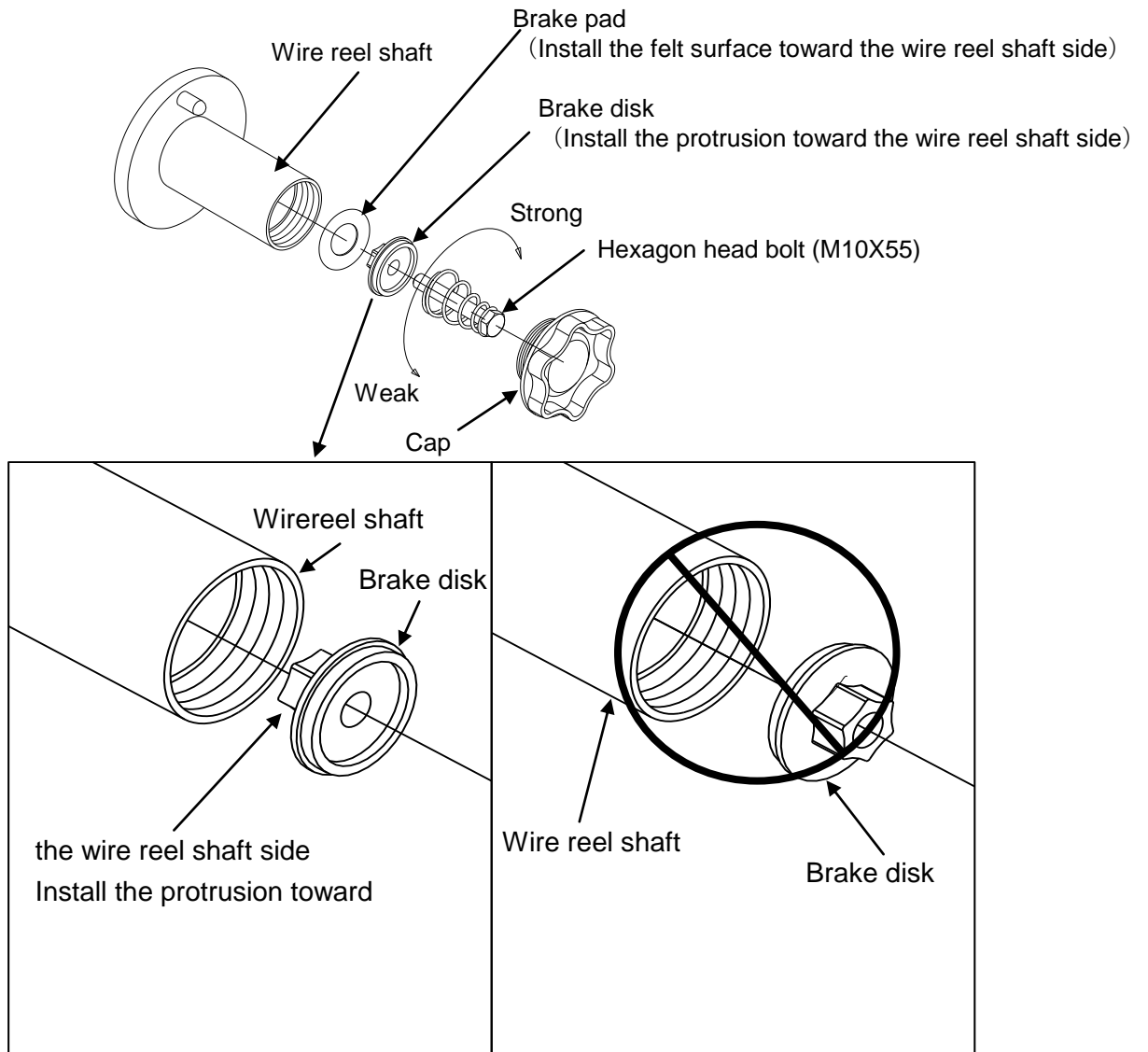
 WARNING
<p>Observe the following precautions to prevent serious personal injury caused by fall of the wire reel at the time of wire reel hub adjustment or hanging bracket installation.</p> <ul style="list-style-type: none"> ●Mount the brake pad to the wire reel shaft as illustrated below with care placed to the mounting direction. ●Mount the brake disk to the wire reel shaft as illustrated below with care placed to the mounting direction. ●In the event that the brake pad and the brake disk are used in wrong directions, the hexagon head bolt comes loose due to rotations of the wire reel shaft and may fall together with the wire reel shaft.

7. WELDING PREPERATION(continued)

How to adjust the wire reel hub





1. Detach the cap knob from the wire reel shaft.
2. Adjustment of the brake can be achieved by turning the hexagon bolt (M10).

If the brake pad and brake disk are disengaged by mistake, assemble them by referring to the diagram below.



7. WELDING PREPERATION(continued)

7.5 Feeding Wire Feeding by Performing Inching Operation

 WARNING	
	● Do not look into the tip hole to check for the rate of wire feeding while inching.
 CAUTION	
	● Keep away your hands, fingers, hair or clothes from the rotating parts of the feed roll, etc. to prevent you from being caught into the rotating parts while inching.

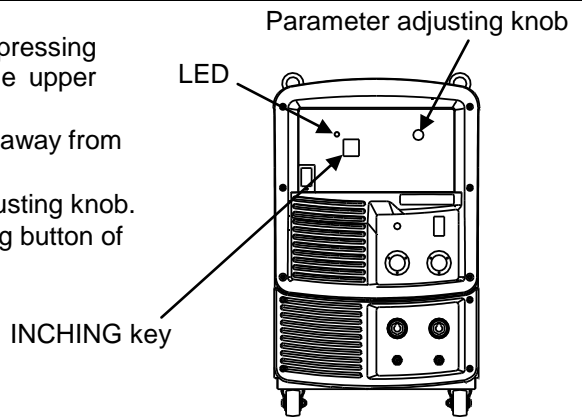
After straightening the welding torch, feed the wire by pressing the INCHING key. (the INCHING lamp located at the upper right of the INCHING key lights up).

Release the inching key when the wire is about 10mm away from the end of the tip. (LED goes out)




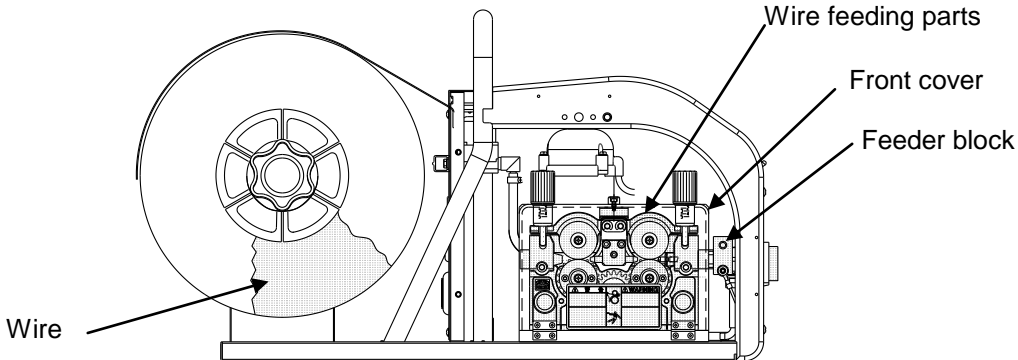
Wire feed rate can be adjusted with the parameter adjusting knob. In addition, operation can also be made with the inching button of the remote controller (optional accessory).

In this case, adjustment can be made with the current knob of the remote controller.


Adjustment cannot be made with the parameter adjusting knob of the front panel.



7. WELDING PREPERATION (continued)

 WARNING	
Touching the charging parts may cause fatal electric shocks and burns.	
	<ul style="list-style-type: none">● Never touch live electrical parts in the wire, wire feeder and feeder block. The parts indicated as  in the figure are the charging parts during welding.● Be sure to close the front cover of the wire feeding section to prevent electric shock and fingers from being caught in the wire feeder. Replace the damaged cover with a new one. Do not use the wire feeder with the front cover removed.
	

7.6 Hanging the Wire Feeder

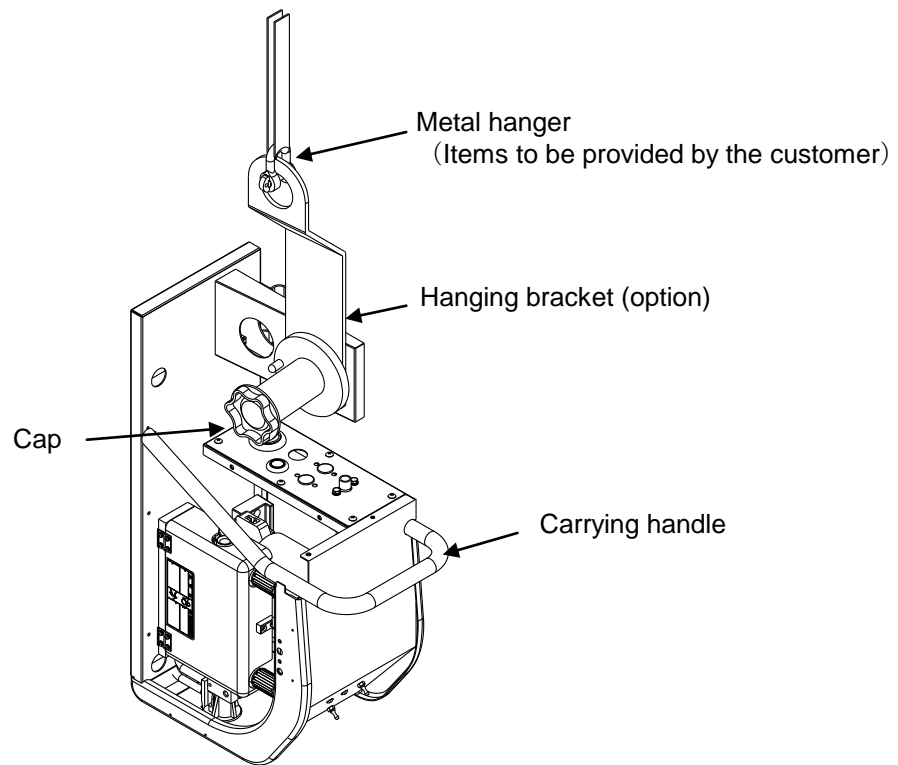
 WARNING	
Be sure to observe the following to prevent serious personal injury.	
<ul style="list-style-type: none">● When hanging the wire feeder, firmly fix the cap knob and clamp screw in position to prevent the device from dropping.● Do not use the carrying handle of the wire feeder to hang the wire feeder.● When hanging the wire feeder, use the hanging bracket (optional bracket of part number U30022Z00).● Prevent unauthorized persons from entering the area of welding machine and welding work.● Tighten the nut section with flat washer and spring washer.● Tighten bolts and nuts to the tightening torque stated on this sheet and check the tightening torque 60. every 3 months.● Check for deformation and damage of bolts and nuts after use and replace if you found any abnormality.	

*Use a metal hanger structured to prevent it from coming off due to swinging, etc.

*Inspect the metal hanger and hanging bracket daily and ensure that they are free from abnormal conditions.

*When using the hanging bracket, be sure to observe the precautions of the instruction manual of the hanging bracket.

7. WELDING PREPERATION (continued)



7. WELDING PREPERATION (continued)

How to attach the hanging bracket

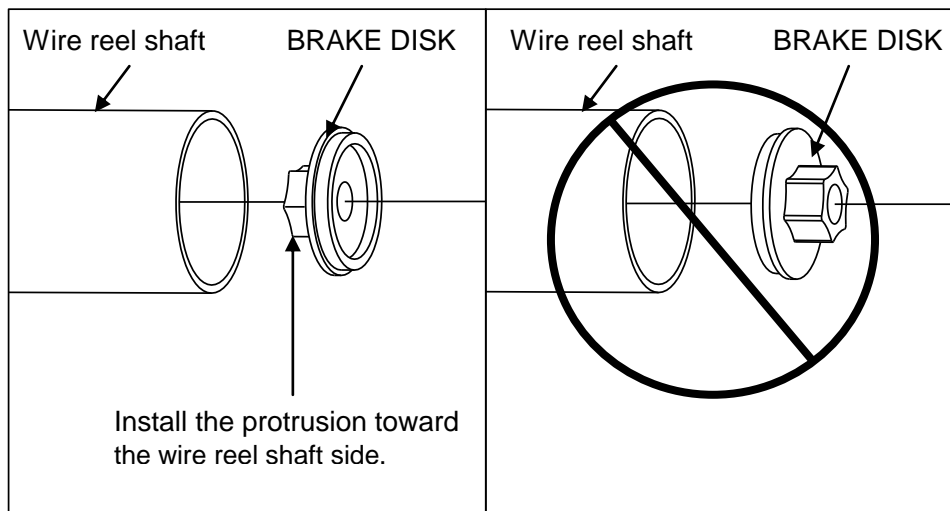
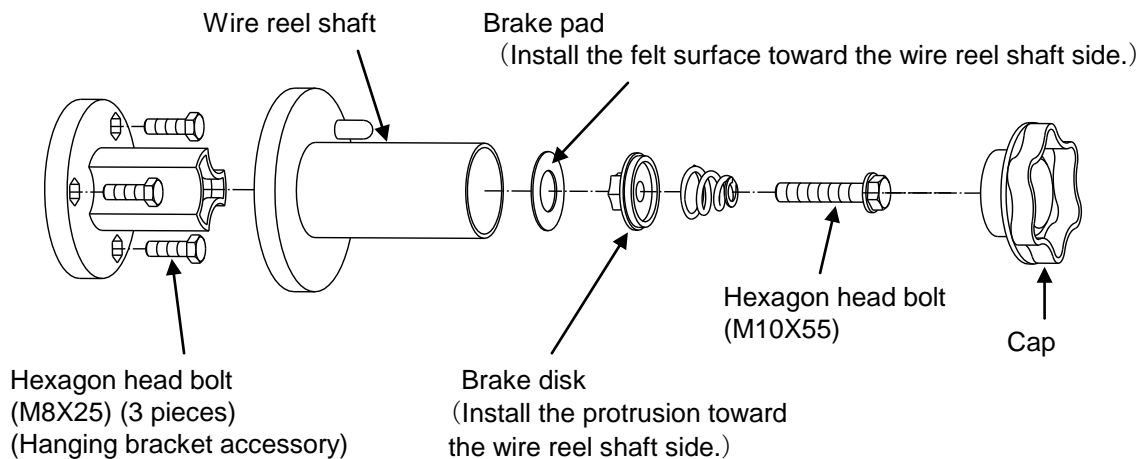


WARNING

Observe the following precautions to prevent serious personal injury caused by fall of the wire reel at the time of wire reel hub adjustment or hanging bracket installation.

- Mount the brake pad to the wire reel shaft as illustrated below with care placed to the mounting direction.
- Mount the brake disk to the wire reel shaft as illustrated below with care placed to the mounting direction.
- In the event that the brake pad and the brake disk are used in wrong directions, the hexagon head bolt comes loose due to rotations of the wire reel shaft and may fall together with the wire reel shaft.

1. Remove hexagon head bolt (M10X16) and Nut (M8) (3pieces) and remove the wire reel hub from the reel bracket.
2. Disassemble the wire reel hub, replace hexagon head bolt (M8X16) (3 pieces) with hexagon head bolt (M8X25) (3 pieces) of the hanging bracket accessory and reassemble the wire reel hub to its original condition. When reassembling, pay attention to the order and direction of parts.

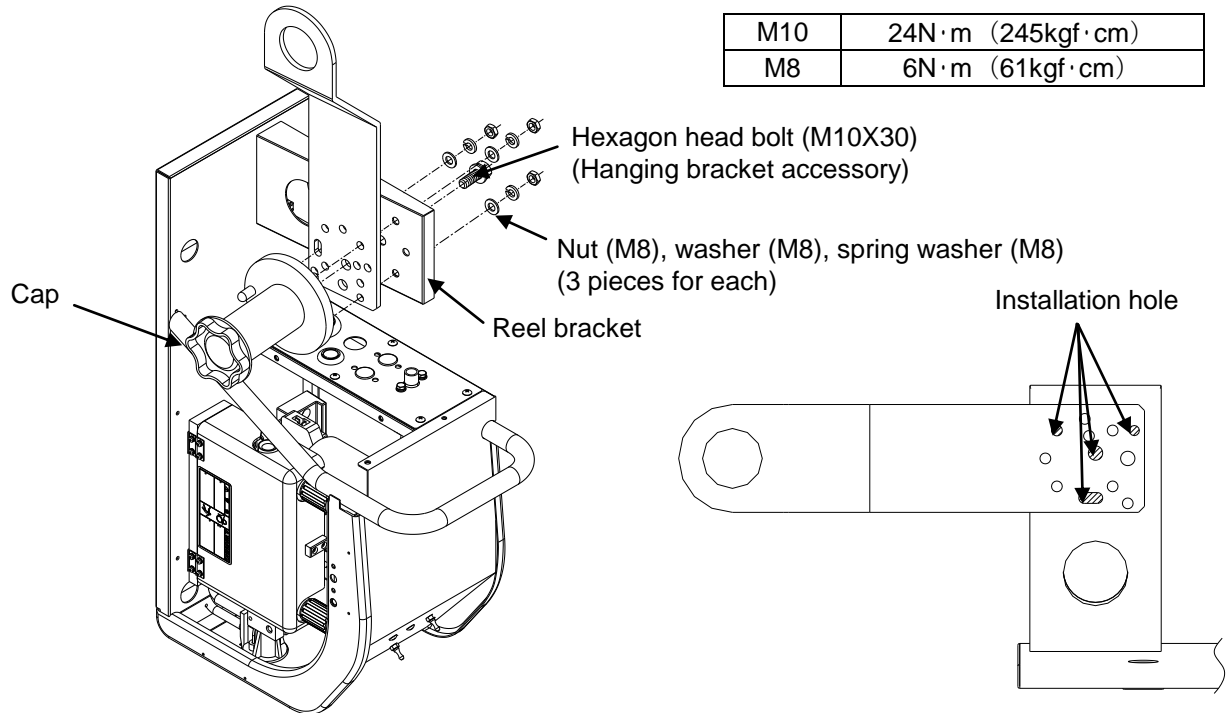


7. WELDING PREPERATION (continued)

3. Install the wire reel hub and hanging bracket on the reel bracket and tighten to the following torque so as not to loose the hexagon head bolt (M10X30), nut(M8), washer (M8) and spring washer (M8) (3 pieces for each) of the hanging bracket accessory in that order.
4. Adjust the wire reel hub



Recommended tightening torque

M10	24N·m (245kgf·cm)
M8	6N·m (61kgf·cm)



8. MAINTENANCE AND TROUBLESHOOTING

8.1 Carrying Out Maintenance

 WARNING	
	<ul style="list-style-type: none"> ● Do not touch live electrical parts inside or outside the wire feeder. ● Disconnect the wire feeder from the welding power source by turning off the line disconnect switch in the power box to avoid an electric shock before carrying the equipment.

In order to use the wire feeder safely and efficiently, be sure to conduct periodical maintenance and inspection. If flaw is found, ask for change or repair of the object part.

○ : Necessary inspection item △ : Recommended inspection item — : Omissible inspection item

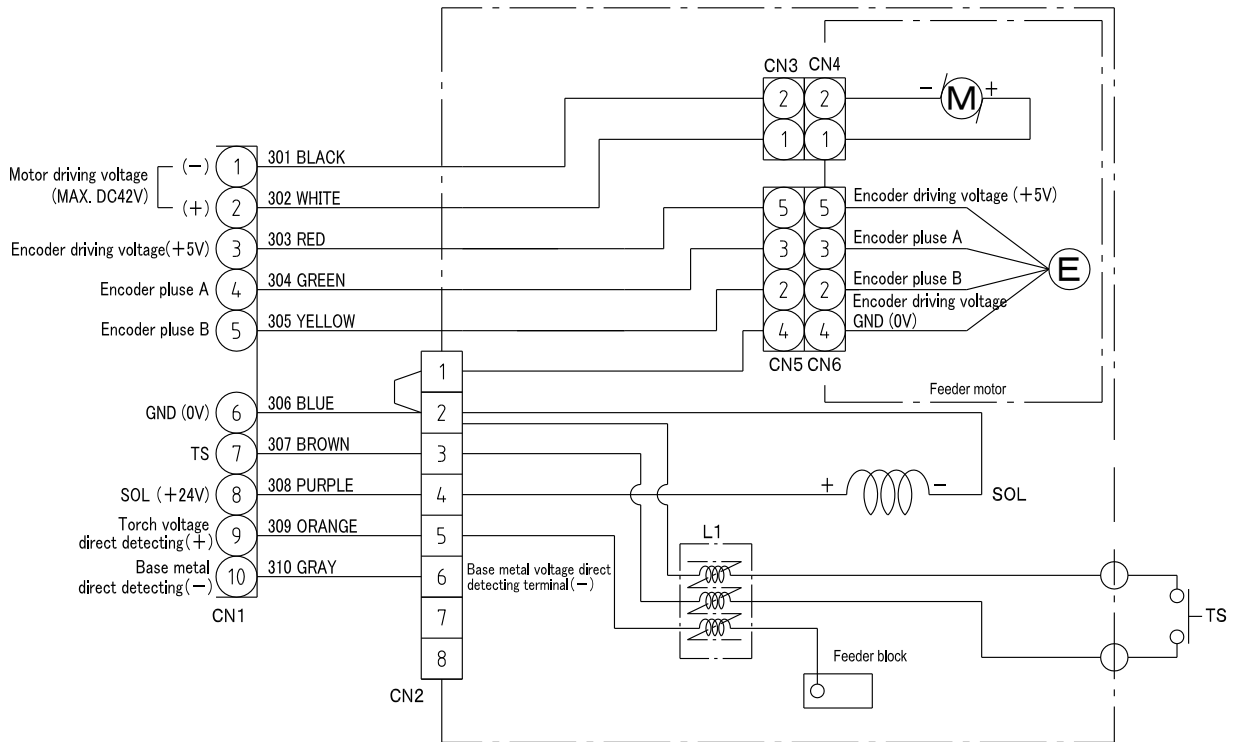
No.	Inspection item	Daily inspection	Periodical inspection in 3 to 6 months
1	Is there not abnormal vibration, buzz or odor?	○	—
2	Are there not discoloration of terminal parts and melting and deterioration of cable jackets?	○	—
3	Are fastening screws not loosened or is contact not deteriorated by rust at power cable connection part on the inlet side of wire feeder? Is insulation not problematic?	△	○
4	Is there not portion of cable that is beginning to break?	○	—
5	Is there not break in frames or covers or deformation in hanging bracket?	○	△
6	Is there not crack or break in parts and sheet metals inside wire feeder?	—	○
7	Is there not portion of wiring inside wire feeder that is beginning to break?	—	○
8	Is there no loosening of parts fixing?	—	○
9	Is there no connecting part of connector that is beginning to come out?	—	○
10	Remove dirt and dust inside wire feeder.	—	○

● **Failure and countermeasures**

No.	Phenomenon	Cause of failure/anomaly	Treatment	
1	Wire is not fed. Wire gets deformed.	Wire pressure is too weak.	Refer to “Recommended wire pressure adjustment” in Section 7.3.	
		Wire pressure is too strong.		
		Feed roll of wrong wire size is used.		Replace it with the feed roll of proper wire size.
		Feed roll are worn.		Replace the feed roll , if necessary.
		Poor contact or breakdown in the control cable.		Confirm state of connection. Confirm cables. Replace cables.
		Trouble with the motor		Replace the motor, if necessary.
2	Shield gas supply does not come out or does not stop.	Dust or chip is accumulated on the outlet guide and on the feed roll.	Remove the dust and chip.	
		Feeding roll bearing failure	Replace it, if necessary.	
3	Gas or water leakage from gas or water hose.	Failure of gas solenoid valve.	Check the socket. Check the cables and replace it, if necessary.	
4	Wire is not fed smoothly through the wire reel.	There are defects such as cracks.	Replace it, if necessary.	
4	Wire is not fed smoothly through the wire reel.	Adjustment of the brake is either too strong or too weak.	Refer to “Adjustment of the wire reel hub” in Section 7.4.	

8. MAINTENANCE AND TROUBLESHOOTING (continued)

< Schematic Diagram >



8.2 Replacing of the Outlet Guide (for CM-7402)

! WARNING

- Do not alter or remodel our products.
- You may get injured or have your equipment damaged because of fire, failure or malfunction caused by altering or remodeling the product.
- The warranty does not cover any altered or remodeled products.

Follow the procedures below when replacing the outlet guide.

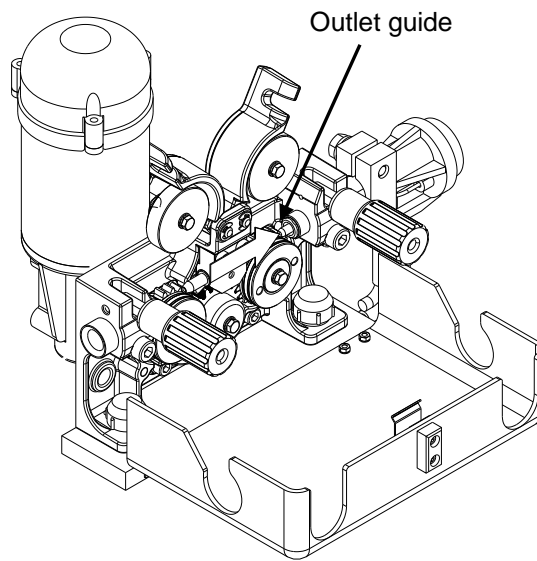
1. Open the front cover.
2. Bring down the pressure handle, then raise the pressure roll holder.
3. Reel the wire on the reel.
4. Remove the torch from the wire feeder.

! WARNING

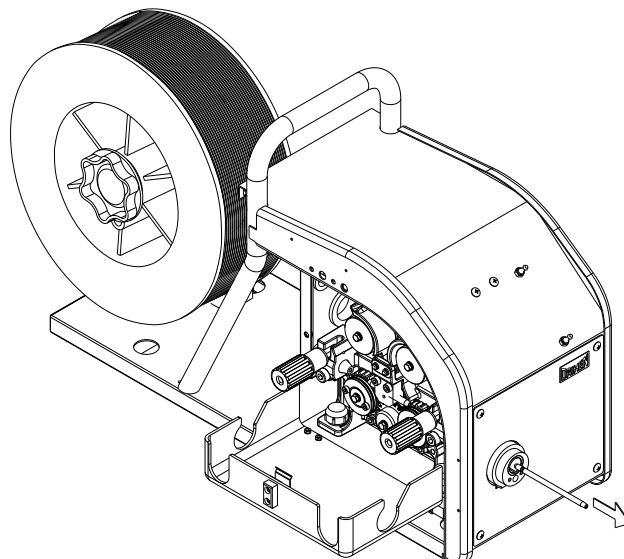
- Do not look into nor bring your face, eyes and body close to the torch connecting opening. Outlet guide or wire may fly out and stick into face, eye or body, causing injury.

8. MAINTENANCE AND TROUBLESHOOTING (continued)

5. Strongly press the outlet guide toward the torch connecting opening until a “click” is felt.

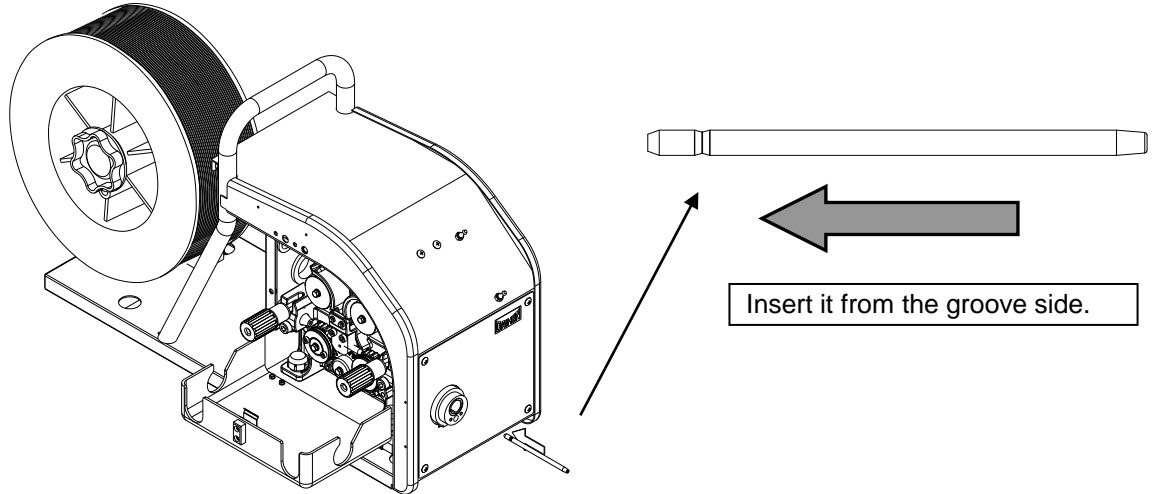


6. Take out the outlet guide from the torch connecting opening.

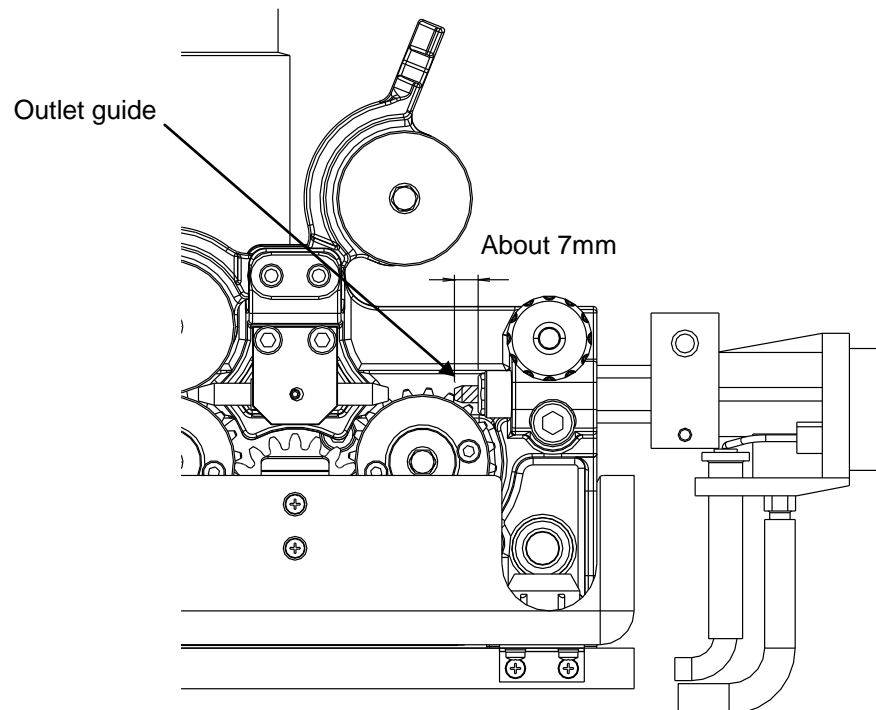


8. MAINTENANCE AND TROUBLESHOOTING (continued)

7. Insert a new outlet guide from the torch connecting opening. In this case, insert the outlet guide along the groove provided in the outlet guide.



8. Press it in straightly until a “click” is felt. Confirm that the outlet guide is protruded by about 7mm.



9. Replace the wire and torch in the reverse procedure.

8. MAINTENANCE AND TROUBLESHOOTING (continued)

CAUTION

- Never attempt to disassemble the feed motor. This may result in damage to the wire feeder.
- Feed motor is built with dustproof structure, in which a rotary encoder is installed. If the feed motor is disassembled, its dustproof function will be lost or the rotary encoder damaged, resulting in failure.
- It is unable to clean the inside of the motor nor replace the brush.

*Target for life and replacement of feed motor

The life of the feeding motor is approximately 3,000 to 4,000 hours.

In addition, the life varies with the load conditions and ambient temperature.

*When the life of the feeding motor expires, the following phenomena occur.

It is recommended that the feeding motor be replaced in advance by referring to the lifetime.

When the motor does not operate, the following warning and abnormal status of the welding machine will be displayed.

Example)

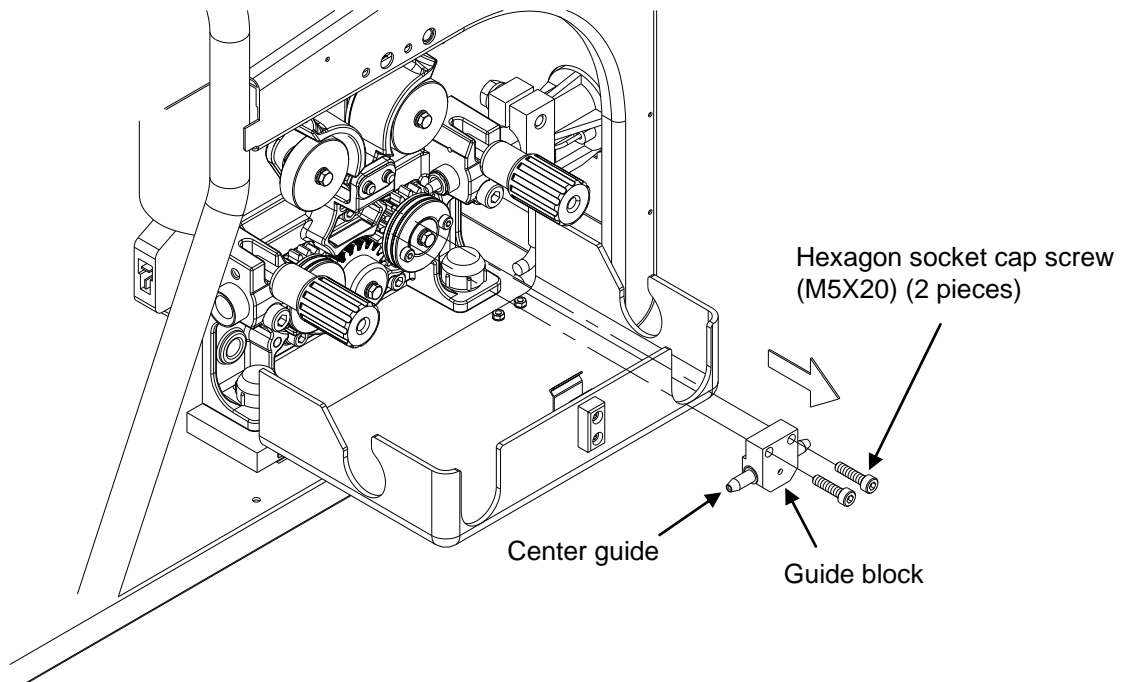
[E-800] Abnormal encoder of feeding motor

[E-820] Motor overcurrent (warning)

[E-830] Motor overcurrent (abnormal status)

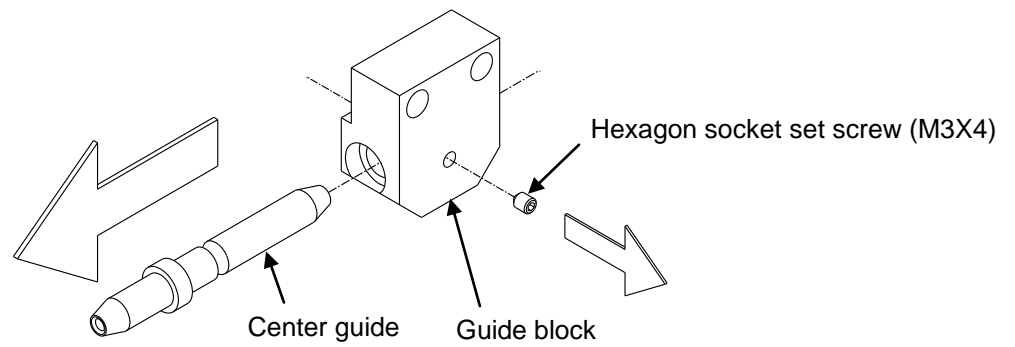
8.4 Replace the center guide.

1. Open the front cover.
2. Bring down the pressure handle, then raise the pressure roll holder.
3. Reel the wire on the reel.
4. Remove hexagon socket head cap screw (M5X20) (2 pieces) and remove the center guide and the guide block together.



8. MAINTENANCE AND TROUBLESHOOTING (continued)

5. Remove the Hexagon socket set screw (M3X4) and pull out the center guide.



6. Replace the center guide and assemble it in the reverse procedure.
7. Close the front cover.

9. PARTS LIST

Please contact your local dealer to order parts. (See the back cover for telephone and fax numbers, and mailing addresses.)

9.1 Main body and wiring (Fig.1)

Ref. No.	Part number		Description	Q'ty	Remarks
	CM-7402	CMW-742			
1	U30022U00		Frame	1	Assembly
2	U30022C05		Strike	2	
3	U30022C01		Side plate	1	Without 3-1
3-1	—		Cross recessed head screw	3	M4X8
4	U30022C02		Rear panel	1	Without 4-1,4-2,4-3,4-4
4-1	—		Cross recessed head screw	6	M4X8
4-2	—		Bushing	2	HP-16
4-3	4739-489		Rubber bush	1	C-30-SG-20A-EP-UL
4-4	100-1380		Rubber bush	1	C-30-SG-36A-EP-UL
5	U30022C03	U30033C03	Front panel	1	Without 5-1
5-1	—		Cross recessed head screw	4	M4X8
5-2	—	4739-507	Grommet	1	
5-3	—	5730-002	Receptacle	1	2P
6	U30023B00	U30033B00	Wire feeder	1	Assembly refer 9.2
7	U30022L00		Feed motor	1	Assembly refer 9.3
8	U30022H00		Feed cover	1	Assembly refer 9.4
9	U30022J00	U30033J00	Attachment	1	Assembly refer 9.5
10	U30022D00		Central adapter	1	Assembly refer 9.6
11	U30022N00	U30033N00	Power cable	1	Assembly
12	U5185J09		Power terminal block	1	
13	4733-370		Terminal block	1	Without 13-1
13-1	—		Cross recessed round head screw	2	M3X14
14	U30022E00		Control cable	1	Assembly, with 14-1
14-1	100-1381		Metal socket	1	DPC25-10A
15	U30022F00		Wire reel hub	1	Assembly, with 15-1,15-2,15-3,15-4
15-1	—		Hexagon head bolt	(1)	M10X16
15-2	—		Nut	(3)	M8
15-3	—		Washer	(3)	M8
15-4	—		Spring washer	(3)	M8
16	U30022G00		Gas line	1	Assembly refer 9.7
17	U30022P00		Common mode coil	1	Assembly
18	U5185J01		Cable clamp	1	Without 18-1
18-1	—		Phillips hexagon head bolt	2	M5X15
19	U1997C02		Hose clamp	1	Without 19-1
19-1	—		Phillips hexagon head bolt	2	M5X15
20	U1997C03		Hose cover	1	
21	U30022C06		Wire reel cover	1	Without 21-1
21-1	—		Cross recessed head screw	2	
22	—	U2028H01	Cable clamp	1	Without 22-1
22-1	—		Cross recessed head screw	2	
23	—	U30033R01	Hose bracket	1	
24	—	U30033P00	Power connection	1	

9. PARTS LIST (continued)

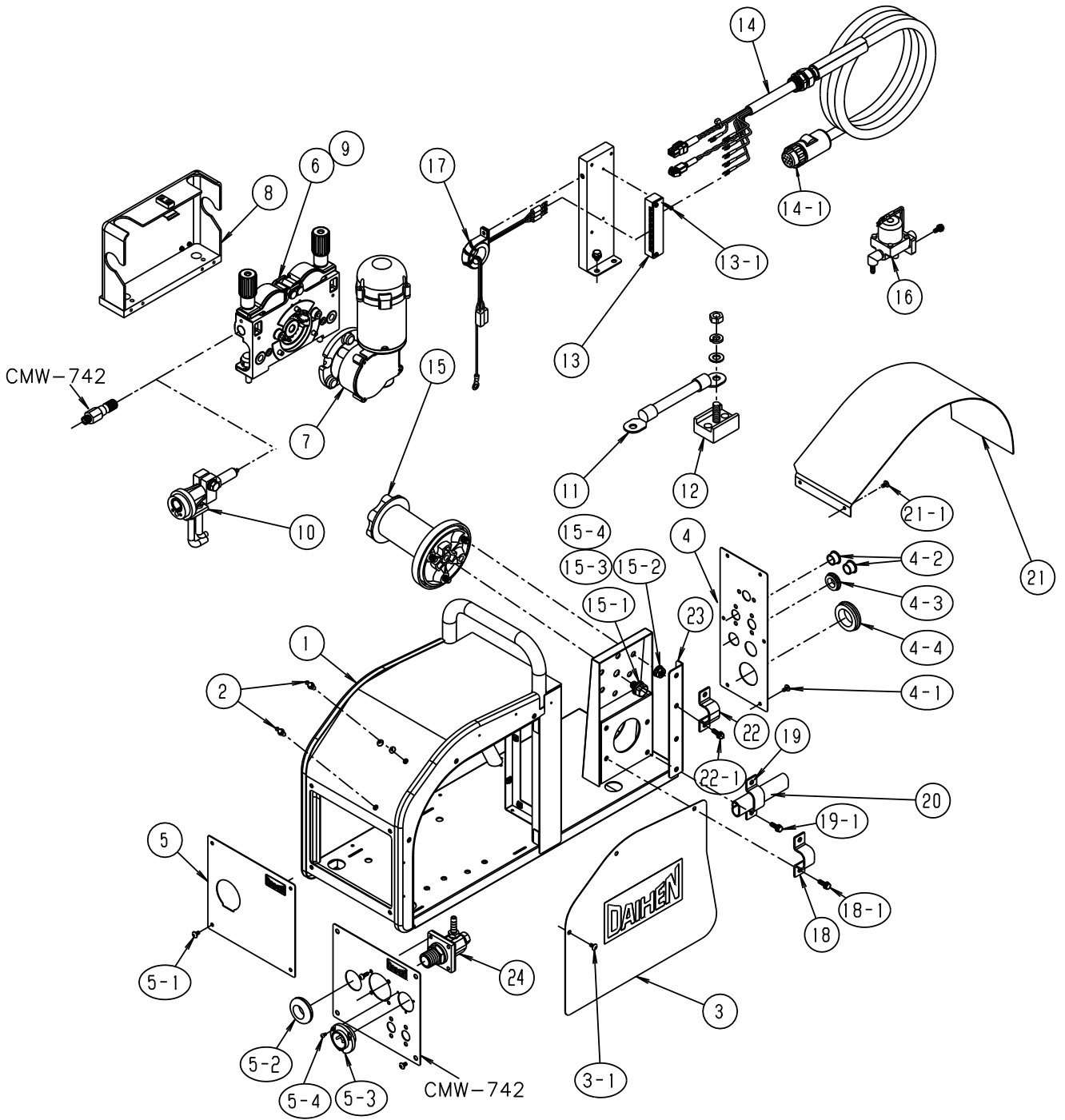


Fig. 1 Main Body and Wiring Assembly

9. PARTS LIST (continued)

9.2 Wire feeder (Fig.2)

Ref. No.	Part number		Description	Q'ty	Remarks
	CM-7402	CMW-742			
1	U30022B01	U30033B01	Main bracket	1	Without 1-1,1-2
1-1	—		Hexagon socket head cap screw	3	M6X18
1-2	—		Small washer	3	M6
2	L10595B02		Pressure roll holder pin	2	Without 2-1
2-1	3361-404		E-type retaining ring	2	E-5
3	L10595B03		Feed roll shaft	2	
4	U30023T00		Pressure roll holder (L)	1	Assembly
5	U30023W00		Pressure roll holder (R)	1	Assembly
6	L10595B04		Coil spring	1	
7	L10595B05		Pressure spring holder	2	
8	L10595B06		Pressure handle	2	
9	L10595B07		Pressure bolt	2	Without 9-1,9-2,9-3
9-1	—		Small washer	2	M6
9-2	3361-404		E-type retaining ring	2	E-5
9-3	4739-043		Spring pin	2	2.5X14
10	L10595B08		Compressed spring	2	
11	U30022B02		Insulation bush	2	Without 11-1,11-2,11-3
11-1	—		Hexagon head bolt	2	M8X40 with washer, spring washer
11-2	—		Washer	2	M8
11-3	—		Nut	2	M8
12	U5185B15		Insulation cover	2	

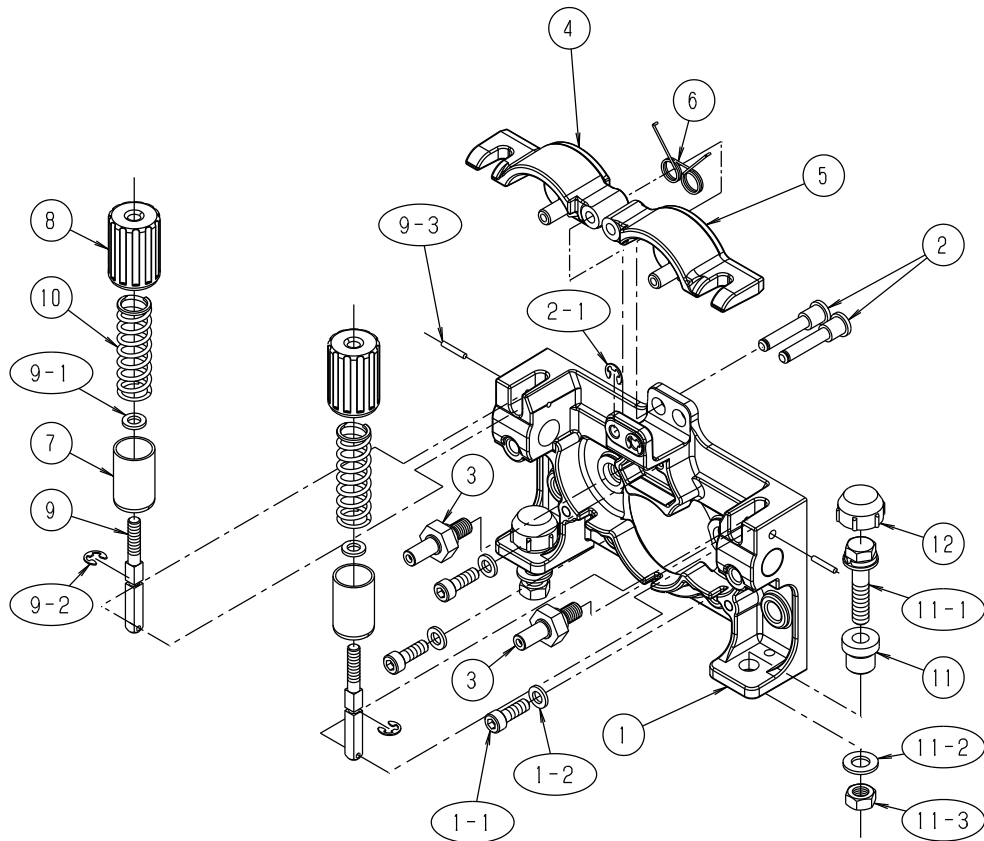


Fig. 2 Wire Feeder Assembly

9. PARTS LIST (continued)

9.3 Feed motor (Fig.3)

Ref. No.	Part number		Description	Q'ty	Remarks
	CM-7402	CMW-742			
1	W-W03593		Feed motor	1	Without 1-1
1-1	—		Hexagon socket head cap screw	3	M6X16
2	U30022L01		Motor mount	1	

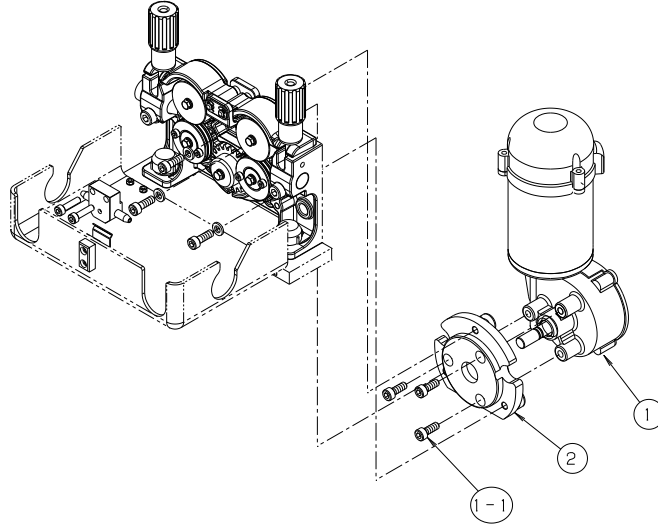


Fig. 3 Feed Motor Assembly

9.4 Feed cover (Fig.4)

Ref. No.	Part number		Description	Q'ty	Remarks
	CM-7402	CMW-742			
1	L10595D02		Base plate	1	Without 1-1
1-1	—		Phillips hexagon head bolt	2	M5X20
2	U30022V00		Front cover	1	Assembly with 2-1,2-2,2-3,2-4
2-1	K5737D01		Front cover	(1)	Without Label
2-2	U30022V02		Cover bracket	(1)	
2-3	—		Hexagon socket head cap screw	(2)	M3X10
2-4	U30022V03		Insulating spacer	(1)	
3	4739-540		Hinge	2	B-1100-1 without 3-1,3-2,3-3
3-1	—		Cross recessed round head screw	8	M3X8 with small washer
3-2	—		Nut	4	M3

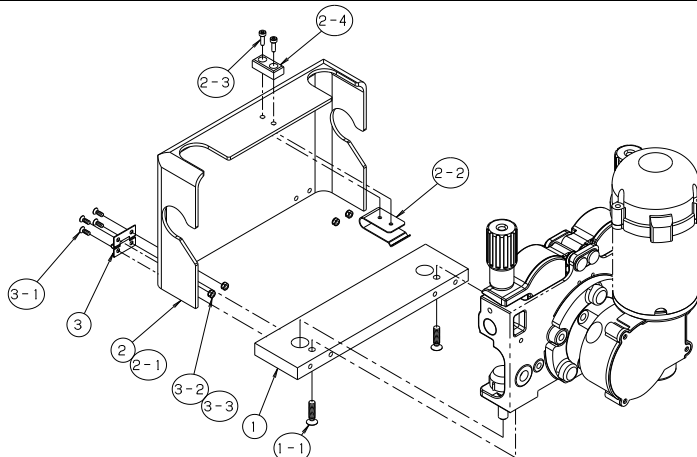


Fig. 4 Feed Cover Assembly

9. PARTS LIST (continued)

9.5 Attachment (Fig.5)

Ref. No.	Part number		Description	Q'ty	Remarks
	CM-7402	CMW-742			
1	L10595C01		Center guide	1	
2	L10595C02		Guide block	1	Without 2-1,2-2
2-1	—		Hexagon socket head cap screw	2	M5X20
2-2	—		Hexagon socket set screw	1	M3X4
3	K5439C00		Pressure roll	2	Without 3-1
3-1	—		Phillips hexagon head bolt	2	M4X10 With washer, spring washer
4	U30022J01		Pilot	1	
5	L10595P00		Gear	2	Assembly, Without 5-1
5-1	—		Phillips hexagon head bolt	2	M4X10 With washer, spring washer
6	K5439B12	—	Feed roll(0.9-1.0/1.2)	2	Without 6-1
	—	K5439B01	Feed roll(1.4/1.6)	2	Without 6-1
6-1	—		Hexagon socket head cap screw	4	M4X16
7	U30022J02		Outlet guide(0.9-1.2)	1	
8	—	U5209J01	Guide adapter	1	
9	—		Hexagon socket head cap screw	2	M6X35
10	—		Washer	2	M6
11	L10595Q00		Drive gear	1	Without 11-1
11-1	—		Phillips hexagon head bolt	1	M4X15 With washer, spring washer

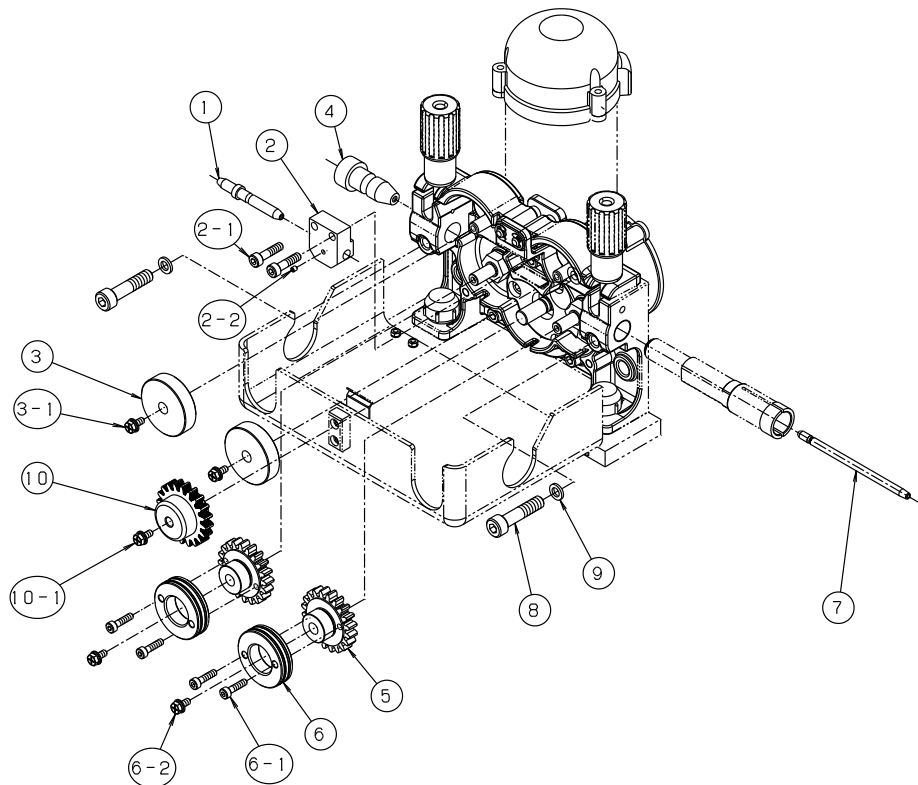


Fig. 5 Attachment Assembly

9. PARTS LIST (continued)

9.6 Central adapter (Fig.6)

Ref. No.	Part number	Description	Q'ty	Remarks
1	U30022W00	Power fitting	1	Assembly
2	K3985E03	Block	1	
3	U30022D01	Feeder block	1	Without 3-1
3-1	—	Hexagon head bolt	1	M8X30 with washer, spring washer
4	U30022D02	Spacer	1	
5	U30022X00	Gas hose	1	With 5-1,5-2
5-1	K3985E04	Hose connector	(1)	
5-2	4734-103	Hose clamp	(1)	MH-4
6	K3985E05	Sleeve	1	
7	U5185V00	Switch code	1	

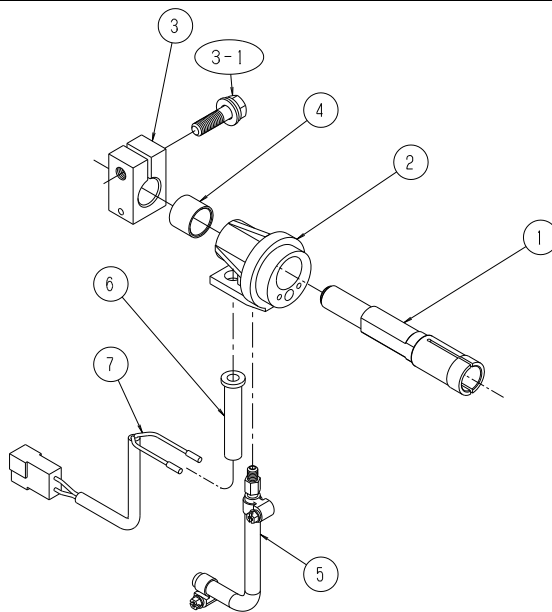


Fig. 6 Central Adapter Assembly

9.7 Gas line (Fig.7)

Ref. No.	Part number	Description	Q'ty	Remarks
1	4813-001	Gas solenoid valve	1	
2	U4179D01	Hose elbow	1	
3	U1997D01	Gas fitting	1	
4	U1997D02	Flange	1	

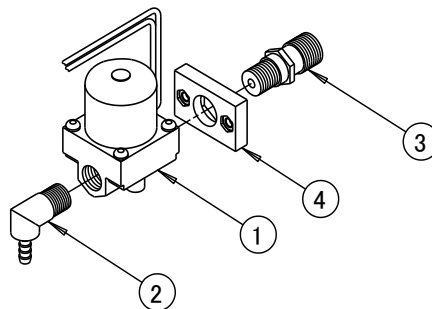


Fig. 7 Gas line Assembly

9. PARTS LIST (continued)

9.8 Optional Accessory

(1) Extension cable/hose

Power cable

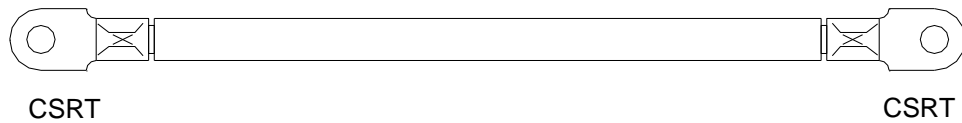
Applicable current (Rated current)		200 A	350 A	500 A	
Cable length	Cable termination	Model	Model	Model	
2m	CSRT	CSRT	BKPT-3802	BKPT-6002	BKPT-8002
	CSRT	Connector	BKPDT-3802	BKPDT-6002	BKPDT-8002
7m	CSRT	CSRT	BKPT-3807	BKPT-6007	BKPT-8007
	CSRT	Connector	BKPDT-3807	BKPDT-6007	BKPDT-8007
12m	CSRT	CSRT	BKPT-3812	BKPT-6012	BKPT-8012
	CSRT	Connector	BKPDT-3812	BKPDT-6012	BKPDT-8012
17m	CSRT	CSRT	BKPT-3817	BKPT-6017*	BKPT-8017
	CSRT	Connector	BKPDT-3817	BKPDT-6017*	BKPDT-8017
22m	CSRT	CSRT	BKPT-3822	BKPT-6022*	BKPT-8022
	CSRT	Connector	BKPDT-3822	BKPDT-6022*	BKPDT-8022

CSRT (Crimp Style Ring Terminal)

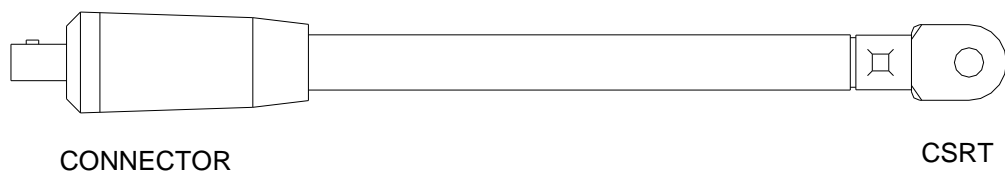
When performing pulse welding using the welding power source with 350 A applicable current and a 17m or more cable, use the thicker cable by one rank. (BKPT-80XX, BKPDT-80XX)

Example:

When using a 22 m cable (crimp style ring terminal – connector)---BKPDT-8022



Power cable BKPT

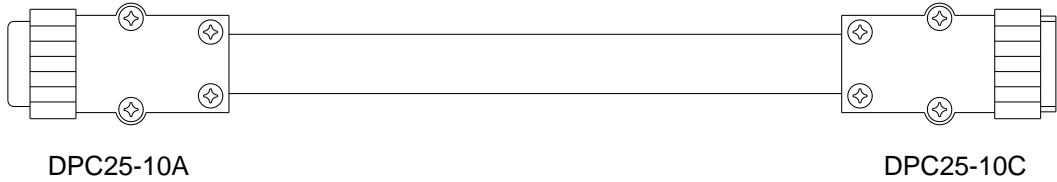


Power cable BKPDT

9. PARTS LIST (continued)

Control cable (10P)

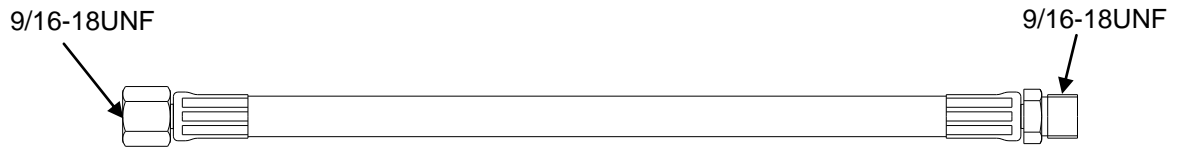
	Cable length			
	5m	10m	15m	20m
Model	BKCPJ-1005	BKCPJ-1010	BKCPJ-1015	BKCPJ-1020



Control cable BKCPJ

Gas hose

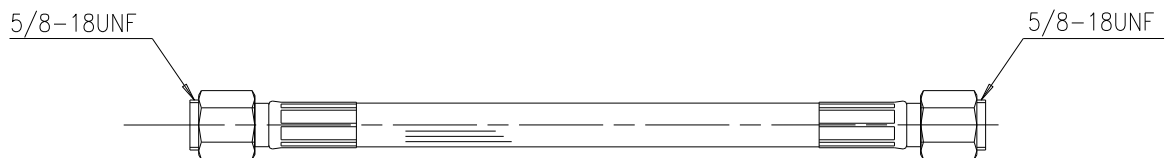
	Hose length			
	5m	10m	15m	20m
Model	BKGG-0605	BKGG-0610	BKGG-0615	BKGG-0620



Gas hose BKGG

Water hose

	Hose length			
	5m	10m	15m	20m
Model	BKWR-0605	BKWR-0610	BKWR-0615	BKWR-0620



Water hose BKWR

9. PARTS LIST (continued)

(2) Feed roll

Part number		Description	Q'ty	Remarks
CM-7402	CMW-742			
	K5439B01	Feed roll (1.4/1.6)	2	
	K5439B04	Feed roll (1.2/1.4)	2	
	K5439B05	Feed roll (1.2/1.2)	2	
	K5439B06	Feed roll (1.4/1.4)	2	
	K5439B07	Feed roll (1.6/1.6)	2	
K5439B09	-	Feed roll (0.6/0.8)	2	
-	K5439B10	Feed roll (1.6/2.0)	2	
	K5439B11	Feed roll (1.2/1.6)	2	
K5439B12	-	Feed roll (0.9-1.0/1.2)	2	
K5439B13	-	Feed roll (0.8/0.9-1.0)	2	

(3) Center guide · Outlet guide

Part number		Description	Q'ty	Remarks
CM-7402	CMW-742			
	L10595C01	Center guide (0.6-1.6)	1	Pre-installed
-	U30033M01	Center guide (2.0)	1	
U30022M01	-	Outlet guide (0.6 - 0.9)	1	
U30022J02	-	Outlet guide (0.9 -1.2)	1	Pre-installed
U30022M02	-	Outlet guide (1.2 -1.6)	1	

(4) Other Optional Parts

Part number or specifications	Description	Q'ty	Remarks
U5191E00	Wire reel cover (simple)	1	
K5439F00	Caster	1	
U30022Z00	Hanging bracket	1	
U30023Y00	Inter lock	1	
FCR-226	CO ₂ gas regulator (with heater)	1	Max. gas flow rate: 25 liter/min
NP-201	CO ₂ gas regulator (without heater)	1	Max. gas flow rate: 20 liter/min
AU-888	CO ₂ gas regulator (without heater)	1	Max. gas flow rate: 20 liter/min
FCR-100N	CO ₂ gas regulator for large current	1	Max. gas flow rate:100 liter/min
D-BHN-2	Argon gas regulator	1	For MAG gas flow rate:28 liter/min
U30023Q00	Wire reel cover (full)	1	Assembly
U30034V00	Reel adapter	1	

10. SPECIFICATIONS

10.1 Specifications

Model		CM-7402 (Air cooling)	CMW-742 (Water cooling)
Applicable wire size		(0.6)*, (0.8), 0.9, 1.0, 1.2, (1.4), (1.6)	(1.2), 1.4, 1.6, (2.0)
Wire		Solid wire, Flux cored wire	
Wire feeding rate		Max. 22 m/min	
Applicable wire reel	Shaft diameter	φ 50mm	
	External diameter	Max. φ 300mm	
	Width	103m	
Mass of applicable wire		Max. 25kg	
Temperature range		-10 ~ 40°C	
Moisture range		20% ~ 80% (no condensation)	
Storage temperature range		-10 ~ 60°C	
Storage moisture range		20% ~ 80% (no condensation)	
External dimensions (WxDxH)		207mm x 588mm x 372mm	207mm x 602mm x 372mm
Mass		12 kg	13 kg

When using φ 0.6 wire, add the welding mode (optional) to the welding power source.

10.2 Available Welding Torch

• For CM-7402

Rated current	Duty cycle	Cable length			
		3m	4m	4.5m	6m
180 A	40%	WT1800-SD	-	-	-
200 A	50%	WT2000-SD	WT2000-MD	-	-
350 A	30%	WT3500-SD	-	WT3500-MD	WT3500-LD
350 A	60%	WT3510-SD	-	WT3510-MD	WT3510-LD
350 A	80%	WT3520-SD	-	WT3520-MD	WT3520-LD
500 A	60%	WT5000-SD	-	WT5000-MD	WT5000-LD

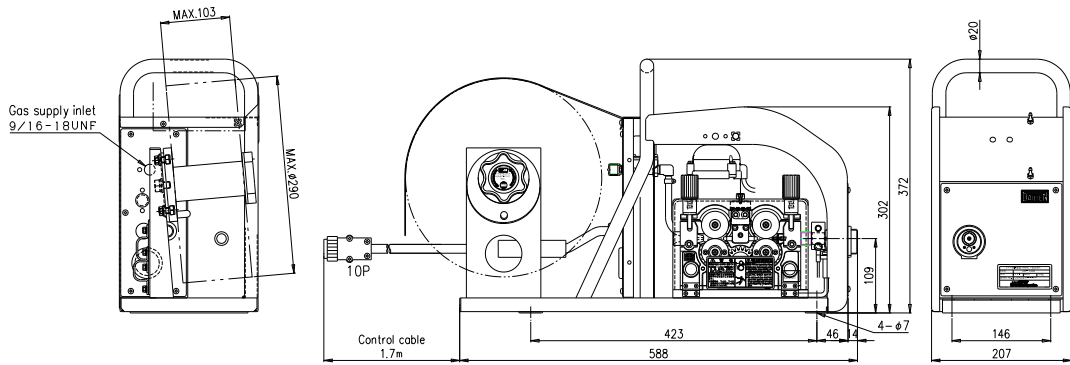
• For CMW-742

Rated current	Duty cycle	Cable length		
		3m	3.6m	5m
500 A	70%	WTCW-5001	-	WTCLW-5001
600 A	100%	-	WTGW-6001	-

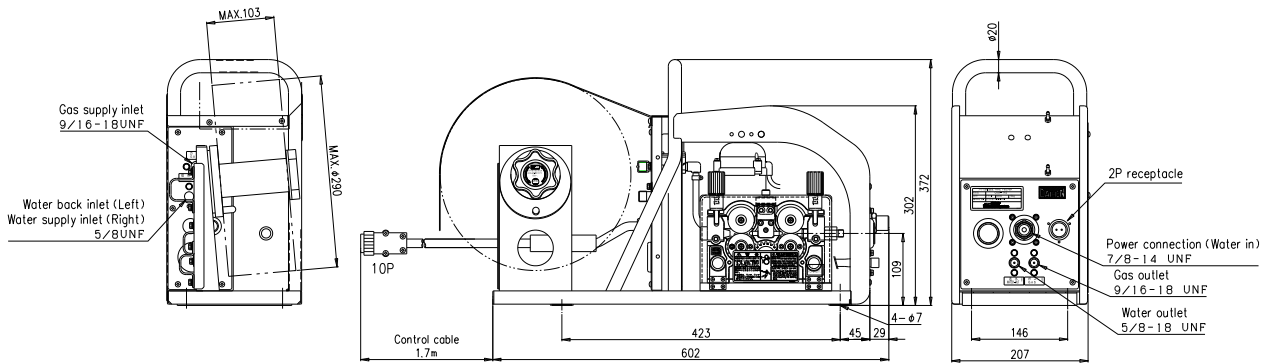
10.3 Standard Accessory

Part number		Description	Quantity	Remarks
CM-7402	CMW-742			
	K5439C00	Pressure roll	(2)	Pre-installed
K5439B12	-	Feed roll (0.9-1.0/1.2)	(2)	Pre-installed
-	K5439B01	Feed roll (1.4/1.6)	(2)	Pre-installed
	K5430A00	Gas hose	1	BKGFF-0603 (3m)
	U1997C03	Hose cover	1	
-	U30033L01	Hose cover	1	
-	U2879J00	Water hose	2	1.7m

10. SPECIFICATIONS (continued)



External View of CM-7402 Type Wire Feeder(mm)



External View of CMW-742 Type Wire Feeder(mm)



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