



No.1L7433

MODEL: L-7433/L-7434

[MIG Wire Feeder (for 4 Roll Type)]

PARTS LIST

DAIHEN Corporation

1. Parts List

1.1 Wire Feeder (L-7433/L-7434) Parts List

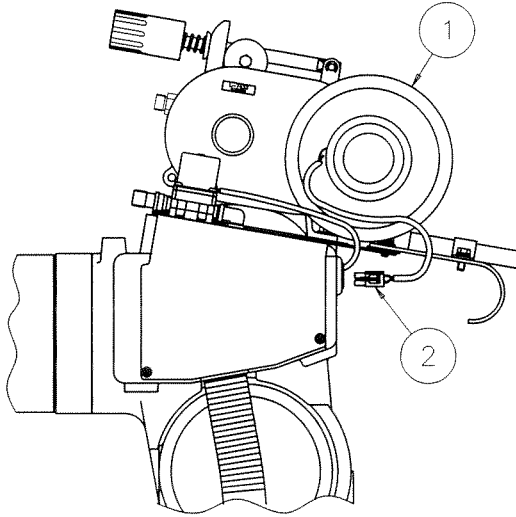


Fig 1. L-7433/L-7434 Parts List

Table 1. L-7433/L7434 Parts List

No.	Part Number		Description	Q'ty	Remarks
	L-7433	L-7434			
1	L7427A	L7428A	Wire Feeder Unit	1	Refer to 1.2
2	L7431B		Cable Assy	1	Refer to 4

1.2 Wire Feeder Unit (L-7427/L-7428) Parts List

Table 2. L-7427/L-7428 Parts List

No.	Part Number		Description	Q'ty	Remarks
	L-7427	L-7428			
1	K1123B01		Gear Case	1	
2	4802-006		Print Motor	1	PMEE-12CBB
3	K5114B01		Pinion	1	
3-1	3361-401		CS Type Snap Ring	1	CSTW-10
4	K1821B02		2-Step Gear	1	
5	K1123B04		Geared Output Shaft	1	
6	3361-206		Key	3	4×4×8
7	K1123B05		Bush	2	
8	K1123B06		Insulating Spacer	1	
9	3311-001		Radial Ball Gear	1	No.6000ZZ
1 0	K5114C01		Gear Case	1	
1 1	K1822C02		Insulating Plate	1	
1 2	K1123C04		Insulating Sleeve	1	
1 3	3311-008		Radial Ball Gear	5	No.6001LL
1 4	K1822C01		Bracket	1	
1 5	K5112C04		Pressure Roll Holder (1)	1	
1 6	K1822C04		Pressure Roll Holder (2)	1	
1 7	K1821C04		Pressure Roll Pin	2	
1 8	K1821C05		Axis Pin	3	
1 9	3361-404		E-type Snap Ring	6	φ 5
2 0	K5112C05		Pressure Bolt	1	
2 1	U929C16		Pressure Spring	1	
2 2	K1123D01		Pressure Handle	1	
2 3	—		CS Type Snap Ring	1	CSTW-6
2 4	K1123D03		Spring Bearing	1	
2 5	K1123D05		Pressure Nut	1	
2 6	K1822C06		Guide Block	1	
2 7	K970G71	—	Center Guide	1	For Mild Steel/Stainless
	—	K1822C07			For Aluminum
2 8	L6542C01		Feed Shaft	2	
2 9	K1822C10		Spacer	3	
29-1	K1123B07		Spacer	1	

1.2 Wire Feeder Unit (L-7427/L-7428) Parts List (continued)

Table 3. L-7427/L-7428 Parts List (continued)

No.	Part Number		Description	Q'ty	Remarks
	L-7427	L-7428			
3 0	L6542C02		Middle Gear	1	
3 1	L6564J	—	Feed Roll (1.2)	2	For Steel/Stainless 1.2
	—	L6564P	Feed Roll (1.0-1.2)		For Aluminum 1.0-1.2
3 2	L6542M	—	Pressure Roll	2	For Steel/Stainless
	—	L6564Q	Pressure Roll (1.0-1.2)		For Aluminum 1.0-1.2
3 3	K1687D13	—	Guide Adapter	1	
3 4	U785C09		Spring Plate	1	
3 5	U785C11		Protection Cover	1	
3 6	K1123C08		Remote Stopper	1	
3 7	K5112C06		Bush	1	For ⑳
3 8	L7427C01		Insulating Plate	1	
3 9	U1997C06		Insulating Bush	1	
4 0	—		Bolt	2	M8×20 (W/W&SW)
4 1	L6542E	—	Wire Straightner	1	For Steel/Stainless (Optional Accessory)
	—	L6564C			For Aluminum

(Optional Accessories)

Wire Feeder Unit (L-7427A) Optional Accessories

Table 4. Parts List of Optional Accessories when Using Steel or Stainless wire

No.	Part Number	Description	Q'ty	Remarks
4 2	L6564F	Feed Roll (0.8)	2	For 0.8
4 3	L6564G	Feed Roll (0.9)	2	For 0.9
4 4	L6564H	Feed Roll (1.0)	2	For 1.0
4 5	L6564K	Feed Roll (1.4)	2	For 1.4
4 6	L6564L	Feed Roll (1.6)	2	For 1.6

Wire Feeder Unit (L-7428A) Optional Accessories

Table 5. Parts List of Optional Accessories when Using Aluminum wire

No.	Part Number	Description	Q'ty	Remarks
4 7	L6564F	Feed Roll (1.2-1.6)	2	For 1.2-1.6
4 8	L6564G	Pressure Roll (1.2-1.6)	2	For 1.2-1.6

1.2 Wire Feeder Unit (L-7427/L-7428) Parts List (continued)

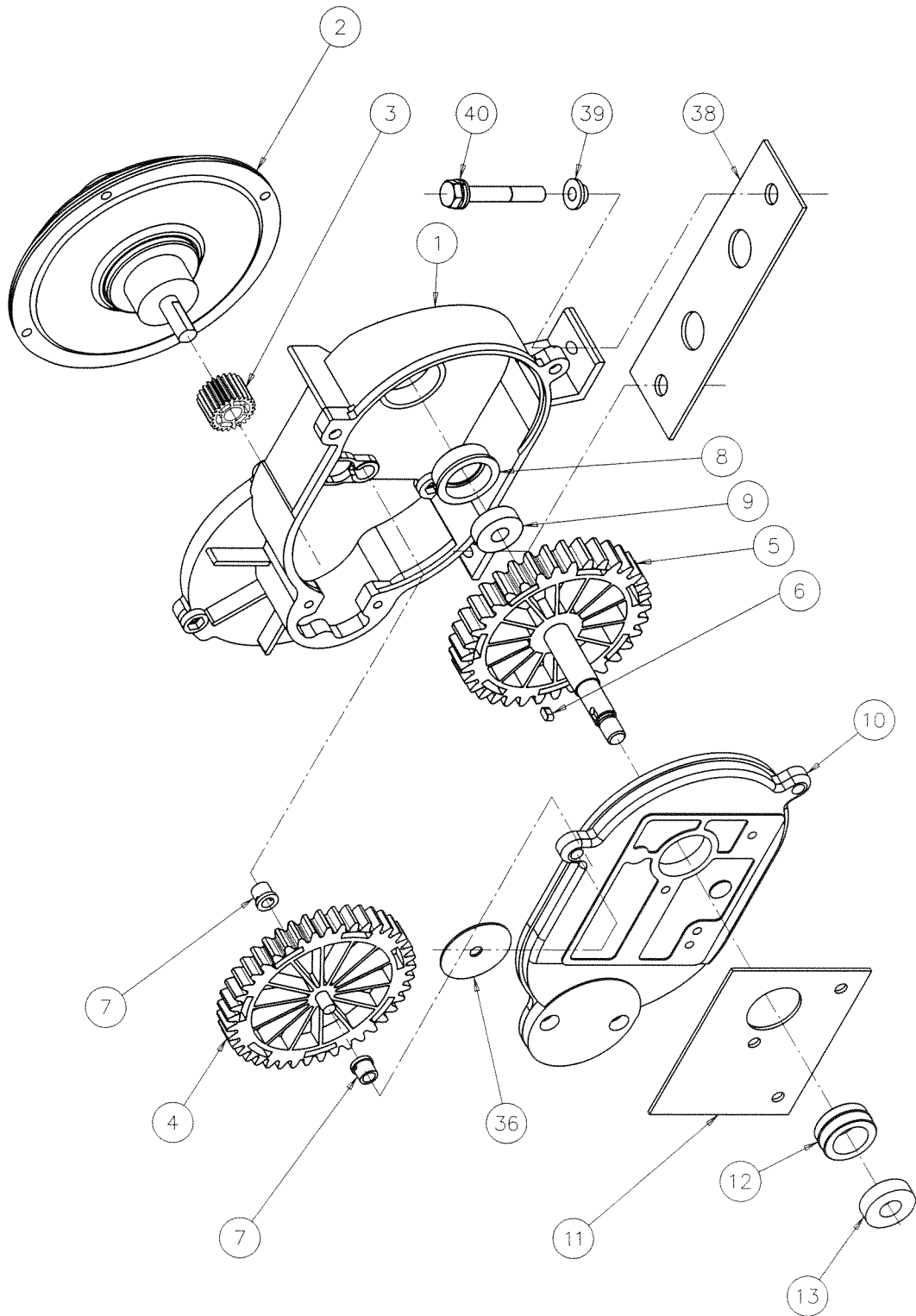


Fig 2. Disassembly Drawing of Wire Feed Reduction Gear Unit

1.2 Wire Feeder Unit (L-7427/L-7428) Parts List (continued)

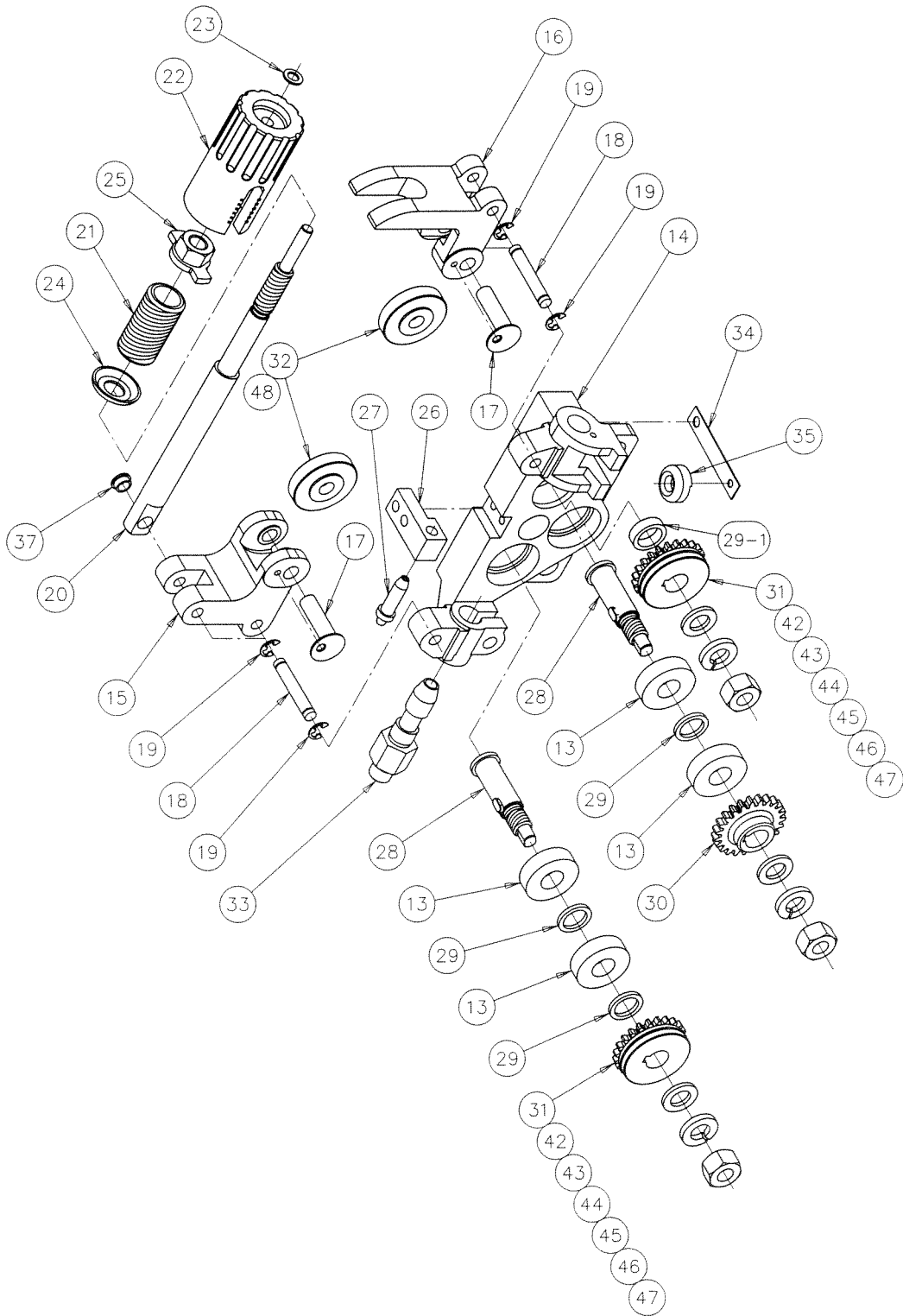


Fig 3. Disassembly Drawing of Wire Feeder and Pressure Parts

2. Changing wire Mild Steel, Stainless Steel ---- Aluminum

When changing wire from steel to Aluminum (from Aluminum to steel),
select parts on Table 6, Table 7

- 2.1 Changing from steel/stainless to aluminum when using wire feeder unit (L-7427),
select feed roll, pressure roll, inlet guide and center guide on table 6.

Table 6. Parts list of changing wire (to Aluminum)

Part Number	Description	Q'ty	Remarks
L6564P	Feed Roll (1.0-1.2)	(2)	For Aluminum 1.0-1.2
L6564Q	Pressure Roll (1.0-1.2)	(2)	For Aluminum 1.0-1.2
L6564R	Feed Roll (1.2-1.6)	(2)	For Aluminum 1.2-1.6
L6564S	Pressure Roll (1.2-1.6)	(2)	For Aluminum 1.2-1.6
U2344C10	Inlet Guide	1	For Aluminum
K1822C07	Center Guide	1	For Aluminum

- 2.2 Changing from aluminum to steel/stainless when using wire feeder unit (L-7428),
select feed roll, pressure roll, inlet guide and center guide on table 7.

Table 7. Parts list of changing wire (to Steel/Stainless)

Part Number	Description	Q'ty	Remarks
L6564F	Feed Roll (0.8)	(2)	For Steel/Stainless 0.8
L6564H	Feed Roll (1.0)	(2)	For Steel/Stainless 1.0
L6564J	Feed Roll (1.2)	(2)	For Steel/Stainless 1.2
L6564K	Feed Roll (1.4)	(2)	For Steel/Stainless 1.4
L6564L	Feed Roll (1.6)	(2)	For Steel/Stainless 1.6
L6542M	Pressure Roll	2	Common part
K970G70	Inlet Guide	1	For Steel/stainless
K970G71	Center Guide	1	For Steel/stainless

3. When the bend in a wire is big...

If the bend in a wire is big and the welding is not executed correctly, install wire Straightner

3.1 Wire Straightner Parts List

Table 8. Wire Straightner Parts List

No.	Part Number		Description	Q'ty	Remarks
	L6542E	L6564C			
4 9	K1821J01		Wire Straightner Body	1	
5 0	K1821J02		Patch	1	
5 1	K1821J03		Adjust Screw	1	
5 2	U2344C04		Roller Shaft	2	
5 3	3311-014		Radial Ball Bearing	2	No.629ZZ
5 4	—		E-type Snap Ring	3	$\phi 7$
5 5	U2344C05		Slide Shaft	1	
5 6	U2344C06		Pointer	1	
5 7	U69C02		Radial Ball Bearing	1	
5 8	—		Adjustment Knob	1	KN15
5 9	U2344C07		Adapter	1	
6 0	K970G70	—	Inlet Guide	1	For Steel/Stainless $\phi 1.2 \sim \phi 1.6$
	—	U2344C10			For Aluminum 1.0-1.6
6 1	L3753B01		Adapter	1	
6 2	U2344C08		Pilot	(1)	Accessories

3. When the bend in a wire is big... (continue)

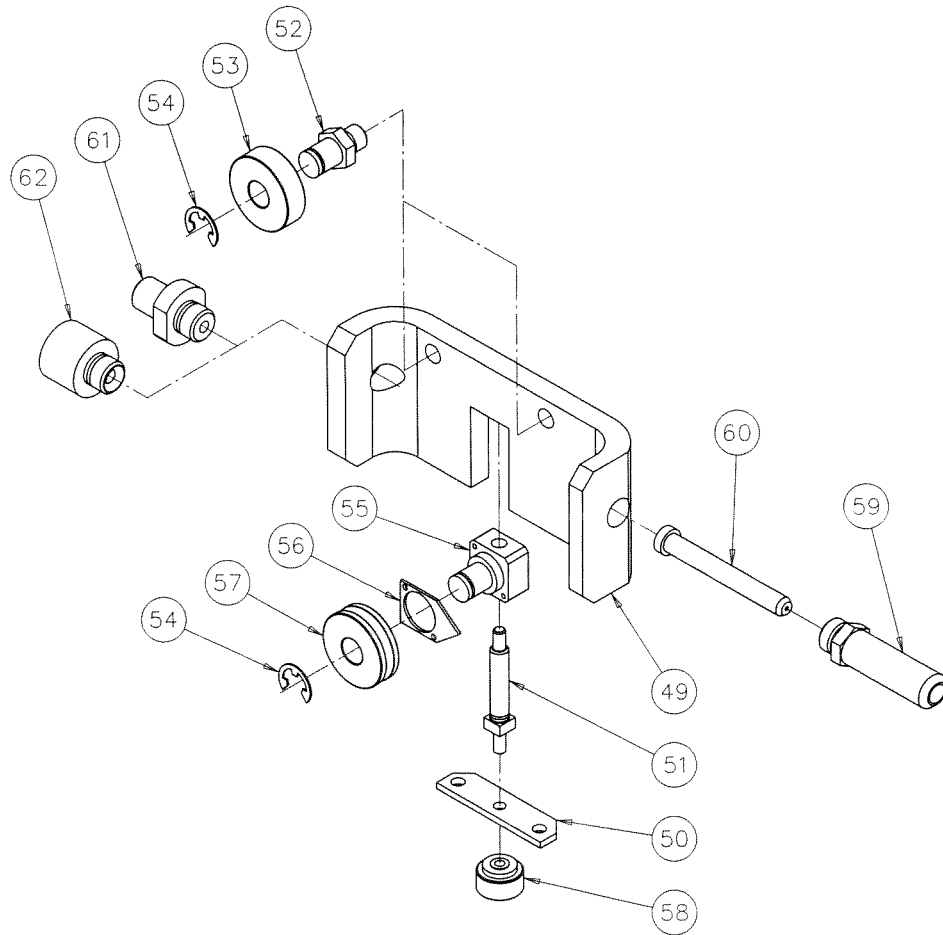
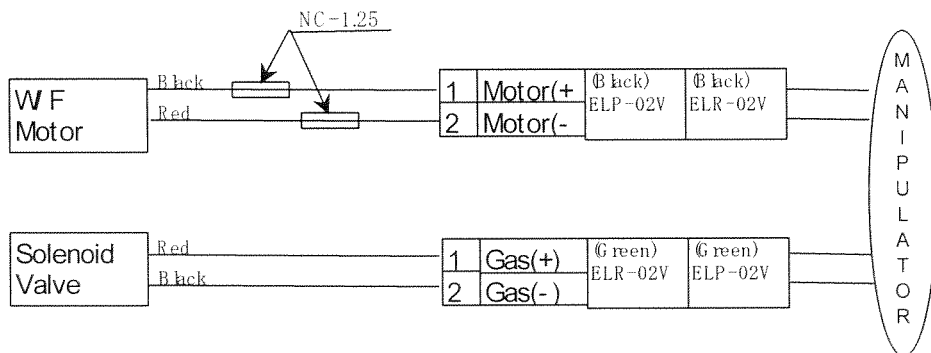


Fig 4. Disassembly Drawing of Wire Straightener

3. Electrical Connection Diagram



Caution) Detail of Solenoid Valve refer to Instruction Manual Almega EX series(Maintenance)