

SPEEDTEC 180C & 200C

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Spare Parts

SP50268 / SP50328 REV06

8/15

ASSEMBLY PAGE NAME			Machine Assembly	Machine Assembly	Wire Drive Assembly	Euro Socket Assembly	Miscellaneous Items	
CODE NO.:	K NO.:	FIGURE NO.:	A	B	C	C	-	
50268	K14098-1	SPEEDTEC 180C	1	1	1	1	1	
50328	K14099-1	SPEEDTEC 200C	2	2	2	2	2	

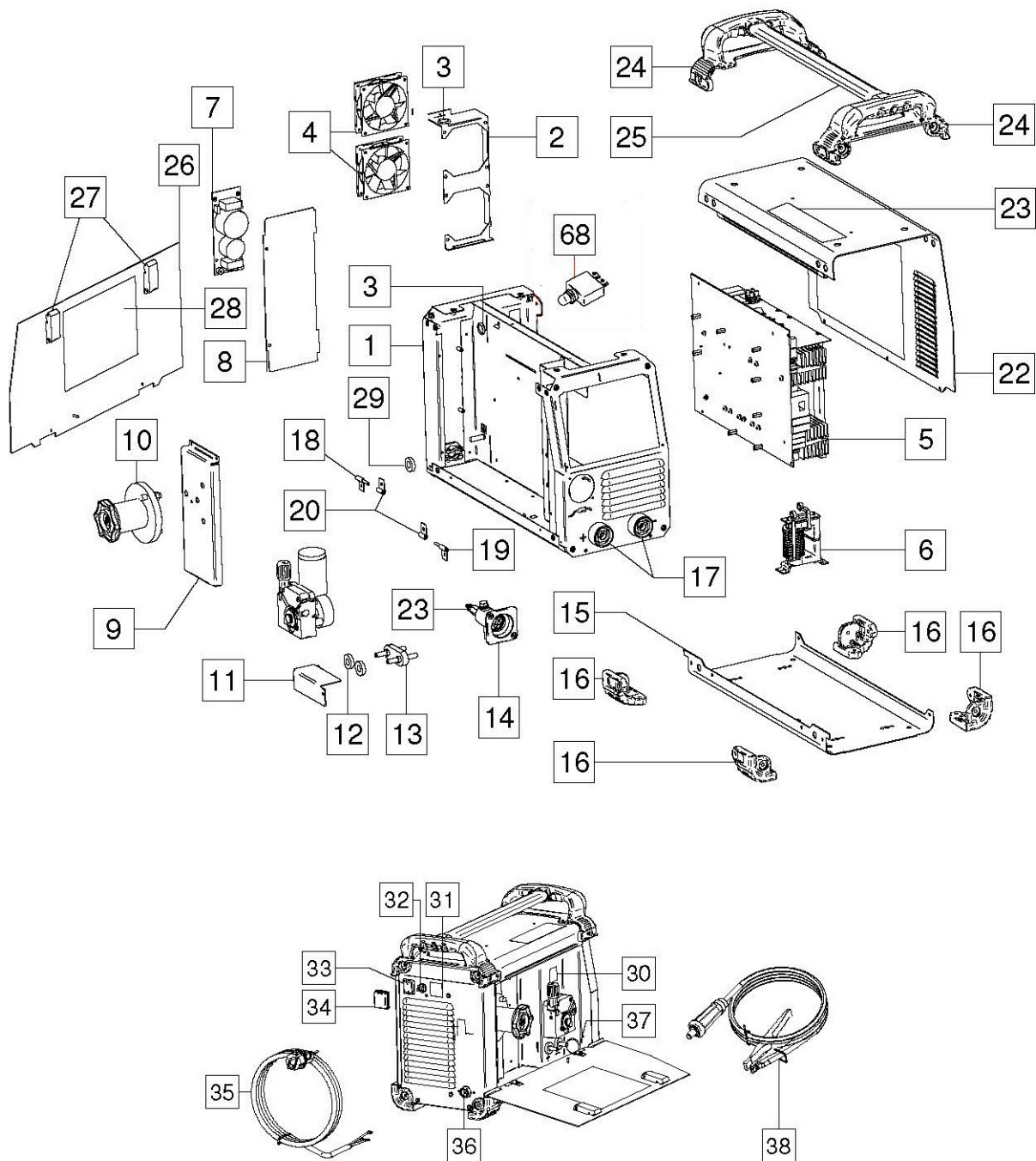
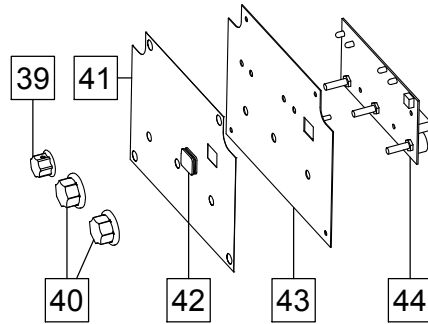


Figure A.

Figure A: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
1	RACK	R-3019-296-1/08R	1	•	•					
2	COVER	R-1019-292-2/08R	1	•	•					
3	RUBBER CABLE BUSH	1373-182-002R	2	•	•					
4	FAN	1111-311-082R	2	•	•					
5	P.C. BOARD	R-6042-064-1R	1	•	-					
	P.C. BOARD	R-6042-064-6R	1	-	•					
6	CHOCKE	R-4034-148-1R	1	•	•					
7	FILTER EMI	Y030-1R	1	•	•					
8	COVER	R-1019-336-1/08R	1	•	•					
9	SUPPORT	R-1019-297-1/08R	1	•	•					
10	REEL HUB COMPLETE	R-2013-126-1R	1	•	•					
11	COVER	R-1019-338-1/08R	1	•	•					
12	INSULATOR RING	D-1869-007-3R	2	•	•					
13	TERMINAL BLOCK X4	1361-599-328R	1	•	•					
14	EURO SLEEVE	0646-231-005R	1	•	•					
15	COVER	R-3019-299-1/02R	1	•	•					
16	CORNER CAP	W95X1147R	4	•	•					
17	SOCKET X2, X3	C-2986-001-2R	2	•	•					
18	HINGLE AND AXLE	D-3574-011-3/02R	1	•	•					
19	HINGLE AND AXLE	D-3574-011-4/02R	1	•	•					
20	HINGLE	D-3574-007-1/33R	2	•	•					
21	COVER	R-1019-342-1R	1	•	•					
22	STICKER (WIRING DIAGRAM)	R-0010-488-1R	1	•	-					
	STICKER (WIRING DIAGRAM)	R-0010-488-2R	1	-	•					
23	STICKER	2719-107-728R	1	•	•					
24	HANDLES	W95X1146R	2	•	•					
25	CENTRAL HANDLE	W92X0228-7R	1	•	•					
26	LEFT SIDE PANEL	R-1019-341-1R	1	•	•					
27	LOCK	0654-610-004R	2	•	•					
28	STICKER (WELDING PARAMETERS)	R-0010-492-1R	1	•	-					
29	FERRITE CORE	W5600005R	1	•	•					
30	STICKER	2719-107-732R	1	•	•					
31	STICKER (GAS)	2719-107-733R	1	•	•					
32	GAS SOLENOID	0972-423-040R	1	•	•					
33	SWITCH	1115-270-019R	1	•	•					
34	BLACK FRAME SHIELD	1115-299-073R	1	•	•					
35	POWER LEAD	R-0010-435-1R	1	•	•					
36	CABLE RELIEF	1361-599-674R	1	•	•					
37	RUBBER CABLE BUSH	1361-599-198R	1	•	•					
38	WORK LEAD	R-5041-277-1R	1	•	•					
68	THERMAL CIRCUIT	1115-299-033R	1	-	•					

SPEEDTEC 180C



SPEEDTEC 200C

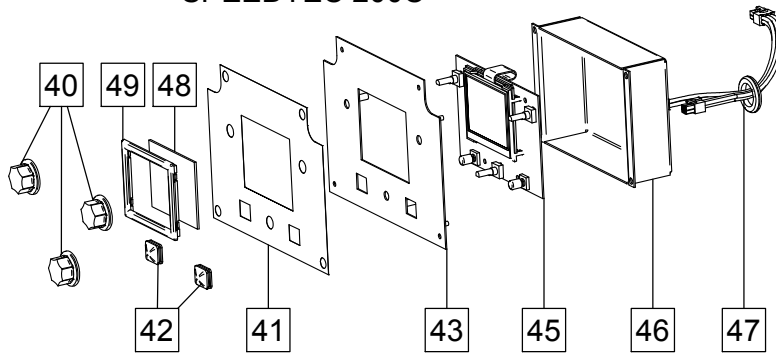


Figure B.

Figure B: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
39	KNOB	9ST13639-3	1	●	-					
40	KNOBS	9SS18425-1	2	●	-					
40	KNOBS	9SS18425-1	3	-	●					
41	STICKER	R-0010-443-1R	1	●	-					
41	STICKER	R-0010-444-1R	1	-	●					
42	RUBBER BUTTOM	1373-182-005R	1	●	-					
42	RUBBER BUTTOM	1373-182-005R	2	-	●					
43	FRONT PANEL	R-3019-268-1/08R	1	●	-					
43	FRONT PANEL	R-3019-269-1/08R	1	-	●					
44	P.C. BOARD	Y031-1R	1	●	-					
45	P.C. BOARD COMPLETE	R-6042-063-1R	1	-	●					
	DISPLAY	0942-172-001R								
46	COVER	R-1019-302-1/08R	1	-	●					
47	WIRING HARNESS	R-5041-250-3R	1	-	●					
48	PROTECTIVE SCREEN	R-0010-450-1R	1	-	●					
49	FRAME	R-0010-423-1R	1	-	●					

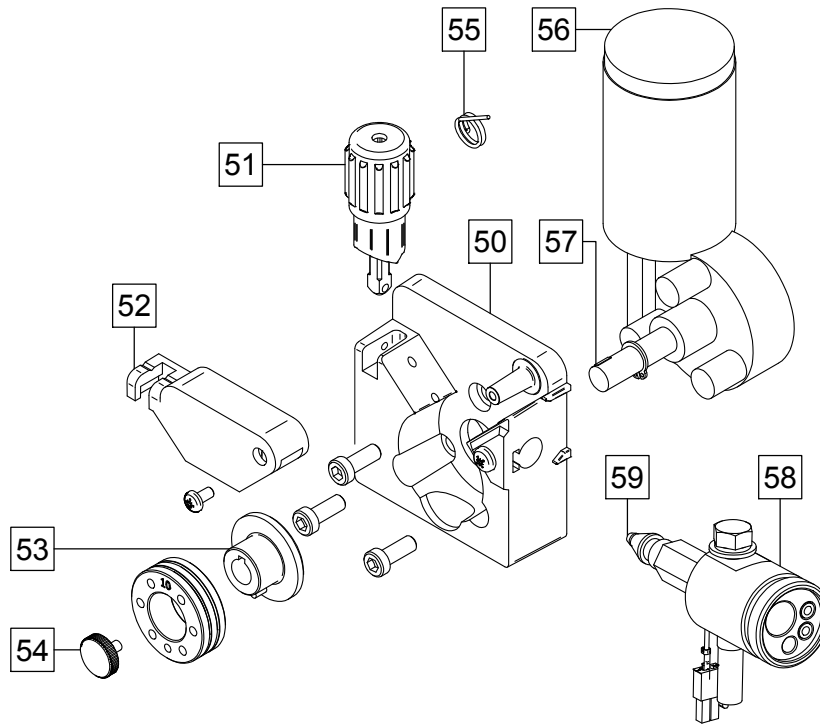


Figure C.

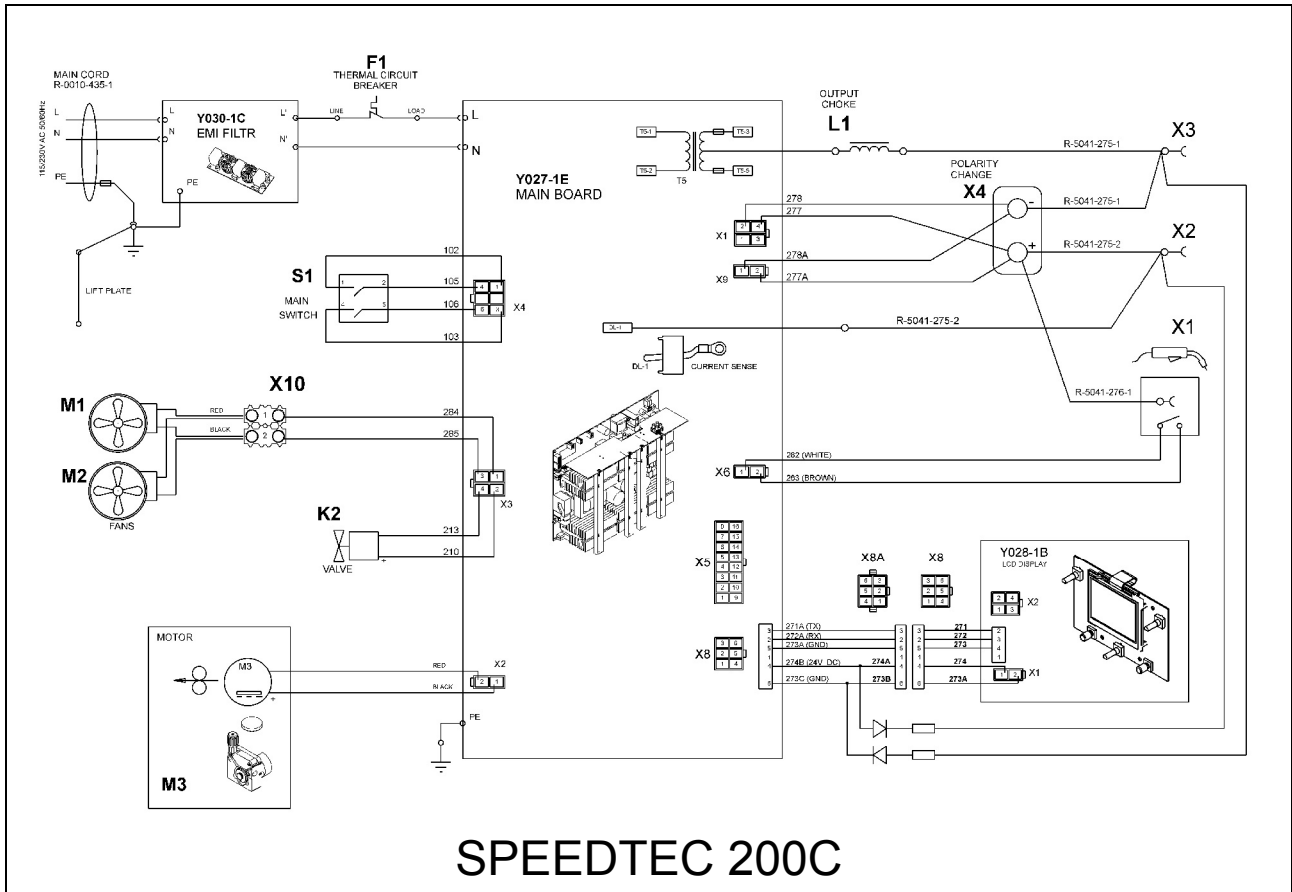
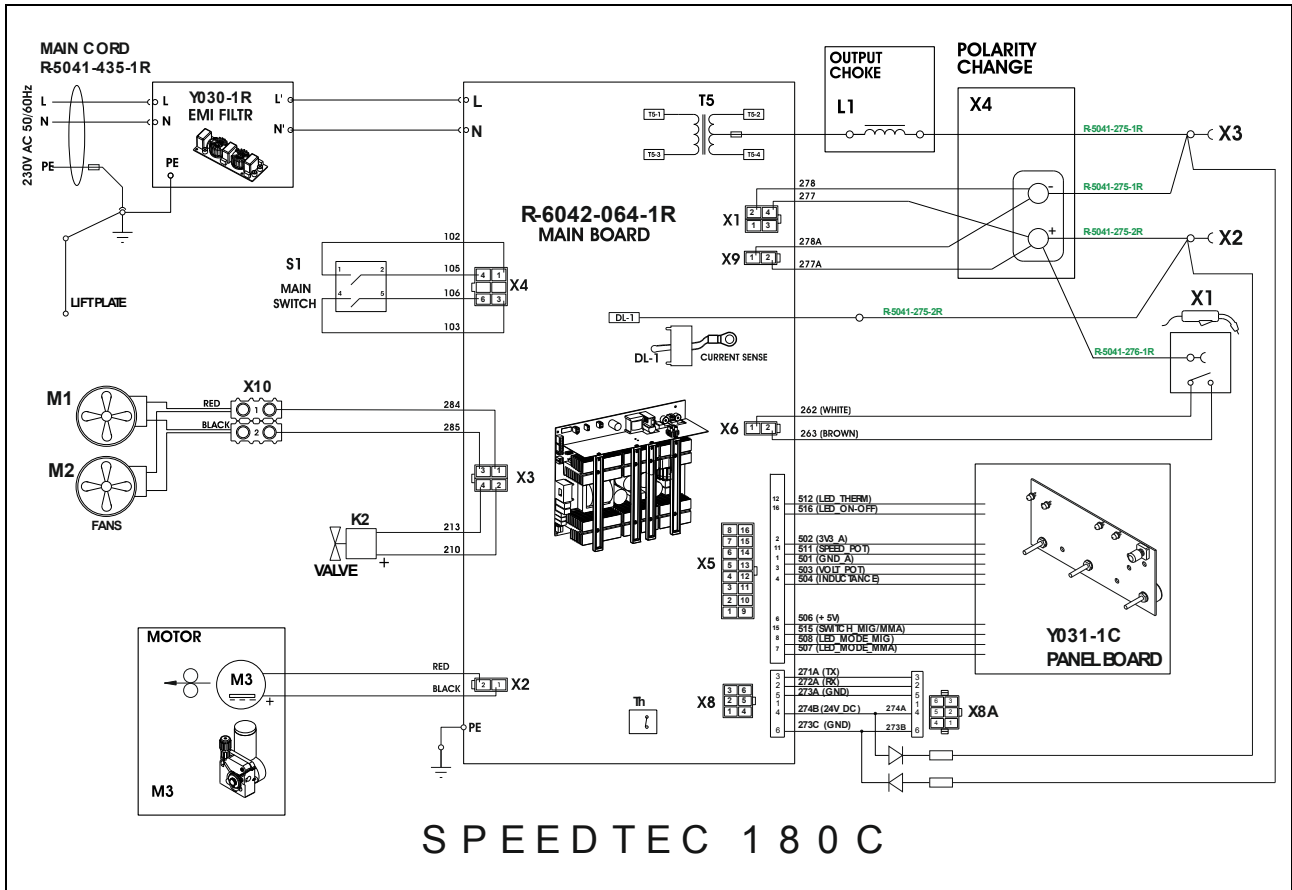
Figure C: Wire Drive Assembly & Euro Socket Assembly

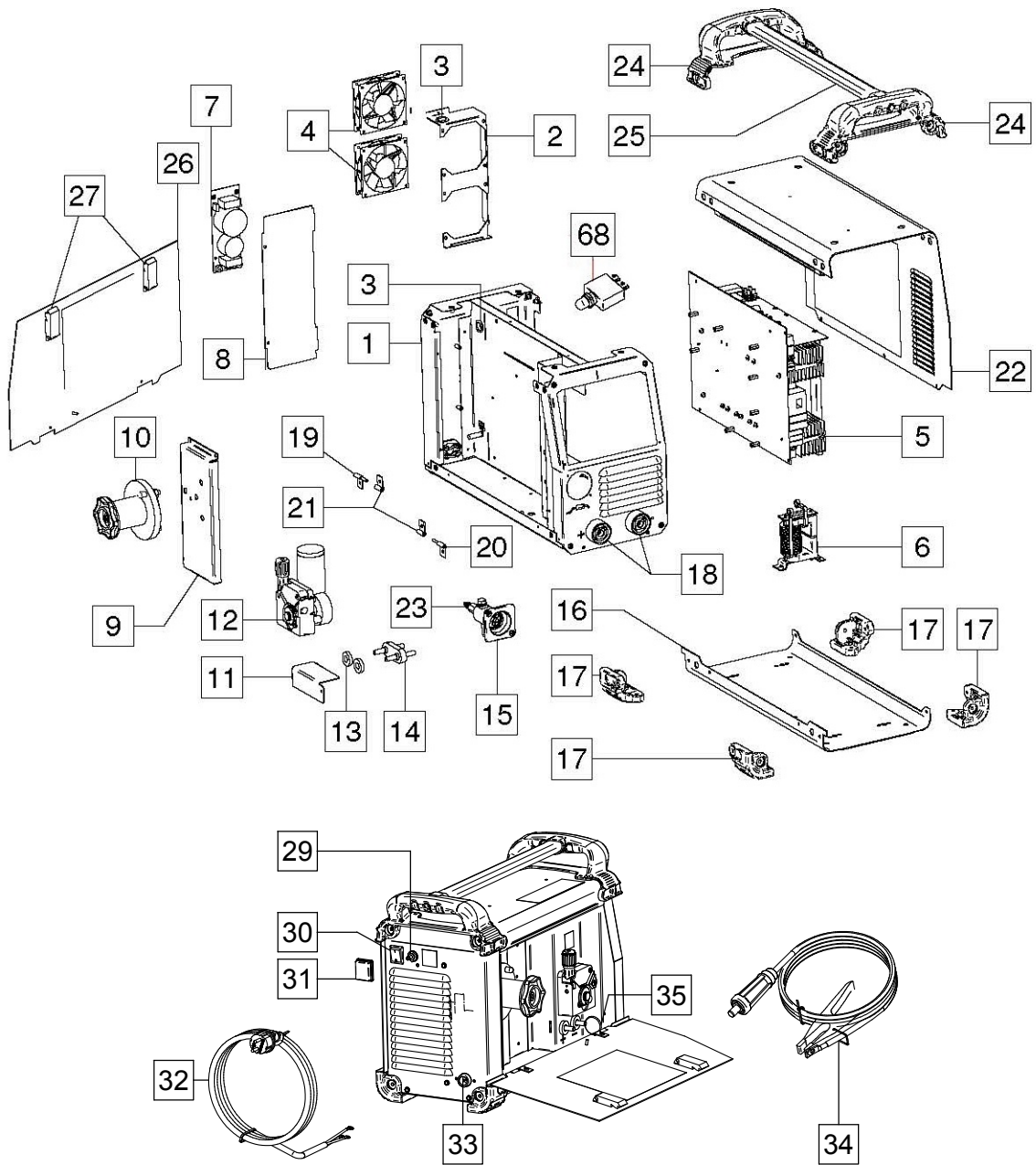
Item	Description	Part Number	QTY	1	2	3	4	5	6	7
	WIRE DRIVE ASSEMBLY	0744-000-246R	1	•	•					
50	FEED PLATE	0744-000-248R	1	•	•					
51	FIXING ARM COMPL.	0646-233-015R	1	•	•					
52	PRESSURE ARM COMPL	0744-000-249R	1	•	•					
53	DRIVE ROLL ADAPTER	0744-000-250R	1	•	•					
54	FIXING CAP	0744-000-251R	1	•	•					
55	SPRING PRESSURE ARM	0744-000-252R	1	•	•					
56	MOTOR	0744-000-253R	1	•	•					
57	WOODROF KEY	0646-231-102R	1	•	•					
58	EURO SOCKET	R-8040-294-1R	1	•	•					
59	OUTLET GUIDE	R-2010-017-1R	1	•	•					

Miscellaneous Items (not shown in figure A, B, C)

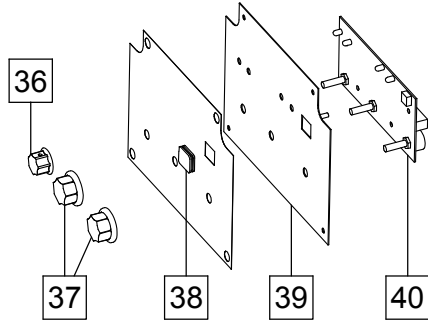
Item	Description	Part Number	QTY	1	2	3	4	5	6	7
60	WIRING HARNESS	R-5041-250-1R	1	•	•					
61	GROUNG WIRE	R-5041-250-6R	1	•	•					
62	WIRING HARNESS	R-5041-250-8R	1	•	•					
63	WIRE	R-5041-275-1R	1	•	•					
64	WIRE	R-5041-275-2R	1	•	•					
65	WIRE	R-5041-276-1R	1	•	•					
66	VRD HARNESS	R-5041-290-1R	1	•	•					
67	WIRE	R-5041-401-1R	1	-	•					

Electrical Schematic

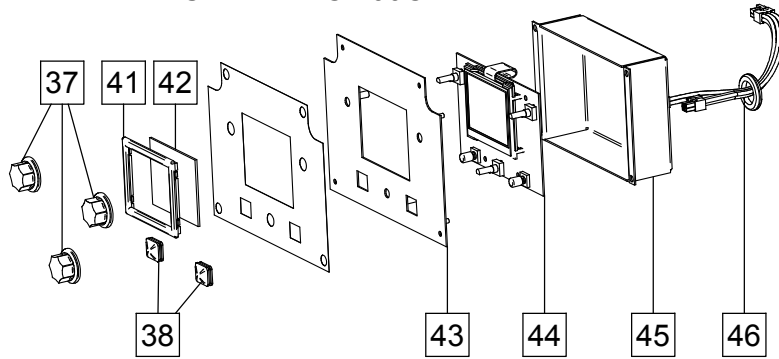




SPEEDTEC 180C



SPEEDTEC 200C



Description	Ref.	Recycle				ST				
		Fe	Al	Cu	Brass	Boards	Plastics	Liquid Cristal	External Electric Cables	Capacitors
RACK	1	X								
COVER	2,	X								
COVER	8, 11, 16, 22, 45		X							
LOCK	27						X			
LEFT SIDE PANEL	26		X							
FAN	4			X			X			
HINGLE	19, 20, 21	X								
P.C. BOARDS	5, 7, 40					X				
P.C. BOARD	44					X	X			
WIRE REEL SPINDLE	10	X					X			
SUPPORT	9	X								
EURO SOCKET	23				X					
EURO SLEEVE	15						X			
SOCKET	18	X		X			X			
SWITCHES	30	X			X					
BLACK FLAME SHIELD	31						X			
KNOB	36, 37						X			
BUTTON	38						X			
GAS SOLENOID	29	X		X	X					
INSULATOR RING	13						X			
WIRE FEEDER	12	X		X			X			
TERMINAL BLOCK	14				X		X			
POWER LEAD	32			X	X		X			
CORNER CAP	17						X			
HANDLE	24						X			

HANDLE	25		X							
WORK LEAD	34								X	
RUBBER CABLE BUSH	3, 35						X			
CABLE RELIEF	33						X			
CHOKE	6	X		X			X			
FRONT PANEL	39, 43	X		X						
PROTECTIVE SCREEN	42						X			
FRAME	41						X			
WIRING HARNESS	46								X	
THERMAL CIRCUIT	68	X			X		X			

Quick Guide

QUICK GUIDE I

	Select Welding Process		SMAW (MMA) Welding		Basic menu
	Burnback		GMAW (MIG/MAG) Manual Welding		Brightness Level
	Run-in WFS		FCAW-S - Self-shielded Manual Welding		View Software and Hardware Version Information
	Preweld Time		GMAW (MIG/MAG) Synergic Welding		User Button
	Postflow Time		Select Process by Number		Cancel an Action
	Inductance		Select Gas		Switch On Output Voltage (TIG/MMA only)
	Spot Welding Setting		Select Wire Type (material)		Switch Off Output Voltage (TIG/MMA only)
	Spot Timer		Select Wire Size (diameter)		Unlock panel
	Switch off Spot Welding		Select Function of Gun Trigger (2-Step/4-Step)		Unlock Panel by Code
	2-Step		Configuration and Set-up		Hot Start
	4-Step		Lock/Unlock Panel		Arc Force
	Memory		Lock Panel		Adjust Voltage
	Save a Memory		Lock Panel by Code		Welding Material Thickness
	Recall a Memory (user memory)		Recall Factory Setting		Welding Current
	Clear a Memory		Select Menu (basic/advanced)		Wire Feeder Speed (WFS)
	GTAW (TIG) Welding		Advanced Menu		

User button

Recalls selection menu (basic)

Recalls selection menu (advanced)

Choose to redefine this button

Navigator knob

Changes the welding modes and their setting

Escape button

1. Cancels an action
2. Locks and Unlocks all Knobs and Buttons on the Panel (Press and Hold Button for 4s)

Spare Parts - Electrical Schematic

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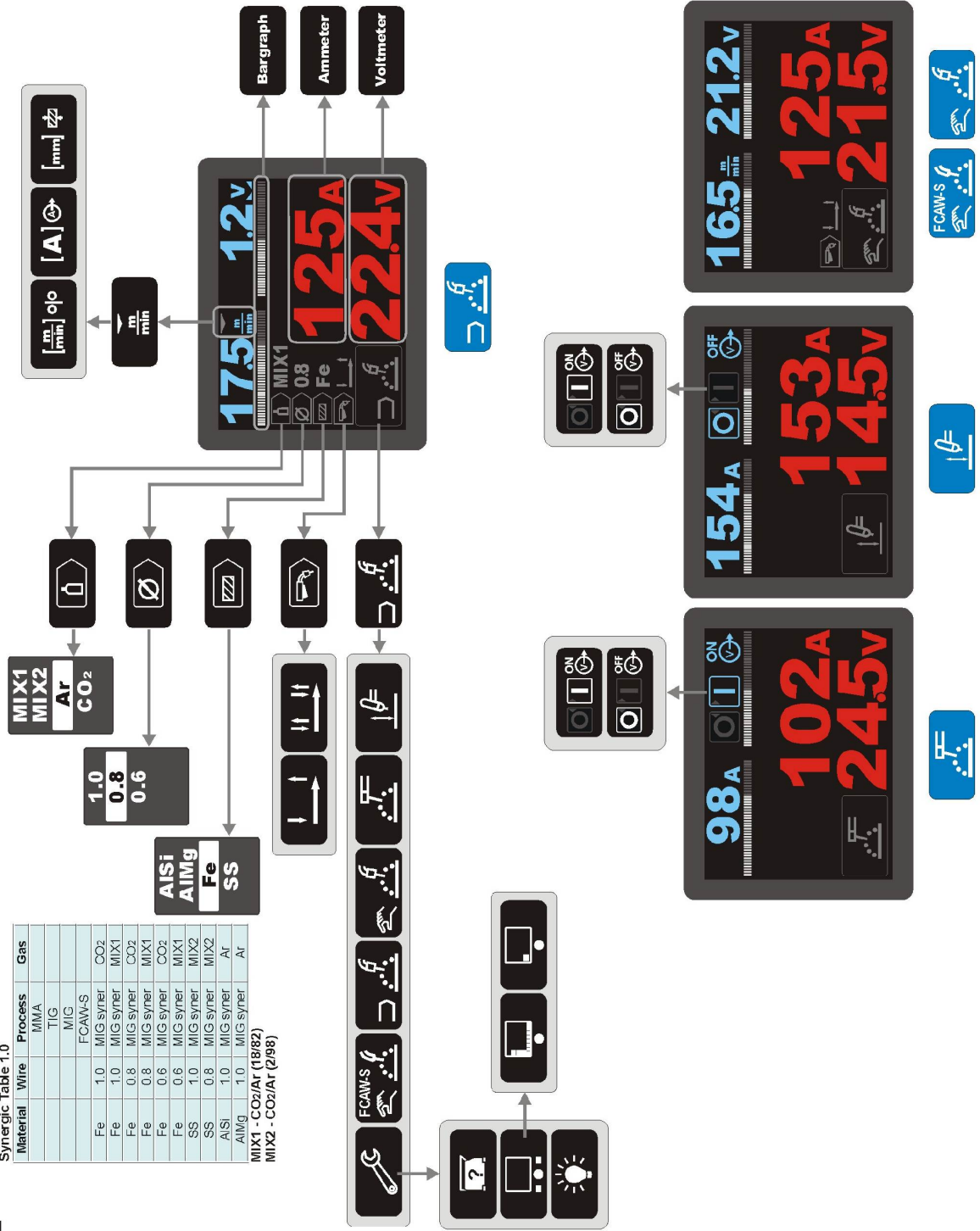
Spare Parts - Electrical Schematic

QUICK GUIDE II BASIC MENU



Synergic Table 1.0

Material	Wire	Process	Gas
		MMA	
		TIG	
		MIG	
		FCAW-S	
Fe	1.0	MIG syner	CO ₂
Fe	1.0	MIG syner	MIX1
Fe	0.8	MIG syner	CO ₂
Fe	0.8	MIG syner	MIX1
Fe	0.6	MIG syner	CO ₂
Fe	0.6	MIG syner	MIX1
SS	1.0	MIG syner	MIX2
SS	0.8	MIG syner	Ar
AlMg	1.0	MIG syner	Ar
MIX1 - CO ₂ /Ar (18/82)			
MIX2 - CO ₂ /Ar (2/98)			



QUICK GUIDE III ADVANCED MENU

