INSTRUCTION MANUAL FOR WIRE WELDING MACHINE

IMPORTANT: BEFORE STARTING THE EQUIPMENT, READ THE CONTENTS OF THIS MANUAL, WHICH MUST BE STORED IN A PLACE FAMILIAR TO ALL USERS FOR THE ENTIRE OPERATIVE LIFE-SPAN OF THE MACHINE. THIS EQUIPMENT MUST BE USED SOLELY FOR WELDING OPERATIONS.

1 SAFETY PRECAUTIONS

WELDING AND ARC CUTTING CAN BE HARMFUL TO YOURSELF AND OTHERS. The user must therefore be educated against the hazards, summarized below, deriving from welding operations. For more detailed information, order the manual code 3.300.758

ELECTRIC AND MAGNETIC FIELDS - May be dangerous.

· Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding/cutting current creates EMF fields around cables and power sources.

· The magnetic fields created by high currents may affect the operation of pacemakers. Wearers of vital electronic equipment (pacemakers) shall consult their physician before beginning any arc welding, cutting, gouging or spot welding operations.

· Exposure to EMF fields in welding/cutting may have other health effects which are now not known.

· All operators should use the following procedures in order to minimize exposure to EMF fields from the welding/cutting circuit:

- Route the electrode and work cables together
- Secure them with tape when possible.
- Never coil the electrode/torch lead around your body.
- Do not place your body between the electrode/torch lead and work cables. If the electrode/torch lead cable is on your right side, the work cable should also be on your right side.
- Connect the work cable to the workpiece as close as possible to the area being welded/cut.
- Do not work next to welding/cutting power source.

EXPLOSIONS

· Do not weld in the vicinity of containers under pressure, or in the presence of explosive dust, gases or fumes. · All cylinders and pressure regulators used in welding operations should be handled with care.

ELECTROMAGNETIC COMPATIBILITY.
This machine is manufactured in compliance with the instructions contained in the standard IEC 60974-10 (CL. A), and must be used solely for professional purposes in an industrial environment. There may be potential difficulties in ensuring electromagnetic compatibility in non-industrial environments.

DISPOSAL OF ELECTRICAL AND ELECTRONIC EQUIPMENT.
Do not dispose of electrical equipment together with normal waste! Electrical equipment that has reached the end of its life must be collected separately and returned to an environmentally compatible recycling facility. As the owner of the equipment, you should get information on approved collection systems from your local representative.
IN CASE OF MALFUNCTIONS, REQUEST ASSISTANCE FROM QUALIFIED PERSONNEL.

Extra precautions are to be observed when working on elevated positions.

Electromagnetic compatibility
In Canada, the EMC classification does not apply to arc welding power source.

Safety standards
To provide minimum requirements and recommendations to protect persons who work in an environment affected by welding, cutting, and allied processes see CAN/CSA-W117.2 standard.

1.1 WARNING LABEL

The following numbered text corresponds to the label numbered boxes.

B. Drive rolls can injure fingers.
C. Welding wire and drive parts are at welding voltage during operation — keep hands and metal objects away.
1 Electric shock from welding electrode or wiring can kill.
1.1 Wear dry insulating gloves. Do not touch electrode with bare hand. Do not wear wet or damaged gloves.

1.2 Protect yourself from electric shock by insulating yourself from work and ground.
1.3 Disconnect input plug or power before working on machine.
2 Breathing welding fumes can be hazardous to your health.
2.1 Keep your head away from fumes.
2.2 Use forced ventilation or local exhaust to remove fumes.
2.3 Use ventilating fan to remove fumes.
3 Welding sparks can cause explosion or fire.
3.1 Keep flammable materials away from welding.
3.2 Welding sparks can cause fires. Have a fire extinguisher nearby and have a watchperson ready to use it.
3.3 Do not weld on drums or any closed containers.
4 Arc rays can burn eyes and injure skin.
4.1 Wear hat and safety glasses. Use ear protection and button shirt collar. Use welding helmet with correct shade of filter. Wear complete body protection.
5 Become trained and read the instructions before working on the machine or welding.
6 Do not remove or paint over (cover) label.

2 GENERAL DESCRIPTIONS

The MULTIMIG 525 welding machine is a system suitable for synergic MIG/MAG and pulsed synergic MIG/MAG welding, developed with inverter technology.
It is equipped with three 4-roller gearmotors.
This welding machine must not be used to defrost pipes.

2.1 EXPLANATION OF TECHNICAL SPECIFICATIONS

No.	Serial number must be indicated on any request for service on the welding machine.
1~	Single-phase static transformer-rectifier frequency converter.
MIG	Suitable for MIG/MAG welding.
U0.	Secondary open-circuit voltage.
X.	Duty cycle percentage. The duty cycle expresses the percentage of 10 minutes during which the welding machine may run at a certain current without overheating.
I2.	Welding current
U2.	Secondary voltage with I2 current
U1.	Rated supply voltage.
1~ 50/60Hz	Single-phase 50 or 50 Hz power supply.
I1 Max	Max. absorbed current at the corresponding I2 current and U2 voltage.
I1 eff	This is the maximum value of the actual current absorbed, considering the duty cycle. This value usually corresponds to the capacity of the fuse (delayed type) to be used as a protection for the equipment.
IP21S	Protection rating for the housing.
S	Suitable for use in high-risk environments.

NOTE:
The equipment has also been designed for use in environments with a pollution rating of 3. (See IEC 60664).

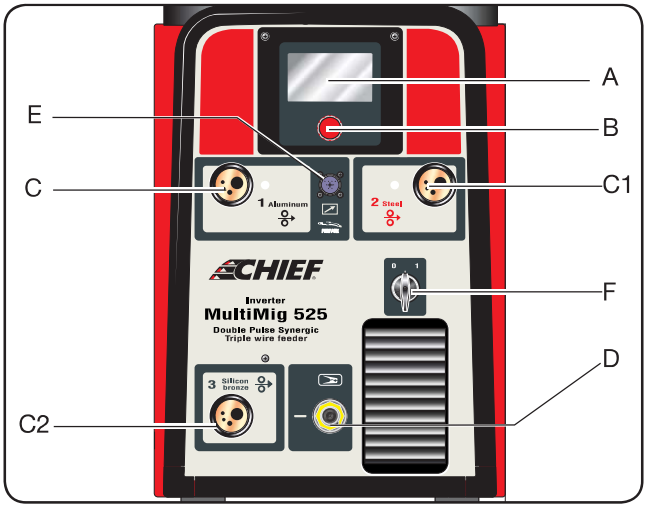
2.2 PROTECTION DEVICES

2.2.1 Block protection
In case of welding machine malfunction, the display screen **A** will show the message WARNING to identify the type of fault. If this message does not disappear when the machine is switched off and back on, contact the after-sales service.

2.2.2 Thermal cutout
This appliance is protected by a thermostat which prevents machine operation whenever acceptable temperatures are exceeded. In these conditions, the fan continues to operate and the display screen **A** shows the message WARNING tH in flashing mode.

2.3.3 Positioning on sloping planes.
Since this welding machine is equipped with wheels without brake, do not position it on sloping planes, to prevent machine tilting or uncontrolled movement.

3 CONTROLS LOCATED ON FRONT PANEL.



A – DISPLAY SCREEN.
This displays both the welding parameters and all the welding functions.

B - KNOB
Selects and adjusts both the welding functions and parameters.

C – CENTRALIZED COUPLING
To which the welding torch must be connected, prepared for aluminum or the Push-Pull torch. **(black handle)**

C1 – CENTRALIZED COUPLING
To which the welding torch must be connected, prepared for steel **(red handle)**

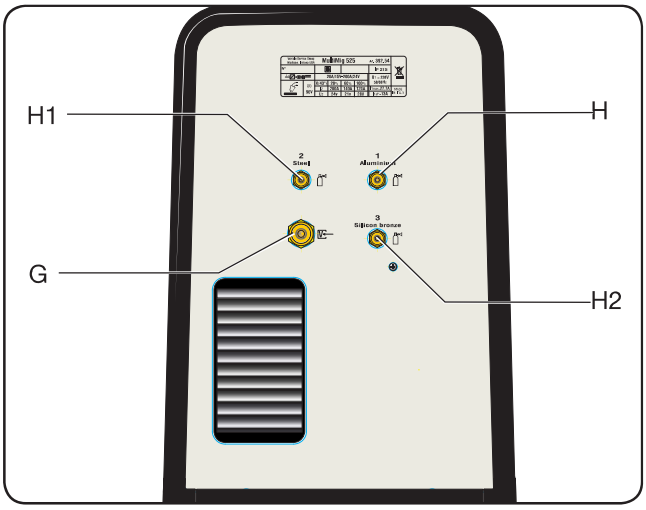
C2 – CENTRALIZED COUPLING
To which the welding torch must be connected, prepared for silicon bronze **(gray handle)**

D – SOCKET FOR GROUND CABLE

E – CONNECTOR
This is where the control cable of the Push Pull welding torch is connected.

F – SWITCH.
Turns on and off the machine

4 CONTROLS LOCATED ON REAR PANEL.



G-MAINS CABLE

H-GAS HOSE CONNECTION for alluminum torch

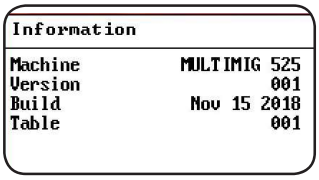
H1-GAS HOSE CONNECTION for steel torch

H2-GAS HOSE CONNECTION for silicon bronze torch

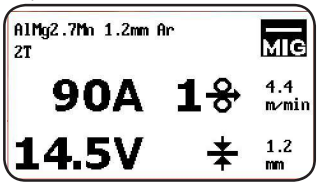
5 INSTALLATION AND START-UP

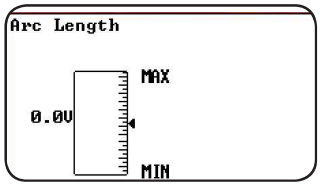
The welding machine must be installed by skilled personnel.
Do not place the welding machine on floor with inclination greater than 10°.
Make sure that the supply voltage is 230V 50/60Hz and a minimum of 30 amp service. If connected to a circuit protected by fuses, use time dely fuse marked "D".Use a plug Nema type 6-30P for 230 V and make sure that the "**green conductor**" of the power supply cable is connected to the ground or “earth” terminal.
Position the welding machine so as to allow the free circulation of air inside and, as much as possible, prevent metal or other dusts from penetrating. Position the welding machine in an area that ensures good stability.
Only skilled personnel should install the machine.
All connections must be carried out in compliance with current standards (IEC/CEI EN 60974-9) and in full observance of current safety laws.
This welding machine has been designed to simultaneously mount 3 welding torches and 3 wire reels with a MAX 200 mm/ 8″ diameter.
The power source can not weld with the 3 torches at the same time, the choice of which torch and type of metal to weld, is made simply by pressing and releasing for a few moments the start button of any of the 3 torches.
On the rear gas bottle support can be placed 2 gas bottles up to 180mm-7.1in in diameter and up to 1000mm-39.4in in height, or a single gas bottle up to 220mm-8.7in in diameter and up to 1600mm-63in in height.
The gas bottles must be firmly anchored to the gas bottle support using the supplied straps, as well the pressure regulators supplied must be assembled on the gas bottles themselves.
Only after placing the gas bottles, connect the outgoing gas hoses from the rear panel of the power source to the supplied pressure regulators.
Open one or all hinged side panels and mount the coil of the chosen metal wire on the appropriate support, insert the wire inside the gearmotor, making sure that the wire diameter is compatible with the wire feed roller and the choice of the type of welding that you want to run.
The wire must be aligned with the roller race and come out of the adapter **C**. Close the drive arm, fit the welding torch and the earth ground cable on socket **D**.
After fitting the reel and torch, switch on the machine,select the synergic curve suitable to the type of wire to be welded, following the instructions given in the service functions (PROCESS PARAMETERS) paragraph. Remove the gas nozzle and remove the welding tip of the torch. Press the torch button until the wire comes out.
BE CAREFUL to keep your face away from the end lance while the wire is coming out, reinstall the welding tip and gas nozzle.
Open the gas regulator and adjust the gas flow to 8 –10 l/min.
During welding, the display screen **A** displays the actual work current and voltage. The displayed values may be slightly different to those set. This can depend on numerous different factors - type of torch, thickness different to nominal thickness, distance between current nozzle and the material being welded, and the welding speed. After welding, the current and voltage values remain stored on the display **A**.
To display the set values, the knob **B** will have to be moved slightly, while, by pushing the torch button without welding, the display screen **A** shows the no load voltage value and a current value of 0.

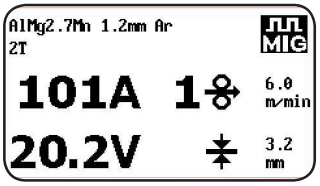
6 DESCRIPTION OF FUNCTIONS SHOWN ON THE DISPLAY SCREEN A.

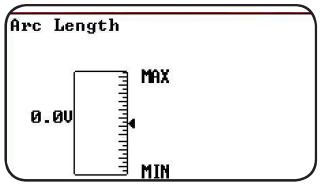


When the machine is switched on, for a few moments the display screen **A** displays: the article number of the machine, the version and development date of the software, and the release number of the synergic curves (this information is also given in Section 7.1 SERVICE FUNCTIONS).
Immediately after switch-on, the display screen **A** shows: The number of used torch, the synergic curve used, the welding mode **2T** ,**4T,** or **3L, SPOT** function, if active, the letters **PP** if a push-pull welding torch is used, the welding process "**SHORT** ,**PULSED or DOUBLE PULSED**", the welding current, the speed of the welding wire in metres/min, the welding voltage and the recommended thickness.
To increase or decrease the welding parameters, simply adjust by means of knob **B.** The values all change together in a **synergic** way.
To change the welding voltage **V,** simply press the knob **B** for less than 2 seconds. The display screen will show (**Arc Length**) an adjustment bar with central 0. The value can be changed by means of the knob **B** from -9.9 to 9.9. To exit from the function, briefly press the knob **B.**
By changing the value, once having exited the sub-menu, alongside the voltage **V**, an arrow will appear turned upwards to indicate a higher adjustment of the set value, while the arrow turned downwards will indicate a lower adjustment.





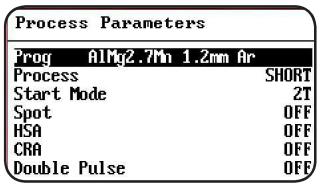


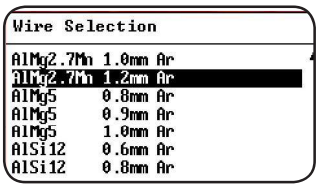


6.1 SERVICE FUNCTIONS (PROCESS PARAMETERS) SHOWN ON THE DISPLAY SCREEN A.

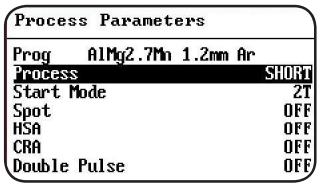
To access these functions, we must start from the main display page and press the knob **B** for at least 2 seconds. To enter the function, simply select it by means of the knob **B** and press it for less than 2 seconds. To return to the main display page, press the knob **B** for at least 2 seconds.
The functions which can be selected are:

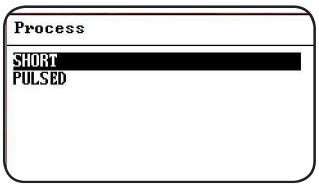
- **Prog (Wire Selection).**
  To choose a new synergic curve, by means of the knob **B**, it is necessary to select and press on the curve presented by the display screen **A.** Simply select the new curve of interest and confirm the choice by pressing the knob **B** for less than 2 seconds.
  After pressing the knob **B,** return is made to the previous display page (**PROCESS PARAMETERS**).





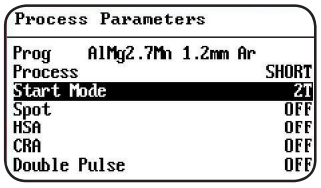
- **Process**

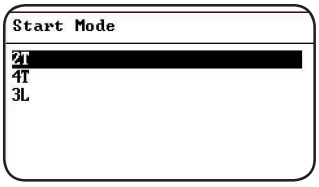




Use knob **B** to choose or confirm a welding mode by selecting and pressing **Short** or **Pulsed** for at least 2 seconds.
Short indicates that the short synergic welding mode is selected.
Pulsed indicates that the pulsed synergic welding mode is selected.

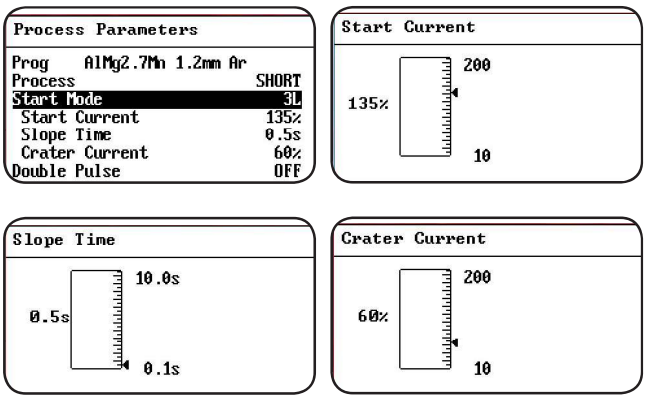
- **Start Mode**
  To choose the welding start mode **2T**, **4T** or **3L**, select one of the 2 modes by means of the knob **B** and press the knob **B** for less than 2 seconds to confirm the choice. This operation always returns us to the previous display page **(PROCESS PARAMETERS).**
  Mode 2T, the machine starts welding when the torch button is pressed and stops when this is released.
  Mode 4T, to start welding, press and release the torch button. To complete welding, press and release again.



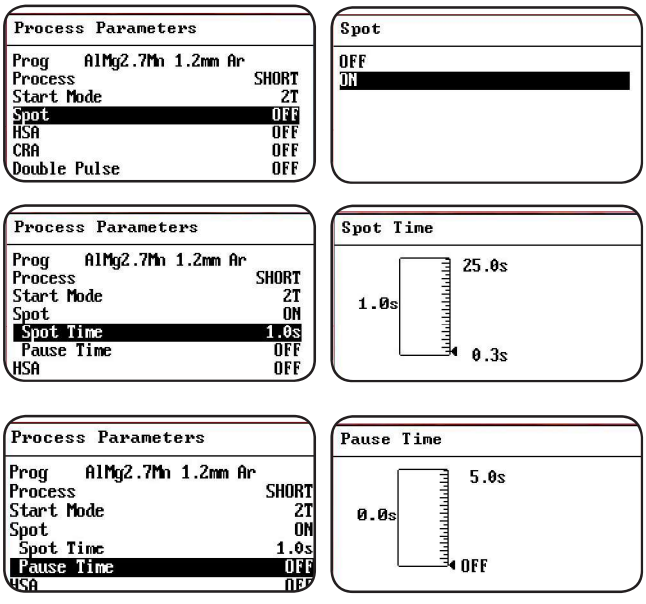


Mode **3L** Specially well suited to weld aluminium.
3 currents are available that can be used in welding by means of the weling torch start button. The current and the slope time values are set as follows:
Start Curr, starting current, adjustable from 10 to 200% of set welding current.
Slope time, possibility of adjusting from 0.1 to 10 seconds. Defines the connection time between starting current (**Start Curr**) and welding current and between welding current and crater filler current or crater filling at the welding end (**Crater Curr**).Possibility of adjusting from 10 to 200% of the set welding current.
Welding starts at the welding torch button.
The named current will be the starting current **Start Curr.** This current is kept as long as the welding torch button is held down; when the welding torch button is released the starting current connects to the welding

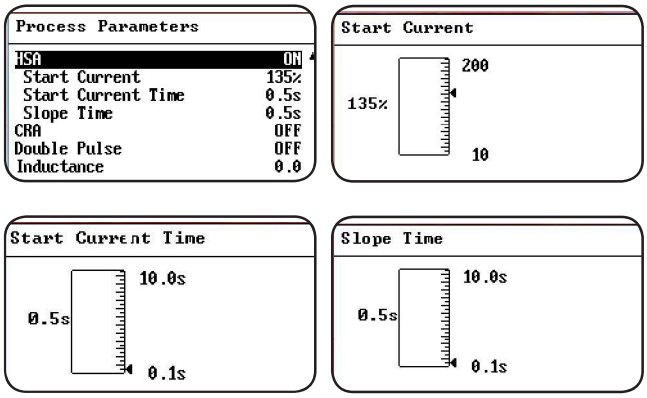
current, which is kept as long as the welding torch button is held down. When the torch trigger is pressed again, the welding current will connect to the crater-filler current (**Crater- Curr**) and it will be maintained until the torch button is released.



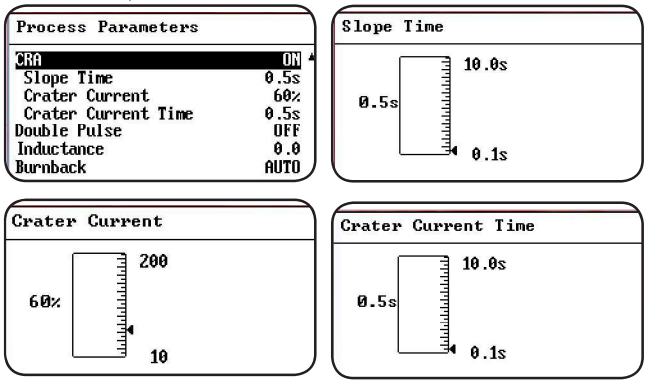
- **Spot and pause time**
  This function is blocked when function **3L** is activated. If we select the **spot ON** time, the **Spot Time** function appears on the display screen. If we select this, we can adjust it from 0.3 to 25 seconds by means of the adjustment bar. Besides this function, the display screen also shows **Pause Time**. If we select this, by means of the adjustment bar, we can regulate the pause time between one welding point or section and another. The pause time varies between 0 (OFF) and 5 seconds.
  To access the **Spot Time** and **Pause Time** functions,press the knob **B** for less than 2 seconds. Adjustment is always made by means of the knob **B.** To confirm,simply press it for less than 2 seconds. Once the choice has been confirmed, return is always made to the display page (**PROCESS PARAMS**).



- **HSA (Automatic Hot Start)**
  This function is blocked when function 3L is activated. Once the function has been enabled, the operator may adjust the starting current (**Start Curr**) from 10 to 200% of the welding current (Default 130%). The duration of this current (**S.C. Time**) may also be adjusted from 0.1 to 10 seconds (default 0,5 sec.). The switching time **Slope Time**) between the starting current (**Start Curr**) and the welding current may also be adjusted from 0.1 to 10 seconds (default 0.5 seconds.).

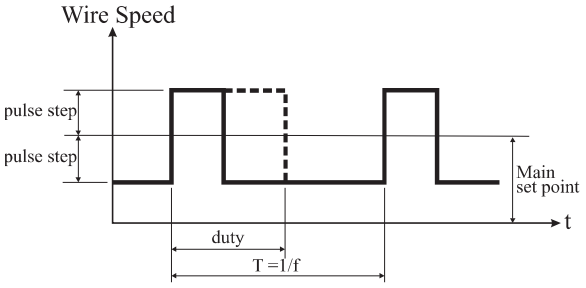


- **CRA (Crater filler – final crater filling)**
  This function is blocked when function 3L is activated. It is working during welding **2T**, **4T** and also in combination with function **HSA.** After activating the function, the operator may adjust the connection time (**Slope Time**) between the welding current and the crater filling current (**Crater Curr.**) from 0.1 to 10 seconds (default 0.5 seconds.).
  The operator may also adjust the crater filling current (**Crater Curr.**) from 10 to 200% of the welding current (Default 60%).
  The time (**C.C. Time**) of the crater filling duration may also be adjusted from 0.1 to 10 seconds (default 0.5 seconds).



- **Double Pulse/Level**
  This type of welding varies the current intensity between two levels. Before setting the double level welding, it is necessary to make a short bead to determine the wire speed and the current to obtain the penetration and the bead width closest to the type of welding to be made. In this way the wire feed speed value (and the corresponding current) is determined; the meters per minute that will be set will be alternatively added to and subtracted from this value. Before start working you should not forget that for a correct bead, the minimum overlapping between two “meshes” must be 50%.

	MIN	*MAX*	*DEF*
FREQUENCY	0,1HZ	5,0HZ	1,5HZ
PULSE STEP	0,1 M/MIN	3,0 M/MIN	1,0 M/MIN
DUTY CYCLE	25%	75%	50%
ARC CORRECTION	-9,9	9,9	0,0

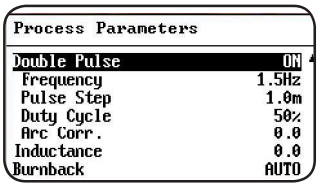


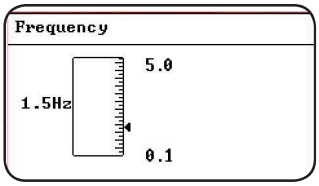
- **Frequency**
  The Hertz frequency is the number of periods per second. Period means the speed alternating from the higher to the lower values. The lower value, that does not penetrate, is used by the operator to change from one mesh to the next one; the higher speed, corresponding to the maximum current, is the penetrating speed and the mesh execution. The operator will stop to make the mesh.

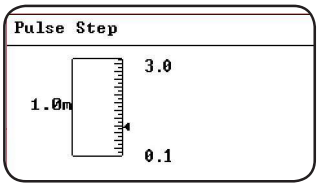
- **Pulse Step**
  Is the amplitude of the speed change in m/min. The speed change determines the sum and the subtraction of m/min from the reference speed described above. Parameters being the same, when the number increases the mesh is wider and penetration is deeper.

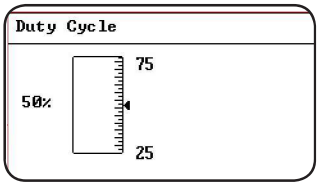
- **Duty Cycle**
  The double level time expressed as a percentage, is the higher speed/current time as compared to period duration. Parameters being the same, it determines the mesh diameter and therefore the penetration.

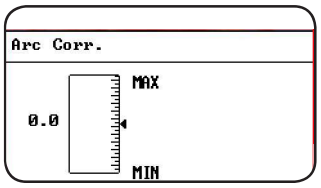
- **Arc Correction**
  Sets arc length of the higher speed/current. **Important**: make sure that the arc length is the same for both currents.



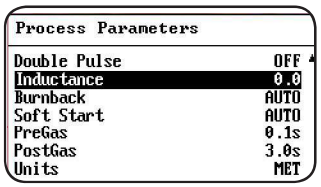


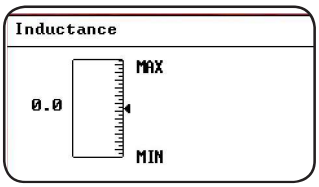




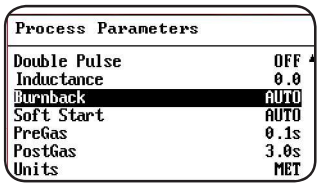


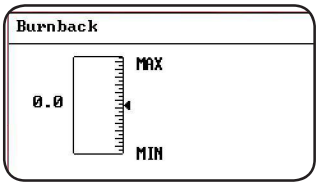
- **Inductance**
  Adjustment can vary from -9.9 to +9.9. Factory setting is zero. If the figure is negative, the impedance drops and the arc becomes harder, while if it increases, the arc is softer. To access this function, simply highlight it using the knob **B** and press it for less than 2 seconds. The display screen **A** shows the adjustment bar. The figure can be changed and confirmed by pressing the knob **B** for less han 2 seconds.



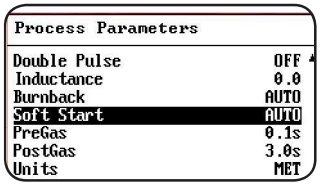


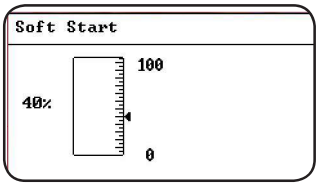
- **Burnback AUTO**
  The adjustment can vary from -9.9 to +9.9. Its purpose is to adjust the length of the wire coming out of the gas nozzle after welding. A positive figure corresponds to greater wire burning. Default is Auto (preset function). To access this function, simply highlight it using the knob **B** and press it for less than 2 seconds. The display screen **A** shows the adjustment bar. The figure can be changed and confirmed by pressing the knob **B** for less than 2 seconds.



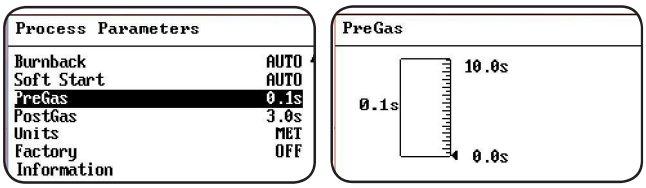


- **Soft Start AUTO**
  Adjustment can vary from 0 to 100%. This is the wire speed expressed in percentage of the speed set for welding, before the wire touches the piece to be welded.
  This adjustment is important to always obtain good starts.
  Default is Auto (preset function).
  To access this function, simply highlight it using the knob **B** and press it for less than 2 seconds. The display screen **A** shows the adjustment bar. The figure can be changed and confirmed by pressing the knob **B** for less than 2 seconds.



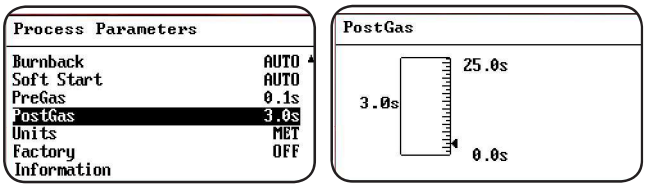


- **Pre Gas**



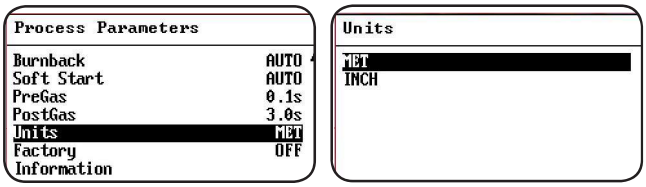
The adjustment can vary from 0 to 10 seconds.
To access this function, simply highlight it using the knob **B** and press it for less than 2 seconds. The display screen **A** shows the adjustment bar. The figure can be changed and confirmed by pressing the knob **B** for less than 2 seconds.

- **Post Gas**

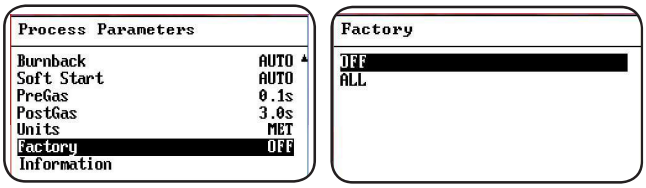


The adjustment can vary from 0 to 25 seconds.
To access this function, simply highlight it using the knob **B** and press it for less than 2 seconds. The display screen **A** shows the adjustment bar. The figure can be changed and confirmed by pressing the knob **B** for less than 2 seconds.

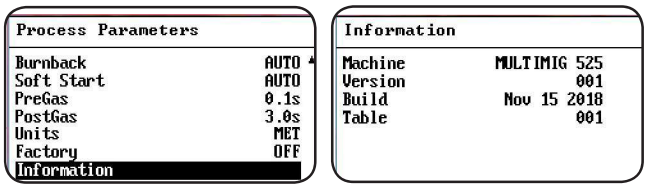
- **Units**
  Function changing the measurement unit from mm to inches



- **Factory Reset**
  The purpose is to return the welding machine to the original default settings.
  To access the function, simply highlight it using the knob **B.** By pressing this knob for less than 2 seconds, the display screen **A** shows the words **OFF** and **ALL.** By highlighting the word **ALL** and briefly pressing the knob **B** reset is made and the display screen **A** shows **Factory Done**!! This indicates the reset has been successful. To return to the previous display page, simply press the knob **B** for more than 2 seconds.



- **Information**



The display shows article number of the machine, version and development date of the software, and the release number of the synergic curves

NOTE. For all the functions adjusted by means of the adjustment bar, the initial default value can be reset.
This operation can be performed by pressing the knob **B** for more than 2 seconds only once the adjustment bar appears on the display screen **A.**

7 MAINTENANCE

All maintenance jobs must be performed by professional personnel according to IEC 60974-4 standard.

7.1 GENERATOR MAINTENANCE

In case of maintenance inside the appliance, make sure the switch **F** is in “O” position and that the power supply cable is disconnected from the mains.
Periodically, also clean the inside of the appliance and remove any metal dust using compressed air.

7.2 HOW TO PROCEED AFTER MAKING REPAIRS.

After making repairs, always ensure the wires are fully insulated between the primary side and the secondary side of the machine. Avoid the wires coming into contact with moving parts or parts that heat up during operation. Fit all the clamps back as on the original machine so as to avoid any contact between the primary and secondary in case of accidental lead breakage or disconnection.
Also fit the screws back on with the lock washers as on the original machine.

NOTA. En todas las funciones que se regulan por medio de la barra de regulación es posible volver al valor inicial (**default**).
La operación puede ser efectuada solo cuando en el display **A** aparece la barra de regulación y se realiza presionando la manecilla **B** por más de 2 segundos.

7 MANTENIMIENTO

Cada intervención de mantenimiento debe ser efectuada por personal cualificado según la norma IEC 60974-4.

7.1 MANTENIMIENTO GENERADOR

En caso de mantenimiento en el interior del aparato, asegurarse de que el interruptor **F** esté en posición "O" y que el cable de alimentación no esté conectado a la red. Periódicamente, además, es necesario limpiar el interior del aparato para eliminar el polvo metálico que se haya acumulado, usando aire comprimido.

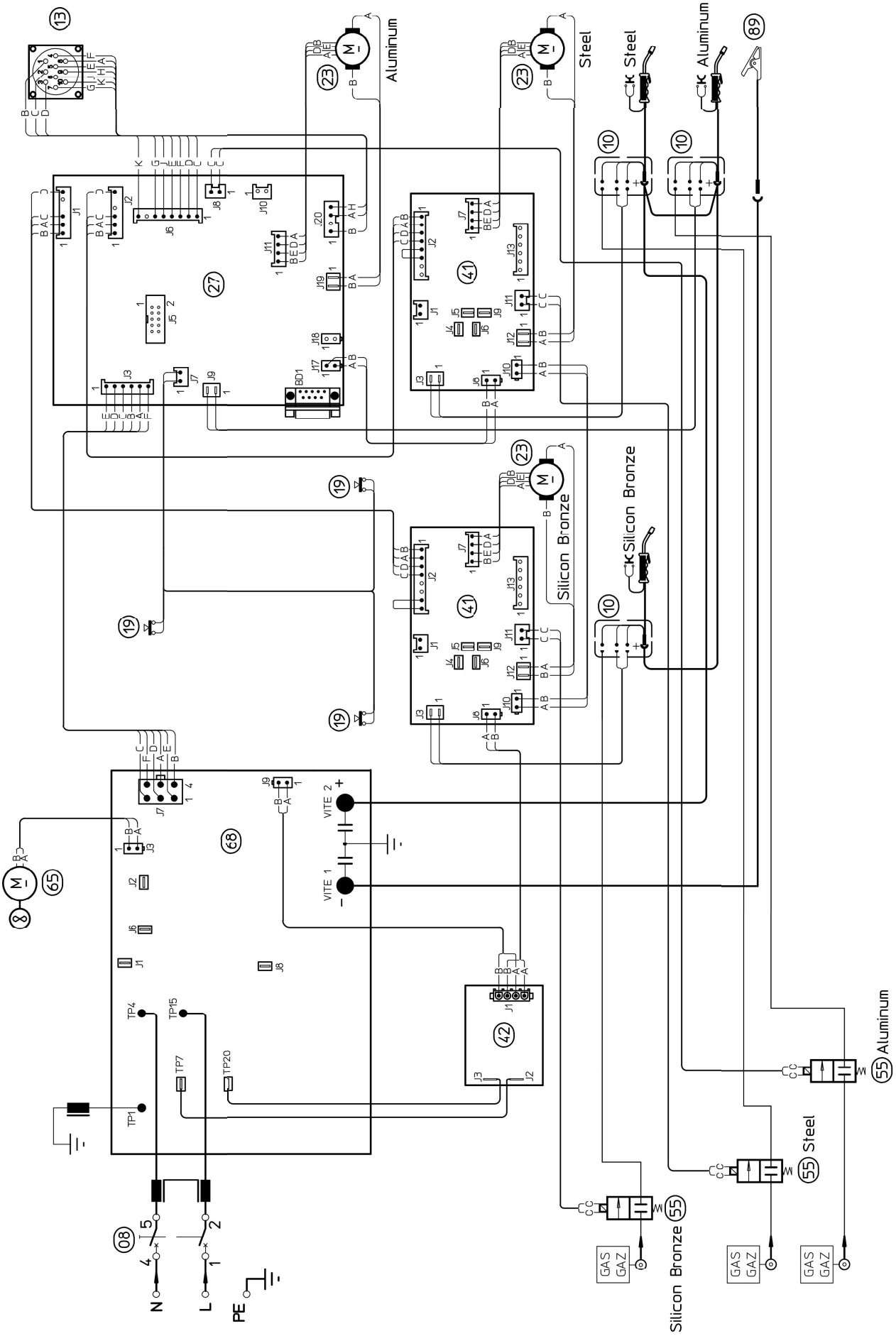
7.2 MEDIDAS A TOMAR DESPUÉS DE UNA INTERVENCIÓN DE REPARACIÓN.

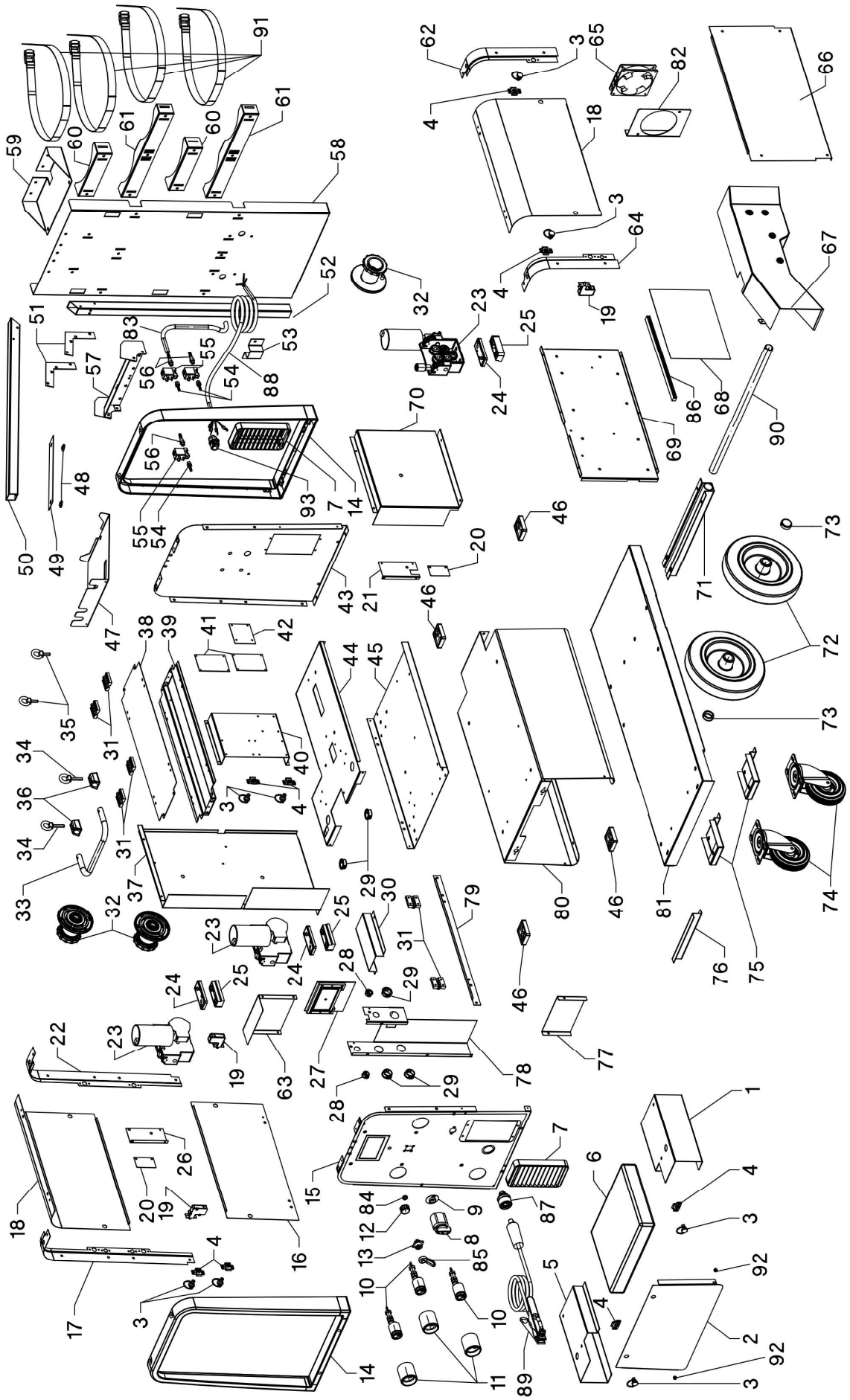
Después de haber realizado una reparación, hay que tener cuidado de reordenar el cablaje de forma que exista un aislamiento seguro entre el lado primario y el lado secundario de la máquina. Evitar que los hilos puedan entrar en contacto con partes en movimiento o con partes que se recalientan durante el funcionamiento. Volver a montar todas las abrazaderas como estaban en el aparato original para evitar que, si accidentalmente un conductor se rompe o se desconecta, se produzca un contacto entre el primario y el secundario.
Volver además a montar los tornillos con las arandelas dentelladas como en el aparato original.

QUESTA PARTE È DESTINATA ESCLUSIVAMENTE AL PERSONALE QUALIFICATO.
THIS PART IS INTENDED SOLELY FOR QUALIFIED PERSONNEL.
DIESER TEIL IST AUSSCHLIESSLICH FÜR DAS FACHPERSONAL BESTIMMT.
CETTE PARTIE EST DESTINEE EXCLUSIVEMENT AU PERSONNEL QUALIFIE.
ESTA PARTE ESTÁ DESTINADA EXCLUSIVAMENTE AL PERSONAL CUALIFICADO.
ESTA PARTE È DEDICADA EXCLUSIVAMENTE AO PESSOAL QUALIFICADO.
TÄMÄ OSA ON TARKOITETTU AINOASTAAN AMMATTITAITOISELLE HENKILÖKUNNALLE.
DETTE AFSNIT HENVENDER SIG UDELUKKENDE TIL KVALIFICERET PERSONALE.
DIT DEEL IS UITSLUITEND BESTEMD VOOR BEVOEGD PERSONEEL.
DENNA DEL ÄR ENDAST AVSEDD FÖR KVALIFICERAD PERSONAL.
ΑΥΤΟ ΤΟ ΤΜΗΜΑ ΠΡΟΟΡΙΖΕΤΑΙ ΑΠΟΚΛΕΙΣΤΙΚΑ ΓΙΑ ΤΟ ΕΙΔΙΚΕΥΜΕΝΟ ΠΡΟΣΩΠΙΚΟ.

WIRING DIAGRAM COLOUR CODE	
A	BLACK
B	RED
C	GREY
D	WHITE
E	GREEN
F	PURPLE
G	YELLOW
H	BLUE
K	BROWN
J	ORANGE
I	PINK

WIRING DIAGRAM COLOUR CODE	
L	PINK-BLACK
M	GREY-PURPLE
N	WHITE-PURPLE
O	WHITE-BLACK
P	GREY-BLUE
Q	WHITE-RED
R	GREY-RED
S	WHITE-BLUE
T	BLACK-BLUE
U	YELLOW-GREEN
V	BLUE


Aluminum
Steel
Steel
Aluminum
Silicon Bronze
Silicon Bronze
Aluminum
Steel
Silicon Bronze
VITE 1
VITE 2
TP1
TP4
TP15
TP7
TP20
N
L
PE
GAS
GAZ



POS	DESCRIPTION
01	DRAWER SUPPORT DX.
02	CLOSING PANEL
03	CLOSING
04	CLOSING
05	DRAWER SUPPORT SX.
06	BOX
07	PANEL
08	SWITCH
09	SWITCH PROTECTION
10	ADAPTER BODY
11	ADAPTER RING
12	HANDLE
13	PUSH-PULL CONNECTION
14	FRAME
15	FRONT PANEL
16	HINGED SIDE PANEL
17	FIXED SIDE PANEL
18	HINGED SIDE PANEL
19	SECURITY SWITCH
20	CLOSING CAP
21	PROTECTION
22	FIXED SIDE PANEL
23	MOTOR
24	SPACER
25	SPACER
26	PROTECTION
27	CONTROL CIRCUIT
28	CABLE
29	CABLE
30	CONVEYOR
31	HINGE
32	COIL SUPPORT
33	HANDLE
34	EYEBOLTS
35	EYEBOLTS
36	HANDLE SUPPORT
37	COIL SUPPORT
38	CLOSING PANEL
39	COVER
40	CIRCUIT SUPPORT
41	CIRCUIT
42	CIRCUIT
43	BACK PANEL
44	INSIDE BAFFLE
45	BOTTOM
46	REST
47	TORCH DOOR PLATE
48	INSULATING BUSH
49	TORCH INSULATION
50	TORCH SUPPORT TUBE
51	CONNECTION PLATE

POS	DESCRIPTION
52	TORCH SUPPORT TUBE
53	TUBE BLOCKING
54	FITTING
55	SOLENOID VALVE
56	FITTING
57	CABLES SUPPORT
58	GAS CYLINDER SUPPORT
59	ATTACK BOTTLE SUPPORT
60	GAS CYLINDER SUPPORT
61	GAS CYLINDER SUPPORT
62	FIXED SIDE PANEL
63	PROTECTION
64	FIXED SIDE PANEL
65	MOTOR WITH FAN
66	FIXED SIDE PANEL
67	COVER
68	POWER CIRCUIT
69	INSIDE BAFFLE
70	GAS CYLINDER SUPPORT
71	AXLE SUPPORT
72	FIXED WHEEL
73	CAP
74	SWIVELING WHEEL
75	WHEELS BRACKET
76	PANEL SUPPORT
77	PROTECTION
78	PROTECTION
79	FIXED SIDE PANEL
80	POWER SOURCE SUPPORT
81	BOTTOM
82	MOTOR WITH FAN\SUPPORT
83	TUBE GAS
84	PROTECTION
85	CAP
86	INSULATION
87	SOCKET
88	NETWORK CABLE
89	EARTH CABLE
90	AXLE
91	BELT
92	BRASS BUSH
93	CABLE CLAMP

When ordering spare parts please always state the machine item and serial number and its purchase data, the spare part position and the quantity.