

PNEUMATIC FEED ASSIST

Product features

The Pneumatic Feed Assist (PFA) provides an economical method to assist your wire feeder in moving wire through the conduit in applications where long conduit runs are a necessity. The PFA reduces wire drag in the conduit for both large and small diameter wires as well as ferrous or non-ferrous metals.

Features

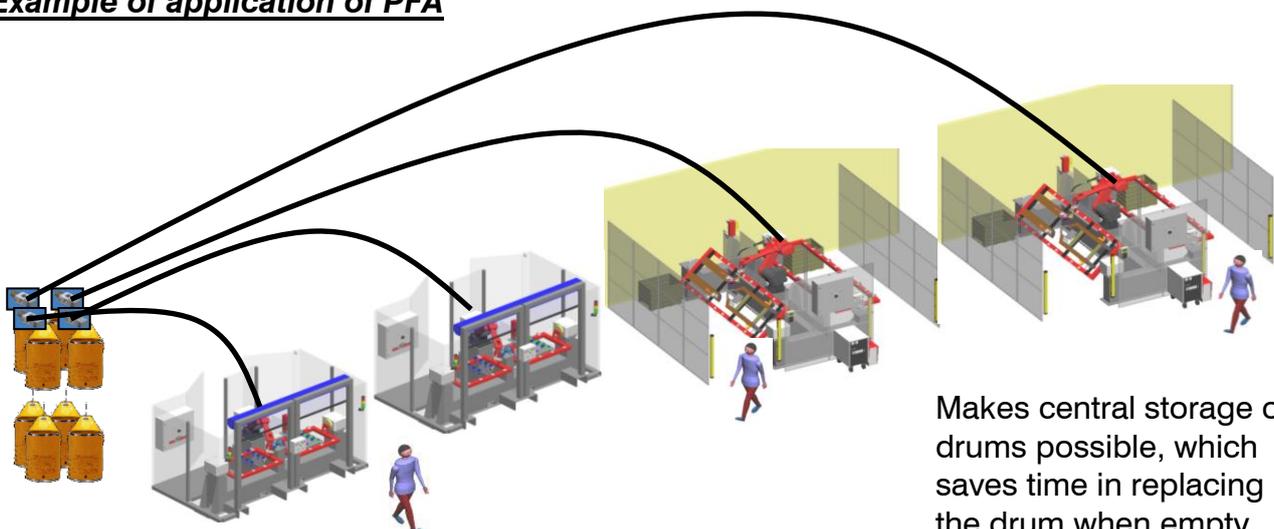
- The PFA works independent and is not linked to the wire feeder. Therefore the PFA is a push-push system and not a push-pull system which are far more fragile
- Extends conduit life
- Increases arc-on time
- Reduces wire drag in the conduit
- Prevents drive roll “slippage”
- Ideal for soft metals like Aluminium and Silicon bronze
- Enables long conduit runs (up till 30 metres)
- Prevents burn back
- Works with any kind of wire packaging
- Requires only shop air to operate



Products

Product	Part number
PFA unit for 1,0mm wire (installation set included)	PFA10
PFA unit for 1,2mm wire (installation set included)	PFA12
PFA unit for 1,4mm wire (installation set included)	PFA14
PFA unit for 1,6mm wire (installation set included)	PFA16
PFA unit for *,*mm wire (installation set included)	PFA** (fill in your diameter)

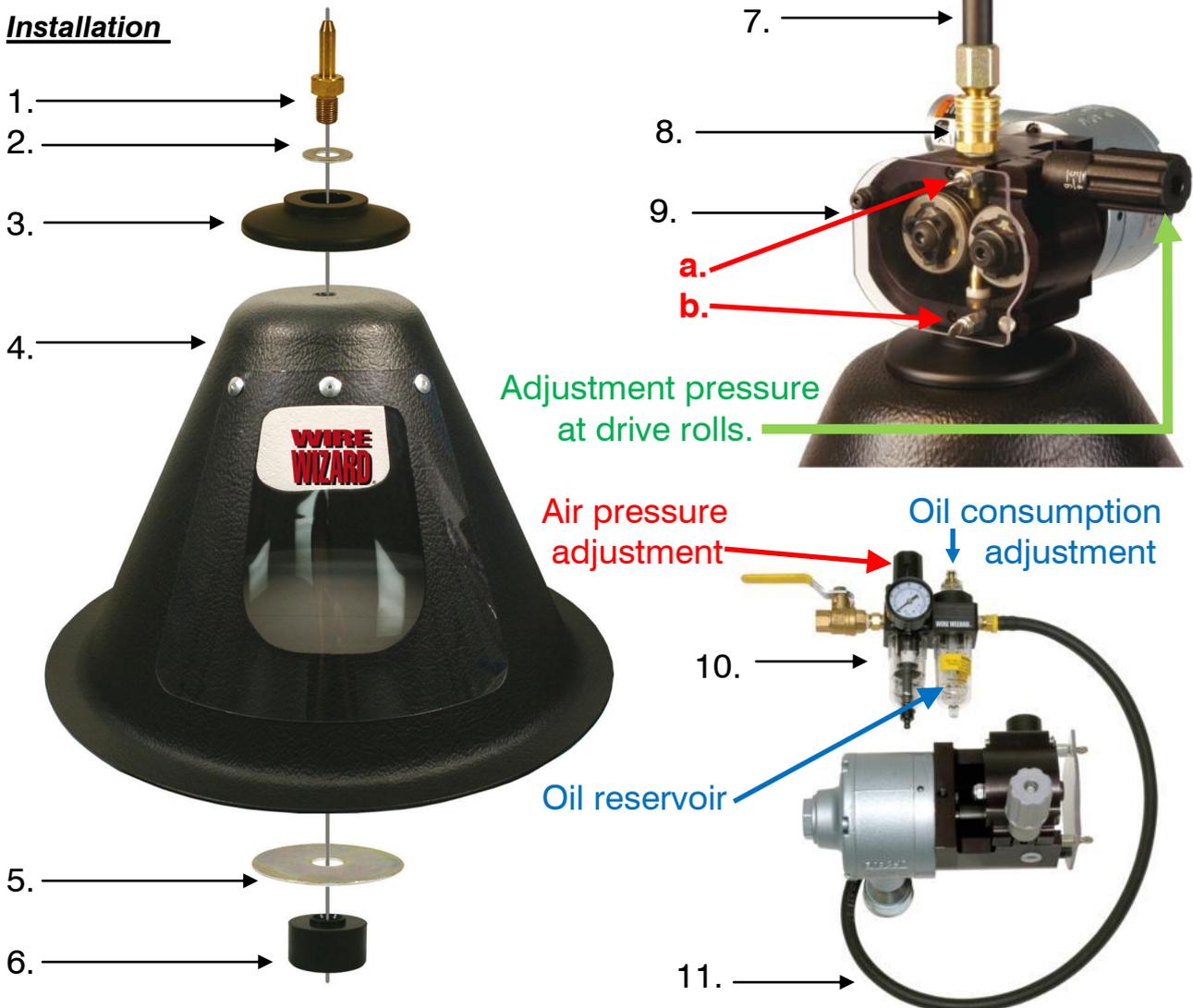
Example of application of PFA



Makes central storage of drums possible, which saves time in replacing the drum when empty.

PNEUMATIC FEED ASSIST

Installation



Step 1	Put the small metal ring (2) at the inlet guide (1).
Step 2	Put the Inlet guide (1) with the metal ring (2) into the plastic base.
Step 3	Put the complete inlet guide with base on top of the cone (4). Cone is not included.
Step 4	Fit the ceramic direct pull(6) at the inside of the drum cover onto the thread of the inlet guide (1), with the large metal ring (5) in between.
Step 5	Place the PFA (9) at the inlet guide at the cone and tighten the reced head screw (b.)
Step 6	Put the outlet guide (8) into the PFA (9) and tighten the reced head screw. (a.) Connect the conduit (7)
Step 7	Connect the air hose (11) to the fittings and secure it with a clamb
Step 8	Mount the FRL (filter, regulator and lubricator no.10) so that it is in vertical position and fill the reservoir with enclosed oil. Make sure the ball valve is closed and connect the compressed air. After you followed the start-up procedure your PFA-unit is ready to use. Adjust the OIL cusumption after some time, oil consumption should be adjusted in a way that the PFA use a minimum of oil. (prevent leakage at the exit filter)

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Start-up procedure

1. First follow all steps of the installation.
2. Before you connect the air supply make sure that the ball valve is closed.
3. Open the bail and feed the wire through the feed assist and close the bail. Ensure that the wire is between the grooves in the drive rolls.

Never open the bail when pneumatic motor is under pressure !

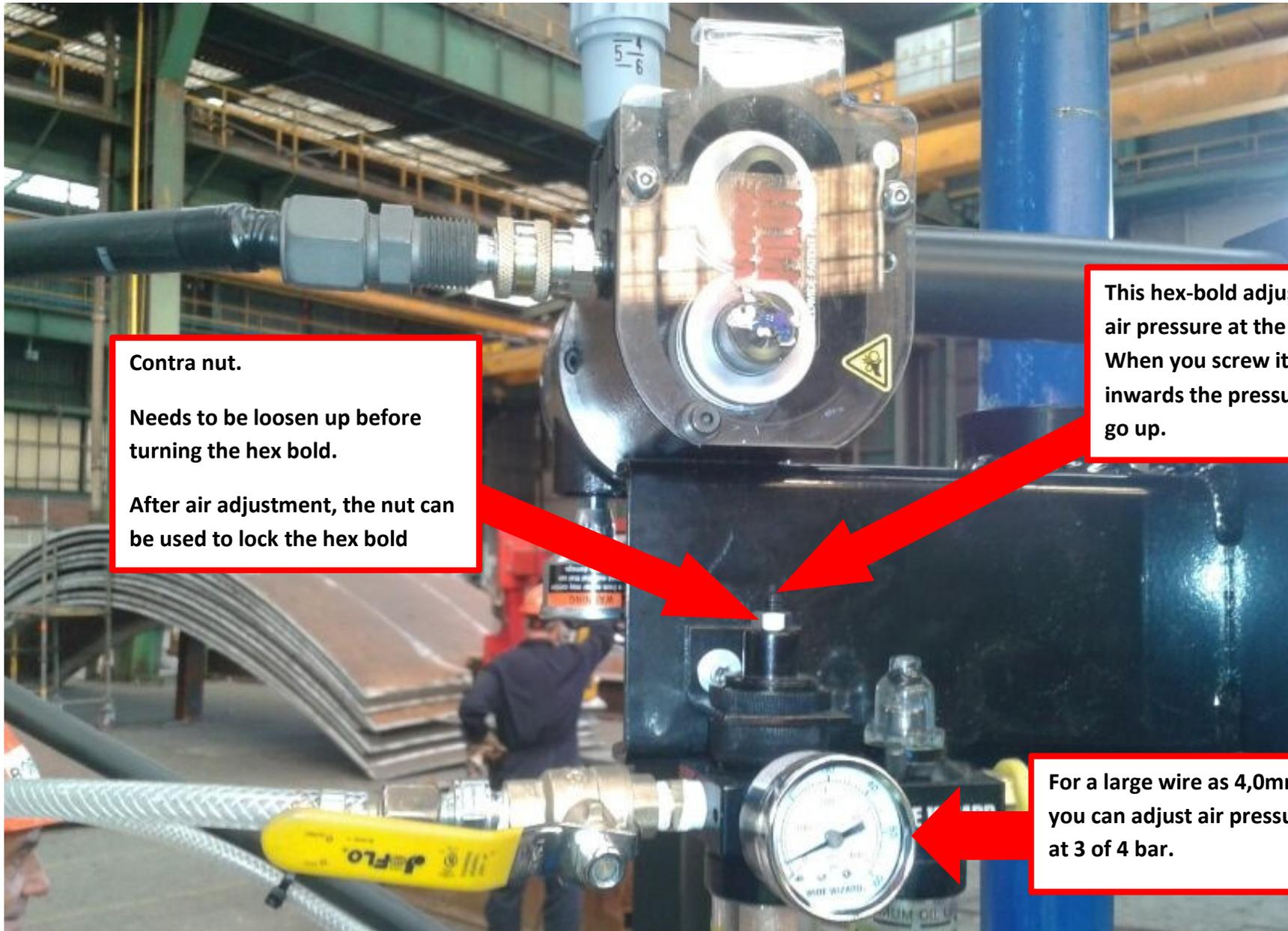
4. Confirm that the air pressure is set at 0 Psi on the regulator gauge. To set pressure at 0 psi lift the Knob and turn anti clockwise until end. (1 Psi = 0,069 Bar)
5. Open the ball valve.
6. Slowly increase the air pressure by turning the knob in a clockwise direction. When pressure is set push the knob to lock. (1 Psi = 0,069 Bar)
7. The amount of air pressure required to push the wire will vary depending on the following: wire diameter, wire source, conduit type, conduit length and the straightness of the conduit.
8. As the air pressure is increased, the motor will start to push the wire. **DO NOT** turn the pressure up more than what is needed to push the wire through the conduit alone, your wire feeder will do the rest. The feed assist motor can provide wire speeds in excess of 30 meter per minute so be careful with the air pressure.
9. If the feed assist is set-up correctly, the feed assist should stop turning when the wire is hold by your wire feeder. When the wire is released (resume welding) the motor must resume pushing.
10. If the drive rolls keep turning even when the wire is stopped, the air pressure is set to high or you should increase the pressure at the drive rolls to prevent the drive rollers to slip and damage the wire. If the pressure at the drive rolls is set to high the motor will use more air than necessary and the rolls might damage the wire.



PFA front view



PFA side view



Contra nut.
Needs to be loosen up before turning the hex bold.
After air adjustment, the nut can be used to lock the hex bold

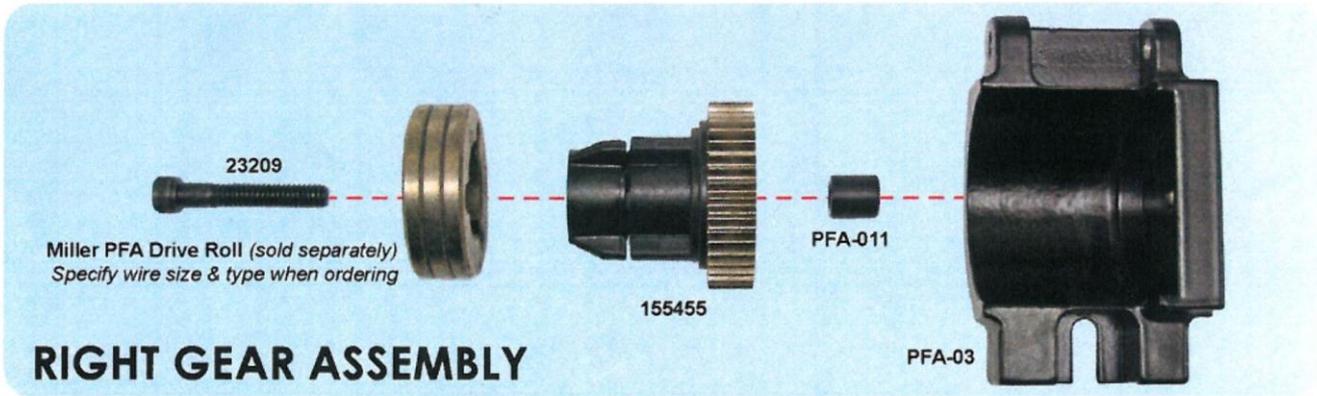
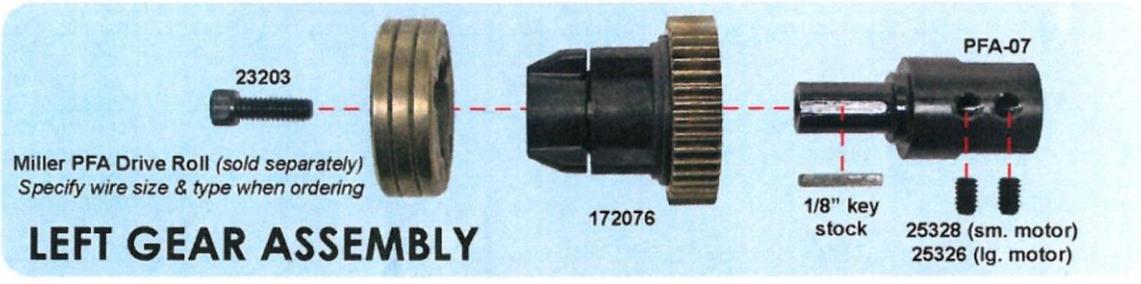
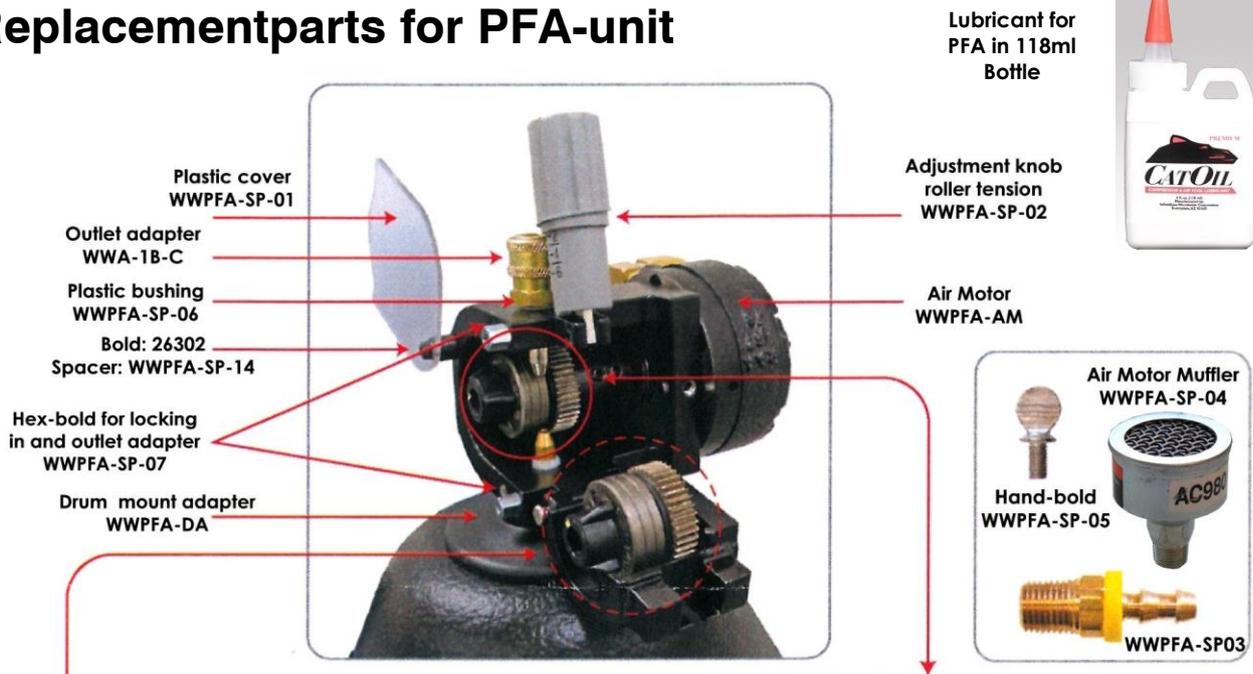
This hex-bold adjust the air pressure at the Motor. When you screw it inwards the pressure will go up.

For a large wire as 4,0mm you can adjust air pressure at 3 of 4 bar.

Keep in mind that the PFA unit is a feed assist and not mend to push the wire all to the end of the conduit. The wire feeder needs to pull the wire. The PFA assists the feeder to make it possible to bridge the long distance.

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Replacementparts for PFA-unit



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Feed Rollers

Diameter	Model	Article number	List price	Stock Item
0,8mm	V-Groove	WW053695	39,50 euro each	Yes
1,0mm	U-Groove	WW072000	39,50 euro each	Yes
1,2mm	U-Groove	WW053701	39,50 euro each	Yes
1,4mm	U-Groove	WW053702	39,50 euro each	Yes
1,6mm	U-Groove	WW053706	39,50 euro each	Yes
2,0mm	U-Groove	WW053704	47,60 euro each	Yes
2,4mm	U-Groove	WW053703	47,60 euro each	Yes
2,8mm	U-Groove	WW053705	47,60 euro each	Yes
3,2mm	U-Groove	WW053707	47,60 euro each	Yes
4,0mm	U-Groove	WW05M532	96,00 euro each	Yes
1,0mm	V-Knurled	WW132958	62,50 euro each	Yes
1,2mm	V-Knurled	WW132957	62,50 euro each	Yes
1,4mm	V-Knurled	WW132956	62,50 euro each	No
1,6mm	V-Knurled	WW132955	62,50 euro each	Yes
2,0mm	V-Knurled	WW132960	62,50 euro each	No
2,4mm	V-Knurled	WW132961	62,50 euro each	No
2,8mm	V-Knurled	WW132962	62,50 euro each	No
3,2mm	V-Knurled	WW132963	62,50 euro each	No

All our feedrollers have 2 groove's in each roller and can be used at both sides.

Replacement parts & accessoires

Item	Article number	List price
Drum mounting installation set (excl. Outlet guide)	WWPFA-DA	89,00 € each
Outlet guide for PFA with quick disconnect	A-1-BC	31,50 € each
Outlet guide for PFA with quick disconnect Large Wire	A-1-BC-HD	31,50 € each
Filter/regulator/lubricator	PFA-FRL	251,00 € each
Lubricant for PFA-unit in 118ml Bottle	PFA-OIL	11,55 € each
Silencer/Reclasifier	PFA-SR	98,50 € each
Bracket for mounting FRL to PFA incl. bolts	PFA-FS	19,90 € each
Bracket for PFA Wall-mounting	PFA-WM	98,50 € each
24-Volt solenoidkit with cable	PFA-SK	251,00 € each
Double Solenoidkit for wire pullback	PFA-SK2	297,50 € each

