

your way to torches

WARTUNG- UND GEBRAUCHSHANDBUCH

Vor Wartung, Inspektion oder dem Auswechseln von Verschleißteilen die Schweißanlage ausschalten. CEI EN 50078

MAINTENANCE MANUAL

Before you maintain or replace torch parts, turn the machine off. Never turn the machine off, before the post air-flow cycle has stopped. CEI EN 50078

MANUALE DI USO E MANUTENZIONE

Togliere tensione al generatore prima di qualsiasi manutenzione della torcia, dopo averla aomunque lasciata raffreddare. CEI EN 50078

MANUEL D'USAGE ET D'ENTRETIEN

Arrêter le générateur après que la torche soit refroidie et avant chaque entreeien. CEI EN 50078

MANTENIMIENTO MANUAL

Quitar la tensión al generador antes de cualquier mantenimiento y antes de substituir o verificar los repuestos de la antorcha, da todas formas, después de haber dejado enfriar la antorcha misma. CEI EN 50078

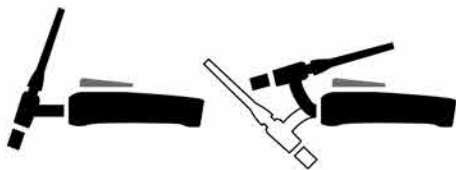
UNDERHALLS MANUAL

Slå ifrån den alektriska spänningen till strömkällan före någon inspektion eller underhåll sker på svetspistolen eller på strömkällan. Se dessutom till att svetspistolen har svalnat innan arbetet med underhållet påbörjas. CEI EN 50078

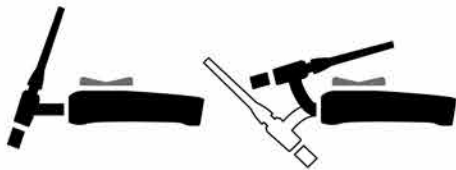


ERGOTIG 9

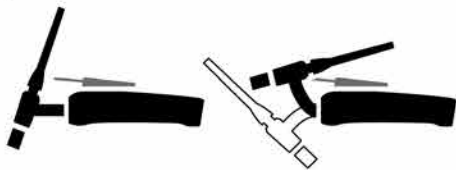
T I G R A N G E



	SINTIG 9	SINTIG 9 FX	m
FITTING	SA 1401	SB 1401	4
M12 x 1	SA 1801	SB 1801	8
FITTING	SA 1402	SB 1402	4
3/8 G	SA 1802	SB 1802	8



	DUALTIG 9	DUALTIG 9 FX	m
FITTING	SA 2401	SB 2401	4
M12 x 1	SA 2801	SB 2801	8



	FRANTIG 9	FRANTIG 9 FX	m
FITTING	SA 3401	SB 3401	4
M12 x 1	SA 3801	SB 3801	8



	TIG 9 V	m
FITTING	SC 4401	4
M12 x 1	SC 4801	8
FITTING	SC 4402	4
3/8 G	SC 4802	8



	FREE 9	m
FITTING	SA 4402	4
3/8 G	SA 4802	8



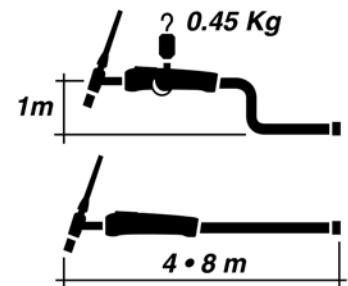
	AUTOTIG 9	m
FITTING	SD 4401	4
M12 x 1	SD 4801	8

Additional KIT	Ø
TT 0103	1.6
TT 0104	2.4
TT 0105	3.2



TECHNICAL DATA

Voltage class	L
Inert gas	Argon
Duty cycle 35% DC	110
Duty cycle 35% AC	95
Electrodes Ø mm	0.5 ÷ 1.6
Cooling	Air cooled



DECLARATION OF CONFORMITY

The undersigned company Trafimet - Via del Lavoro, 8 - 36023 Castegnero (VI) - Italy - declares that the product identified and described on this page complies with standard EN 60974-7 in accordance with the requirements contemplated by directive EEC 73/23 low voltage.

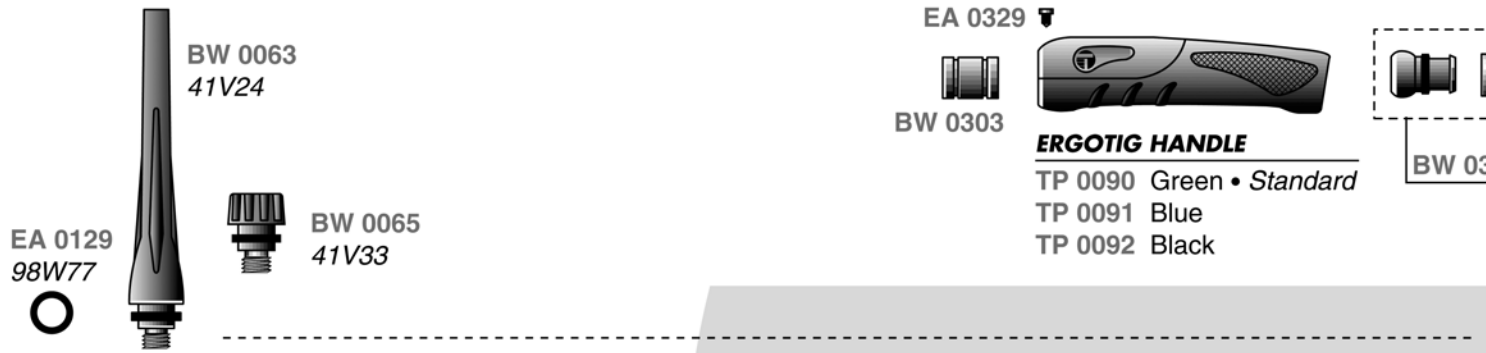


EN 60974-7



ERGOTIG 9

T I G R A N G E



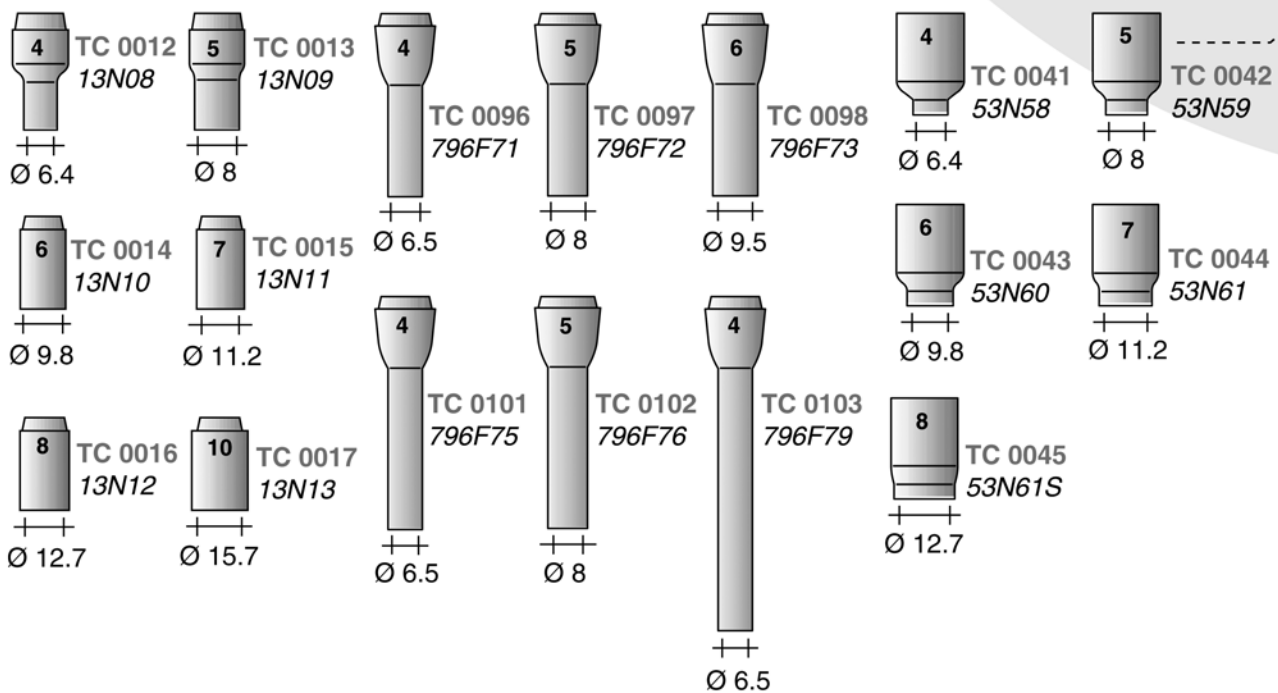
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- Ø 1.0 TD 0003-10 13N21
- Ø 1.2 TD 0003-12
- Ø 1.6 TD 0003-16 13N22
- Ø 2.0 TD 0003-20
- Ø 2.4 TD 0003-24 13N23
- Ø 3.2 TD 0003-32 13N24

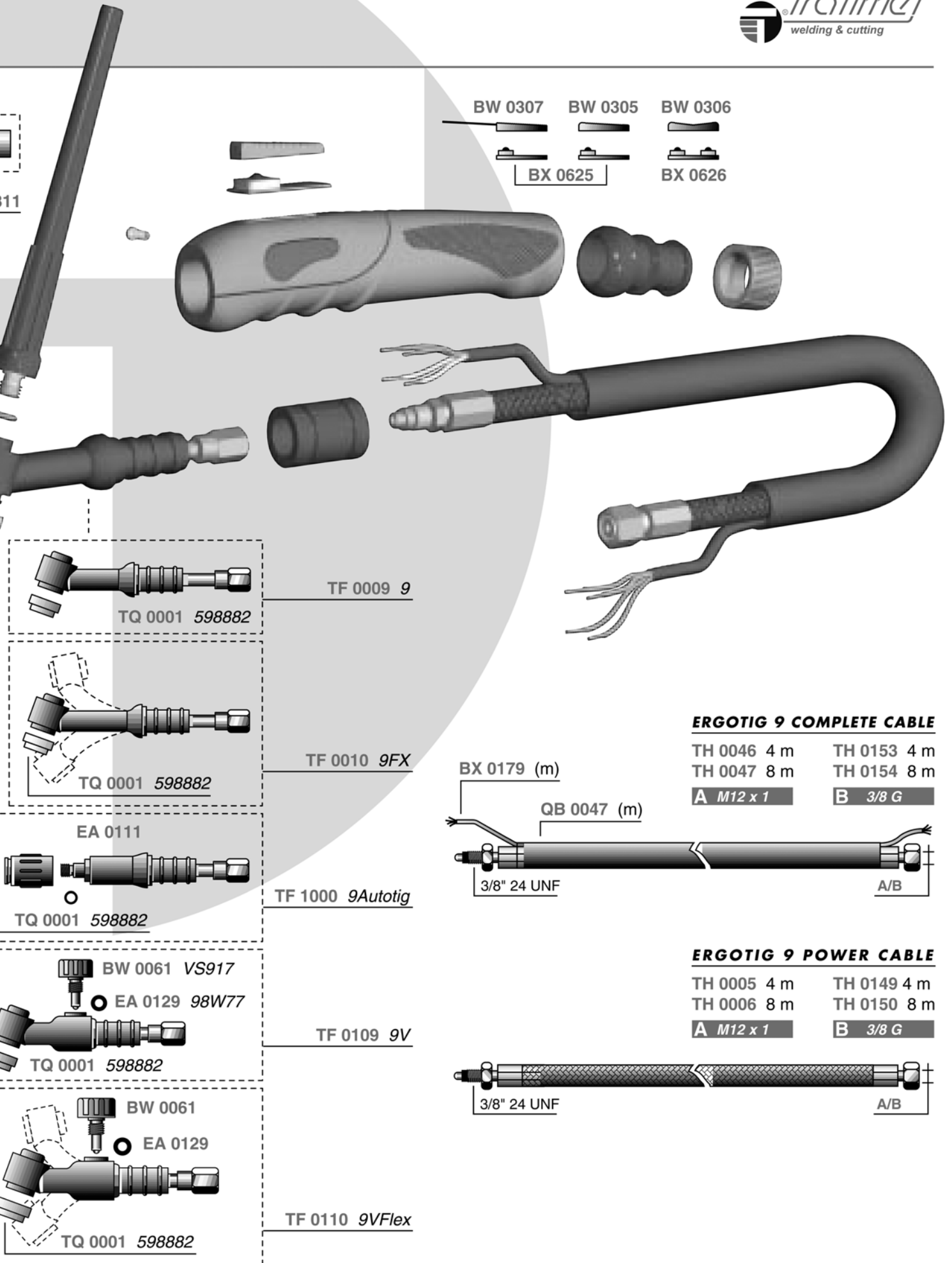


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- Ø 1.2 TE 0003-12
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- Ø 2.0 TE 0003-20
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- Ø 3.2 TE 0003-32 13N29



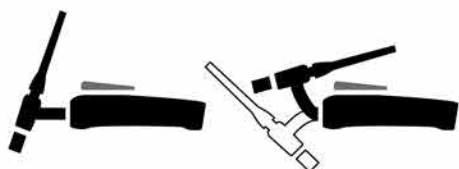
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- Ø 3.2 TE 0005-32 45V45



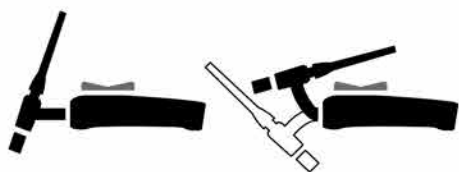


ERGOTIG 17

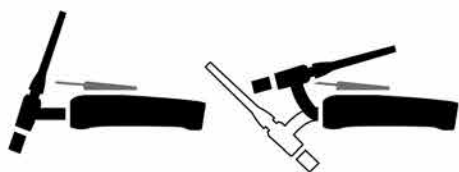
T I G R A N G E



	SINTIG 17	SINTIG 17 FX	m
FITTING	SF 1401	SG 1401	4
	SF 1801	SG 1801	8
M12 x 1			
FITTING	SF 1402	SG 1402	4
	SF 1802	SG 1802	8
3/8 G			



	DUALTIG 17	DUALTIG 17 FX	m
FITTING	SF 2401	SG 2401	4
	SF 2801	SG 2801	8
M12 x 1			



	FRANTIG 17	FRANTIG 17 FX	m
FITTING	SF 3401	SG 3401	4
	SF 3801	SG 3801	8
M12 x 1			



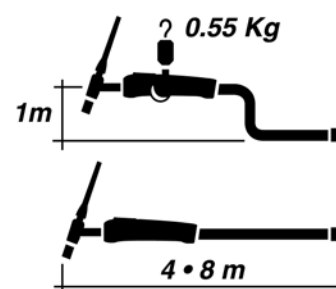
	TIG 17 V	FREE 17	m
FITTING	SH 4401		4
	SH 4801		8
M12 x 1			
FITTING	SH 4402	SF 4402	4
	SH 4802	SF 4802	8
3/8 G			

Additional KIT	Ø
TT 0103	1.6
TT 0104	2.4
TT 0105	3.2



TECHNICAL DATA

Voltage class	L
Inert gas	Argon
Duty cycle 35% DC	140
Duty cycle 35% AC	125
Electrodes \varnothing mm	0.5 ÷ 2.4
Cooling	Air cooled



DECLARATION OF CONFORMITY

The undersigned company Trafimet - Via del Lavoro, 8 - 36023 Castegnero (VI) - Italy - declares that the product identified and described on this page complies with standard EN 60974-7 in accordance with the requirements contemplated by directive EEC 73/23 low voltage.



EN 60974-7



ERGOTIG 17

T I G R A N G E

EA 0329



BW 0303



ERGOTIG HANDLE

- TP 0090 Green • Standard
- TP 0091 Blue
- TP 0092 Black



BW 0303

EA 130
98W18



BW 0066
57Y02



BW 0067
57Y04

- Ø 0.5 TD 0001-05 10N21
- Ø 1.0 TD 0001-10 10N22
- Ø 1.6 TD 0001-16 10N23
- Ø 2.0 TD 0001-20
- Ø 2.4 TD 0001-24 10N24
- Ø 3.2 TD 0001-32 10N25
- Ø 4.0 TD 0001-40 54N20
- Ø 4.8 TD 0001-48 30028



50



52

- Ø 1.0 TD 0022-10
- Ø 1.6 TD 0022-16
- Ø 2.4 TD 0022-24
- Ø 3.2 TD 0022-32
- Ø 4.0 TD 0022-40

- Ø 0.5 TE 0001-05 10N29
- Ø 1.0 TE 0001-10 10N30
- Ø 1.6 TE 0001-16 10N31
- Ø 2.4 TE 0001-24 10N32
- Ø 3.2 TE 0001-32 10N28
- Ø 4.0 TE 0001-40 406488
- Ø 4.8 TE 0001-48 30126



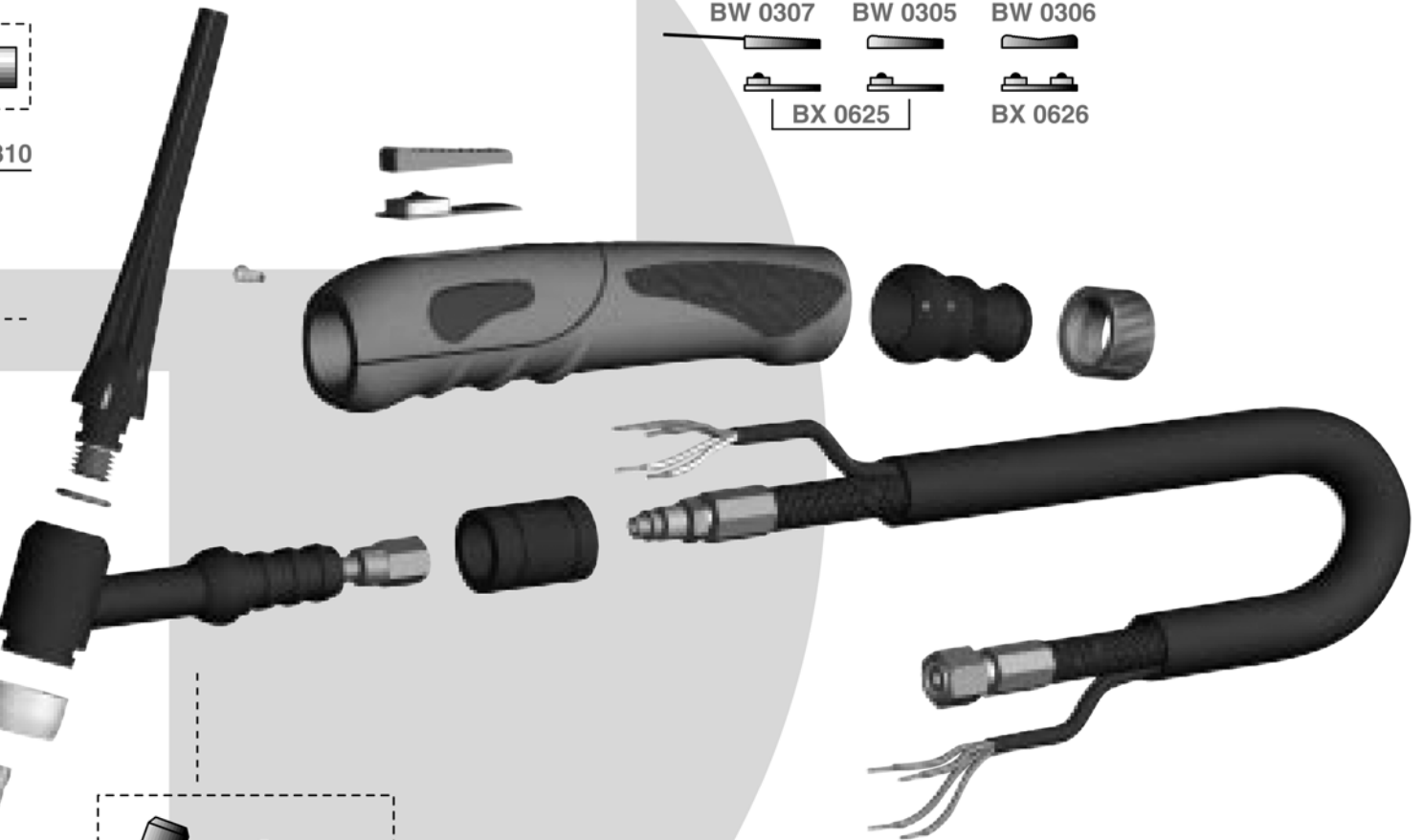
TQ 0003 54N01

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- Ø 1.0 TE 0006-10 45V24
- Ø 1.6 TE 0006-16 45V25
- Ø 2.4 TE 0006-24 45V26
- Ø 3.2 TE 0006-32 45V27
- Ø 4.0 TE 0006-40 45V28



- 4 TC 0002 10N50
Ø 6.4
- 8 TC 0006 10N46
Ø 12.7
- 5 TC 0091 10N49L
Ø 8
- 5 TC 0003 10N49
Ø 8
- 10 TC 0007 10N45
Ø 15.7
- 6 TC 0092 10N48L
Ø 9.5
- 6 TC 0004 10N48
Ø 9.8
- 12 TC 0008 10N44
Ø 19
- 7 TC 0093 10N47L
Ø 11

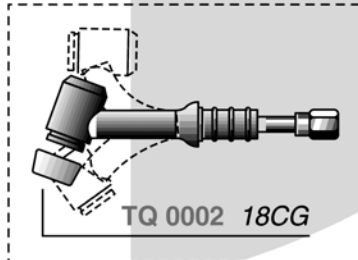
- 4 TC 0031 54N18
Ø 6.4
- 7 TC 0034 54N15
Ø 11.2
- 5 TC 0086 54N17L
Ø 8
- 5 TC 0032 54N17
Ø 8
- 8 TC 0035 54N14
Ø 12.7
- 6 TC 0087 54N16L
Ø 9.5
- 6 TC 0033 54N16
Ø 9.8
- 12 TC 0036 54N19
Ø 17.2
- 7 TC 0088 54N15L
Ø 11



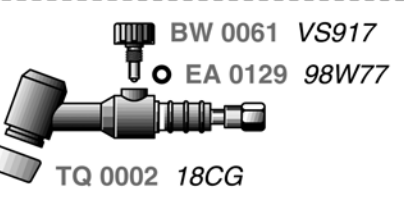
BW 0307 BW 0305 BW 0306
 BX 0625 BX 0626



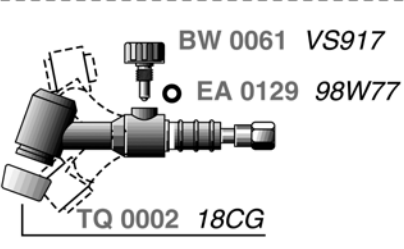
TQ 0002 18CG TF 0017 17



TQ 0002 18CG TF 0022 17FX



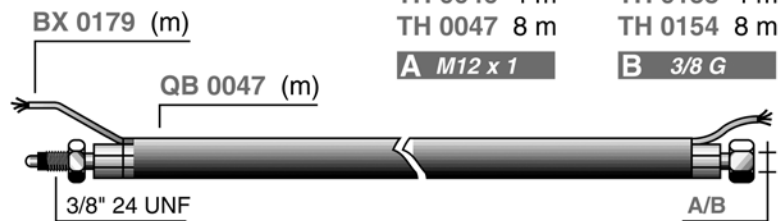
BW 0061 VS917
 EA 0129 98W77
 TQ 0002 18CG TF 0117 17V



BW 0061 VS917
 EA 0129 98W77
 TQ 0002 18CG TF 0118 17VFX

ERGOTIG 9/17 COMPLETE CABLE

TH 0046 4 m	TH 0153 4 m
TH 0047 8 m	TH 0154 8 m
A M12 x 1	B 3/8 G



ERGOTIG 9/17 POWER CABLE

TH 0005 4 m	TH 0149 4 m
TH 0006 8 m	TH 0150 8 m
A M12 x 1	B 3/8 G



ERGOTIG 18

T I G R A N G E



SINTIG 18 DUALTIG 18 m

	SR 1401	SR 2401	4
FITTING	SR 1801	SR 2801	8
M12x1	SR 1402		4
FITTING	SR 1802		8
3/8G			

Additional KIT Ø

TT 0103	1.6
TT 0104	2.4
TT 0105	3.2



FRANTIG 18 AUTOTIG 18 m

	SR 3401	ST 4401	4
FITTING	SR 3801	ST 4801	8
M12x1		ST 4402	4
FITTING		ST 4802	8
3/8G			

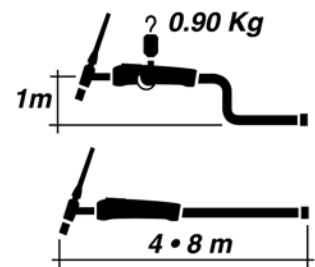


FREE 18 m

	SR 4402	4
FITTING	SR 4802	8
3/8G		

TECHNICAL DATA

Voltage class	L
Inert gas	Argon
Duty cycle 100% DC	320
Duty cycle 100% AC	270
Electrodes Ø mm	0.5 ÷ 4
Cooling	Water cooled
Max. liquid temp. °C	60
Water min. flow rate l/min	1.5
Max. inlet pressure bar	4
Min. inlet pressure bar	2
Gas flow rate l/min	7 ÷ 20



DECLARATION OF CONFORMITY

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EN 60974-7



ERGOTIG 18

T I G R A N G E

EA 0329



ERGOTIG HANDLE

- TP 0090 Green • Standard
- TP 0091 Blue
- TP 0092 Black

BW 03

EA 130
98W18



BW 0066
57Y02



BW 0067
57Y04

- Ø 0.5 TD 0001-05 10N21
- Ø 1.0 TD 0001-10 10N22
- Ø 1.6 TD 0001-16 10N23
- Ø 2.0 TD 0001-20
- Ø 2.4 TD 0001-24 10N24
- Ø 3.2 TD 0001-32 10N25
- Ø 4.0 TD 0001-40 54N20
- Ø 4.8 TD 0001-48 30028



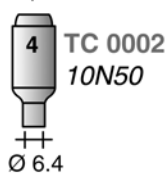
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- Ø 1.6 TD 0022-16
- Ø 2.4 TD 0022-24
- Ø 3.2 TD 0022-32
- Ø 4.0 TD 0022-40

- Ø 0.5 TE 0001-05 10N29
- Ø 1.0 TE 0001-10 10N30
- Ø 1.6 TE 0001-16 10N31
- Ø 2.4 TE 0001-24 10N32
- Ø 3.2 TE 0001-32 10N28
- Ø 4.0 TE 0001-40 406488
- Ø 4.8 TE 0001-48 30126

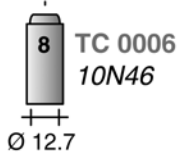


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- Ø 1.0 TE 0006-10 45V24
- Ø 1.6 TE 0006-16 45V25
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- Ø 3.2 TE 0006-32 45V27
- Ø 4.0 TE 0006-40 45V28



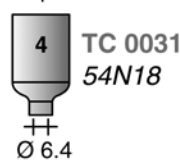
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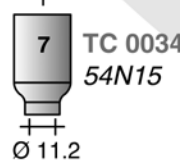
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10N49L



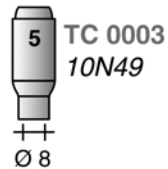
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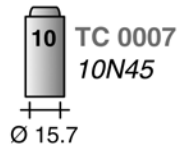
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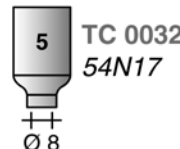
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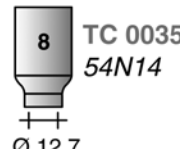
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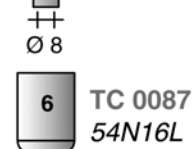
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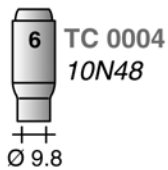
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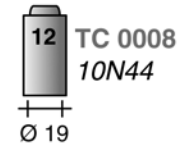
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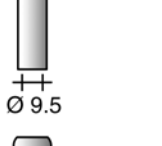
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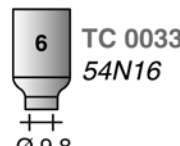
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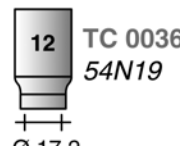
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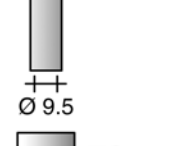
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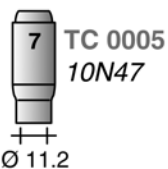
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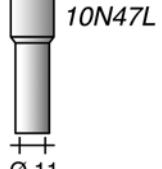
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54N19



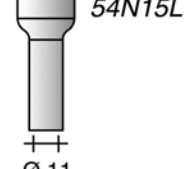
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7 TC 0005
10N47



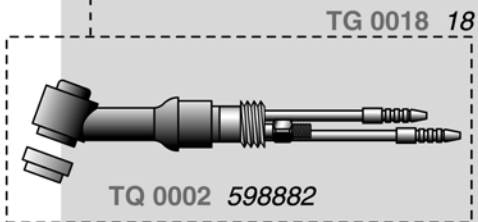
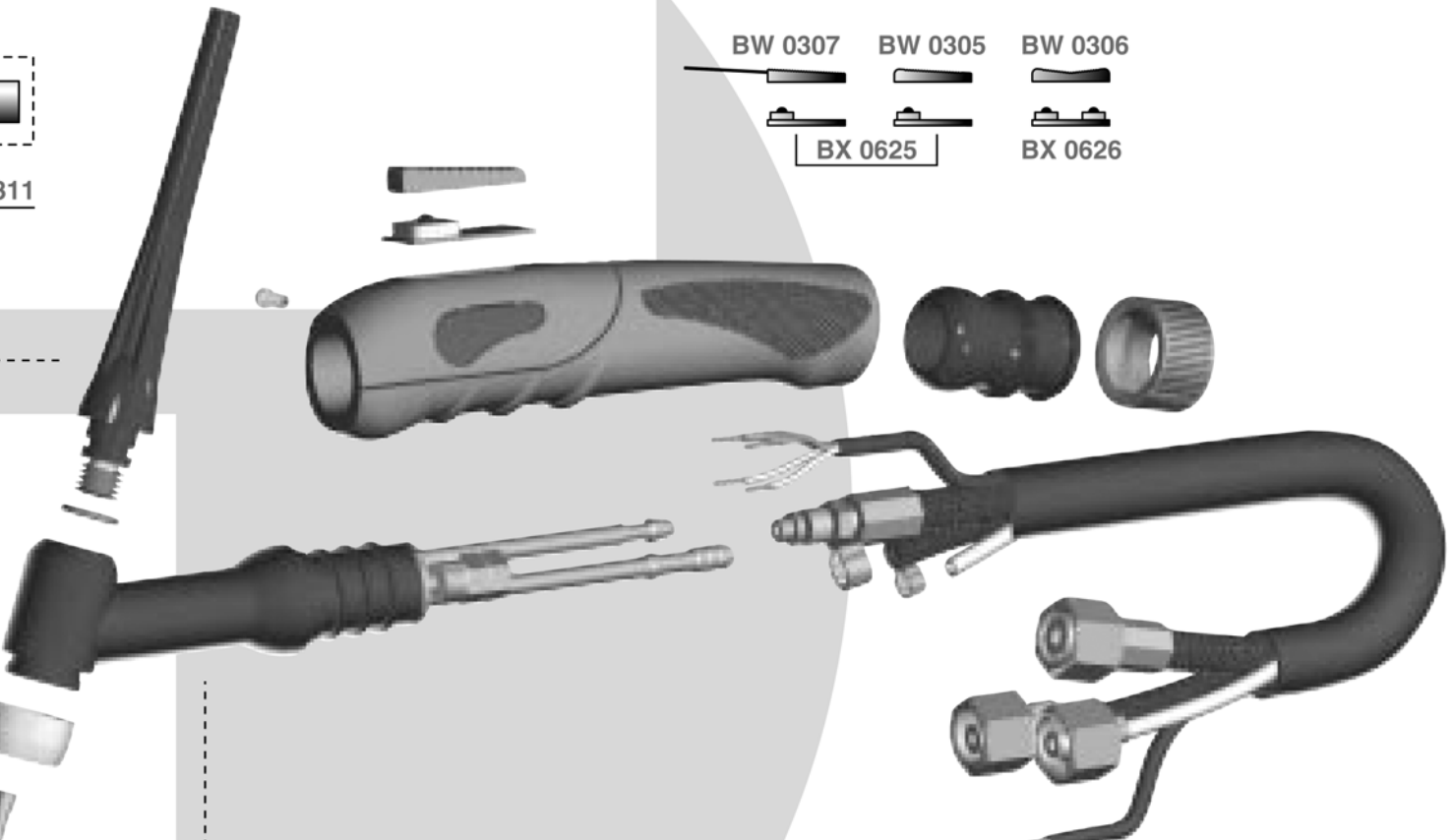
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10N47L



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54N15L

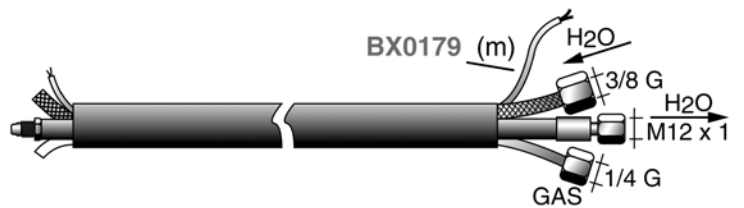


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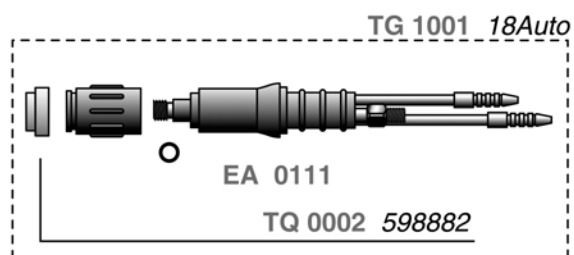
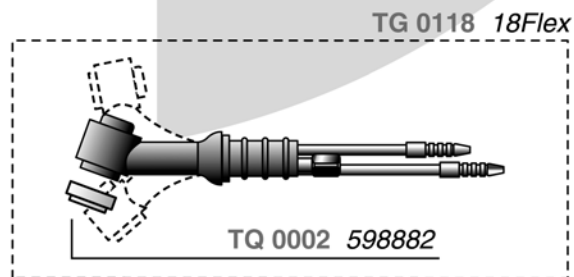
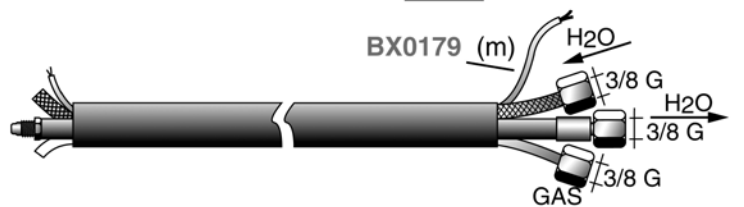
Complete cable m

	TH 0062	4
FITTING	TH 0063	8
M12x1		



Complete cable m

	TH 0076	4
FITTING	TH 0077	8
3/8 G		



Water cable Gas Cable Water and Power m

	TH 0104	TH 0096	TH 0082	4
FITTING	TH 0105	TH 0097	TH 0083	8
M12x1				
	TH 0104	TH 0098	TH 0080	4
FITTING	TH 0105	TH 0099	TH 0081	8
3/8 G				

ERGOTIG 20-25

T I G R A N G E



SINTIG 20 DUALTIG 20 m

	SV 1401	SV 2401	4
FITTING	SV 1801	SV 2801	8
M12x1	SV 1402	SV 2402	4
FITTING	SV 1802	SV 2802	8
3/8G			



FRANTIG 20 FREE 20 AUTOTIG 20 m

	SV 3401		SX 4401	4
FITTING	SV 3801		SX 4801	8
M12x1		SV 4402	SX 4402	4
FITTING		SV 4802	SX 4802	8
3/8G				



SINTIG 25 FRANTIG 25 m

	SW 1401	SW 3401	4
FITTING	SW 1801	SW 3801	8
M12x1	SW 1402		4
FITTING	SW 1802		8
3/8G			

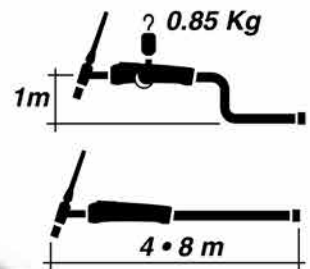
Additional KIT Ø

TT 0101	1.6
TT 0102	2.4



TECHNICAL DATA

Voltage class	L
Inert gas	Argon
Duty cycle 100% DC	250
Duty cycle 100% AC	220
Electrodes Ø mm	0.5 ÷ 3.2
Cooling	Water cooled
Max. liquid temp. °C	60
Water min. flow rate l/min	1
Max. inlet pressure bar	4
Min. inlet pressure bar	2
Gas flow rate l/min	7 ÷ 18



DECLARATION OF CONFORMITY

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EN 60974-7

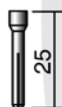


ERGOTIG 20-25

T I G R A N G E



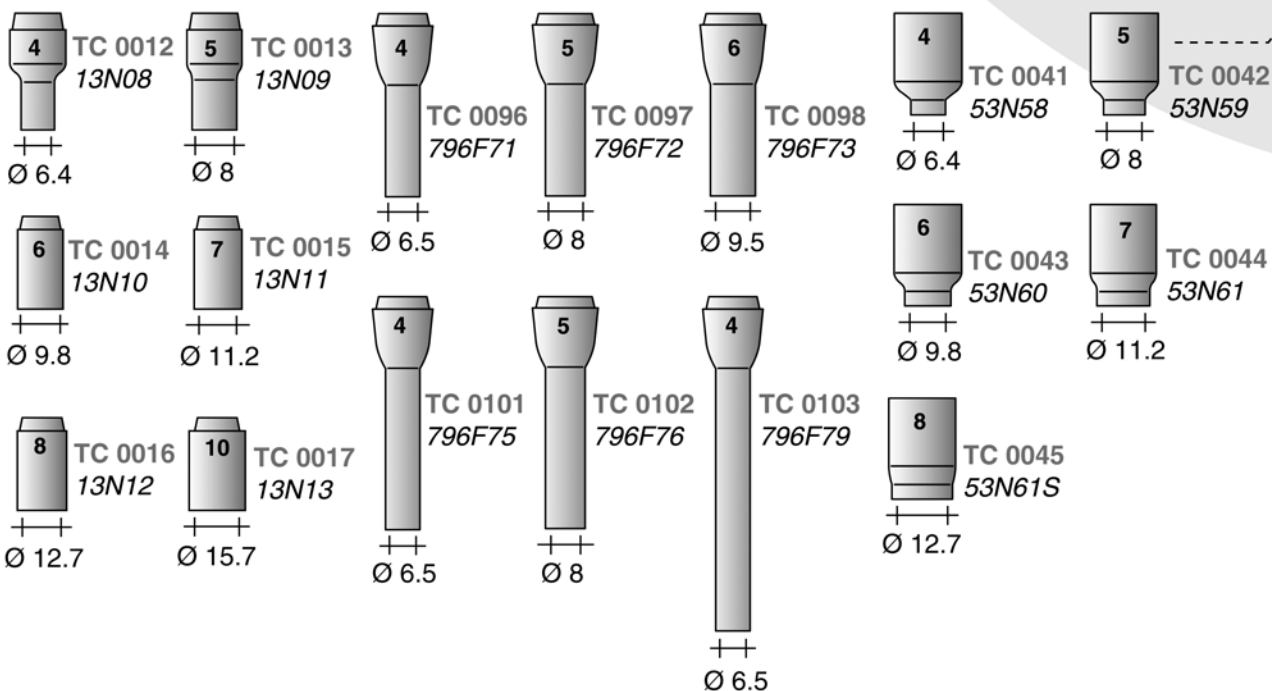
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- Ø 1.0 TD 0003-10 13N21
- Ø 1.2 TD 0003-12
- Ø 1.6 TD 0003-16 13N22
- Ø 2.0 TD 0003-20
- Ø 2.4 TD 0003-24 13N23
- Ø 3.2 TD 0003-32 13N24

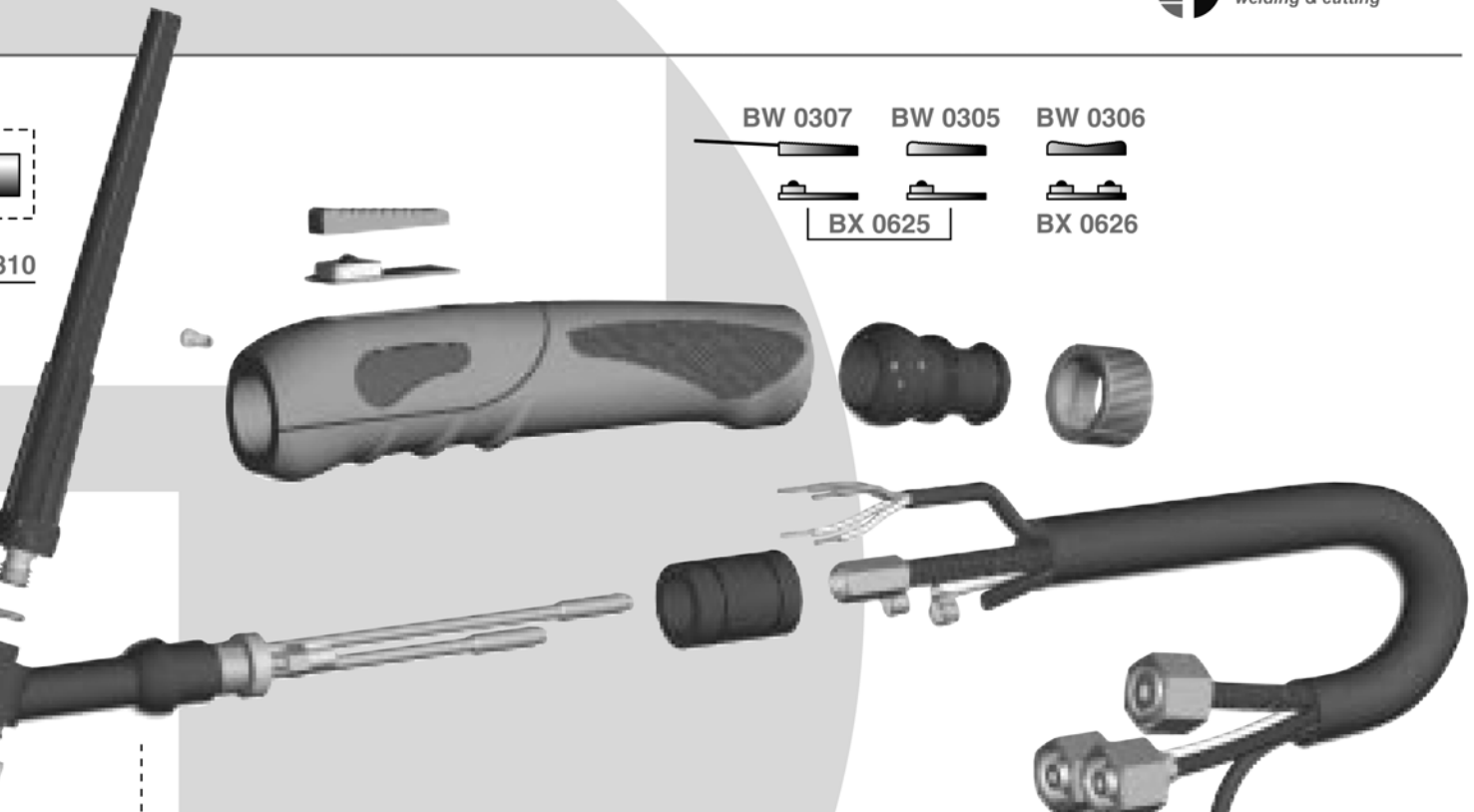


- Ø 0.5 TE 0003-05 13N25
- Ø 1.0 TE 0003-10 13N26
- Ø 1.2 TE 0003-12
- Ø 1.6 TE 0003-16 13N27
- Ø 2.0 TE 0003-20
- Ø 2.4 TE 0003-24 13N28
- Ø 3.2 TE 0003-32 13N29



- Ø 0.5 TE 0005-05 45V41
- Ø 1.0 TE 0005-10 45V42
- Ø 1.6 TE 0005-16 45V43
- Ø 2.4 TE 0005-24 45V44
- Ø 3.2 TE 0005-32 45V45

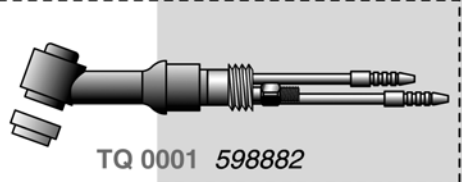




BW 0307 BW 0305 BW 0306
 BX 0625 BX 0626

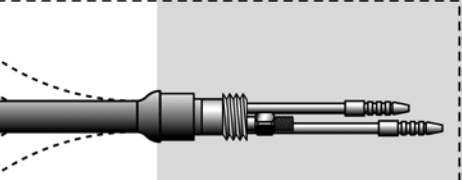
310

TG 0020 20



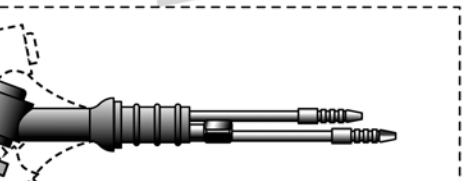
TQ 0001 598882

TG 0025 25



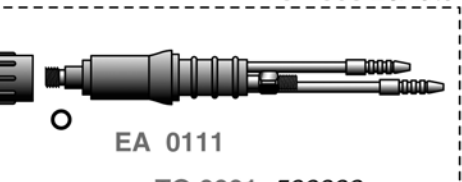
TQ 0001 598882

TG 0220 20Flex



TQ 0001 598882

TG 1000 20Auto



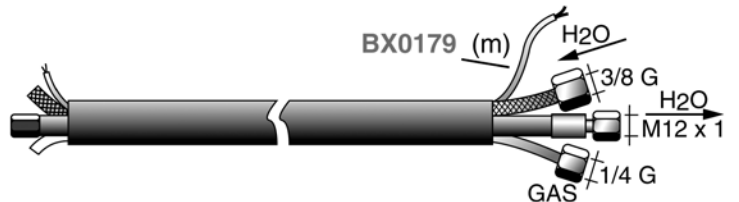
EA 0111

TQ 0001 598882



Complete cable m

	TH 0064	4
FITTING	TH 0065	8
M12x1		



Complete cable m

	TH 0078	4
FITTING	TH 0079	8
3/8 G		



Water cable Gas Cable Water and Power m

	TH 0106	TH 0096	TH 0086	4
FITTING	TH 0107	TH 0097	TH 0087	8
M12x1				
	TH 0106	TH 0098	TH 0084	4
FITTING	TH 0107	TH 0099	TH 0085	8
3/8 G				

ERGOTIG 24

T I G R A N G E



SINTIG 24 SINTIG 24 FX m

	SP 1401	SQ 1401	4
FITTING	SP 1801	SQ 1801	8
M12x1			
	SP 1402	SQ 1402	4
FITTING	SP 1802	SQ 1802	8
3/8G			

Additional KIT Ø

TT 0203	1.6
TT 0204	2.4



FRANTIG 24 FRANTIG 24 FX m

	SP 3401	SQ 3401	4
FITTING	SP 3801	SQ 3801	8
M12x1			

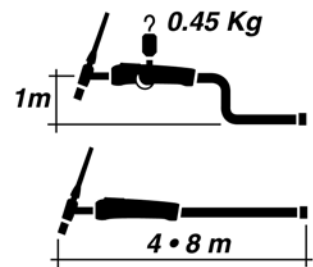


FREE 24 FREE 24 FX m

	SP 4402	SQ 4402	4
FITTING	SP 4802	SQ 4802	8
3/8G			

TECHNICAL DATA

Voltage class	L
Inert gas	Argon
Duty cycle 35% DC	110
Duty cycle 35% AC	95
Electrodes \varnothing mm	0.5 ÷ 2.4
Cooling	Air cooled



DECLARATION OF CONFORMITY

The undersigned company Trafimet - Via del Lavoro, 8 - 36023 Castegnero (VI) - Italy - declares that the product identified and described on this page complies with standard EN 60974-7 in accordance with the requirements contemplated by directive EEC 73/23 low voltage.



EN 60974-7



ERGOTIG 24

T I G R A N G E

EA 0329



BW0303

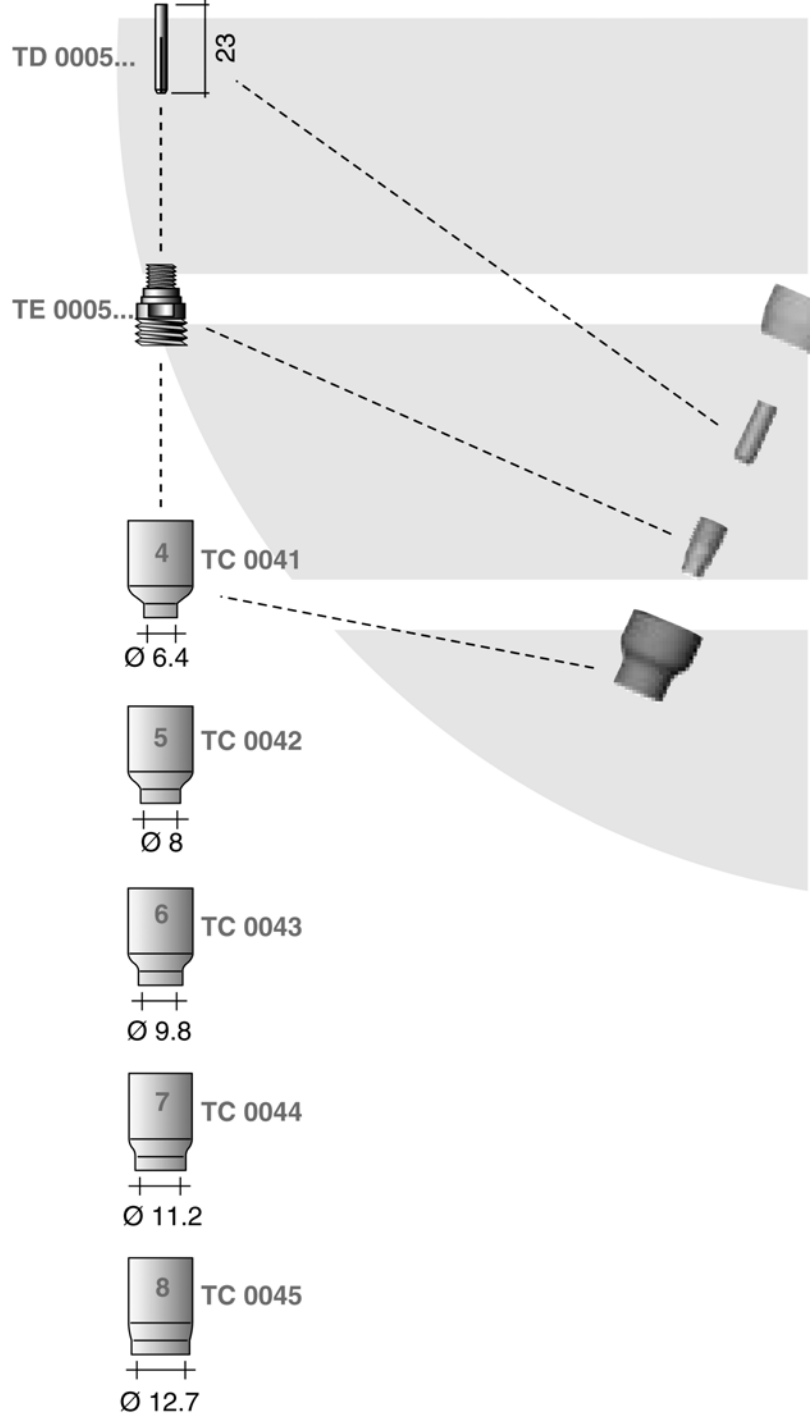
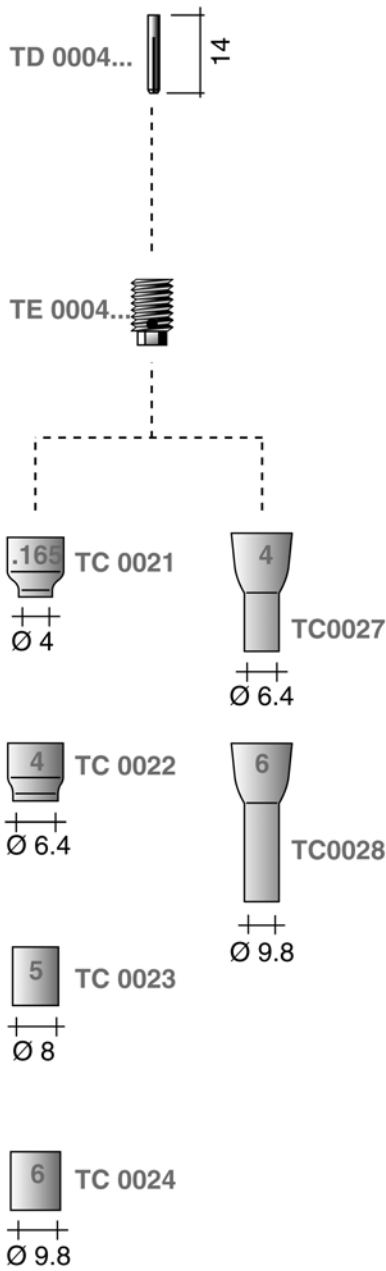


ERGOTIG HANDLE

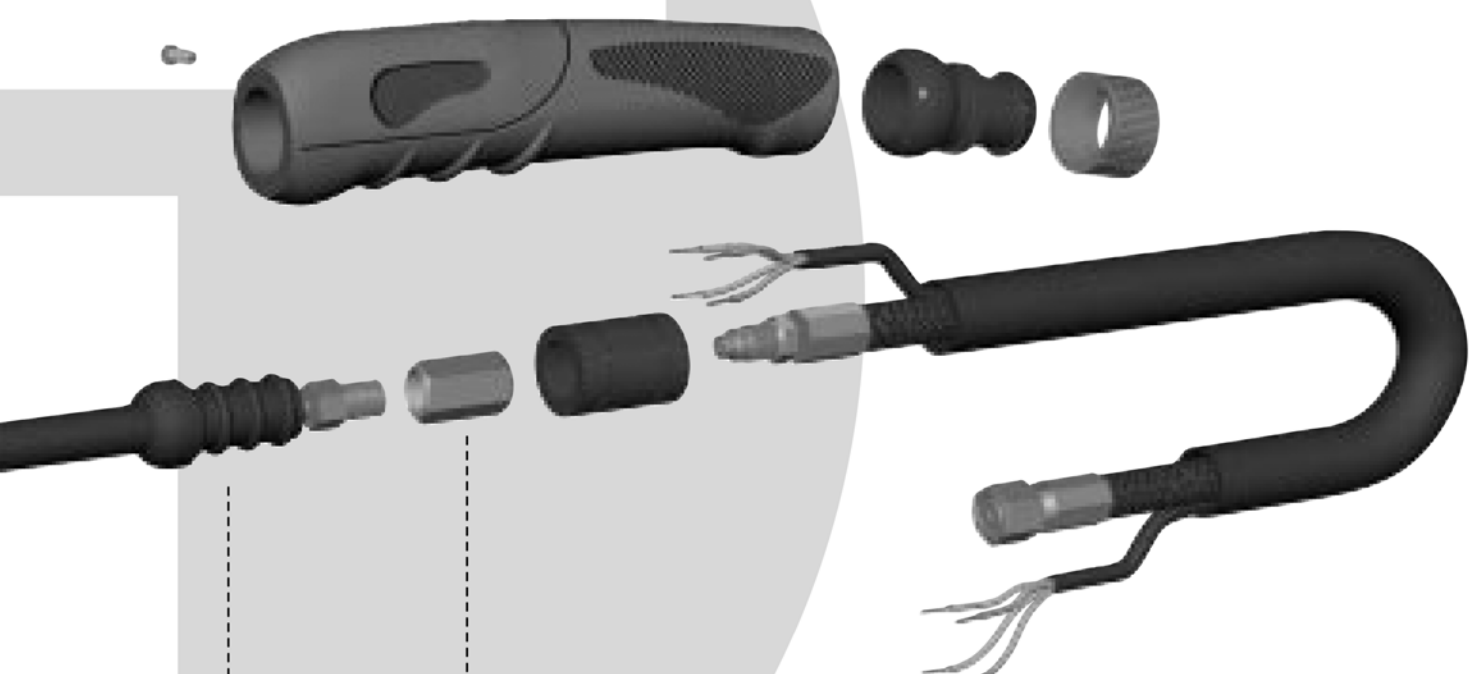
TP 0090 Green • Standard
 TP 0091 Blue
 TP 0092 Black



BW 03



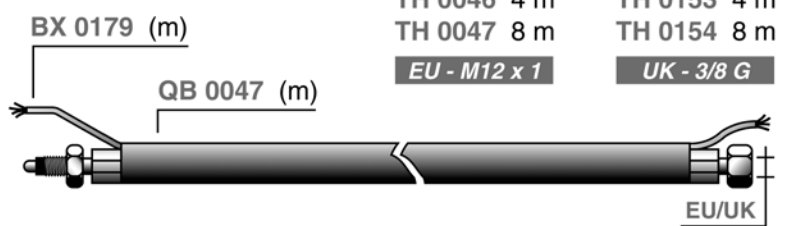
010



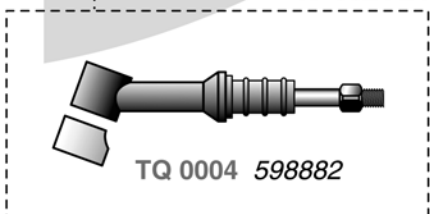
FA5130

ERGOTIG 24 COMPLETE CABLE

TH 0046 4 m	TH 0153 4 m
TH 0047 8 m	TH 0154 8 m
EU - M12 x 1	UK - 3/8 G



TF 0024 24

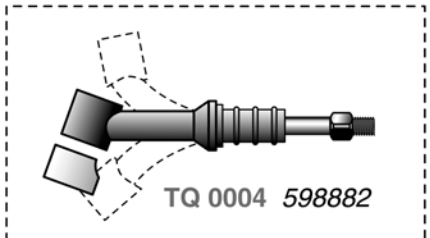


ERGOTIG 24 POWER CABLE

TH 0005 4 m	TH 0149 4 m
TH 0006 8 m	TH 0150 8 m
EU - M12 x 1	UK - 3/8 G



TF 0224 24Flex



ERGOTIG 24W

T I G R A N G E



SINTIG 24W SINTIG 24W FX m

	SY 1401	SZ 1401	4
FITTING	SY 1801	SZ 1801	8
M12x1	SY 1402	SZ 1402	4
FITTING	SY 1802	SZ 1802	8
3/8G			

Additional KIT Ø

TT 0203	1.6
TT 0204	2.4



FRANTIG 24W FRANTIG 24W FX m

	SY 3401	SZ 3401	4
FITTING	SY 3801	SZ 3801	8
M12x1			

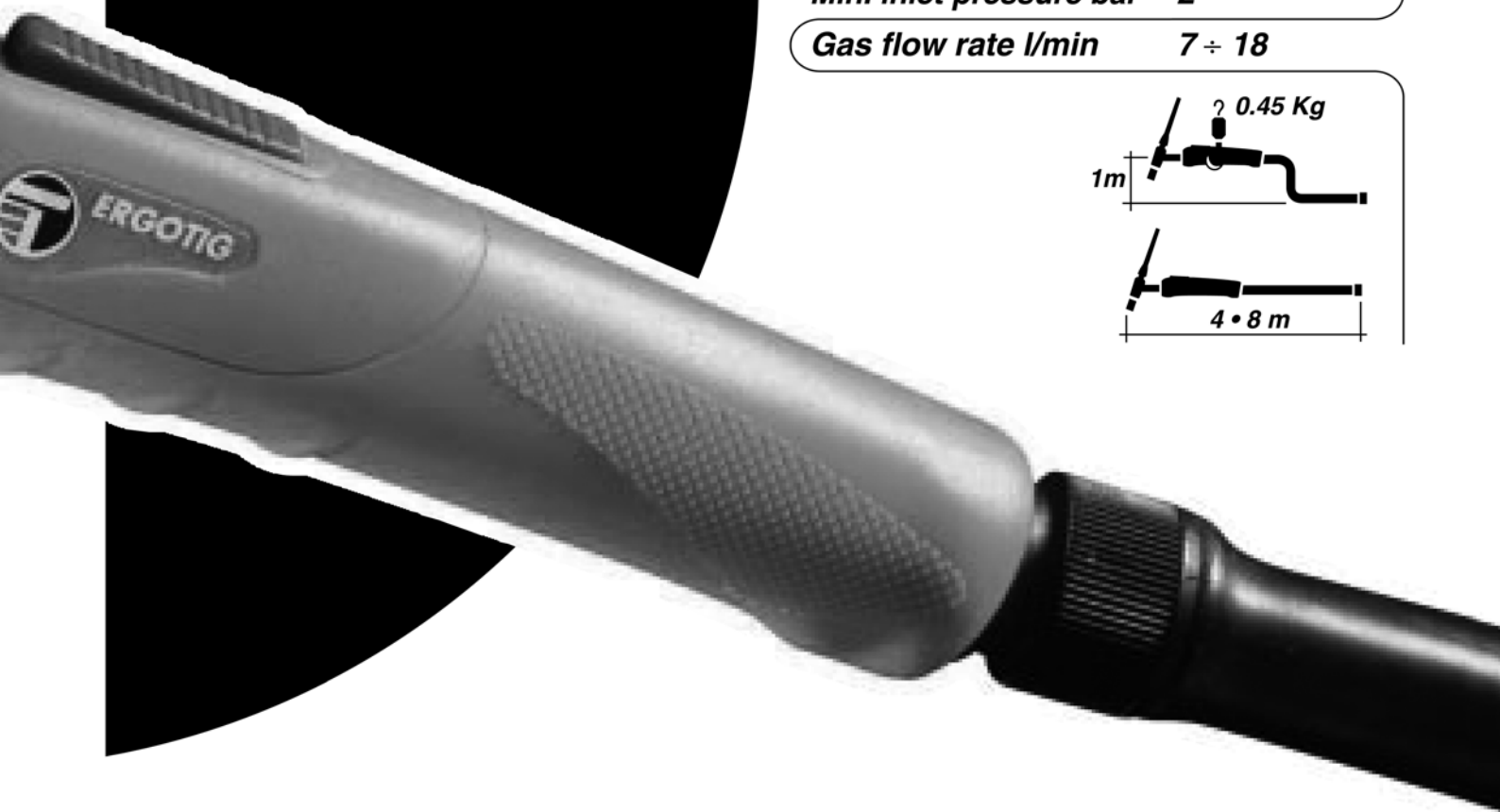
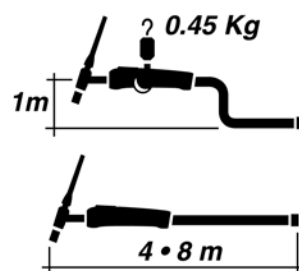


FREE 24W FREE 24W FX m

	SY 4402	SZ 4402	4
FITTING	SY 4802	SZ 4802	8
3/8G			

TECHNICAL DATA

Voltage class	L
Inert gas	Argon
Duty cycle 100% DC	180
Duty cycle 100% AC	120
Electrodes Ø mm	0.5 ÷ 2.4
Cooling	Water cooled
Max. liquid temp. °C	60
Water min. flow rate l/min	1
Max. inlet pressure bar	4
Min. inlet pressure bar	2
Gas flow rate l/min	7 ÷ 18



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EN 60974-7



ERGOTIG 24W

T I G R A N G E

EA 0329



BW0303



ERGOTIG HANDLE

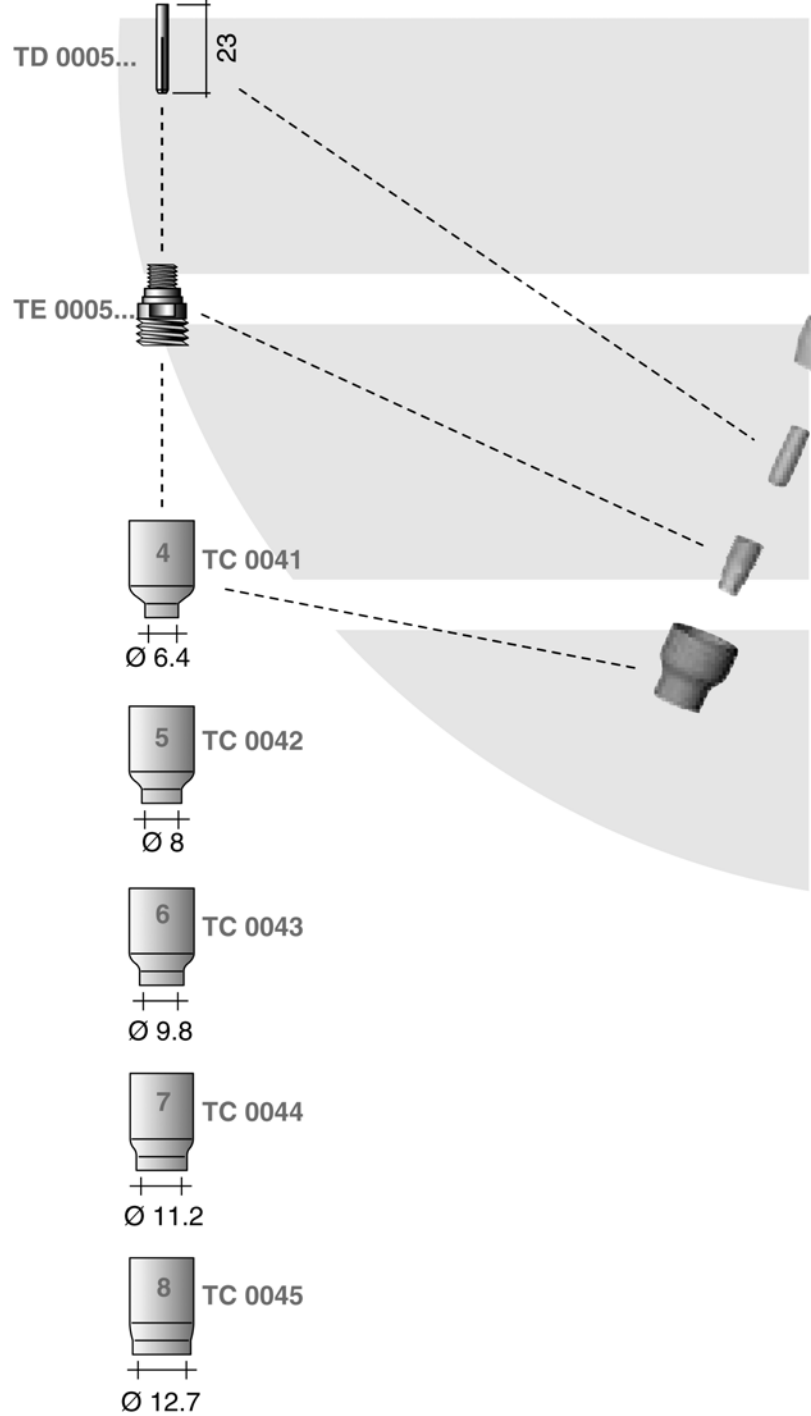
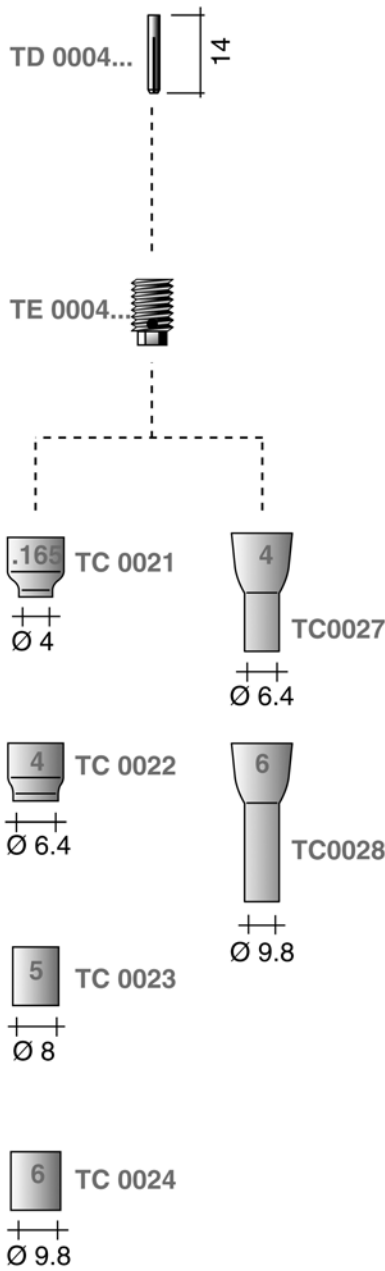
TP 0090 Green • Standard

TP 0091 Blue

TP 0092 Black

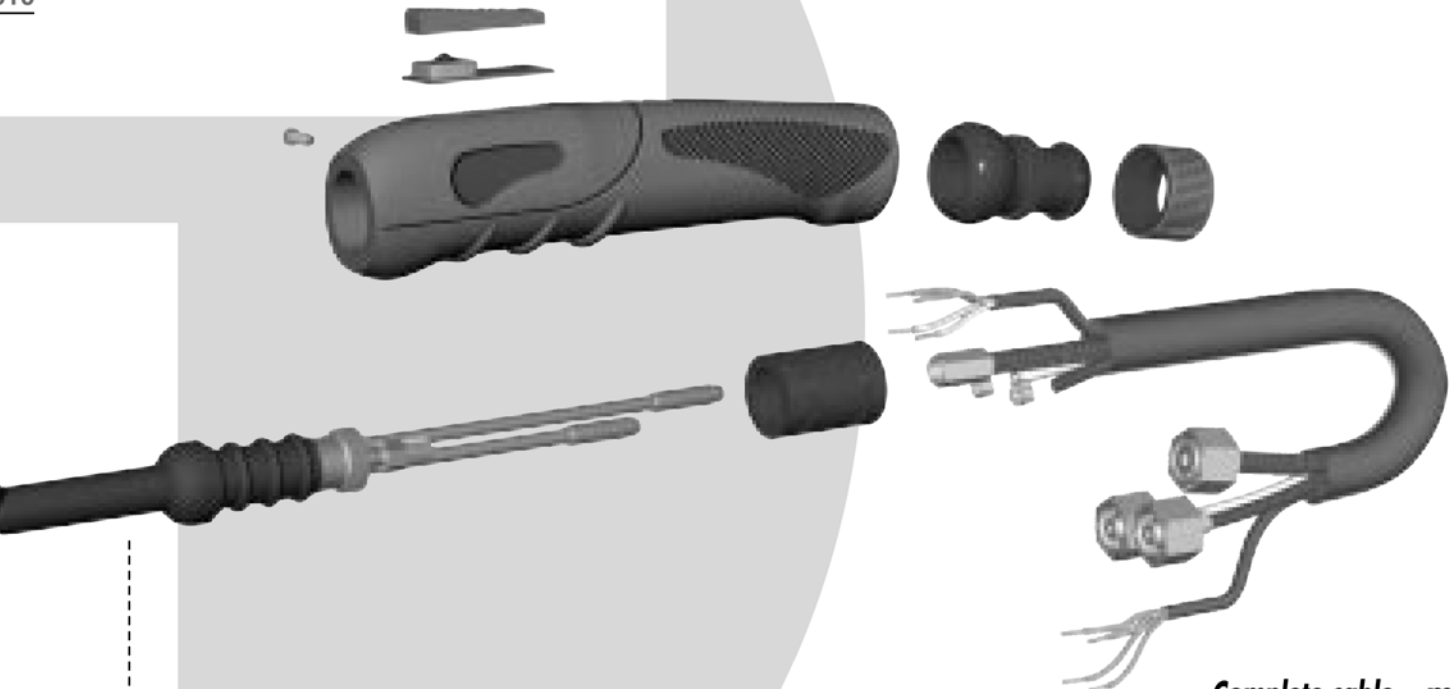


BW 03





010



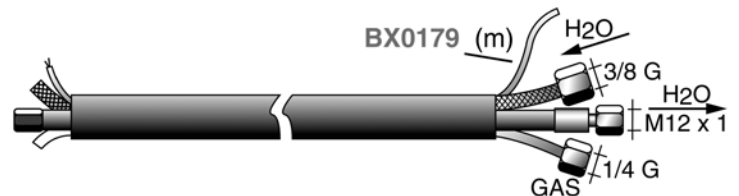
Complete cable m

	TH 0064	4
FITTING	TH 0065	8
	M12x1	

TG 0024 24W



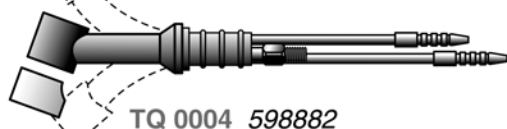
TQ 0004 598882



Complete cable m

	TH 0078	4
FITTING	TH 0079	8
	3/8G	

TG 0224 24WFlex



TQ 0004 598882



Water cable Gas Cable Water and Power m

	TH 0106	TH 0096	TH 0086	4
FITTING	TH 0107	TH 0097	TH 0087	8
	M12x1			
	TH 0106	TH 0098	TH 0084	4
FITTING	TH 0107	TH 0099	TH 0085	8
	3/8G			

ERGOTIG 26

T I G R A N G E



	SINTIG 26	SINTIG 26 FX	m
FITTING	SK 1401	SL 1401	4
M12 x 1	SK 1801	SL 1801	8
FITTING	SK 1402	SL 1402	4
3/8 G	SK 1802	SL 1802	8



	DUALTIG 26	DUALTIG 26 FX	m
FITTING	SK 2401	SL 2401	4
M12 x 1	SK 2801	SL 2801	8



	FRANTIG 26	FRANTIG 26 FX	m
FITTING	SK 3401	SL 3401	4
M12 x 1	SK 3801	SL 3801	8



	TIG 26 V	m
FITTING	SM 4401	4
M12 x 1	SM 4801	8
FITTING	SM 4402	4
3/8 G	SM 4802	8



	FREE 26	m
FITTING	SK 4402	4
3/8 G	SK 4802	8



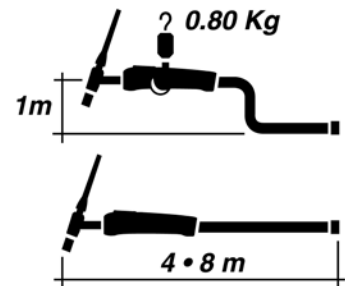
	AUTOTIG 26	m
FITTING	SN 4401	4
M12 x 1	SN 4801	8

Additional KIT	Ø
TT 0103	1.6
TT 0104	2.4
TT 0105	3.2



TECHNICAL DATA

Voltage class	L
Inert gas	Argon
Duty cycle 35% DC	180
Duty cycle 35% AC	150
Electrodes \varnothing mm	0.5 ÷ 4
Cooling	Air cooled



DECLARATION OF CONFORMITY

The undersigned company Trafimet - Via del Lavoro, 8 - 36023 Castegnero (VI) - Italy - declares that the product identified and described on this page complies with standard EN 60974-7 in accordance with the requirements contemplated by directive EEC 73/23 low voltage.

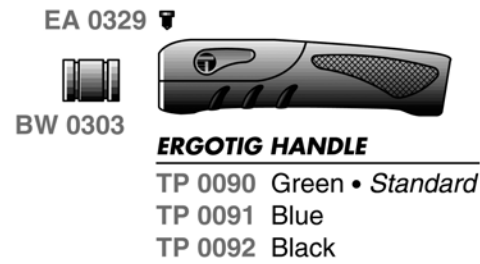
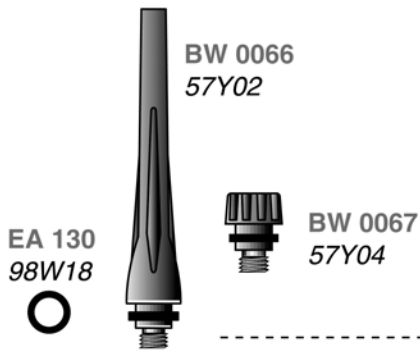


EN 60974-7



ERGOTIG 26

T I G R A N G E



- Ø 0.5 TD 0001-05 10N21
- Ø 1.0 TD 0001-10 10N22
- Ø 1.6 TD 0001-16 10N23
- Ø 2.0 TD 0001-20
- Ø 2.4 TD 0001-24 10N24
- Ø 3.2 TD 0001-32 10N25
- Ø 4.0 TD 0001-40 54N20
- Ø 4.8 TD 0001-48 30028



- Ø 1.0 TD 0022-10
- Ø 1.6 TD 0022-16
- Ø 2.4 TD 0022-24
- Ø 3.2 TD 0022-32
- Ø 4.0 TD 0022-40

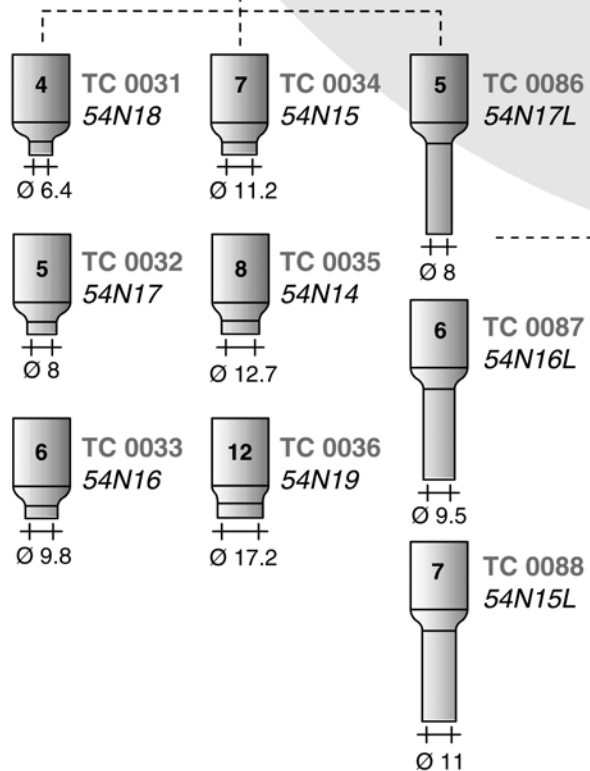
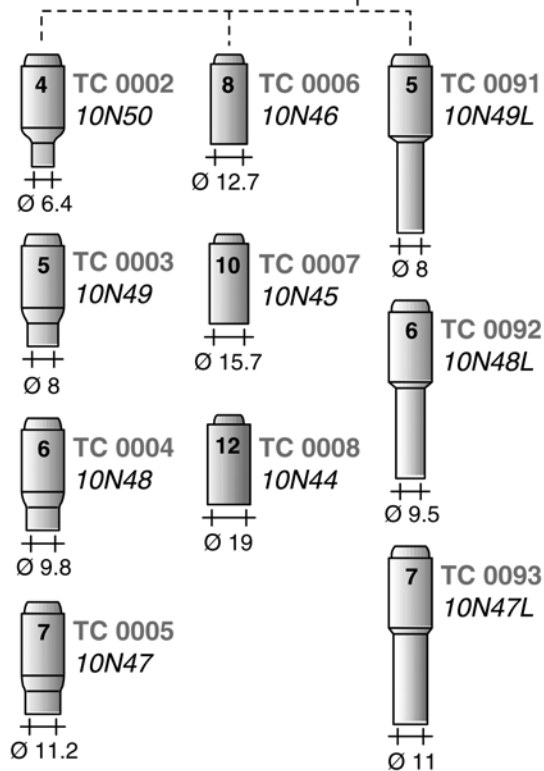


- Ø 0.5 TE 0001-05 10N29
- Ø 1.0 TE 0001-10 10N30
- Ø 1.6 TE 0001-16 10N31
- Ø 2.4 TE 0001-24 10N32
- Ø 3.2 TE 0001-32 10N28
- Ø 4.0 TE 0001-40 406488
- Ø 4.8 TE 0001-48 30126



TQ 0003 54N01

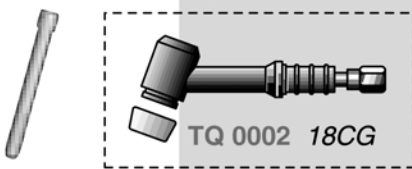
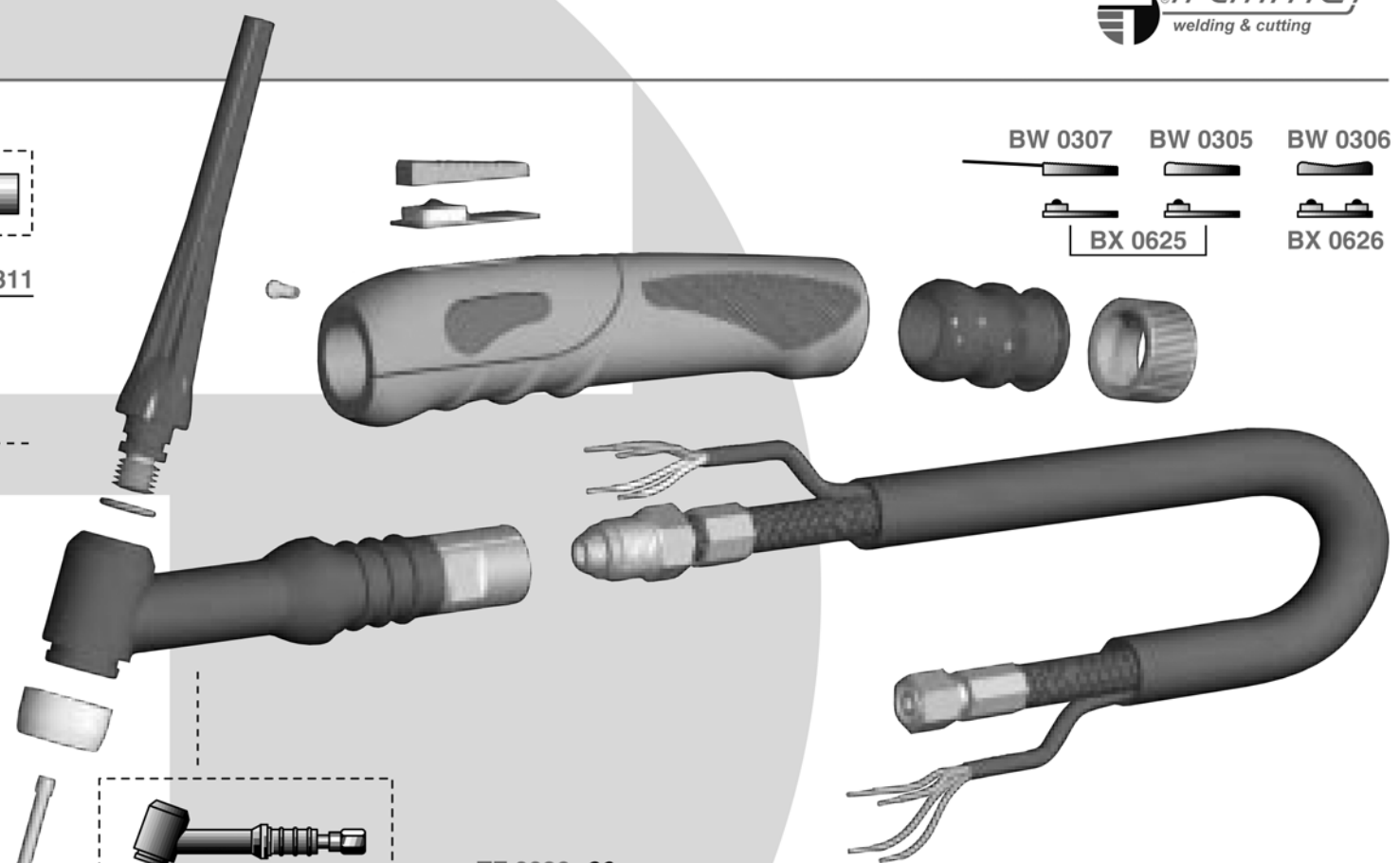
- Ø 0.5 TE 0006-05 45V29
- Ø 1.0 TE 0006-10 45V24
- Ø 1.6 TE 0006-16 45V25
- Ø 2.4 TE 0006-24 45V26
- Ø 3.2 TE 0006-32 45V27
- Ø 4.0 TE 0006-40 45V28



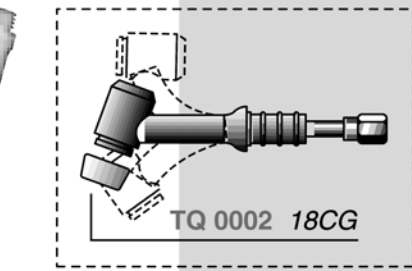
311

BW 0307 BW 0305 BW 0306

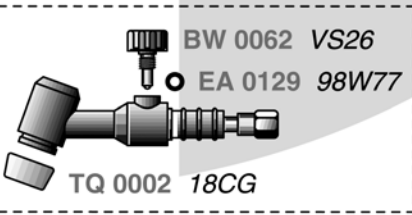
 BX 0625 BX 0626



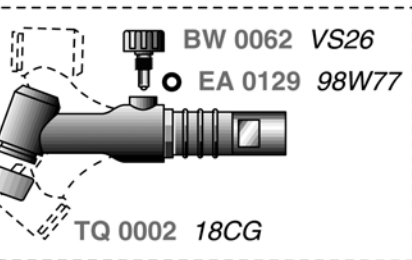
TF 0026 26



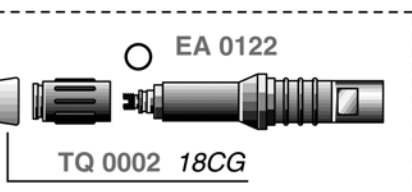
TF 0027 26FX



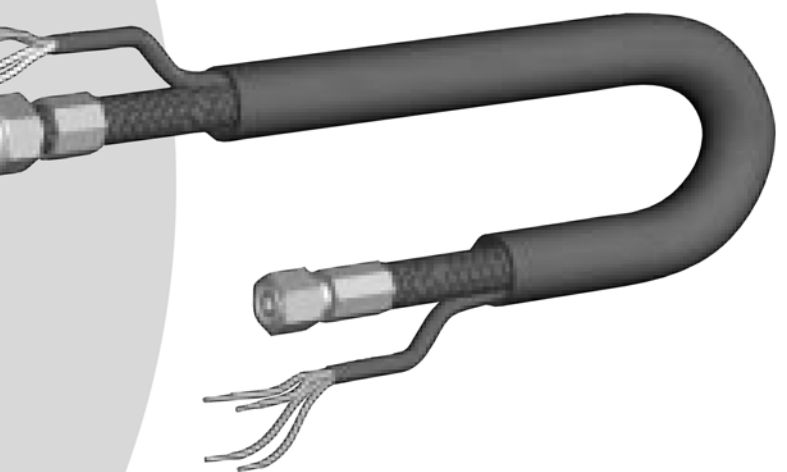
TF 0126 26V



TF 0127 26VFX

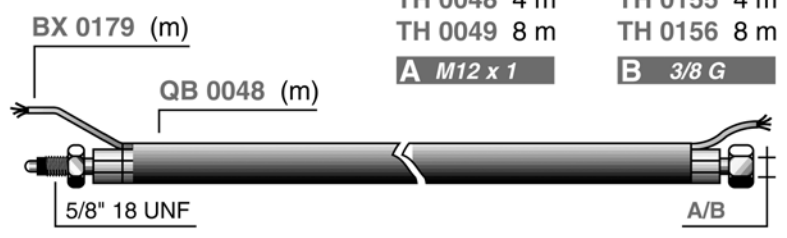


TF 1001 26Autotig



ERGOTIG 26 COMPLETE CABLE

TH 0048 4 m	TH 0155 4 m
TH 0049 8 m	TH 0156 8 m
A M12 x 1	B 3/8 G



ERGOTIG 26 POWER CABLE

TH 0007 4 m	TH 0151 4 m
TH 0008 8 m	TH 0152 8 m
A M12 x 1	B 3/8 G



SICHERHEITSVORSCHRIFTEN

Wir danken Ihnen für das Vertrauen, das Sie uns durch den Erwerb dieses Geräts entgegenbringen, welches Ihre Erwartungen bei Beachtung der einschlägigen Betriebs- u. Wartungsvorschriften zu Ihrer uneingeschränkten Zufriedenheit erfüllen wird.

ACHTUNG: Die Firma haftet nicht bei Anbau von Komponenten oder Untergruppen bzw. bei kundenseitig oder von Dritten vorgenommenen Änderungen jeglicher Art des Gerätes oder der Anlage, ohne vorausgehende schriftliche und spezifische Zustimmung seitens der Firma.

A) Wartung/ Entstörung

Vor jeglichem Eingriff im Innern des Gerätes bzw. vor jeglicher Reparatur haben Sie sicherzustellen, daß das Gerät in abgesicherter Weise von der E-Versorgung getrennt wurde - unter abgesichert ist zu verstehen: eine Reihe von Maßnahmen, die geeignet sind, das Gerät vom Enetz zu trennen und spannungslos zu halten.

Im weiteren haben Sie alle 6 Monate den ordnungsgemäßen Zustand der E-Isolierungen u. Geräteanschlüsse sowie des Elektrik-Zubehörs zu prüfen, d.h.: - E-Anschlüsse, Flexkabel, Kabelwege, E-Ummantelungen, Stecker, E-Verlängerungen, Werkstück-Klemmen, Elektrodenhalter bzw. Brenner . Wartungs- u. Reparaturarbeiten an den Gehäusen, Kapselungen u. Isolierungen haben äußerst sorgfältig zu erfolgen.

Eingriffe nur Fachleuten anvertrauen - besser noch - schadhafte Teile direkt austauschen.

Regelmäßig den korrekten Anzug u. die Sauberkeit der E-Anschlüsse kontrollieren.

B) Arbeitsstation

Ausschließlich Elektrodenhalter u.. Brenner mit einwandfreier Isolierung verwenden.

Der Bediener muß gegenüber dem Erdboden u. dem zu schweißenden Werkstück isoliert sein (Handschuhe, Sicherheitsschuhe, trockene Kleidung, Lederschürze, usw. ...).

Keinesfalls gleichzeitig den Elektroden Draht (bzw. die Düse) und das Werkstück in direktem Kontakt berühren.

C) Sicherheit gegen Lichtstrahlen (UV-Abschirmung)

Die Augen müssen obligatorisch gegen Schweiß-Lichtblitze geschützt werden (Blendgefahr beim Anlassen des Lichtbogens im sichtbaren Lichtspektrum und im UV-Bereich).

Die Schweißermaske - mit oder ohne Helm - muß in allen Fällen mit einem Schutzglas ausgestattet sein, dessen Filterkategorie auf die Intensität des Schweißlichtbogens abzustimmen ist (Norm EN 169).

SAFETY INSTRUCTIONS

We thank you for your trust in our company by purchasing this equipment which will provide you with complete satisfaction if you comply with its conditions for use and maintenance.

CAUTION: The company declines all responsibility in case of modification, addition of components or subassemblies, or any transformation of the equipment carried out by the customer or a third-party, without prior specific written agreement from the company.

A) Maintenance / Troubleshooting

Before any internal verifications and repair work, make sure that the equipment is separated from the electric installation by electrical isolation (by electrical isolation is meant a group of operations designed to separate and keep the equipment de-energized).

At least every six months, you must check the proper condition of the insulation and connections of the electric equipment and accessories such as plugs, flexible wires, ducts, connectors, extension leads, part-holders, electrode-holders, or torches... Maintenance and repair work on the jackets and insulating ducts must be carried out extremely carefully.

Have defective parts repaired by a specialist, or better still, have them replaced.

Routinely check the proper tightening and cleanliness of the electric connections.

B) Work-station

Use only electrode holders and torches which are perfectly insulated.

The Operator must be insulated from the ground-surface and the workpiece (gloves, safety shoes, dry clothes, leather apron, and so forth ...).

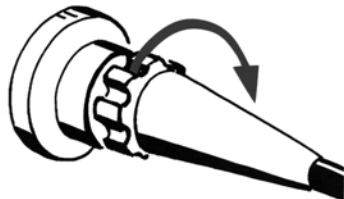
Do not touch the electrode wire and the pari (or the nozzle) simultaneously.

C) Protection from luminous radiation

It is absolutely essential that you protect your eyes from blinding glare (glare of arc invisible light and infrared and ultraviolet radiation).

The welding mask, without or with helmet, must always be equipped with a protective Filter whose gradation depends on the welding arc current intensity (EN 169 Standard).



I**GB****D****F****E****S****ALLACCIAMENTI****ANSCHLÜßE****CONEXIONES****CONNECTION****CONNEXION****ANSLUTNING**

Chiudere con una certa pressione l'attacco posteriore. Nel caso di attacco diretto collegare il tubo del gas e i fili di comando pulsante.

Screw back adaptor tight. Connect gas hose and trigger control leads in case of direct adaptor.

Überwurfmutter des Zentralanschlusses handfest anziehen. Keine Werkzeuge benutzen.

Fermer l'adaptateur postérieur. Connecter le tuyau gaz et les câbles de commande de la gâchette si l'adaptateur est direct.

Hacer una presión sobre el acople posterior. En el caso de un acople directo colocar el acople de gas y los cables del micro para el comando del microinterruptor.

Anslut central adaptern ordentligt. Anslut gasslang och strömställarkablarna i fallet direktanslutning.



Blu - Blue
Blau - Bleu
Azul - Blå

Ø 0.6 ± 0.9

Rosso - Red
Rot - Rouge
Rojo - Röd

Ø 1.0 ± 1.2

Giallo - Yellow
Gelb - Jaune
Amarillo - Gul

Ø 1.2 ± 1.6

Controllare che la guaina guidafile e il tubetto di contatto corrispondano al diametro del filo da saldare.

Make sure that liner and contact tip match with diameter of welding wire.

Die Stromdüse und die Führungsspirale müssen dem zu verwendenden Draht-Durchmesser entsprechen.

Contrôler si la gaine guide fil et le tube contact correspondent au diamètre du fil de soudure.

Controlar que el pico de contacto y el flexible del alambre correspondan al alambre a utilizar.

Kontrollera att tråledare och kontaktmunstycke överensstämmer med tråddiametern.



Arrottonare la punta del filo prima di inserirlo nella torcia.

Make tip of wire round before fitting into torch.

Schweißdraht sollte bei gerade ausgelegtem Brenner eingeführt werden.

Arrondir la pointe du fil avant de l'introduire dans la torche.

Redondear la punta del alambre antes de introducirlo en la antorcha.

Kontrollera att svetstråden inte har några vassa grader i tråddänden innan den matas in i tråledaren.



Controllare la corretta circolazione del liquido refrigerante per le torce con questo tipo di raffreddamento.

Make sure that flow of refrigerant liquid is correct in the torches with such cooling system.

Bitte den korrekten Wasserdurchfluß am Wasserkühlergerät kontrollieren, damit der Brenner mit ausreichender Kühlung versorgt wird. Eine zu geringe Wassermenge kann zum Überhitzen des Brennerkopfes und Stromkabel führen.

Contrôler la bonne circulation du liquide réfrigérant pour les torches avec ce type de refroidissement.

En las antorchas refrigeradas, asegurarse de que el caudal de líquido refrigerante sea el correcto.

Kontrollera vid vattenkylda brännare att kylsystemet fungerar.

PRECAUZIONI DI SICUREZZA**VORSICHTSMAßREGELN****NORMAS DE SEGURIDAD****SAFETY PRECAUTIONS****PRÉCAUTIONS DE SÉCURITÉ****SÄKERHET ÅTGÄRDER**

Non rivolgere la torcia contro se stessi.

Turn torch away from yourself and others.

Brenner immer von sich weg-halten. Niemals ohne ausreichenden Augenschutz schweißen.

Ne pas tourner la torche contre vous-même.

No dirigir la antorcha hacia si mismo y o hacia otras personas.

Vänd brännaren från dig liksom från andra personer i din omgivning.



Usare una maschera di protezione. L'arco è pericoloso per gli occhi. Attenzione alle persone circostanti.

Use mask. Arc is dangerous to eyes. Nearby people should wear eye protection.

Immer einen Augenschutz tragen, da beim Zünden und Schweißen UV-Strahlen entstehen, die das Auge verletzen können. Beistehende Mitarbeiter sollten niemals ohne ausreichenden Augenschutz den Schweißvorgang beobachten.

Utiliser un masque de protection. L'arc est dangereux pour les yeux. Protéger les gens à votre côté.

Utilizar una máscara de protección adecuada. Cuidar a las personas que se encuentran cerca en el momento de soldar.

Använd svetshjälm eller svetskärm med rätt mörkhetsgrad på svetsglaset. Den elektriska ljusbågen är farlig för ögonen.



Usare guanti e abbigliamento adeguato.

Use gloves and suitable wear.

Immer ausreichend geschützte Handschuhe und Arbeitskleidung tragen.

Utiliser des gants et un vêtement approprié.

Utilizar guantes y ropa de protección adecuada.

Använd handskar och lämplig klädsel.

I**GB****D****F****E****S****PRECAUZIONI DI SICUREZZA****SAFETY PRECAUTIONS****VORSICHTSMAßREGELN****PRÉCAUTIONS DE SÉCURITÉ****NORMAS DE SEGURIDAD****SÄKERHET ÅTGÄRDER**

Non passare con carrelli sopra il cavo di saldatura.

Protect all cables for damages.

Alle Kabel und Leitungen vor Beschädigungen schützen.

Ne pas passer sur le câble de soudure avec des chariots, fenwick, etc.

No pisar con carretillas el cable de la antorcha.

Skydda slangar och kablar från att bli överkörda av fordon e.dyl.



Non chiudere in morsa la torcia.

Do not fasten torch with a tools.

Den Plasmabrenner nicht als zwecken-fremdetes Werkzeug benutzen.

Ne pas bloquer la torche dans un étau.

No prensar la antorcha en una prensa.

Sätt inte fast svetspistolens med tving, tånd e.dyl.



Non battere l'estremità della torcia.

Never use a rise or rise-grips to ex-change parts, could damage the torch.

Den Brenner niemals als eine Art Werkzeughammer benutzen.

Pas taper l'extrémité de la torche.

No golpear la antorcha para quitar las proyecciones.

Ta inte på svetspistolens främre delar - De kan vara varma.



I fumi sono dannosi alla salute. Usare degli aspiratori o operare in ambienti ventilati.

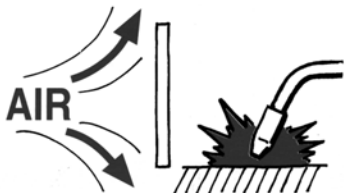
Fumes are hazardous for health. Operate under a hood or in ventilated areas only.

Plasmaschneiden sollte nur in gut ventilierten Räumen bzw. mit einer ausreichend dimensionierten Absauganlage vorgenommen werden. Der entstehende Plasmastaub ist gesundheitsschädigend.

Les fumées sont nuisibles pour la santé. Utiliser des aspirateurs ou travailler dans un environnement aéré.

Los humos son dañinos a la salud. Utilizar extractores u operar en ambientes ventilados.

Rökutvecklingen är skadlig för hälsan. Använd därför rökutagningsutrustning eller arbeta i väl ventilerade lokaler/områden.



Proteggere da correnti d'aria il bagno di saldatura.

Protect welding from drafts of air.

Nicht in Zugluft schweißen.

Protéger la soudure par courants d'air.

Protejer de las corrientes de aire en el momento de soldar.

Undvik svetsning där skyddsgasen kan blåsa bort vid svetsning.



Saldare lontano da liquidi infiammabili.

Never use a torch in close range to flammable material.

Niemals in der Nähe von entflammablen Materialien schweißen.

Souder loin des liquides inflammables.

Soldar alejado de los líquidos inflamables.

Svetsa inte med brännbara vätskor i närheten.



Non saldare su superfici verniciate.

Do not weld on painted surfaces.

Nicht auf lackierten Materialien schweißen.

Ne pas souder sur des surfaces peintes.

No soldar sobre piezas pintadas.

Svetsa inte på målade plåtytor.



Non saldare in ambienti molto umidi.

Do not weld in humid surroundings.

Niemals in feuchten Räumen schweißen.

Ne pas souder dans un environnement humide.

No soldar sobre piezas húmedas o mojadas.

Undvik svetsning i närhet av människor som inte har skydd för ögonen.



MANUTENZIONI
MAINTENANCE

WARTUNG
ENTRETIEN

MANTENIMIENTO
UNDERHÅLL



Togliere tensione al generatore prima di qualsiasi manutenzione o prima di sostituire o controllare i ricambi della torcia, dopo averla comunque lasciata raffreddare.

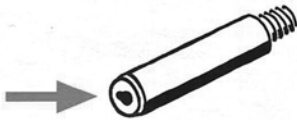
Before you maintain or replace torch parts, turn the machine off. Never turn the machine off, before the post air-flow cycle has stopped.

Vor Wartung, Inspektion oder dem Auswechseln von Verschleißteilen die Schweißlage ausschalten.

Arrêter le générateur après que la torche soit refroidie et avant chaque entretien et avant remplacer ou contrôler les pièces d'usure.

Quitar la tensión al generador antes de cualquier mantenimiento y antes de substituir o verificar los repuestos de la antorcha, da todas formas, después de haber dejado enfriar la antorcha misma.

Slå ifrån den elektriska spänningen till strömkällan före någon inspektion eller underhåll sker på svetspistolen eller på strömkällan. Se dessutom till att svetspistolen har svalnat innan arbetet med underhållet påbörjas.



Sostituire il tubetto di contatto qualora presenti il foro allargato o deformato.

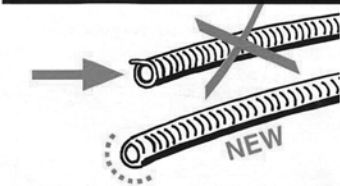
Replace contact tip if hole is enlarged or deformed. Always make sure to use the correct diameter for the Amp.

Die Stromdüse sollte ersetzt werden, wenn die Bohrung deformiert bzw. ausgewaschen ist.

Si le diamètre interne du tube contact est élargie ou déformé, le remplacer.

Cambiar el pico de contacto cuando el agujero esta deformado.

Byt ut kontaktmunstycket då hålet i munstycket är slitet eller deformat.



Sostituire la guaina guidafile quando risulta avere il foro intasato. Smussare la testa della guaina.

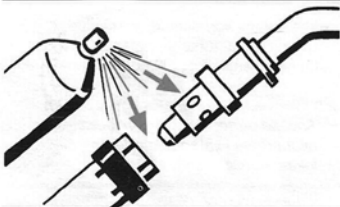
Replace liner if hole is obstructed. Smooth head of liner.

Die Spirale sollte bei verstopfter Bohrung ausgetauscht werden. Bei Montage einer neuen Spirale, bitte die ordnungsgemäße Installation beachten.

Si le trou de la gaine guide fil est obstrué, la nettoyer ou la changer.

Cambiar el flexible de alambre cuando se tapa el agujero o se frene el alambre.

Byt tråddledaren om hålet i den är slitet och försvarar trådgenomföringen. Byt tråddledaren om den har blivit mjuk i speciellt den främre delen i svetspistolen.



Pulire periodicamente l'interno dell'ugello e i fori del diffusore gas. Usare uno spray antiadesivo.

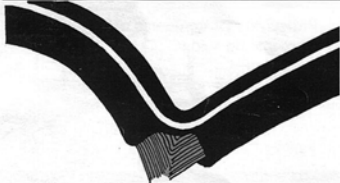
Periodically clean inside of nozzle and holes of gas diffuser. Use an anti-adhesive spray.

Die Gasdüse sollte in Abständen innen gereinigt werden, damit keine Ablagerung von Schweißspritzen einen Kurzschluß erzeugen kann. Ein Silikonfreies Antihafspray sollte verwendet werden.

Nettoyer périodiquement l'intérieur de la buse et les trous du diffuseur gaz. Utiliser un vaporisateur anti-adherent.

Periodicamente limpiar la tobera por dentro, así como los orificios del difusor. Usar líquido anti-adherente.

Rengör med jämna tidsmellanrum kontaktmunstycket, gaskåpan och hålen i gasfordelaren. Använd silikonfri spray.



Controllare il buon stato del cavo. Non eseguire riparazioni di fortuna.

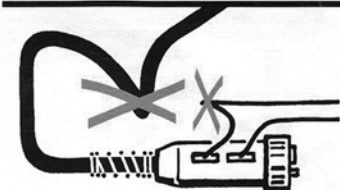
Check condition of cable. Do not make temporary repairs. Repairs should only be made by qualified personal.

Kabel und Zuleitung vor Beschädigungen schützen und kontrollieren.

Contrôler le bon état du câble. Ne pas effectuer des réparations de fortune.

Verificar el buen estado del cable. No hacer reparaciones provisionales.

Kontrollera kablar och slangarnas beskaffenhet och kondition.



Evitare piegature strette del fascio cavi o dei tubi per non creare strozzature del passaggio del gas o del liquido refrigerante.

Do not bend cables and hoses too tightly, to avoid damage that may prevent gas and coolant from free flowing.

Um einen optimalen Gas bzw. Wasserdurchfluß zu gewährleisten, sollten die Schlauchpakete bzw. Gas und Wasserschläuche nicht in zu engen Schleifen verlegt werden. Abgeknickte Schläuche führen zum Überhitzen und Beschädigung der Brenner.

Ne pas plier étroitement housse du faisceau de câbles ou tuyaux afin d'éviter des étranglements du passage gaz ou du liquide réfrigérant.

Para evitar el estrancamiento de la refrigeración, no es conveniente doblar en exceso la manguera.

För att undvika kvävning eller reduktion av gasflödet respektive vatten cirkulationen se till att kabel- och slangpaket inte ligger i för skarpa veck eller böjningar.



Non disperdere nell'ambiente i ricambi usati.

Used parts should be recycled in a proper way, meeting the local requirements.

Benutzte Teile immer ordnungsgemäß entsorgen.

Ne pas laisser les pièces d'usure dans l'environnement.

No botar en el ambiente las refacciones usadas.

Kontrollera att vattenflödet och kylningen av svetspistolen fungerar tillfredsställande.