



Butt Welder Docking Station

Designed for use with the Non-Stop Wire Dispensing™ System, the Wire Wizard® Wire Butt Welder Docking Station quickly and efficiently join ferrous metal wires up to .078 (2mm) in diameter. This unit will weld both solid and cored ferrous wires. *Not compatible with non-ferrous wires, such as aluminum.*

! SAFETY PRECAUTIONS:

- Do not touch the wire or butt welder components during the butt welding cycle
- Protective gloves and safety glasses are required when operating this unit
- Do not operate near explosive or flammable materials
- Inspect cables for damage prior to use
- Do not operate butt welder with exterior cover removed



WARNING: THIS WELDING MACHINE MUST BE CONNECTED TO POWER SOURCE IN ACCORDANCE WITH APPLICABLE ELECTRICAL CODES.

! PRÉCAUTIONS DE SÉCURITÉ:

- Ne touchez pas le fil ou bout composants de soudeur pendant le cycle de soudage en bout
- Gants de protection et des lunettes de sécurité sont nécessaires lors de l'utilisation de cet appareil
- Ne pas utiliser à proximité de matériaux explosifs ou inflammables
- Inspectez l'état des câbles avant de les utiliser
- Ne pas utiliser bout soudeur avec couverture extérieure retiré

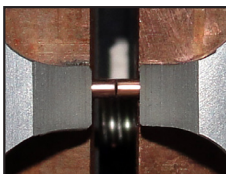


AVERTISSEMENT: LE RACCORDEMENT DE CETTE MACHINE DE SOUDAGE A L'ALIMENTATION DOIT ETRE CONFORME AUX CODES D'ELECTRICITE PERTINENTS.



BUTT WELDING INSTRUCTIONS:

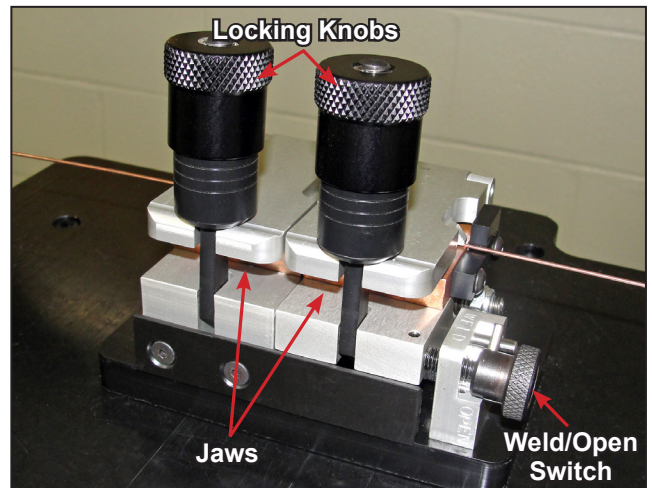
1. Ensure the Wire Size Select switch is in the OFF position (center). Connect Butt Welder to power supply.
2. Pull down both locking knobs to open wire clamps.
3. Pull and turn the Weld/Open switch to the "Open" position.
4. Snip off each end of the wire using a pair of Wire Parters (included). Insert each wire end in grooves until centered in the space between the 2 jaws. Lock wire into place one side at a time by pulling the locking knobs back into place. Ensure the wire ends are flat and evenly aligned. Wire ends must be in contact in order to weld.



IMPORTANT!
Ensure wire ends are evenly aligned prior to butt welding.

Continued on page 2...

Control Panel



Butt Welder



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5. Turn the Weld/Open switch to the "Weld" position.
6. Turn switch on control panel to appropriate setting for wire size.
7. Press green Cycle Start button on the control panel to weld the wire ends together (there will be a slight delay). If the Reset is popped out, push back in to weld.

CAUTION! Keep hands clear of butt welder components and wire when welding.

ATTENTION! Ne touchez pas le fil ou bout composants de soudeur pendant le cycle de soudage en bout.

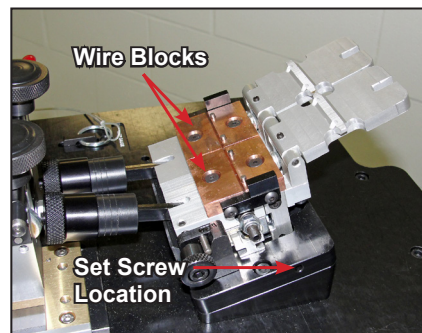
8. Open wire clamps by pulling down both locking knobs.
Remove wire. **CAUTION: Wire may be hot!** **ATTENTION: Fil peut être chaud!**
9. Remove the burr in the wire joint using the optional Wire Sizer or other method of creating a smooth joint. It is recommended to check the joint using a Wire Gage Block to ensure smooth wire feeding.
10. Insert wire onto pathway between the two wire packages installed on the Non-Stop System. Repeat process when replacing empty drums.

TECHNICAL DATA:

Weight: 100 lbs / 45.4 kg	Wire Compatibility: .030 to .078 (0.8 to 2 mm) ferrous wire
Dimensions: 20" W x 24" L x 42"H / 508 x 610 x 1067 mm	Power Requirements: 120v, 5 Amps

TROUBLESHOOTING:

Unit does not power on	<ul style="list-style-type: none"> • Ensure power cable is connected and power source is functioning properly • Press reset button if it has been engaged (popped out)
Wire does not weld	<ul style="list-style-type: none"> • Check power connection and reset button • Wire ends are not in contact when the weld button is pressed. Open jaws and ensure wire ends are in contact and attempt weld again. • Turn wire block set screw (see photo below) counter-clockwise a quarter turn and attempt weld again, continue to turn the screw in even increments and attempt weld again if the first retry fails.
Wire ends weld unevenly	<ul style="list-style-type: none"> • Snip each wire end with the wire parters and retry weld. Ensure the wire ends are in contact and evenly aligned prior to welding. • If wire grooves appear uneven, adjust screws on the wire blocks until they are level (see photo below)
Butt welder continues to cycle after weld is complete (wire will glow red and become extremely hot)	<ul style="list-style-type: none"> • Immediately deactivate by pressing the Emergency Stop button • Turn set screw (see photo below) clockwise a quarter turn and attempt weld again, continue to turn the screw in even increments and attempt weld again if the unit is still getting stuck • Contact customer service, unit may require servicing
Reset button continues to engage	<ul style="list-style-type: none"> • Ensure there are no problems with the power source connected to the unit • Contact customer service, unit may require servicing

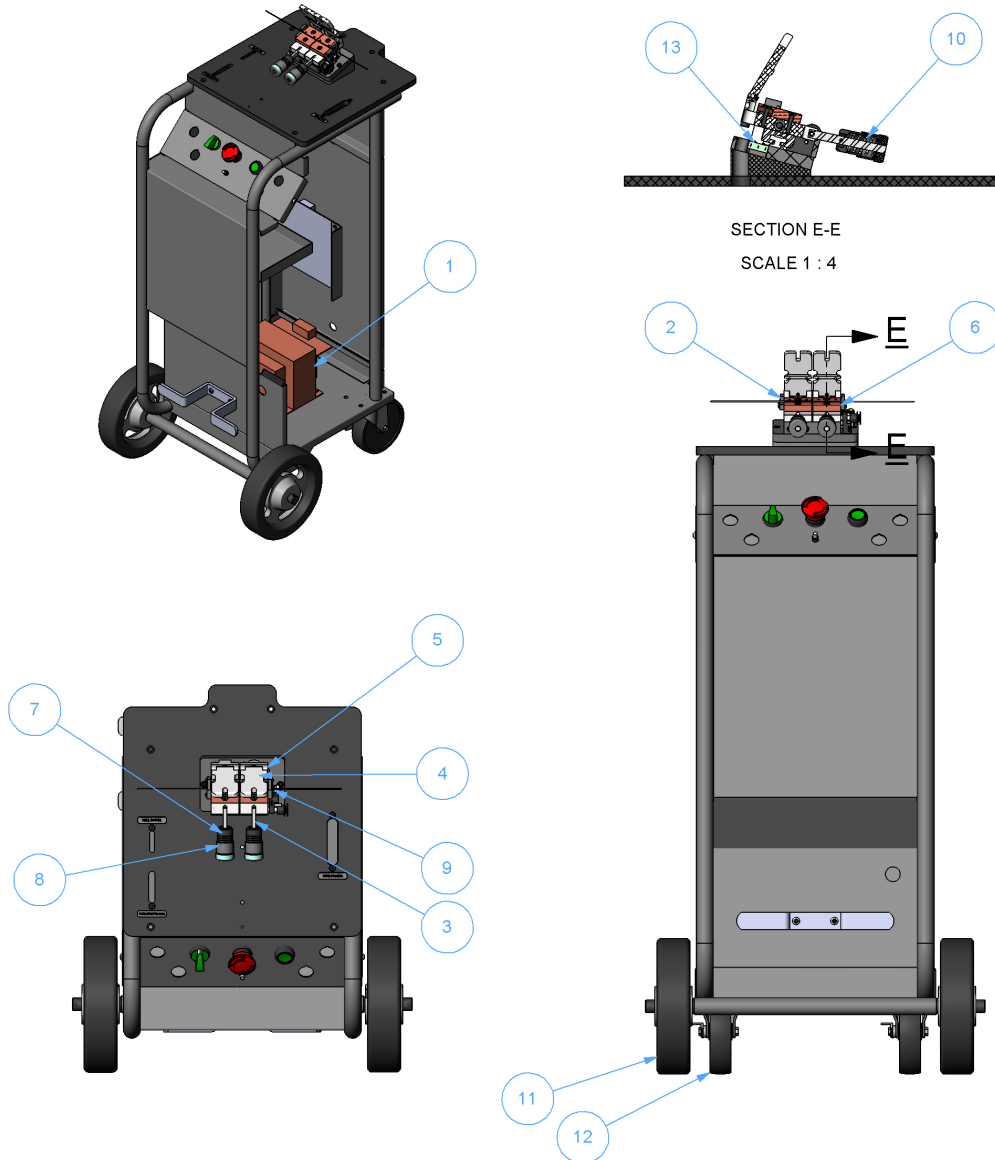


Note: Adjustment of the wire blocks / set screw is only necessary when troubleshooting.

MAINTENANCE:

The Butt Welder Docking Station is generally maintenance free. Cables should be inspected for damage periodically and replaced as needed. If dirty, the butt welder jaws may be wiped clean with a dry rag (do not allow moisture to come in contact with any components).

SPARE PARTS LIST:



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	NSW-BW-TRANS	TRANSFORMER	1
2	NSW-BW-17-11	ROUGH LOCATOR	2
3	NSW-BW-23	PIVOT FASTENER	2
4	NSW-BW-30	CLAMP ARM	2
5	NSW-BW-31	CLAMP UPRIGHT	2
6	NSW-BW-33	LOWER JAW	2
7	NSW-BW-39	ADJUSTER KNOB BASE	2
8	PFA-38	ADJUSTER KNOB	2
9	c0360-042-1250-m	TENSION SPRING	1
10	C0720-085-1250-M	COMPRESSION SPRING	2
11	2319T95	RUBBER WHEEL	2
12	2835T16	SWIVEL WHEEL W/BRAKE	2
13	7658K190	SWITCH	1

**SPARE PARTS SHOWN ARE
PRIMARILY FOR THE BUTT WELDER
ASSEMBLY. CONTACT CUSTOMER
SERVICE PRIOR TO ATTEMPTING
TO SERVICE THE BASE UNIT WITH
ELECTRICAL COMPONENTS.**

SAVE THESE INSTRUCTIONS

