Wire Pilot® Dual Drive Feed Assist Installation

Installation Instructions

1. Installation of the Wire Pilot® Pneumatic Feed Assist should be as close to the wire source (drum, spool or wood reel) as possible. Two M8 X 1.25 mounting holes are located on the side of the unit. Assembly reference drawings are on the back of this page.
2. On many units the drive rolls will be pre-installed. If not, to install the drive rolls, first open the cover (by pulling the locks on the sides of the cover). Follow the steps shown in the photos to install the drive rolls. See the drive roll disassembly diagrams on the back page for further reference. **When installing new drive rolls, ensure the gears are aligned by lining up the marked reference points as shown in the photos at right.**

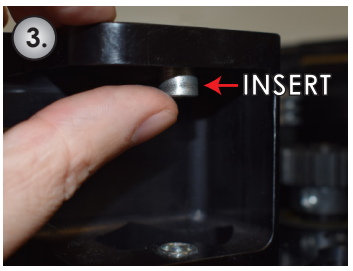
   Drive Roll Screw Torque Setting: 18-20 in/lbs
3. Mount the filter/regulator/lubricator (FRL) so that it is in the vertical position. Cut the air hose to length and connect to the air inlet next to the muffler. Lubricant is recommended but not required. If lubricating, fill the reservoir with air tool lubricating oil or a light grade industrial oil with a viscosity rating of 150 VC 15-20 (SAE5W). Set lubricator so it provides 1 drop of oil for every two minutes of operation at 20 PSI (1.4 bar). See back page for detailed instructions.
4. Ensure that the ball valve is closed and connect the air supply to the inlet of FRL. Air supply should be a 3/8" diameter line (standard shop air 80-100 psi).
5. Feed the wire through the feed assist and close the bail. **Ensure that the wire is between the grooves in the drive rolls.**
6. Confirm the air pressure is set at **0 PSI** on the regulator gauge.
7. Open the ball valve on the filter/regulator.
8. With the ball valve open, slowly increase the air pressure by turning the knob in a **clockwise** direction. 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.
9. 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. The feed assist can provide wire speeds in excess of 1200 IPM.
10. To fine tune the Feed Assist, loosen the tension knobs on the bails until the wire starts to slip between the drive rolls, then tighten it back 1/4 to 1/2 turn. If the unit is set up correctly, the motor should stall when grasping the wire and resume pushing wire when pressure is released. **Do not overtighten drive rolls.**

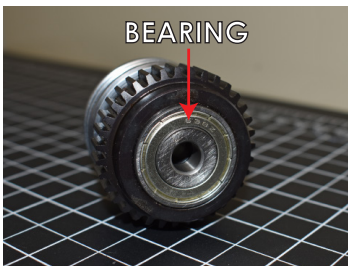
NOTE: When the air pressure is **set too high,** the wire may "bird's nest" or push past the drive rolls when the wire feeder is not feeding wire. If the pressure is **set too low,** it creates drag on the wire feeder causing the drive rolls to slip.

Drive Roll Installation

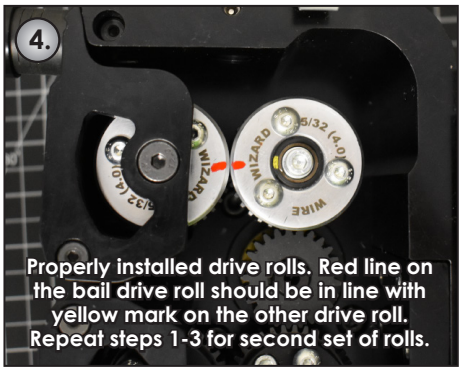
Install the accessible drive roll using 3 screws. On the bail side, remove bolt holding the gear assembly in place.

Install second drive roll and use a marker to mark the drive roll, in line with the yellow mark on the gear.

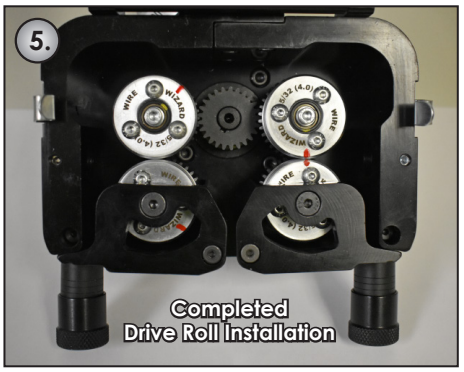




Reinstall the the drive roll and gear assembly into the bail. **Take care to ensure the insert (left) and the bearing (right) are inserted prior to inserting the bolt.**



Properly installed drive rolls. Red line on the bail drive roll should be in line with yellow mark on the other drive roll. Repeat steps 1-3 for second set of rolls.



Completed Drive Roll Installation

Last Revised: 9/26/19

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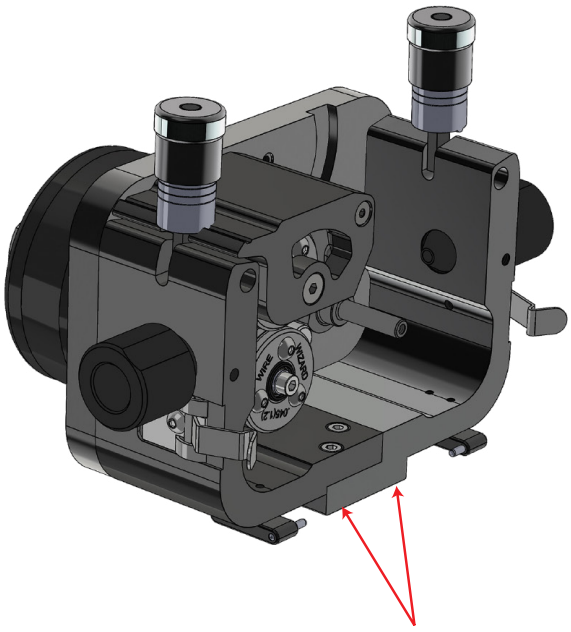
Wire Feed Assist Gear & Drive Roll Assembly

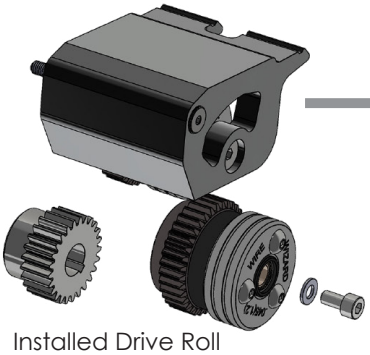
Oiler Adjustment Instructions:

Lubricant is optional for this motor

1. Turn air pressure off.
2. Open the bail on the right side of the motor.
3. Turn air pressure up to 20 PSI (1.4 bar)
4. Adjust oiler until one drop of oil is added for every two minutes of operation.



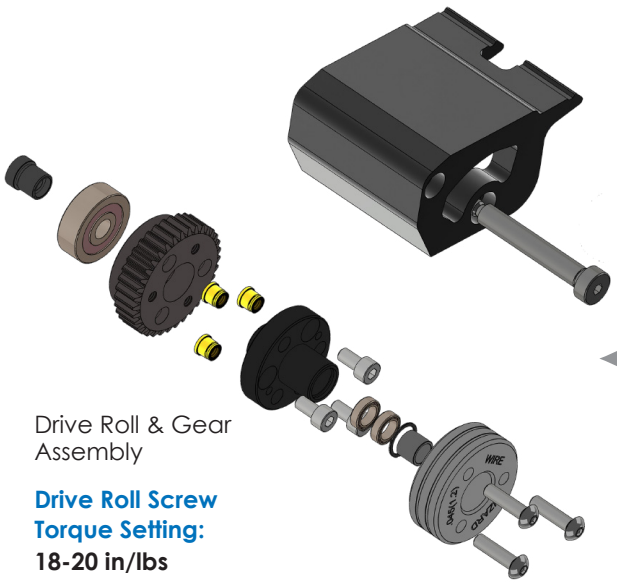
M8 X 1.25 Mounting Holes
(bolts not included)



Installed Drive Roll

Drive Roll Screw Torque Setting:
18-20 in/lbs

PFA-DD
Wire Pilot® Feed Assist
(installed on vertical dereeler)



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