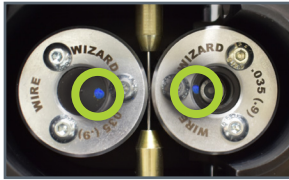


### MODEL PFA-LM-20

1. Installation of the Wire Pilot® Pneumatic Feed Assist should be as close to the wire source (drum, spool or wood reel) as possible (see photos). Dimensional mounting data can be found on the back of this page.

2. Open the clear cover and bail (by lifting the handle up) and install the two drive rolls on the Wire Pilot® motor. Secure them into place with the six screws provided (5/32" allen wrench required). **Upon initial setup, as well as any time the bail is opened and closed, ensure the two blue markings are facing each other as shown for proper gear alignment.**



**Drive Roll Screw Torque Setting: 18 – 20 in/lbs**

3. Mount the filter, regulator, lubricator (FRL) so that it is in the vertical position. 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 for detailed instructions.

4. Ensure that the ball valve is closed and connect the air supply to the inlet of FRL.

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.

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 motor can provide wire speeds in excess of 1200 IPM.

10. To fine tune the Feed Assist, loosen the tension knob on the bail until the wire starts to slip between the drive rolls, then tighten it back 1/4 to 1/2 turn. If the feed assist 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.



Wire Pilot® Feed Assist Mounted on a WGM-PFA-STAND  
(wire drum below).



**Feed Assist Drum  
Adapter Kit**  
PFA-DA



**Adjustable Stand**  
WGM-PFA-STAND

Shown with two Feed  
Assists and four drums

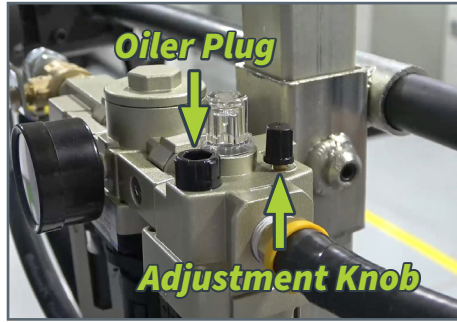
Scan here for  
instructional video  
[youtube.com/WireWizardUS](https://youtube.com/WireWizardUS)



# OILER ADJUSTMENT INSTRUCTIONS

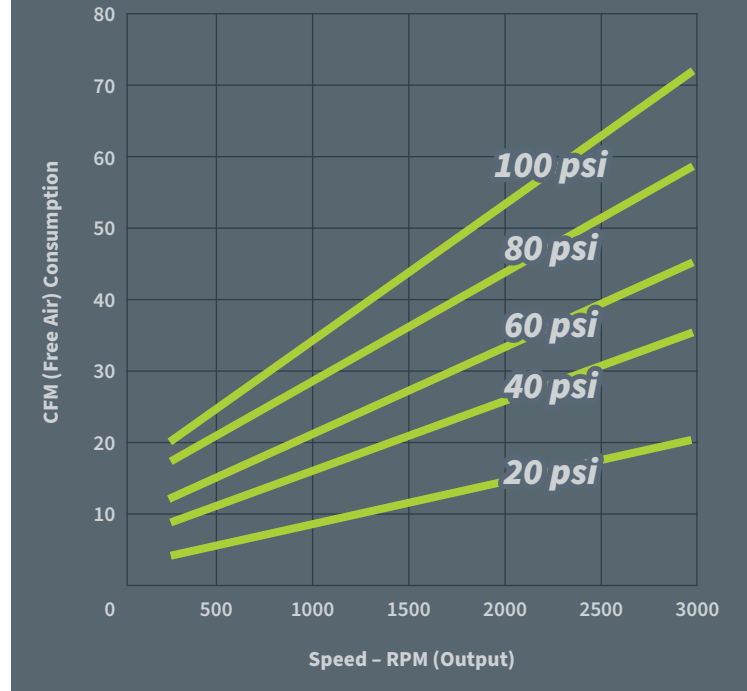
Lubricant is optional for this motor

1. Turn air pressure off.
2. Open 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.



No.	Part No.	Description	Qty.
1	129P01-6-4	3/8 X 1/4 Barb Fitting	1
2	64075	1/8 DIA. X 1/2 Large Roll Pin	1
3	93890A552	3/16 DIA. X 1-1/32 OAL Clevis Pin with E-Clips	1
4	94115A537	Soft Nose Set Screw	2
5	60569	5/16-18 Heli-Coil Insert	1
6	C0720-085-1250-M	Compression Spring	1
7	2780T51	Bearing	2
8	4AM-NRV-54ANLP	Air Motor	1
9	25439	5/16-18 X 1/2 Large Set Screw	1
10	25326	1/4-20 x .25 Large Set Screw	2
11	93806	1/4-28 X 1.000 SHCS Zinc	1
12	HM50 X 207P	Metric Press-In Inserts	6
13	23163	10-32 X .38 LG. SHCS	6
14	41312	M5 X .8 X 20MM LG BHCS Zinc	6
15	94049	1/4-20 X .500 BHCS Zinc	2
16	94028	10-24 X .250 BHCS Zinc	4
17	93201	1/4-20 X 1/2 SHCS Zinc	1
18	26301	1/4 X .375 LG Shoulder Bolt	1
19	91259A546	1/4 X 1 1/2 Shoulder Bolt	1
20	PFA-01-1	Housing	1
21	PFA-03-2	Bail	1
22	PFA-19-1	Gear	1
23	PFA-19-2	Gear	1
24	PFA-21	Shaft Adapter	1
25	PFA-22-1	Shaft Adapter	1
26	PFA-23-2	Spacer	1
27	PFA-26-1	Cover	1
28	PFA-33	Bushing	2
29	PFA-36	Pivot Fastener	1
30	PFA-37	Adjuster Knob Base	1
31	PFA-38	Adjuster Knob	1
32	PFA-66	Front Cover	1
33	PFA-67	Window	1
34	WIRE PILOT DECAL-20	Decal	1
35	PFA-LM-20-SERIAL TAG	Model/Serial Tag	1
36	41212	1/8 X 1/4 Pop Aluminum Rivet	2
37	91744A540	1/4-20 X .750 Spade Head Thumb Screw	2
38	2418T112	AS568A-006 Silicone "O"-Ring	2

## PFA MOTOR AIR CONSUMPTION



## ASSEMBLY & REPLACEMENT PARTS

