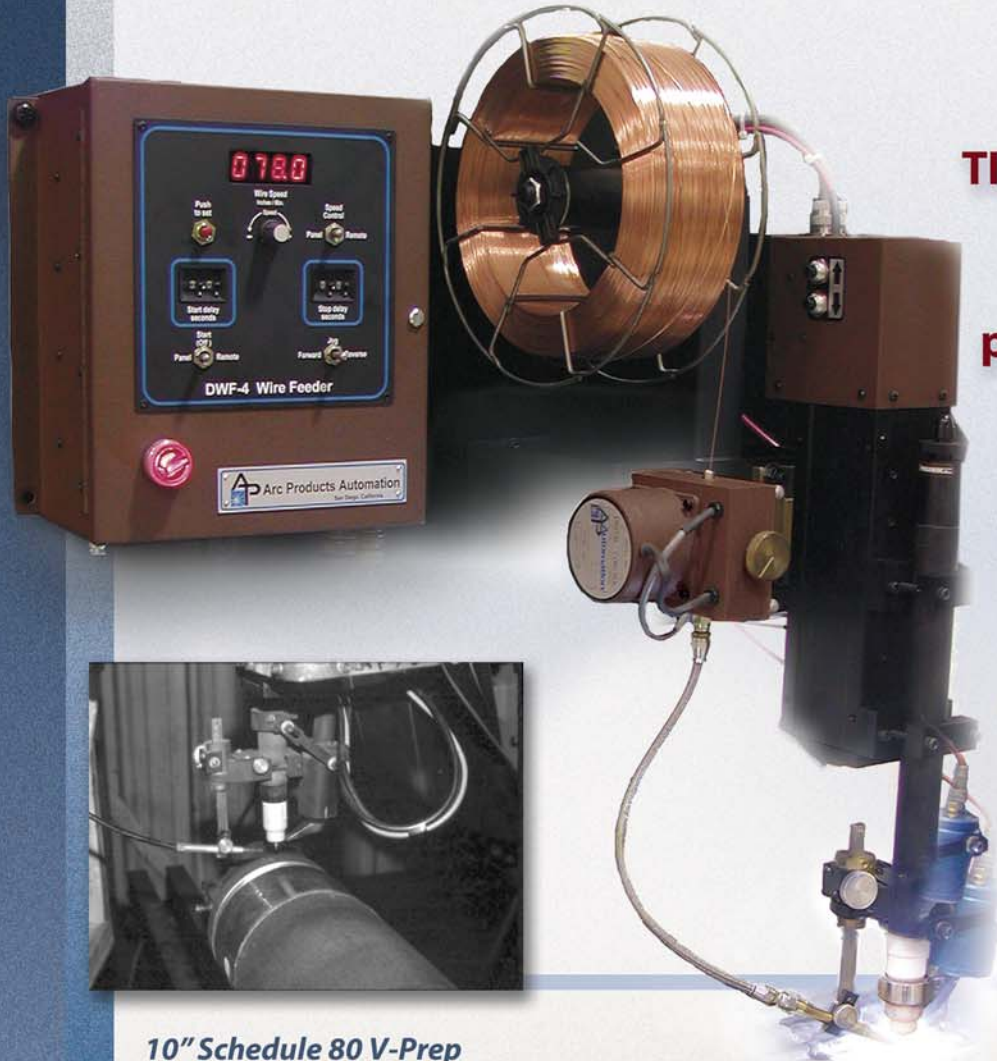


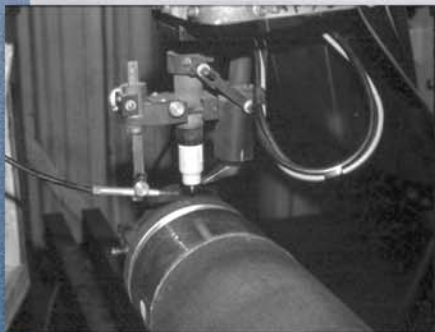
# TIG Wire Feed

*Accurate, Repeatable Feed Rates*



**AP Automation's rugged, precise TIG Wire Feed System automatically delivers TIG and plasma filler wire to the welding arc.**

The DWF-4 and precision stepper drive produce accurate wire feed speeds from .1 to 300 ipm.



## **10" Schedule 80 V-Prep**

*0.6-inch wall thickness is completed in four passes. High wire feed deposition with magnetic weave fills in and caps a wide weld joint. Deep side wall penetration is achieved with a magnetic oscillator. Each pass requires a different wire feed rate.*

## **TIG Wire Feed is used in these typical industries:**

- **Tube and Pipe Mills**
- **Fuel Tanks & Pressure Vessels**
- **Aviation/Aerospace**
- **Multi-pass Pipe Welding**



**1-800-770-0063**

619-628-1022 Fax: 619-628-1028

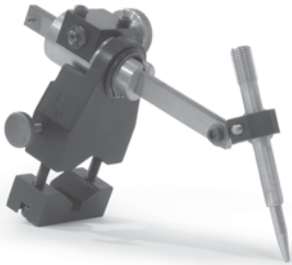
## DWF-4 Control Unit



Engineered for easy operation, the all-digital control unit features the following controls:

- **Start Selector Switch** selects manual start or remote start.
- **Wire Speed** is adjusted by a ten-turn potentiometer and displayed on a digital readout.
- **Speed Control Switch** selects front panel potentiometer or remote speed control signal.
- **Jog** controls forward/reverse wire jog at 100 ipm.
- **Start Delay** inhibits wire feed for an adjustable time until the weld puddle has formed.
- **Stop Delay** continues wire feed for an adjustable time during end of weld down slope to fill in the crater.

## Wire Guide Manipulator



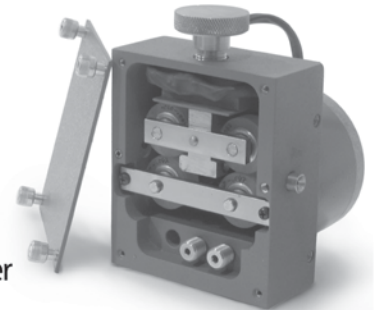
The 4-axis wire guide manipulator allows the operator to make precise adjustments to wire location in the weld pool during welding. Special length conduits also available.

## Compact Drive Unit



For tight clearance requirements, the compact model incorporates both the drive mechanism and the wire guide manipulator into a single, space efficient unit.

## Wire Drive Unit



The AP Automation wire drive unit is a compact, fully enclosed drive mechanism. It incorporates four-gear drive rolls driven by a stepper motor through a set of drive rolls, equipped with replaceable polyurethane driving surfaces, accommodates a wire size range of .020 to .062 in. Drive roll force is controlled by a single thumbscrew.

## System Specifications

**Wire Sizes:** 0.020" - 0.062"  
**Speed Range:** 0 - 299.9 ipm  
**C-DWF:** 0 - 74.9 ipm  
**Speed Resolution:** 0.1 ipm  
**Start Delay Range:** 0 - 9.9 sec.  
**Stop Delay Range:** 0 - 9.9 sec.  
**Delay Resolution:** 0.1 sec.  
**Conduit Length:** 3', other lengths available  
**Drive Cable Length:** 8', extensions available  
**Power Cable Length:** 7.5'

**Input Power Requirement:** 115/230 VAC, 50/60 Hz  
**Torch Sizes:** up to 2" dia.  
**C-DWF:** From 3/4" to 1-5/8" dia.  
**Control Weight:** 13.8 lbs.  
**DWF-4 Drive Weight:** 6.2 lbs.  
**DWF-4 Conduit and Manipulator Weight:** 2 lbs.  
**DWF-4 System Shipping Weight:** 24 lbs.  
**C-DWF-4 Drive Weight:** 4.75 lbs.  
**C-DWF-4 Conduit and Manipulator Weight:** 2 lbs.



AP Automation offers advanced, rugged, and affordable welding equipment and systems.

Call 1-800-770-0063

E-mail [sales@arc-products.com](mailto:sales@arc-products.com), [service@arc-products.com](mailto:service@arc-products.com)