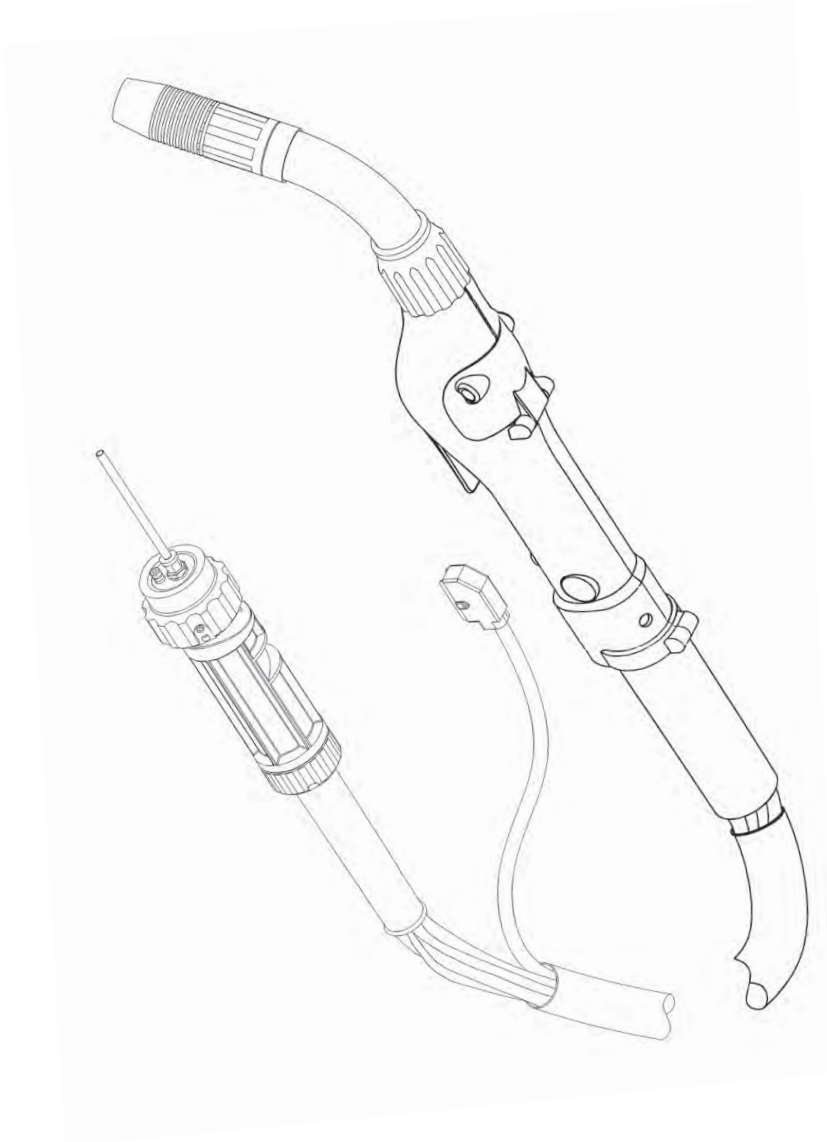




PYTHON[®] **F r o n i u s** **Owner's Manual**

Product:	Python Fronius
Manual:	091-0567
Serial:	06100001
Voltage Rating:	24 VDC
Revision:	Oct 2006 Rev C
Gun models:	231-XXX



225 Ampere Push-Pull Welding Gun

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
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MK Repair Stations

Safety Warnings

Warranty

Declaration of Conformity for European Community (CE) Products

Note  This information is provided for units with CE certification (see rating label on unit).

Manufacturer's Name: **MK Products, Inc.**

Manufacturer's Address: 16882 Armstrong Ave.
Irvine, CA 92606

Declares that the product: **Python[®]**

conforms to the following Directives and Standards:

Directives

Low Voltage Directive: 73/23/EEC

Electromagnetic Compatibility (EMC) Directive: 89/336/EEC

Standards

Arc Welding Equipment Part I: Welding Power Sources: IEC 60974-1
(September 1998 – Second Edition)

Arc Welding Equipment: Wirefeed Systems: IEC 974-5
(September 1997 – Draft Revision)

Degrees of Protection Provided By Enclosures (IP Code): IEC 529:1989
(November 1989 - First Edition)

Insulation Coordination For Equipment With Low-Voltage Systems:
Part I: Principles, Requirements and Tests: IEC 664-1: 1992
(October 1992 – First Edition)

Electromagnetic Compatibility, (EMC): EN 50199
(August 1995)

Torches And Guns For Arc Welding, EN 50078

SAFETY CONSIDERATIONS

ELECTRIC ARC WELDING EQUIPMENT

CAUTION : READ BEFORE ATTEMPTING INSTALLATION, OPERATION OR MAINTENANCE OF THIS EQUIPMENT

1-1 INTRODUCTION

This equipment is intended for ultimate application by commercial/industrial users and for operation by persons trained and experienced in the use and maintenance of welding equipment. Operation should not be undertaken without adequate training in the use of such equipment. Training is available from many public and private schools or similar facilities.

Safe practices in the installation, operation and maintenance of this equipment requires proper training in the art, a careful study of the information provided with the equipment, and the use of common sense. Rules for safe use are generally provided by suppliers of welding power sources, compressed gas suppliers, and electrode suppliers. Careful compliance with these rules will promote safe use of this equipment.

The following Safety Rules cover some of the more generally found situations. READ THEM CAREFULLY. In case of any doubt, obtain qualified help before proceeding.

1-2 GENERAL PRECAUTIONS

A. Burn Prevention

ELECTRIC ARC WELDING PRODUCES HIGH INTENSITY HEAT AND ULTRAVIOLET RADIANT ENERGY WHICH MAY CAUSE SERIOUS AND PERMANENT EYE DAMAGE AND WHICH MAY DAMAGE ANY EXPOSED SKIN AREAS.

Wear helmet with safety goggles or glasses with side shields underneath, appropriate filter lenses or plates (protected by clear cover glass). This is a must for welding or cutting (and chipping) to protect the eyes from radiant energy and flying metal. Replace cover glass when broken, pitted, or spattered.

Medical first aid and eye treatment. First aid facilities and a qualified first aid person should be available for each shift unless medical facilities are close by for immediate treatment of flash burns of the eyes and skin burns.

Wear protective clothing - leather (or asbestos) gauntlet gloves, hat, and high safety-toe shoes. Button shirt collar and pocket flaps, and wear cuffless trousers to avoid entry of sparks and slag.

Avoid oily or greasy clothing. A spark may ignite them.

Flammable hair preparations should not be used by persons intending to weld or cut.

Hot metal such as electrode stubs and

work pieces should never be handled without gloves.

Ear plugs should be worn when working on overhead or in a confined space. A hard hat should be worn when others work overhead.

B. Toxic Fume Prevention

WARNING: The use of this product may result in exposure to chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

Adequate ventilation. Severe discomfort, illness or death can result from fumes, vapors, heat, or oxygen enrichment or depletion that welding (or cutting) may produce. Prevent them with adequate ventilation. NEVER ventilate with oxygen.

Lead-, cadmium-, zinc-, mercury-, beryllium-bearing and similar materials, when welded or cut, may produce harmful concentrations of toxic fumes. Adequate local exhaust ventilation must be used, or each person in the area, as well as the operator, must wear an air-supplied respirator. For beryllium, both must be used.

Metals coated with or containing materials that emit toxic fumes should not be heated unless coating is removed from the work surface, the area is well ventilated, or the operator wears an air-supplied respirator.

Work in a confined space only while it is being ventilated and, if necessary, while wearing an air-supplied respirator.

Gas leaks in a confined space should be avoided. Leaked gas in large quantities can change oxygen concentration dangerously. Do not bring gas cylinders into a confined space.

Leaving confined space, shut OFF gas supply at source to prevent possible accumulation of gases in the space if downstream valves have been accidentally opened or left open. Check to be sure that the space is safe before reentering it.

Vapors from chlorinated solvents can be decomposed by the heat of the arc (or flame) to form PHOSGENE, a highly toxic gas, and other lung and eye irritating products. The ultraviolet (radiant) energy of the arc can also decompose trichloroethylene and perchloroethylene vapors to form phosphene. DO NOT WELD or cut where solvent vapors can be drawn into the welding or cutting atmosphere or where the radiant energy can penetrate to atmospheres containing even minute amounts of trichloroethylene or perchloroethylene.

C. Fire and Explosion Prevention

Causes of fire and explosion are: combustibles reached by the arc, flame, flying sparks, hot slag, or heated material,

misuse of compressed gases and cylinders, and short circuits.

BE AWARE THAT flying sparks or falling slag can pass through cracks, along pipes, through windows or doors, and through wall or floor openings, out of sight of the goggled operator. Sparks can fly many feet.

To prevent fires and explosion:

Keep equipment clean and operable, free of oil, grease, and (in electrical parts) of metallic particles that can cause short circuits.

If combustibles are in area, do NOT weld or cut. Move the work if practicable, to an area free of combustibles. Avoid paint spray rooms, dip tanks, storage areas, ventilators. If the work cannot be moved, move combustibles at least 35 feet away, out of reach of sparks and heat; or protect against ignition with suitable and snug-fitting, fire-resistant covers or shields.

Walls touching combustibles on opposite sides should not be welded on (or cut). Walls, ceilings, and floor near work should be protected by heat-resistant covers or shields.

Fire watcher must be standing by with suitable fire extinguishing equipment during and for some time after welding or cutting if:

1. Appreciable combustibles (including building construction) are within 35 feet.
2. Appreciable combustibles are further than 35 feet, but can be ignited by sparks.
3. Openings (concealed or visible) in floors or walls within 35 feet may expose combustibles to sparks.
4. Combustibles adjacent to walls, ceilings, roofs, or metal partitions can be ignited by radiant or conducted heat.

Hot work permit should be obtained before operation to ensure supervisor's approval that adequate precautions have been taken.

After work is done, check that area is free of sparks, glowing embers, and flames.

An empty container that held combustibles, or that can produce flammable or toxic vapors when heated, must never be welded on or cut, unless container has first been cleaned in accordance with industry standards.

This includes: a thorough steam or caustic cleaning (or a solvent of water washing, depending on the combustible's solubility), followed by purging and inerting with nitrogen or carbon dioxide,

and using protective equipment.

Water-filling just below working level may substitute for inerting.

A container with unknown contents should be cleaned (see paragraph above). Do NOT depend on sense of smell or sight to determine if it is safe to weld or cut.

Hollow castings or containers must be vented before welding or cutting. They can explode.

Explosive atmospheres. NEVER weld or cut where the air may contain flammable dust, gas, or liquid vapors (such as gasoline).

D. Compressed Gas Equipment

The safe handling of compressed gas equipment is detailed in numerous industry publications. The following general rules cover many of the most common situations.

1. Pressure Regulators

Regulator relief valve is designed to protect only the regulator from overpressure; it is not intended to protect any downstream equipment. Provide such protection with one or more relief devices.

Never connect a regulator to a cylinder containing gas other than that for which the regulator was designed.

Remove faulty regulator from service immediately for repair (first close cylinder valve). The following symptoms indicate a faulty regulator:

Leaks - if gas leaks externally.

Excessive Creep - if delivery pressure continues to rise with downstream valve closed.

Faulty Gauge - if gauge pointer does not move off stop pin when pressurized, nor returns to stop pin after pressure release.

Repair. Do NOT attempt repair. Send faulty regulators for repair to manufacturer's designated repair center, where special techniques and tools are used by trained personnel.

2. Cylinders

Cylinders must be handled carefully to prevent leaks and damage to their walls, valves, or safety devices:

Avoid electrical circuit contact with cylinders including third rails, electrical wires, or welding circuits. They can produce short circuit arcs that may lead to a serious accident. (See 1-3C)

ICC or DOT marking must be on each cylinder. It is an assurance of safety when the cylinder is properly handled.

Identifying gas content. Use only cylinders with name of gas marked on them; do not rely on color to identify gas content. Notify supplier if unmarked. NEVER DEFACE or alter name, number, or other markings on a cylinder. It is illegal and hazardous.

Empties: Keep valves closed, replace

caps securely; mark MT; keep them separate from FULLS, and return promptly.

Prohibited use. Never use a cylinder or its contents for other than its intended use, NEVER as a support or roller.

Locate or secure cylinders so they cannot be knocked over.

Passageways and work areas. Keep cylinders clear of areas where they may be stuck.

Transporting cylinders. With a crane, use a secure support such as a platform or cradle. Do NOT lift cylinders off the ground by their valves or caps, or by chains, slings, or magnets.

Do NOT expose cylinders to excessive heat, sparks, slag, and flame, etc. that may cause rupture. Do not allow contents to exceed 55 degrees C (130 degrees F.) Cool with water spray where such exposure exists.

Protect cylinders, particularly valves from bumps, falls, falling objects, and weather. Replace caps securely when moving cylinders.

Stuck valve. Do NOT use a hammer or wrench to open a cylinder valve that cannot be opened by hand. Notify your supplier.

Mixing gases. NEVER try to mix any gases in a cylinder.

NEVER refill any cylinder.

Cylinder fittings should never be modified or exchanged.

3. Hose

Prohibited use. Never use hose other than that designed for the specified gas. A general hose identification rule is: red for fuel gas, green for oxygen, and black for inert gases.

Use ferrules or clamps designed for the hose (not ordinary wire or other substitute) as a binding to connect hoses to fittings.

No copper tubing splices. Use only standard brass fittings to splice hose.

Avoid long runs to prevent kinks and abuse. Suspend hose off ground to keep it from being run over, stepped on, or otherwise damaged.

Coil excess hose to prevent kinks and tangles.

Protect hose from damage by sharp edges, and by sparks, slag, and open flame.

Examine hose regularly for leaks, wear, and loose connections. Immerse pressured hose in water; bubbles indicate leaks

Repair leaky or worn hose by cutting area out and splicing. Do NOT use tape.

4. Proper Connections

Clean cylinder valve outlet of impurities that may clog orifices and damage seats before connecting regulator. Except for hydrogen, crack valve momentarily, pointing outlet away from people and sources of ignition. Wipe with a clean, lintless cloth.

Match regulator to cylinder. Before connecting, check that the regulator label

and cylinder marking agree, and that the regulator inlet and cylinder outlet match. NEVER Connect a regulator designed for a particular gas or gases to a cylinder containing any other gas.

Tighten connections. When assembling threaded connections, clean and smooth seats where necessary. Tighten. If connection leaks, disassemble, clean, and retighten, using properly fitting wrench.

Adapters. Use a CGA adapter (available from your supplier) between cylinder and regulator, if one is required. Use two wrenches to tighten adapter marked RIGHT and LEFT HAND threads.

Regulator outlet (or hose) connections may be identified by right hand threads for oxygen and left hand threads (with grooved hex on nut or shank) for fuel gas.

5. Pressurizing Steps:

Drain regulator of residual gas through suitable vent before opening cylinder (or manifold valve) by turning adjusting screw in (clockwise). Draining prevents excessive compression heat at high pressure seat by allowing seat to open on pressurization. Leave adjusting screw engaged slightly on single-stage regulators.

Stand to side of regulator while opening cylinder valve.

Open cylinder valve slowly so that regulator pressure increases slowly. When gauge is pressurized (gauge reaches regulator maximum) leave cylinder valve in following position: for oxygen and inert gases, open fully to seal stem against possible leak; for fuel gas, open to less than one turn to permit quick emergency shut-off.

Use pressure charts (available from your supplier) for safe and efficient recommended pressure settings on regulators.

Check for leaks on first pressurization and regularly thereafter. Brush with soap solution. Bubbles indicate leaks. Clean off soapy water after test; dried soap is combustible.

E. User Responsibilities

Follow all Safety Rules.

Remove leaky or defective equipment from service immediately for repair. Read and follow user manual instructions.

F. Leaving Equipment Unattended

Close gas supply at source and drain gas.

G. Rope Staging-Support

Rope staging-support should not be used for welding or cutting operation; rope may burn.

1-3 ARC WELDING

Comply with precautions in 1-1, 1-2, and this section. Arc Welding, properly done, is a safe process, but a careless operator invites trouble.

The equipment carries high currents at significant voltages. The arc is very bright and hot. Sparks fly, fumes rise, ultraviolet and infrared energy radiates, weldments are hot, and compressed gases may be used. The wise operator avoids unnecessary risks and protects himself and others from accidents.

A. Burn Protection

Comply with precautions in 1-2.

The welding arc is intense and visibly bright. Its radiation can damage eyes, penetrate lightweight clothing, and burn the skin and eyes. Skin burns resemble acute sunburn; those from gas-shielded arcs are more severe and painful. **DON'T GET BURNED; COMPLY WITH PRECAUTIONS.**

1. Protective Clothing

Wear long-sleeve clothing in addition to gloves, hat, and shoes. As necessary, use additional protective clothing such as leather jacket or sleeves, flameproof apron, and fire-resistant leggings. Avoid outer garments of untreated cotton.

Bare skin protection. Wear dark, substantial clothing. Button collar to protect chest and neck, and button pockets to prevent entry of sparks.

2. Eye and Head Protection

Protect eyes from exposure to arc. Eyes may be damaged by radiant energy when exposed to the electric arc, even when not looking in the direction of the arc. Never look at an electric arc without protection.

Welding helmet or shield containing a filter plate shade no. 12 or denser must be used when welding. Place over face before striking arc.

Protect filter plate with a clear cover plate.

Cracked or broken helmet or shield should NOT be worn; radiation can be passed through to cause burns.

Cracked, broken, or loose filter plates must be replaced IMMEDIATELY. Replace clear cover plate when broken, pitted, or spattered.

Flash goggles with side shields MUST be worn under the helmet to give some protection to the eyes should the helmet not be lowered over the face before an arc is struck. Looking at an arc momentarily with unprotected eyes (particularly a high intensity gas-shielded arc) can cause a retinal burn that may leave a permanent dark area in the field of vision.

3. Protection of Nearby Personnel

Enclose the welding area. For production welding, a separate room or enclosed bay is best. In open areas, surround the operation with low-reflective, noncombustible screens or panels. Allow for free air circulation, particularly at floor level.

Viewing the weld. Provide face shields

for all persons who will be looking directly at the weld.

Others working in area. See that all persons are wearing flash goggles.

Before starting to weld, make sure that screen flaps or bay doors are closed.

B. Toxic Fume Prevention

Comply with precautions in 1-2B.

Generator engine exhaust must be vented to the outside air. Carbon monoxide can kill.

C. Fire and Explosion Prevention

Comply with precautions in 1-2C.

Equipment's rated capacity. Do not overload arc welding equipment. It may overheat cables and cause a fire.

Loose cable connections may overheat or flash and cause a fire.

Never strike an arc on a cylinder or other pressure vessel. It creates a brittle area that can cause a violent rupture or lead to such a rupture later under rough handling.

D. Compressed Gas Equipment

Comply with precautions in 1-2D.

E. Shock Prevention

Exposed electrically hot conductors or other bare metal in the welding circuit, or in ungrounded, electrically-HOT equipment can fatally shock a person whose body becomes a conductor. **DO NOT STAND, SIT, LIE, LEAN ON, OR TOUCH** a wet surface when welding without suitable protection.

To protect against shock:

Keep body and clothing dry. Never work in damp area without adequate insulation against electrical shock. Stay on a dry duckboard, or rubber mat when dampness or sweat cannot be avoided. Sweat, sea water, or moisture between body and an electrically HOT part - or grounded metal - reduces the body surface electrical resistance, enabling dangerous and possibly lethal currents to flow through the body.

1. Grounding the Equipment

When installing, connect the frames of each unit such as welding power source, control, work table, and water circulator to the building ground. Conductors must be adequate to carry ground currents safely. Equipment made electrically HOT by stray currents may shock, possibly fatally. Do NOT GROUND to electrical conduit, or to a pipe carrying ANY gas or a flammable liquid such as oil or fuel.

Three-phase connection. Check phase requirement of equipment before installing. If only three-phase power is available, connect single-phase equipment to only two wires of the three-phase line. Do NOT connect the equipment ground lead to the third (live) wire, or the equipment will become electrically HOT - a dangerous condition that can shock, possibly fatally.

Before welding, check ground for continuity. Be sure conductors are touching bare metal of equipment frames at connections.

If a line cord with a ground lead is provided with the equipment for connection to a switch box, connect the ground lead to the grounded switch box. If a three-prong plug is added for connection to a grounded mating receptacle, the ground lead must be connected to the ground prong only. If the line cord comes with a three-prong plug, connect to a grounded mating receptacle. Never remove the ground prong from a plug, or use a plug with a broken ground prong.

2. Connectors

Fully insulated lock-type connectors should be used to join welding cable lengths.

3. Cables

Frequently inspect cables for wear, cracks, and damage. IMMEDIATELY REPLACE those with excessively worn or damaged insulation to avoid possibly lethal shock from bared cable. Cables with damaged areas may be taped to give resistance equivalent to original cable.

Keep cable dry, free of oil and grease, and protected from hot metal and sparks.

4. Terminals and Other Exposed Parts

Terminals and other exposed parts of electrical units should have insulating covers secured before operation.

5. Electrode Wire

Electrode wire becomes electrically HOT when the power switch of gas metal-arc welding equipment is ON and welding gun trigger is pressed. Keep hands and body clear of wire and other HOT parts.

6. Safety Devices

Safety devices such as interlocks and circuit breakers should not be disconnected or shunted out.

Before installation, inspection, or service of equipment, shut OFF all power, and remove line fuses (or lock or red-tag switches) to prevent accidental turning ON of power. Disconnect all cables from welding power source, and pull all 115 volts line-cord plugs.

Do not open power circuit or change polarity while welding. If, in an emergency, it must be disconnected, guard against shock burns or flash from switch arcing.

Leaving equipment unattended. Always shut OFF, and disconnect all power to equipment.

Power disconnect switch must be available near the welding power source.

Thank You

For selecting a quality product. We want you to take pride in operating this product...as much pride as we have in bringing the product to you!

Please Examine Carton and Equipment For Damage Immediately

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

Please record your equipment identification information below for future reference. This information can be found on your machine nameplate.

Model Name & Number _____

Code & Serial Number _____

Date of Purchase _____

Whenever you request replacements parts for, or information on this equipment always supply the information you have recorded above.

Read this Owner's Manual completely before attempting to use this equipment. Save this manual and keep it handy for quick reference. Pay particular attention to the safety instructions we have provided for your protection.

Section A



Installation

Technical Specifications

Wire Capacity

Aluminum and Cored Wire **.030" - 1/16" (0.8 mm - 1.6 mm)**
Solid and Hard Wire **.030" - .045" (0.6 mm - 1.2 mm)**

Wire Speed (*At rated feeder input voltage*) **70 - 800 ipm (20.3 mpm)**

Duty Cycle - 60% (*All ratings are using Argon gas*) **225 Amps**

Shipping Weight (approximate) **19.29 lbs. (8.29 Kg)**

Gun weight (less leads)..... **2.5 lbs. (1.13 Kg)**

Support Equipment Required

- C.V. or C.C. power source of sufficient capacity for your needs.
- Regulated gas supply and hoses.
- Properly sized power leads from power source to wire feeder and ground.

Gun Lead Connections

Power Cable

A #2 AWG power cable is used on the Python®. The gun end of the cable has a fitting crimped to the copper cable strands. This fitting is then threaded into the gun body. The cabinet end of the power cable is incorporated into the central body connector.

Conduit

The Python® comes standard with a poly-lined conduit, for feeding aluminum wire. The longer fitting with a shallow groove is used on the gun end. A set screw located on top of the gun handle secures the conduit in place. The cabinet end of the conduit is incorporated into the central body connector.

The conduit liner extends from the central body adapter fitting and is designed to slide into the TPS-2700 wire drive up to the trailing drive rolls.

Gas Hose

The gas hose is pushed over a barbed fitting on the gun body and secured with a plastic tie wrap. The cabinet end of the gas hose is incorporated into the central body connector.

Electric Cable

A multi-conductor control cable is used on the Python®. The gun end of the cable is secured with a cable clamp and the wires are connected to the potentiometer, micro switch, motor and the gun body mechanically. Slack is left in the electric cable as it exits the back of the gun to prevent cable and/or wire breakage. The cabinet end of the control cable uses a 9-Pin, rectangular connector.

Section B

Operation

General

The Python® maintains a constant, steady, uniform wire feed speed, regardless of curved or looped wire conduit. The constant push exerted by the slave motor in the cabinet, combined with the pull of the gun motor, causes the wire to literally float friction-free through the wire conduit. The 24VDC gun motor is controlled by a three and three-quarter (3 3/4) turn

potentiometer in the gun handle.

Controls and Settings

Potentiometer

The laterally-positioned potentiometer is located in the lower end of the handle, providing up to 800 ipm (20.3 mpm) with 3 3/4 turns.

Micro Switch

The micro switch assembly consists of a normally open micro switch and solder-attached leads.

Trigger Sensitivity

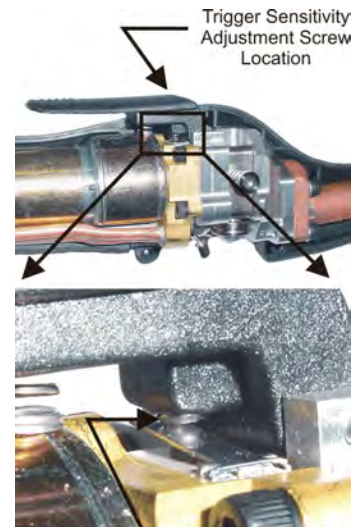
The amount of trigger level travel can be shortened for a quicker or more responsive action.

A more sensitive trigger lever is produced by reducing the gap between the trigger lever and the micro switch lever. By turning-in the trigger sensitivity adjustment screw, it closed the gap between the trigger lever and the micro switch lever.

This will enable the operator to increase the sensitivity of the trigger lever.

Sensitivity Adjustment

With the wire feeder turned on (with or without welding wire loaded), turn the screw in until the micro-switch is activated. Once activated, the gun and wire feeder motors will begin feeding wire. Retract the screw accordingly until the system is deactivated and adjusted to the operators' satisfaction.



Screw adjusted out of trigger, pre-setting the micro-switch lever for shorter trigger motion sensitivity.

Drive Roll and Idler Rolls

The Python® comes standard with a knurled drive roll and a grooved idler roll, which will handle both steel and aluminum wire with diameters from .030-1/16 inch. Optional insulated V-groove drive rolls are also available for aluminum wire if desired (see optional kits).

Drive roll tension is accomplished with a unique spring-loaded pressure screw. The Python® comes from the factory with the pressure adjustment screw preset.

NO ADJUSTMENT REQUIRED FOR ANY WIRE SIZE AND ALLOY

Drive Roll Installation/Removal

Note: Neither of the handles needs to be removed to access the drive or idler rolls.

1. Pull the cam lever away from the idler roll. This will relieve the pressure against the drive roll (as shown in Figure 1).
2. Align the drive roll removal tool over the flats of the drive roll (as shown in Figure 2). Hold the gun with one hand or on a table top, with the other hand give the removal tool a quick snap-turn in the **CLOCKWISE DIRECTION**.



Figure 1

3. Once the drive roll is loose, continue to spin drive roll in the clockwise direction to remove the drive roll from the gun.
4. Install a new drive roll on the left-hand threaded shaft. The drive roll will self-tighten when it is feeding wire.



Figure 2

Idler Roll Installation and Removal
(Reference Figure 3)

1. Using a slot type screwdriver, loosen idler screw, taking care not to lose lock washer under idler roll.
2. Insert new idler roll and lock washer onto screw, insuring that idler groove is toward top and lock washer is beneath.

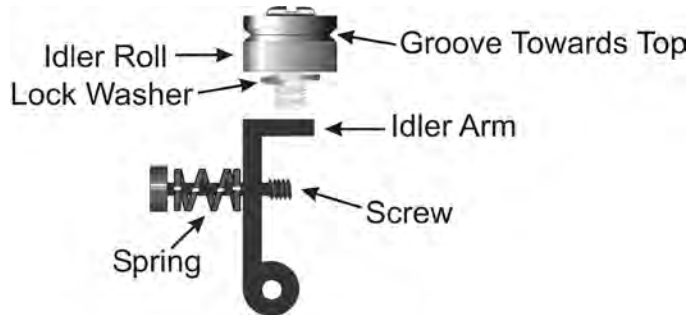


Figure 3

3. Tighten screw until tight.

NOTE: Lock washer must be under idler roll or it will not turn freely.

Section C

Options and Accessories

Insulated Drive Roll Kits

Used to prevent preheating of the wire which may soften it and clog the liner. This picking up of current at the drive rolls rather than at the contact tip is usually not a problem unless using too large of a contact tip or excessively oxidized aluminum wire.

Insulated Groove Drive Roll Kit.....005-0640

For **.030"** (0.8 mm) dia. aluminum wire. Includes insulated drive roll and idler roll assy.

Insulated Groove Drive Roll Kit.....005-0641

For **.035"** (0.9 mm) dia. aluminum wire. Includes insulated drive roll and idler roll assy.

Insulated Groove Drive Roll Kit.....005-0642

For **.040"** (1.0 mm) dia. aluminum wire. Includes insulated drive roll and idler roll assy.

Insulated Groove Drive Roll Kit.....005-0643

For **.045"** (1.2 mm) dia. aluminum wire. Includes insulated drive roll and idler roll assy.

Insulated Groove Drive Roll Kit.....005-0644

For **.062"** (1.6 mm) dia. aluminum wire. Includes insulated drive roll and idler roll assy.

Replacement Kits

Handle Kit..... **005-0699**

Left and right handles, screws and drive roll door, as a replacement for all Python® guns.

Trigger Kit..... **005-0694**

Trigger adjustment kit includes a spring and sensitivity adjustment screw replacement for all Python® guns.

Micro Switch Kit..... **005-0701**

Replacement micro switch assembly for all Python® guns.

Potentiometer Kit..... **005-0695**

Replacement potentiometer assembly for all Python® guns.

Barrel Insulator Kit **005-0696**

Replacement barrel insulator and taper lock nut.

Snake Skins

A Snake Skin protective cover is standard on the Python®.

Replacement Snake Skin **931-0122**

Contact Tips



Heavy Duty Contact Tip - 3/8" Diameter*				
Wire Size	Tip ID	Arc	Tip Length	Part No.
.030" (0.8mm)	.040" (1.0mm)	Spray	1.57" (39.9mm)	621-0390-25
		Short	1.82" (46.2mm)	621-0396-25
.035" (0.9mm)	.045" (1.1mm)	Spray	1.57" (39.9mm)	621-0391-25
				621-0391-250†
		Short	1.82" (46.2mm)	621-0397-25
.047" (1.2mm)	.054" (1.37mm)	Spray	1.57" (39.9mm)	621-0392-25
				621-0392-250†
		Short	1.82" (46.2mm)	621-0392-500††
				621-0398-25
1/16" (1.6mm)	.060" (1.5mm)	Spray	1.57" (39.9mm)	621-0393-25**
				621-0393-250†
		Spray	1.57" (39.9mm)	621-0393-500††
1/16" (1.6mm)	.074" (1.9mm)	Spray	1.57" (39.9mm)	621-0394-25
		Spray		621-0395-25

*Use of tip removal tool is recommended

**This size tip furnished with gun

†Also sold in quantities of 250

††Also sold in quantities of 500

Finned Copper Cups



Finned Copper Gas Cups		
Cup Size	Cup I.D.	Part No.
No. 6	3/8" (9.5mm)	621-0248
No. 8	1/2" (12.7mm)	621-0249
No. 10	5/8" (15.8mm)	621-0250*
Heavy Duty Finned Copper Gas Cups		
Cup Size	Cup I.D.	Part No.
10	5/8" (15.8mm)	621-0251
12	3/4" (19.0mm)	621-0252

*Standard - furnished with gun

Section D

Gun Barrel Liners	
Part Number	Description
931-0137	Teflon liner package, 5 pieces
621-0424	Python® tip extender (Air cooled barrel only)

Barrel

The Python® comes standard with a 60° curved barrel. The barrel assembly locks to the Python® body using the patented EZ Lock™ system.

Optional Barrels - Air Cooled

6" Straight.....	003-2151
6" Curved, 45°	003-2152
12" Straight.....	003-2156
12" Curved, 45°	003-2158
18" Straight	003-2157
18" Curved, 45°	003-2159

Barrel Removal and Installation

To remove the barrel assembly, loosen the patented EZ Lock™ taper lock nut until it is clear of the threads. Pull barrel out of the gun body.

To replace a barrel assembly, push the barrel assembly into the gun body until it clicks to a stop. To assure proper seating of the barrel, open the drive/idler roll door in the top of the handle. The rear face of the barrel should now be flush with the gun body. Take care not to damage the o-rings when inserting into the body. Tighten taper lock nut assembly firmly so that barrel cannot rotate while welding.

Barrel Rotation

To rotate a barrel assembly, loosen the patented EZ Lock™ taper lock nut assembly no more than 1 turn. Rotate barrel to the position of your choice and re-tighten taper lock nut assembly firmly so that the barrel cannot rotate.

CAUTION: Do not attempt to weld without the barrel being tightly secured in the gun body, or damage to the barrel or body may result.

Maintenance

Periodic Maintenance

Your Python® is designed to provide years of reliable service. Maintenance of the gun will normally consist of a general cleaning of the wire guide system, including barrels, drive rolls, and conduits at regular intervals.

Remove spatter build-up from inside of nozzles with a hardwood stick.

The only parts that are subject to normal wear are the conduit, contact tips, nozzles, barrel liners, wire guides, drive and idler rolls. A supply of these parts should be maintained on hand.

The number of units in operation and the importance of minimal down time will determine to what extent spare parts should be stocked on hand. See the recommended spare parts list for the most commonly replaced parts.

Maintenance Tools	
Tool	Part Number
Drive Roll Removal Tool	931-0100

It is recommended that you blow out your conduit each time you install a new spool of wire.

If repairs do become necessary, qualified shop maintenance personnel can easily replace any part.

Reference the table below for suggested Maintenance Tools used with the Python® welding gun.

Recommended Spare Parts

Listed in the table below is the factory recommendation of the necessary spare parts which should be kept on hand for maintaining proper operation of the Python® welding gun.

This list, in no way, indicates that these parts are more likely to fail or cause equipment damage. This is not an indication of premature failure or defect in manufacture of said parts.

Recommended Spare Parts List		
Qty.	Part Number	Description
1	615-0604-15	15' Conduit
1	615-0604-25	25' Conduit
1	615-0604-35	35' Conduit
1	615-0604-50	50' Conduit
2	005-0694	Trigger Assy Kit
2	005-0695	Potentiometer Assy Kit
1	005-0699	Handle Kit
2	005-0701	Micro-Switch Assy Kit
10	511-0101	Drive Roll
5	005-0686	Idler Roll Kit
2	931-0137	Liner Package - 5 pieces each

Section E

Troubleshooting Guide

To aid in troubleshooting problems with your welding equipment, it is best to understand the basic theory of operation for this Push-Pull System. The slave motor in the feeder runs at a fast, constant speed, but has very low torque. It is always trying to feed more wire than the gun motor wants, and when the motor gets all it wants, it slows the slave motor, preventing a bird's nest. Because of the low torque produced by the slave motor, a brake system is used to prevent wire overrun rather than tension. The drag adjustment in the feeder is used simply to keep the wire slightly taut, so it will not pull off the spool while feeding wire.

The high torque 24VDC gun motor is controlled by a solid state speed control located in the feeder, and a pot located in the gun. The gun motor, potentiometer, and micro switch are connected to the cabinet/control box via a control cable and Amphenol connector. If this cable becomes damaged, a variety of symptoms can occur, depending on which wire(s) break. To test, check each wire for continuity and shorts.

Remember, the micro switch in the gun activates both the slave motor and gun motor circuits in the cabinet. Therefore, if the slave motor and brake solenoid operate, but the gun does not, look more toward the gun motor's 24VDC circuits, speed control, control cable, or the gun motor. If nothing operates, look more toward the slave motor's input, micro switch leads, or micro switch.

Testing The Gun

Reference the 9-pin rectangular diagram on the Python® electrical diagram for information about pin-outs and locations.

Motor Check

Remove the connector from the cabinet.

Using the 9-pin connector, check the resistance across pins "1" and "6" (motor leads). The resistance across the motor should be between **5 - 10 ohms** as the potentiometer is turned.

If an open circuit or short exist, check the motor leads and motor independently.

Testing the Gun Potentiometer

Using the 9-pin connector, check the resistance across pin "3" (wiper) and pin "2". The resistance should vary from **0 - 5K ohms** as the potentiometer is turned.

Check the resistance across pin "3" (wiper) and pin "7". The resistance should vary from **5K - 0 ohms** as the potentiometer is turned.

Testing the Micro Switch

Using the 9-pin connector, check for continuity across pins "9" and "5" when the trigger is pressed.

Troubleshooting Table

Symptoms	Cause	Remedy
No wire feed at gun, feeder not operating, i.e. no slave motor or brake solenoid.	Circuit breaker in feeder/control box open.	Reset.
	Micro-switch defective/not being activated.	Replace switch. Check switch for operation.
	Broken electrical cable.	Check micro-switch wires for continuity.
No wire feed at gun, feeder operating properly.	Circuit breaker in feeder/control box open.	Check motor leads for short. Reset.
	Bad potentiometer.	Check potentiometer with meter.
	Broken electrical cable.	Check motor and potentiometer wires for continuity.
	Bad speed control/PCB.	See specific feeder/control box owner's manual for speed control operation.
Wire feeds, but welding wire is not energized.	Loose or no cable connections.	Check all power connections.
	Contactors control cable loose or in wrong position.	Check power supply owner's manual for location and type of contactor signal required.
	Welding power source.	Check power source.
Wire feeds erratically.	Dirty or worn conduit.	Blow out or replace conduit.
	Wrong size contact tip.	See contact tip table.
	Idler roll stuck.	Check for lock washer under idler roll, or replace if damaged.
Wire feeds one speed only.	Bad potentiometer.	Check with meter.
	Broken electrical cable.	Check potentiometer wires for continuity or short.
	Bad speed control.	See specific feeder/control owner's manual for speed control operation.
Wire walks out of drive rolls.	Idler roll upside-down.	Place groove in idler roll toward top.
	Rear wire guide missing.	Replace wire guide.

Consult wire feeder and welding power supply owners manuals for further problem solving solutions.

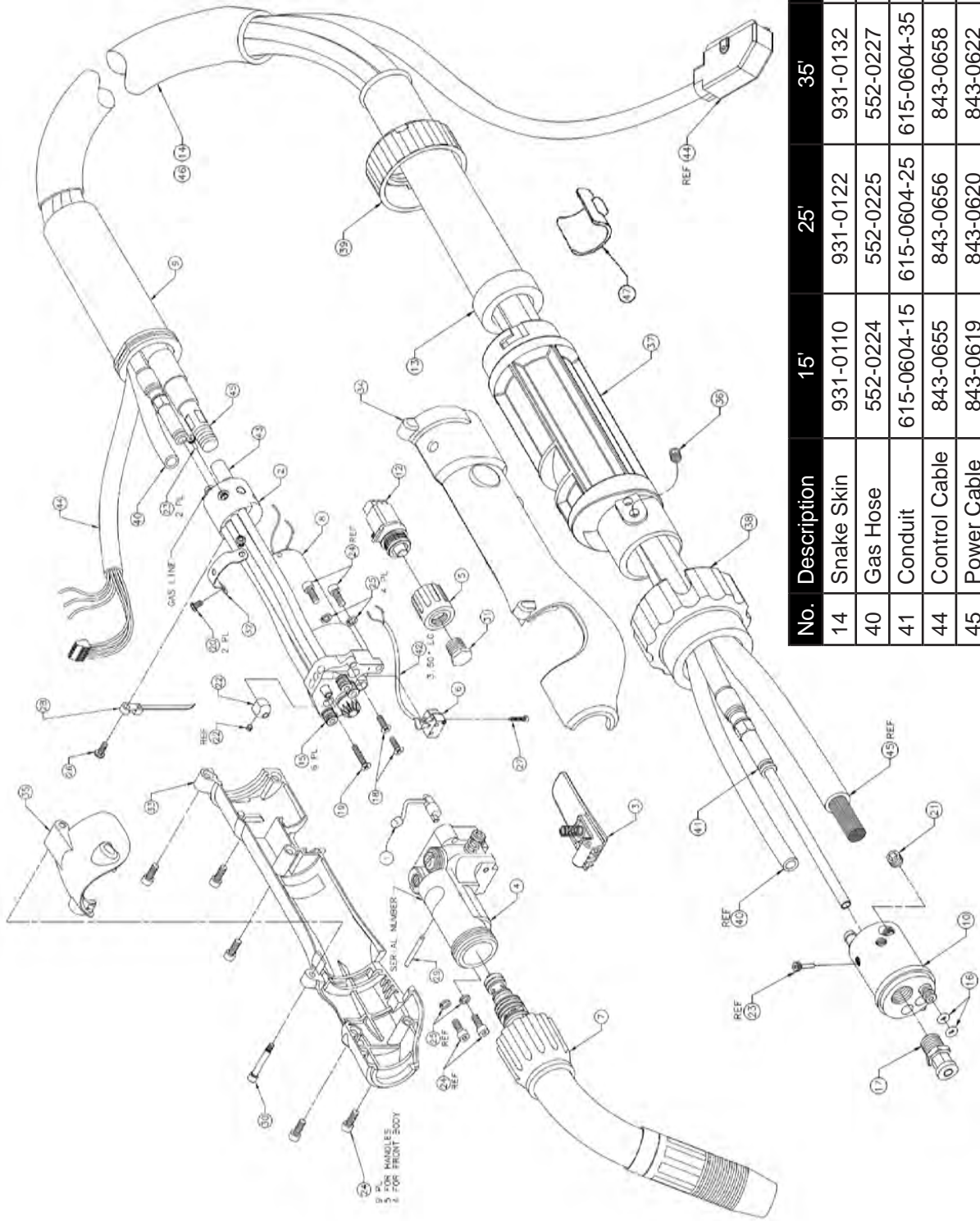
Section F

Appendices

Python® Diagrams / Parts List

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Python®

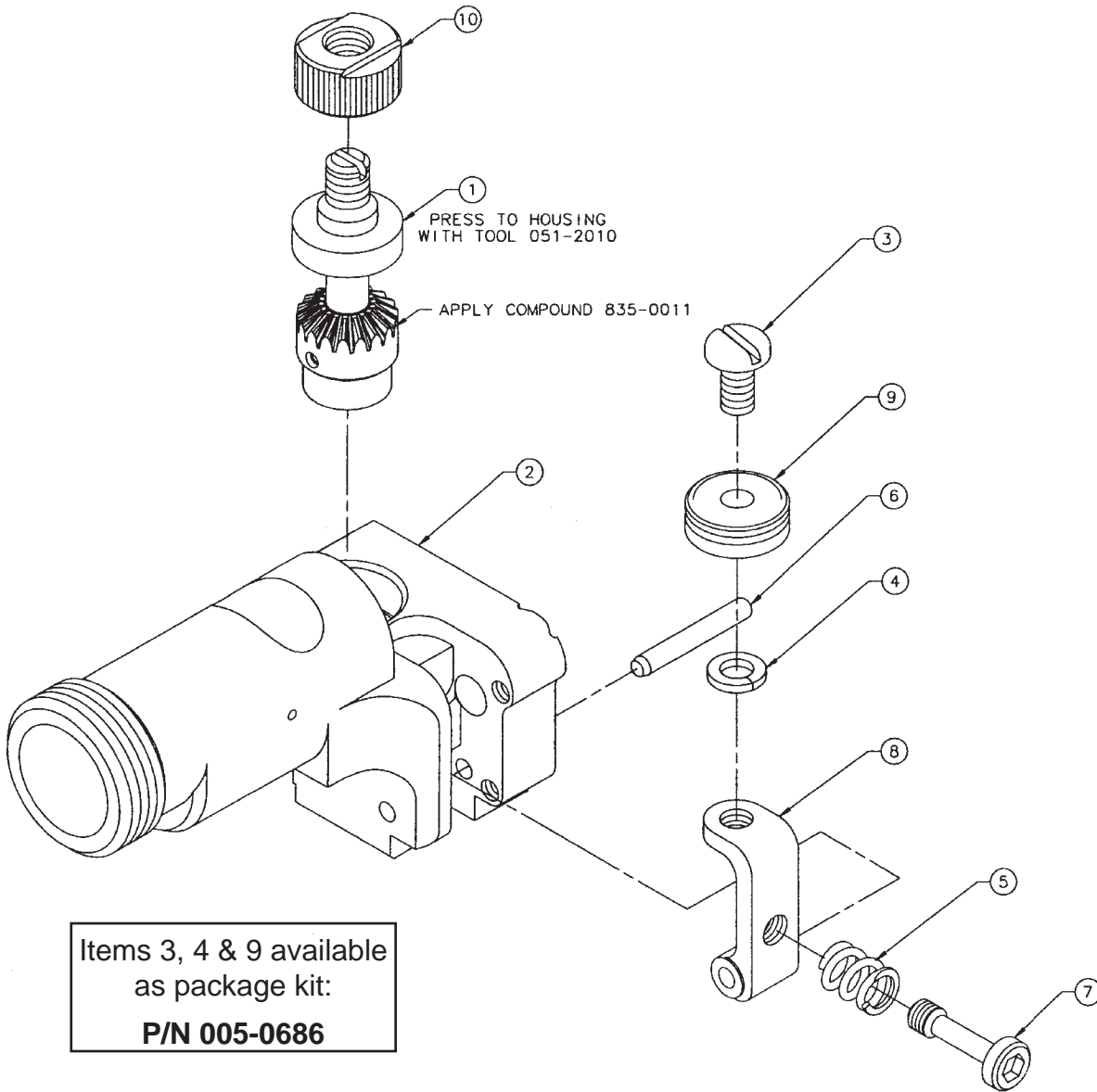


No.	Description	15'	25'	35'	50'
14	Snake Skin	931-0110	931-0122	931-0132	931-0123
40	Gas Hose	552-0224	552-0225	552-0227	552-0226
41	Conduit	615-0604-15	615-0604-25	615-0604-35	615-0604-50
44	Control Cable	843-0655	843-0656	843-0658	843-0657
45	Power Cable	843-0619	843-0620	843-0622	843-0621

Python Fronius Parts List

No.	Qty	Part No.	Description	No.	Qty	Part No.	Description
1	1	002-0629	Cam Idler Arm Assy	25	4	333-0005	Spring Lock Washer #6
2	1	002-0631	Brazed Rear Body	26	1	336-0020	Screw PH Phil 4-40 x 5/16 SST
3	1	005-0694	Trigger Kit	27	1	338-0153	Screw SHC 1-72 x 3/8
4	1	003-2108	Front Body Assy	28	1	411-0243	Eyelet Tie Wrap
5	1	003-2125	Knob Pot Assy	29	1	421-0018	Pin Dowel 3/32 x 7/8 SST
6	1	005-0701	Micro Swx Kit	30	1	431-1622	Shoulder Screw 1/8 x 4-40
7	1	003-2147	Barrel 60° Air Cooled	31	1	431-1637	Hex Screw 3/8-20 x 3/8
8	1	211-0077	Motor 24VDC	32	1	435-1585	Strap Motor
9	1	003-2153	Gun Boot Assy	33			Handle Kit: includes line items 24, 30, and 35
10	1	002-0654	Central Body Adapter	34	1	005-0699	
--	--	--	--	35	1	437-0253	Door Molded
12	1	005-0695	Pot Assy Kit	36	1	321-0071	Set Scr Cup #10-32 x 1/4
13	1	301-0108	Boot Cable Support	37	1	437-0264	Handle Adapter Support
14	1	REF TABLE	Snake Skin	38	1	437-0265	Nut Handle Adapter
15	6	303-0096	O-Ring 2-007	39	1	437-0266	Ring Bayonet
16	2	303-0097	O-Ring 2-005 Buna N	40	1	REF TABLE	Gas Hose
17	1	431-1788	Conduit Liner Fitting	41	1	REF TABLE	Conduit Assy
18	2	319-0254	Screw FH Phil 82 4-40 x 3/8 SST	42	0.30 FT	737-0048	Tube Insulation 9 AWG Clear
19	1	319-0258	Screw FH Phil 82 4-40 x 5/8 SST	43	1	751-0020	Cap Plug 0.218 ID x 0.50 LG
20	2	320-0084	Screw Button 4-40 x 3/16 ST	44	1	REF TABLE	Cable Ctrl Assy
21	1	321-0518	Set Scr Cup 1/4-20 x 3/8	45	1	REF TABLE	Cable Power Assy
22	1	003-2209	Wire Guide Assy	46	2	261-0094	Wrap Spiral Cord
23	2	321-1104	Set Screw Mod #8-32	47	1	437-0268	Knob Cover
24	9	328-0012	Screw SHC 6-32 x 3/8				

Python® Front Body Assembly P/N 003-2108

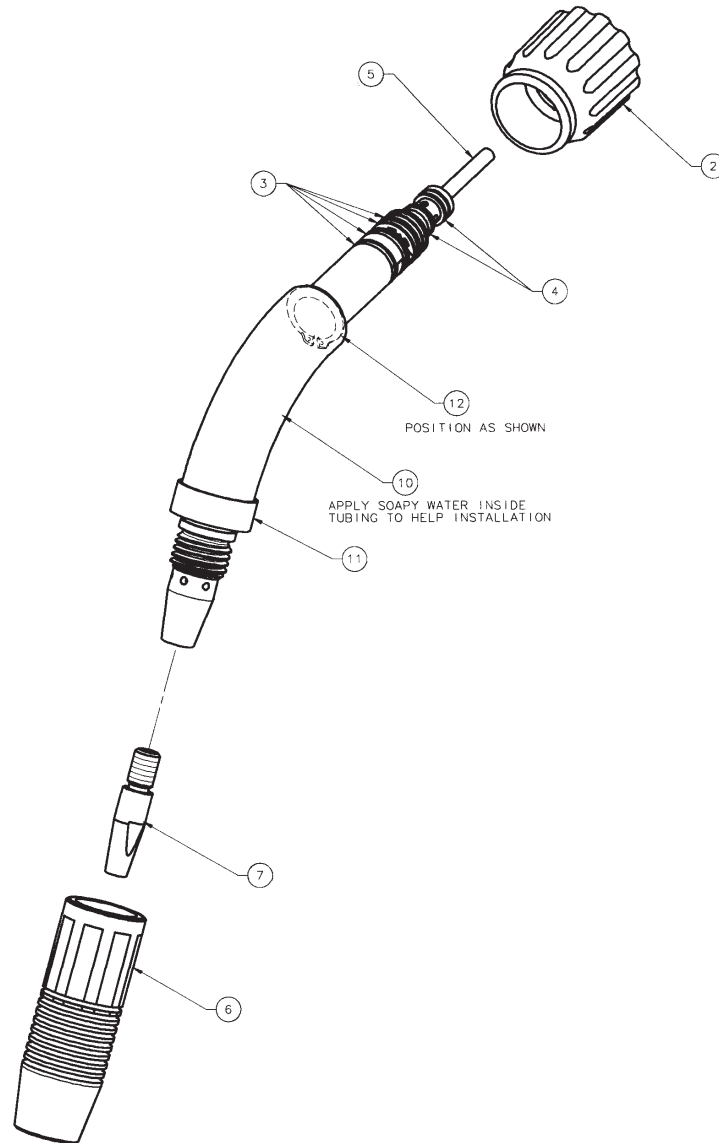


Items 3, 4 & 9 available
as package kit:
P/N 005-0686

Python® Front Body Assembly			
No.	Qty.	Part No.	Description
1	1	003-2083	Output Shaft Assembly
2	1	003-2106	Body Assembly
3	1	325-0206*	10-24 x 3/8 PH Screw
4	1	333-0082*	# 10 Lock Washer
5	1	419-0092	0.29 x 0.047 x 0.32 Comp. Spring
6	1	421-0525	1/8 x 7/8 SST Dowel Pin
7	1	431-1663	Idler Adjusting Screw
8	1	431-1598	Idler Arm
9	1	511-0001*	Idler Wire Feed Assembly
10	1	511-0101	Drive roll

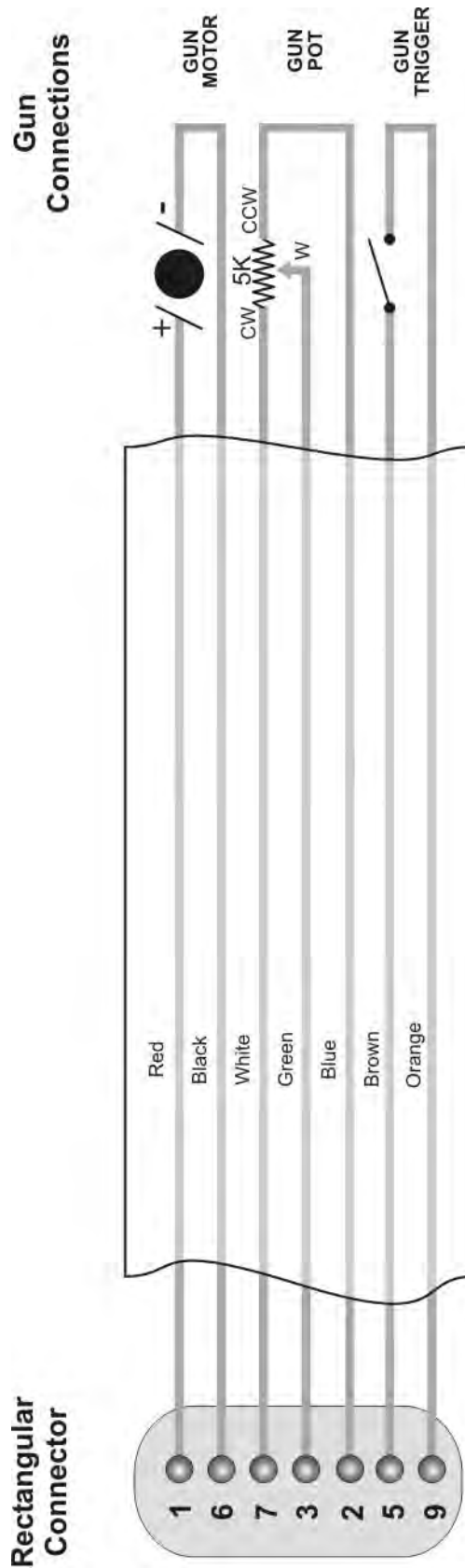
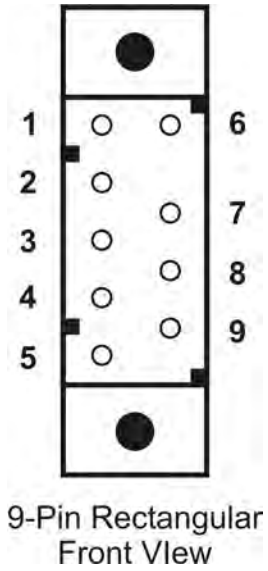
* Items 3, 4 & 9 available as package kit: **Part number 005-0686**

Python® Barrel Assembly P/N 003-2147



Python® Air/Water Cooled 60° Barrel Assembly			
No.	Qty.	Part No.	Description
1	---	---	---
2	1	003-2213	Assy Taper Lock Barrel
3	1	303-0010	O-Ring, 0.489 ID x 0.070 WT
4	1	303-0094	O-Ring, 0.301 ID x 0.070 WT
5	1	931-0137	Liner Package - 5 pcs.
6	4	621-0250	Assy Cup CPR Finned #10
7	2	621-0393	Tip HD .060
8	---	---	---
9	---	---	---
10	1	005-0696	Insulator Replacement Kit
11	1	431-1774	Cup Insulator
12	1	313-0091	Retaining Ring 5/8 Shaft

Python® Electrical Schematic/ Connector Pinout



LIMITED WARRANTY

Effective October 1, 2006

This warranty supersedes all previous MK Products warranties and is exclusive, with no other guarantees or warranties expressed or implied.

LIMITED WARRANTY - MK Products, Inc., Irvine, California warrants that all new and unused equipment furnished by MK Products is free from defects in workmanship and material as of the time and place of delivery by MK Products. No warranty is made by MK Products with respect to trade accessories or other items manufactured by others. Such trade accessories and other items are sold subject to the warranties of their respective manufacturers, if any.

MK Products' warranty does not apply to components having normal useful life of less than one (1) year, such as relay points, wire conduit, tungsten, and welding gun parts that come in contact with the welding wire, including gas cups, gas cup insulators, and contact tips where failure does not result from defect in workmanship or material.

MK Products shall, exclusively remedy the limited warranty or any duties with respect to the quality of goods, based upon the following options

- (1) repair
- (2) replacement
- (3) where authorized in writing by MK Products, the reasonable cost of repair or replacement at our Irvine, California plant.

As a matter of general policy only, MK Products may honor an original user's warranty claims on warranted equipment in the event of failure resulting from a defect within the following periods from the date of delivery of equipment to the original user:

- 1. Power Supplies and Wire Feed Cabinets 3 years
- 2. Weldheads, Positioners, Prince XL and Prince XL Spool Guns, Python, CobraMAX, Cobra SX, Cobra MX 1 year
- 3. Sidewinder® Spool Gun, Prince SG Spool Guns, Modules 180 days
- 4. Repairs/Exchanges/Parts 90 days

Classification of any item into the foregoing categories shall be at the sole discretion of MK Products. Notification of any failure must be made in writing within 30 days of such failure.

A copy of the invoice showing the date of sale must accompany products returned for warranty repair or replacement.

All equipment returned to MK Products for service must be properly packaged to guard against damage from shipping. MK Products will not be responsible for any damages resulting from shipping.

Normal surface transportation charges (one way) for products returned for warranty repair or replacement will be borne by MK Products, except for products sold to foreign markets.

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