



**EN**

## Retrofit option

### ON HASE XQ

Torch hose package support arm

099-004314-EW501

Observe additional system documents!

15.03.2022

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# General instructions

## WARNING



### **Read the operating instructions!**

#### **The operating instructions provide an introduction to the safe use of the products.**

- Read and observe the operating instructions for all system components, especially the safety instructions and warning notices!
- Observe the accident prevention regulations and any regional regulations!
- The operating instructions must be kept at the location where the machine is operated.
- Safety and warning labels on the machine indicate any possible risks. Keep these labels clean and legible at all times.
- The machine has been constructed to state-of-the-art standards in line with any applicable regulations and industrial standards. Only trained personnel may operate, service and repair the machine.
- Technical changes due to further development in machine technology may lead to a differing welding behaviour.

**In the event of queries on installation, commissioning, operation or special conditions at the installation site, or on usage, please contact your sales partner or our customer service department on +49 2680 181-0.**

**A list of authorised sales partners can be found at [www.ewm-group.com/en/specialist-dealers](http://www.ewm-group.com/en/specialist-dealers).**

Liability relating to the operation of this equipment is restricted solely to the function of the equipment. No other form of liability, regardless of type, shall be accepted. This exclusion of liability shall be deemed accepted by the user on commissioning the equipment.

The manufacturer is unable to monitor whether or not these instructions or the conditions and methods are observed during installation, operation, usage and maintenance of the equipment.

An incorrectly performed installation can result in material damage and injure persons as a result. For this reason, we do not accept any responsibility or liability for losses, damages or costs arising from incorrect installation, improper operation or incorrect usage and maintenance or any actions connected to this in any way.

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Dr. Günter-Henle-Strasse 8  
56271 Mündersbach Germany  
Tel.: +49 2680 181-0, Fax: -244  
Email: [info@ewm-group.com](mailto:info@ewm-group.com)

**[www.ewm-group.com](http://www.ewm-group.com)**

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The content of this document has been prepared and reviewed with all reasonable care. The information provided is subject to change; errors excepted.

### **Data security**

The user is responsible for backing up data of all changes from the factory setting. The user is liable for erased personal settings. The manufacturer does not assume any liability for this.

**1 Safety instructions****1.1 For your safety****⚠ WARNING****No improper repairs and modifications!**

To prevent injuries and damage to the machine, only competent personnel (authorised service personnel) are allowed to repair or modify the machine.

**Unauthorised manipulations will invalidate the warranty!**

- Instruct competent personnel (authorised service personnel) to repair the machine.

**Risk of accidents due to non-compliance with the safety instructions!****Non-compliance with the safety instructions can be fatal!**

- Carefully read the safety instructions in this manual!
- Observe the accident prevention regulations and any regional regulations!
- Inform persons in the working area that they must comply with the regulations!

**⚠ CAUTION****Obligations of the operator!**

The respective national directives and laws must be complied with when operating the machine!

- Implementation of national legislation relating to framework directive 89/391/EEC on the introduction of measures to encourage improvements in the safety and health of workers at work and associated individual guidelines.
- In particular, directive 89/655/EEC concerning the minimum safety and health requirements for the use of work equipment by workers at work.
- The regulations applicable to occupational safety and accident prevention in the country concerned.
- Setting up and operating the machine as per IEC 60974.-9.
- Brief the user on safety-conscious work practices on a regular basis.
- Regularly inspect the machine as per IEC 60974.-4.

**These supplementary sheets must be used in conjunction with the appropriate standard operating instructions for the described product! These supplementary sheets expand or replace one or more chapters of the same name(s) in the standard description.**

**Read and observe the operating instructions for all system components, especially the safety instructions!**

## 2 Intended use

### 2.1 General

#### **WARNING**



##### **Hazards due to improper usage!**

The machine has been constructed to the state of the art and any regulations and standards applicable for use in industry and trade. It may only be used for the welding procedures indicated at the rating plate. Hazards may arise for persons, animals and material objects if the equipment is not used correctly. No liability is accepted for any damages arising from improper usage!

- The equipment must only be used in line with its designated purpose and by trained or expert personnel!
- Do not improperly modify or convert the equipment!

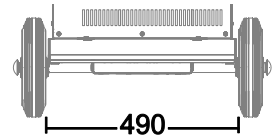
#### **CAUTION**



##### **Unsuitable tread width of the power source!**

Machines with an unsuitable tread width may not be equipped with this option as they could topple and cause injuries.

- The carriage of the power source must have a tread width of at least 490 mm!



**2.2 Applications**

Support arm for torch hose packages.

**For machine variants with wheel spacers only!**

**2.3 Use and operation solely with the following machines**

- Drive XQ
- Drive XQ AC

**2.4 Short description of the working steps required**

- Mount the support arm on the foot plate.
- Put the foot plate in place and screw it on.
- Mount the wire feeder on the support arm.
- Mount the telescope arm on the support arm.

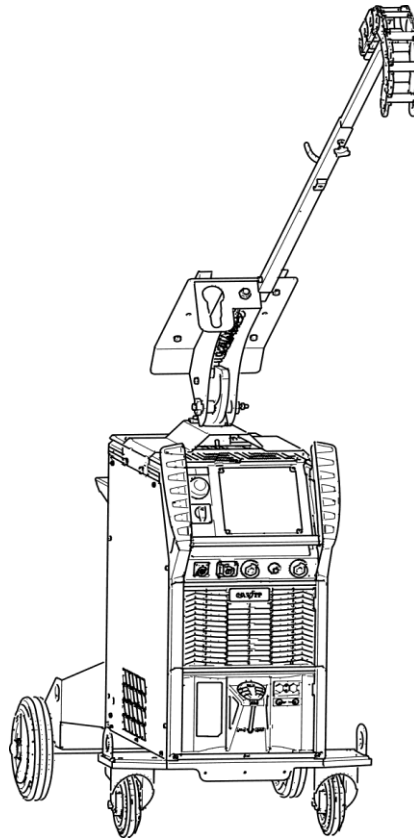
**2.5 Diagram of the assembled option**

Figure 2-1

## 3 Conversion

### 3.1 General



### ⚠ DANGER

**Risk of injury from electric shock!**

**Servicing machines that are not disconnected from the mains can lead to serious injuries!**

- Disconnect the machine completely from the mains.  
Pull out the mains plug!
- Wait for 4 minutes until the capacitors have discharged!

### 3.2 Parts list

Before conversion, check that the retrofit kit is complete (see parts list).

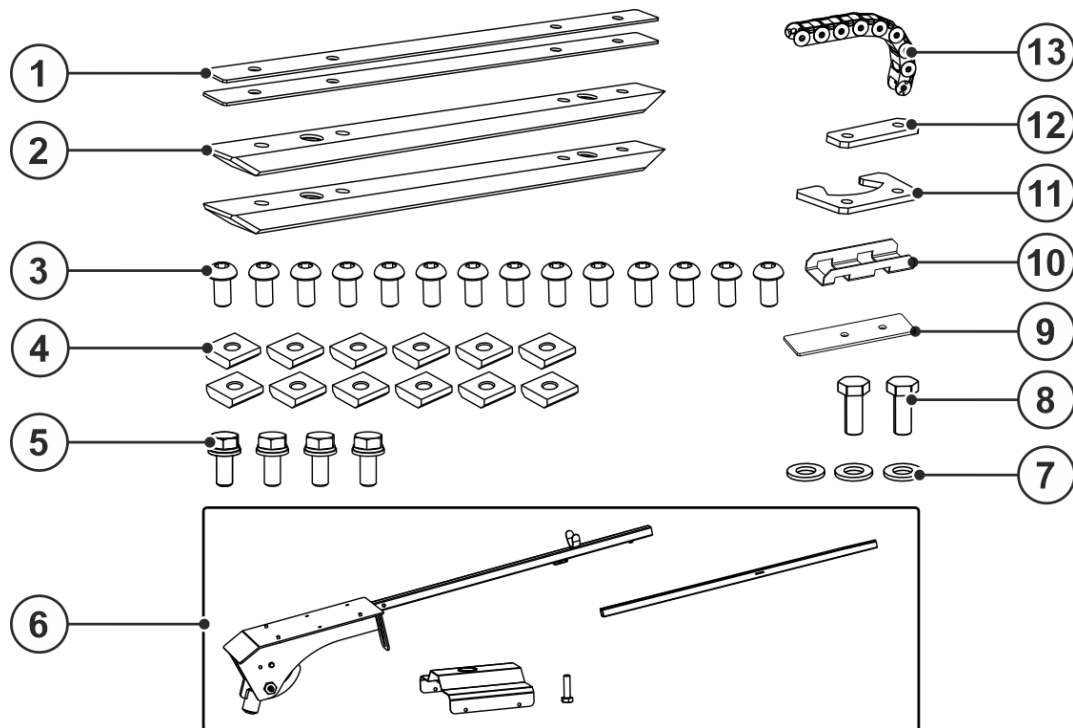






Figure 3-1

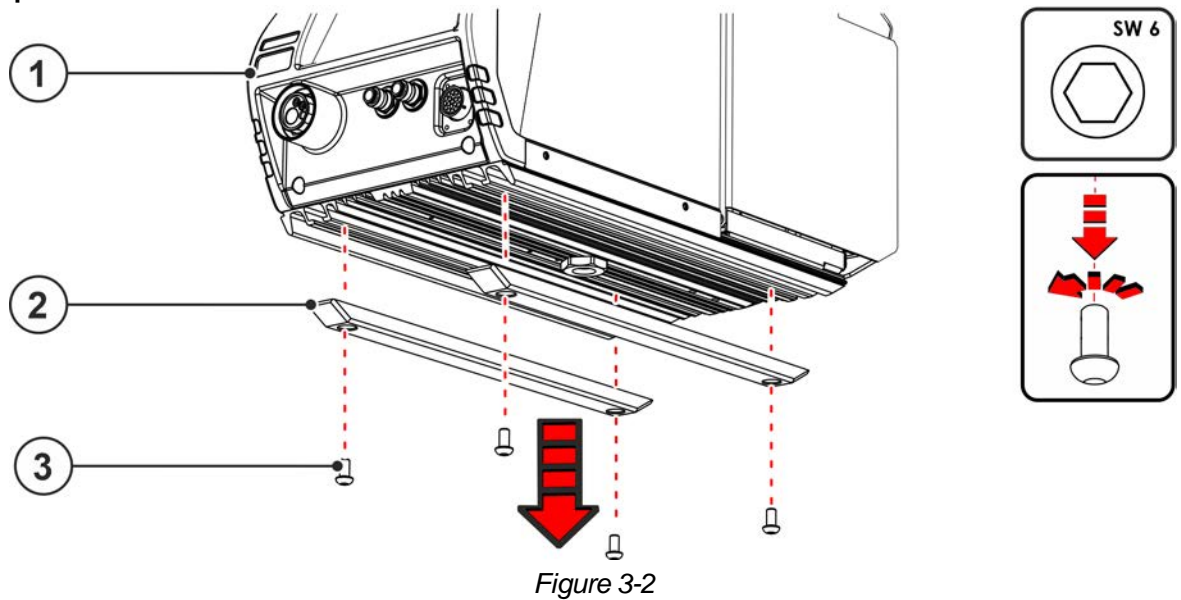
Item	Quantity	Description	Item number
1	2	Insulation plate	094-025087-00001
2	2	Sliding rail	092-003512-00000
3	14	Flat head screw (hexagon socket) - M8 x 16	094-007803-00000
4	12	Sliding block - M8	094-008640-00000
5	4	Hexagonal screw (parts are captive) - M8 x 20	064-000511-00000
6	1	Support arm	092-004271-00000
7	3	Plain washer - M8	064-000586-00000
8	2	Hexagon screw - M8 x 25	064-000657-00000
9	1	Pressure plate	094-028041-00000
10	1	Mounting plate	094-028042-00000
11	1	Lock plate	094-028076-00000
12	1	Spacer plate	094-028077-00000
13	1	Drag chain	094-028032-00000

### 3.3 Tools and auxiliaries

The specified tools are not included.

Symbol	Type	Description
	WAF 6	Tool for hexagonal socket screws with a width across flats of 6 mm
	WAF 13	Tool for hexagonal screws with a width across flats of 13 mm
	WAF 22	Tool for hexagonal screws with a width across flats of 22 mm
	WAF 30	Tool for hexagonal screws with a width across flats of 30 mm

### 3.4 Preparations



Item	Quantity	Description	Item number
1	1	Wire feed unit	
2	2	Sliding rail	
3	4	Oval head screw (hexagonal internal thread) - M8 x 16	094-007803-00000

- Remove the sliding rails from the wire feeder.

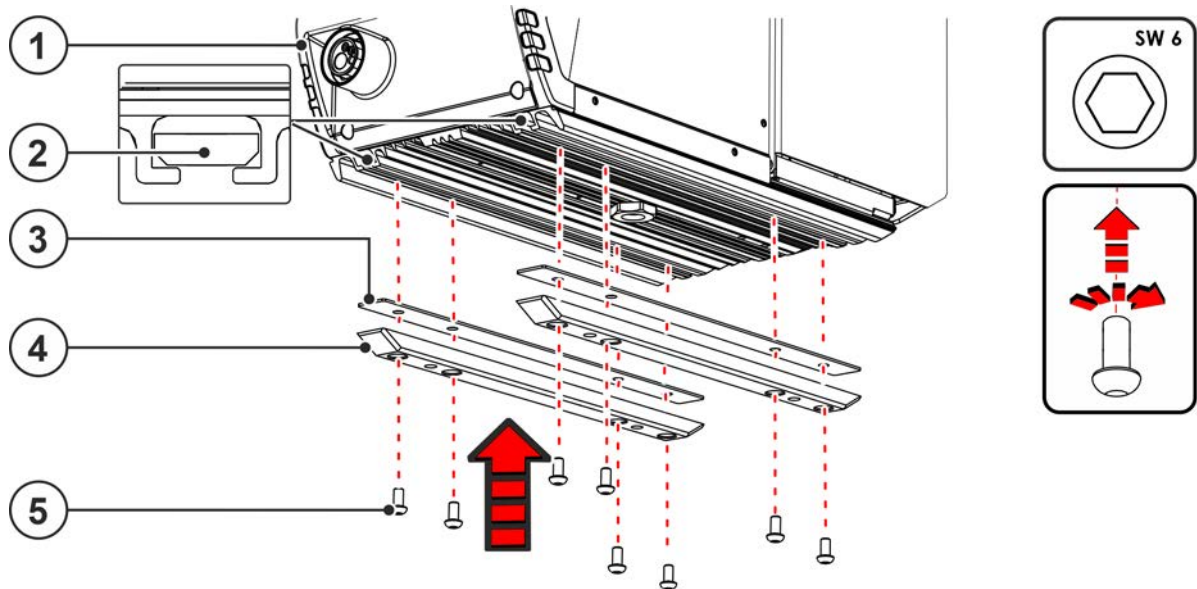


Figure 3-3

Item	Quantity	Description	Item number
1	1	Wire feed unit	
2	8	Sliding block - M8	094-008640-00000
3	2	Insulation plate	094-025087-00001
4	2	Sliding rail	092-003512-00000
5	8	Flat head screw (hexagon socket) - M8 x 16	094-007803-00000

- Mount the slide rails and insulating plates on the wire feeder using the fastening material.

### 3.5 Assembly

#### 3.5.1 Support arm for the torch hose package

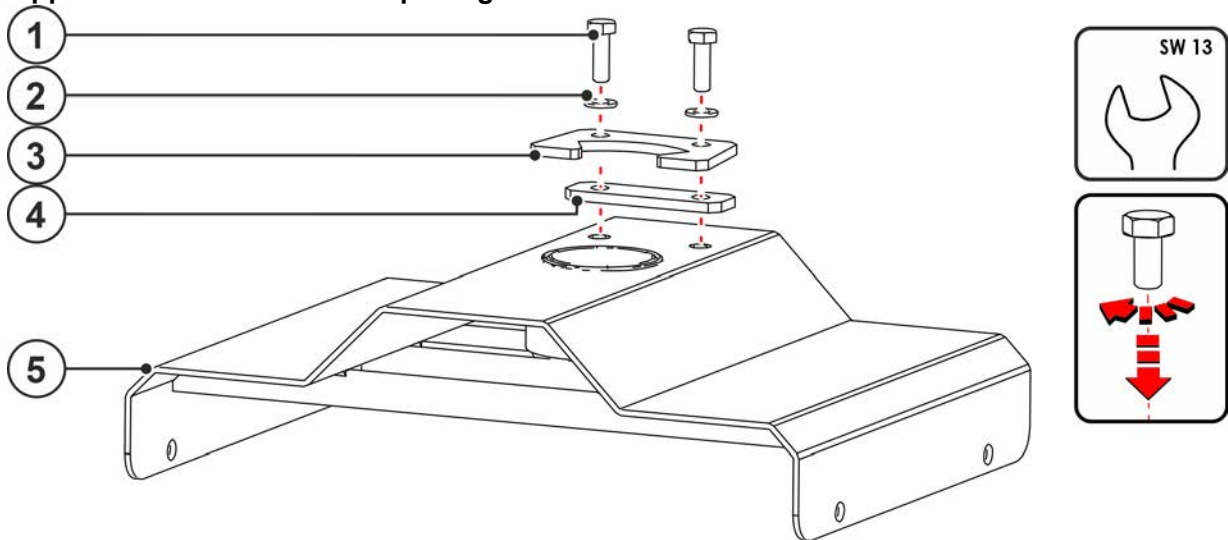


Figure 3-4

Item	Quantity	Description	Item number
1	2	Hexagon screw - M8 x 25	064-000657-00000
2	2	Plain washer M8	064-000586-00000
3	1	Lock plate	094-028076-00000
4	1	Spacer plate	094-028077-00000



Item	Quantity	Description	Item number
5	1	Foot plate	

- Mount the lock plate with the spacer plate and fastening material on the foot plate.

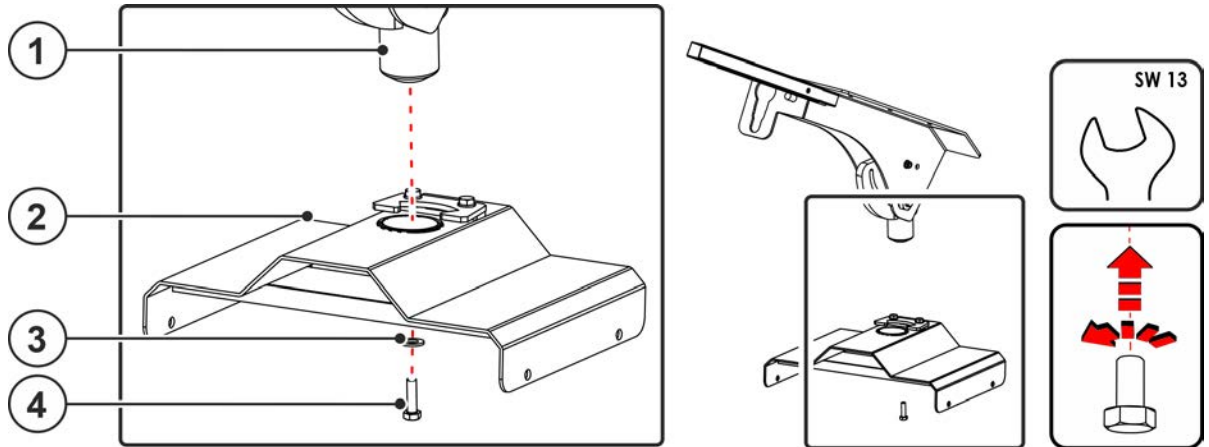


Figure 3-5

Item	Quantity	Description	Item number
1	1	Turning mandrel	
2	1	Foot plate	
3	1	Plain washer - M8	064-000586-00000
4	3	Hexagonal screw - M8 x 30	

- Mount the turning mandrel of the support arm on the foot plate using the fastening material.

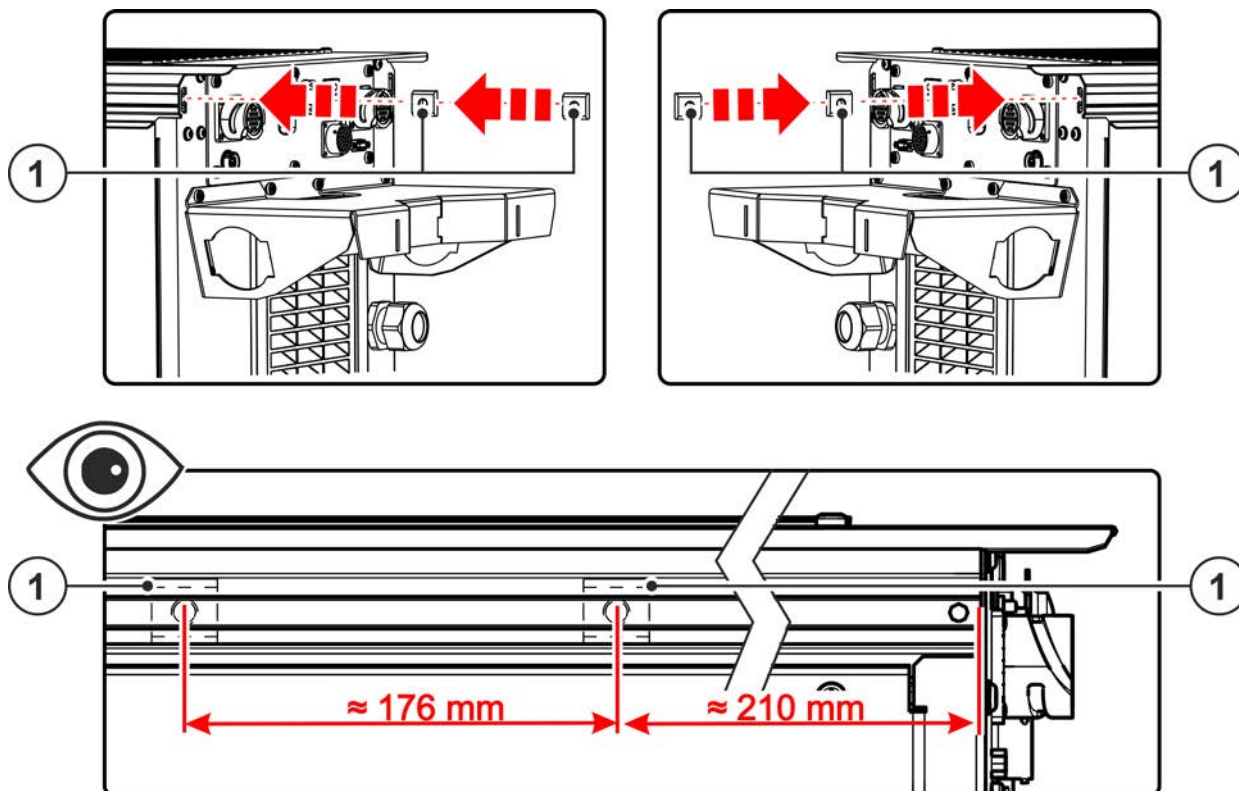


Figure 3-6

Item	Quantity	Description	Item number
1	4	T-nut M8	094-008640-00000

- Insert the sliding blocks into the groove and position them.

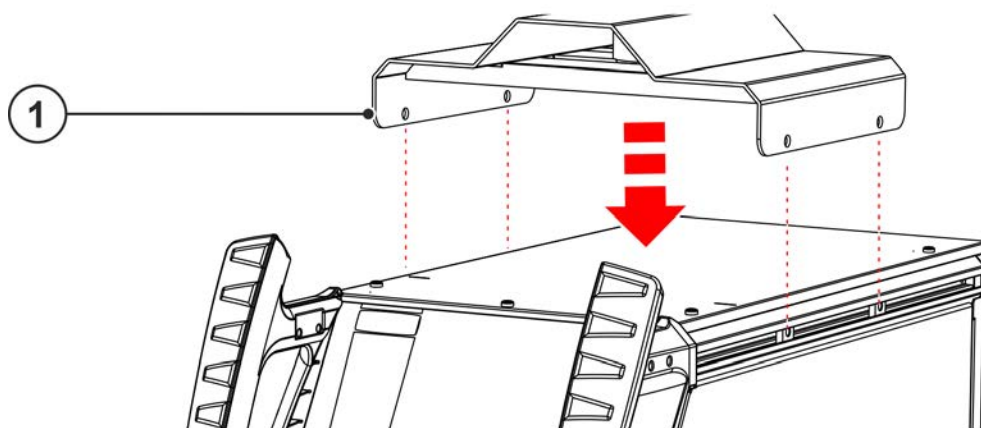


Figure 3-7

Item	Quantity	Description	Item number
1	1	Foot plate	

- Position the foot plate on the power source.

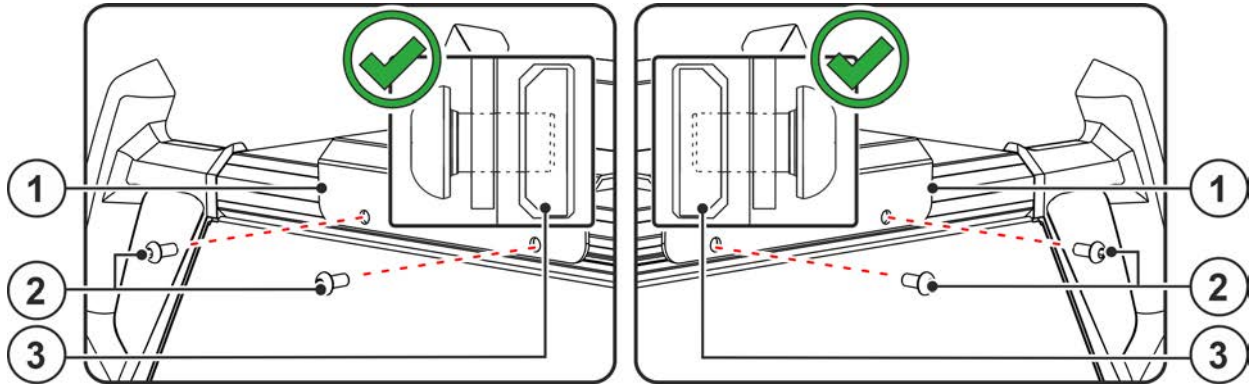


Figure 3-8

Item	Quantity	Description	Item number
1	1	Foot plate	
2	4	Oval head screw (hexagonal internal thread) - M8 x 16	094-007803-00000
3	4	T-nut M8	094-008640-00000

- Mount the foot plate on the power source using the fastening material.

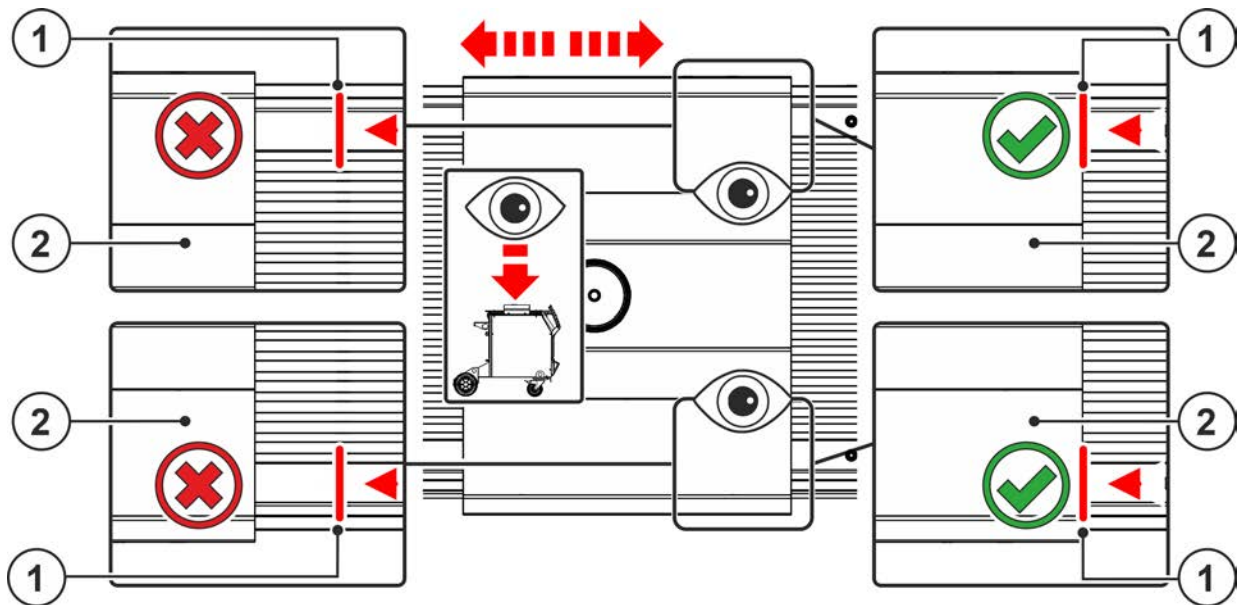


Figure 3-9

Item	Quantity	Description	Item number
1	1	Foot plate	
2	1	Position marker	

- Align the foot plate with the position marker.

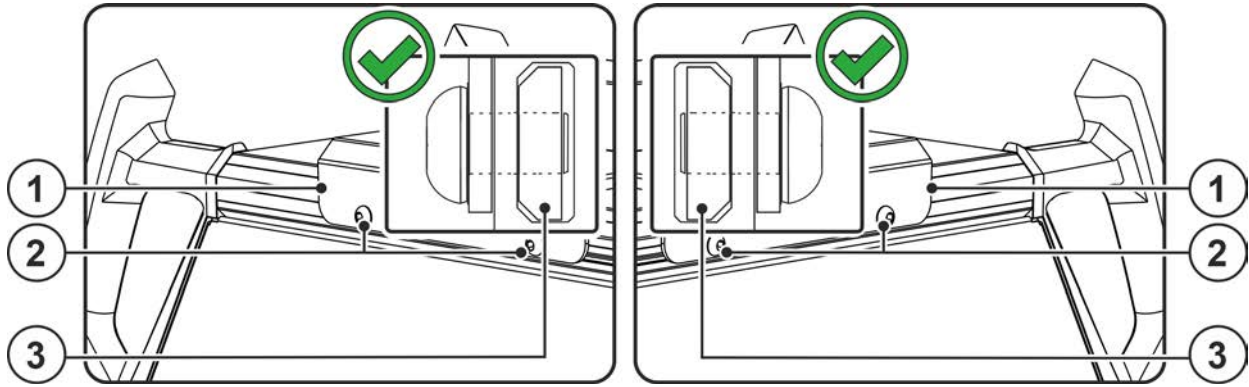


Figure 3-10

Item	Quantity	Description	Item number
1	1	Foot plate	
2	4	Oval head screw (hexagonal internal thread) - M8 x 16	094-007803-00000
3	4	T-nut M8	094-008640-00000

- Tighten the fastening material of the foot plate.

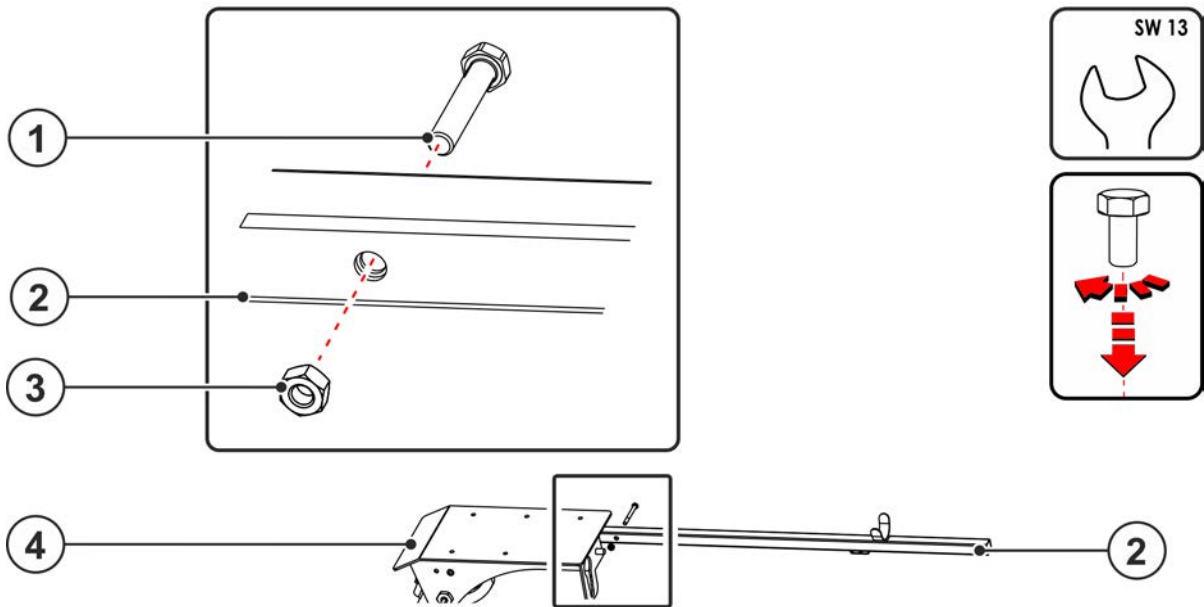


Figure 3-11

Item	Quantity	Description	Item number
1	1	Hexagonal screw	
2	1	Telescope arm	
3	1	Hexagonal nut	
4	1	Support arm	

- Slide the telescopic tube onto the support arm and mount it with the fastening material.

## 3.5.2 Lowering the support arm

### ⚠ CAUTION



**Danger from the falling support arm!**

When releasing the tension spring, the support arm may come loose uncontrolled and injure people as a result.

- Secure the support arm when removing the hexagonal nut.
- Mount the telescope arm after installing the wire feeder.

To avoid any squeaking, maintenance spray should be used.

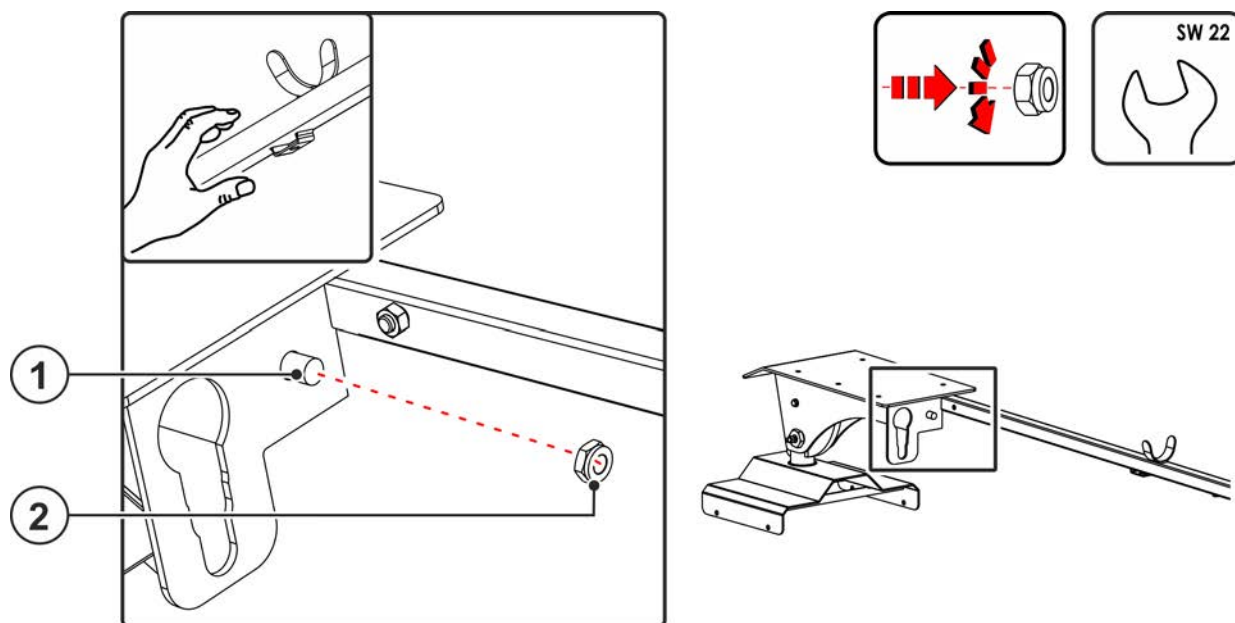


Figure 3-12

Item	Quantity	Description	Item number
1	1	Hexagonal nut	
2	1	Eyelet of the tension spring	

- Secure the support arm.
- Remove the hexagonal nut from the tension spring.
- Lower the support arm into the horizontal position.

### 3.5.3 Wire feed unit

#### ⚠ CAUTION



#### Risk of falling!

If an accessory component is not properly positioned on the support, it may fall down, get damaged and subsequently injure persons.

- Prior to any transport and prior to any commissioning, check secure fit of the accessory components!
- Observe the safety instructions regarding transport, positioning and lifting by crane provided in the operating instructions for the power source or for the wire feeder!
- Do not apply tensile forces to the torch hose package! If it can be foreseen that tensile forces cannot be avoided, the wire feeders must be removed from the support!

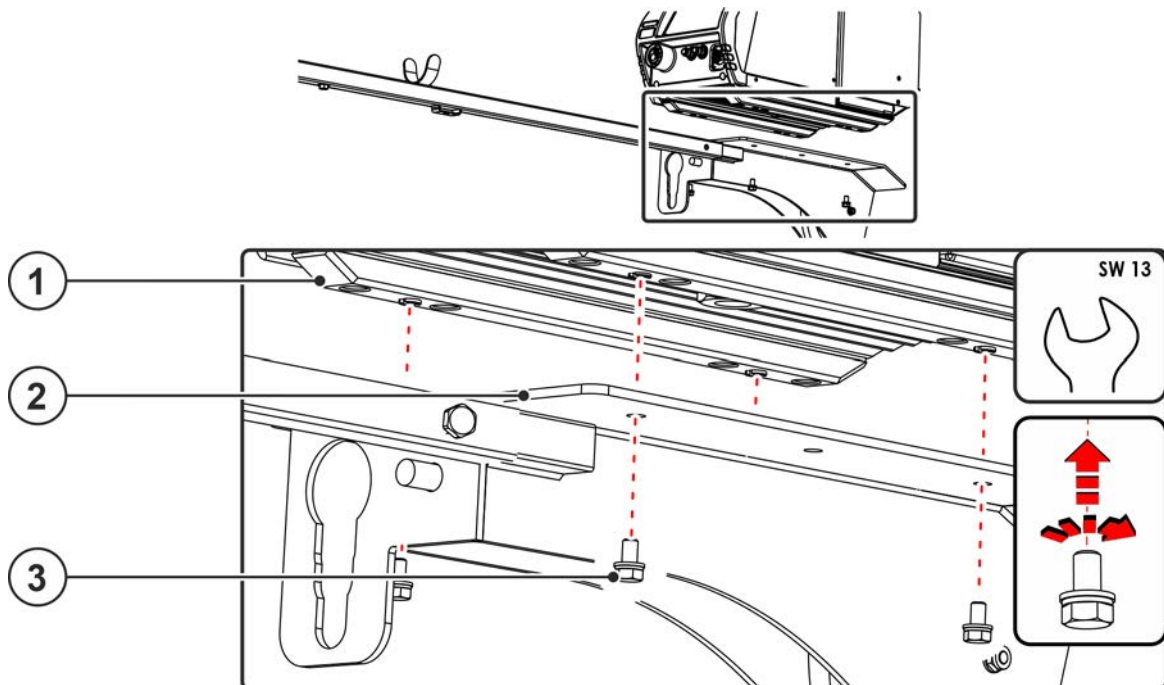


Figure 3-13

Item	Quantity	Description	Item number
1	2	Sliding rail	092-003512-00000
2	1	Carrier plate	
3	4	Hexagonal screw (parts are captive) - M8 x 20	064-000511-00000

- Mount the wire feeder on the carrier plate using the fastening material.



**3.5.4 Telescope arm**

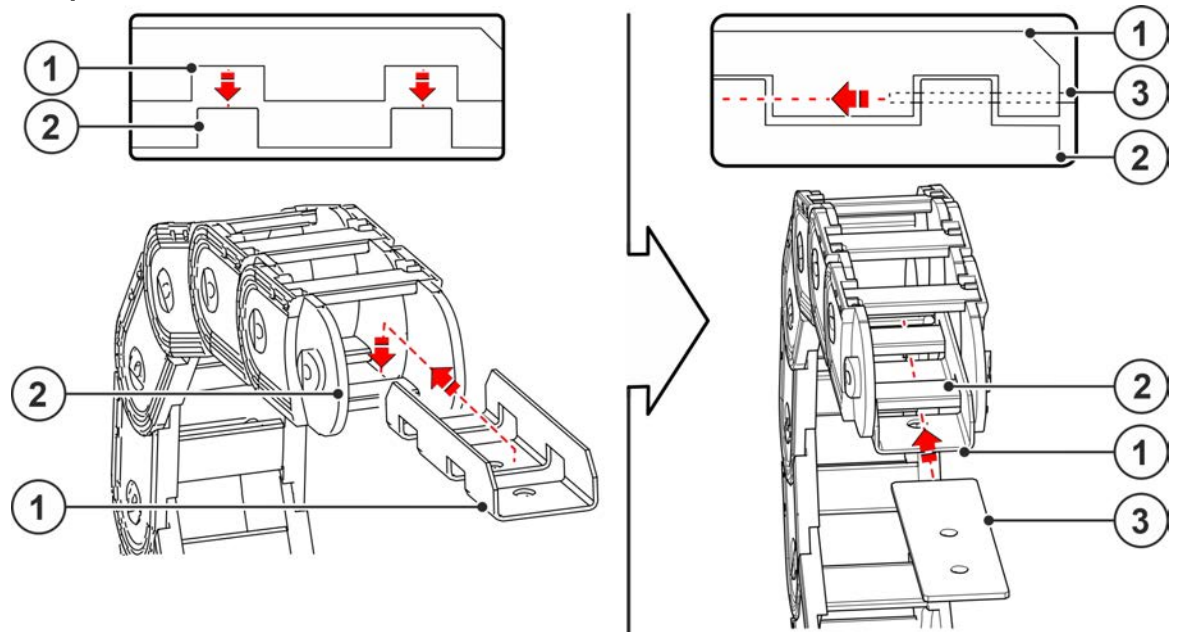


Figure 3-14

Item	Quantity	Description	Item number
1	1	Mounting plate	094-028042-00000
2	1	Drag chain	094-028032-00000
3	1	Pressure plate	094-028041-00000

- Place the mounting plate in the drag chain and secure it with the pressure plate.

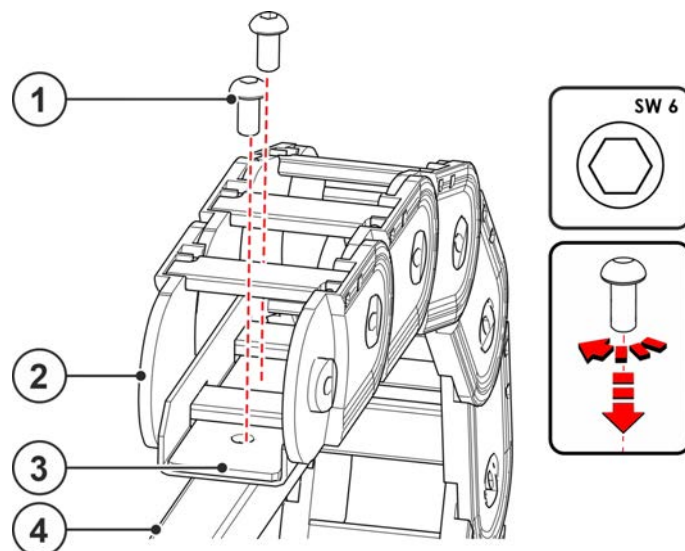


Figure 3-15

Item	Quantity	Description	Item number
1	2	Oval head screw M8 x 16 with hexagonal internal thread	094-007803-00000
2	1	Drag chain	094-028032-00000
3	1	Pressure plate	094-028041-00000
4	1	Telescope arm	

- Mount the drag chain on the telescope arm using the fastening material.

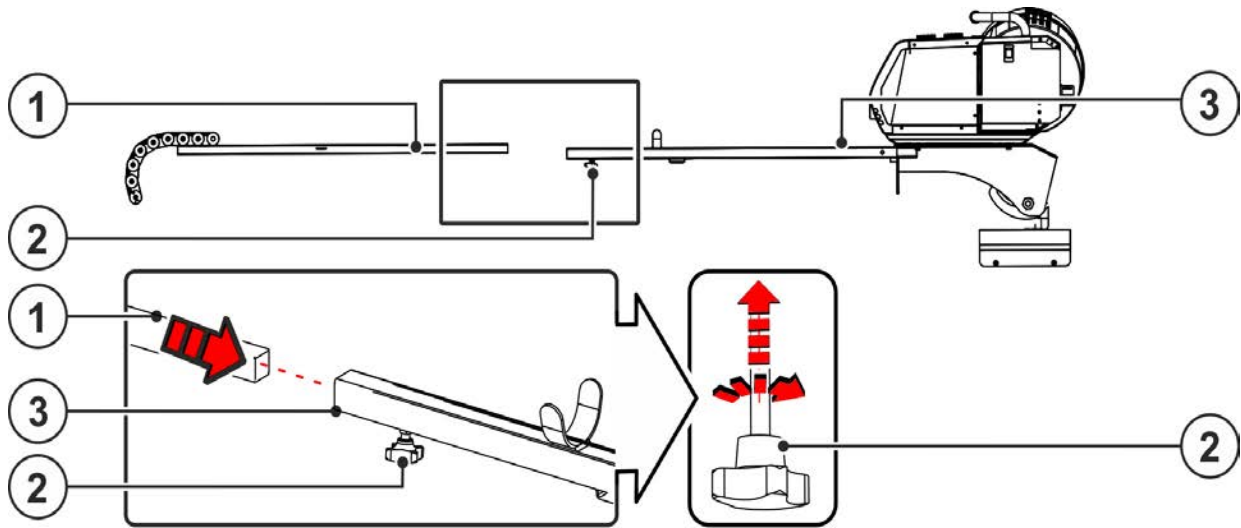


Figure 3-16

Item	Quantity	Description	Item number
1	1	Telescope arm	
2	1	Star handle	
3	1	Support arm	

- Push the telescope arm into the support arm and secure it with the star handle.

**3.5.5 Installing the torch hose package**

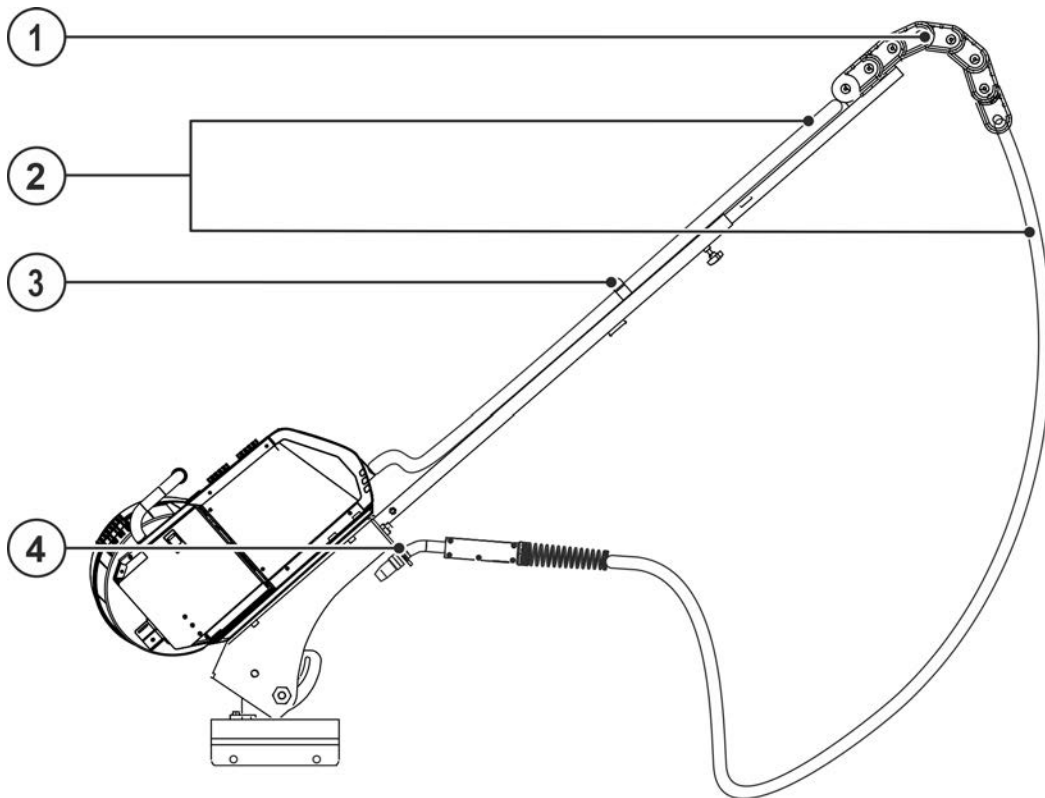


Figure 3-17

Item	Symbol	Description
1		Drag chain
2		Welding torch hose package
3		Hose package holder



Item	Symbol	Description
4		Torch holder

- Open all links of the drag chain.
- Install the torch hose package as shown in the figure.
- Close the links of the drag chain.
- Park welding torch in torch holder.

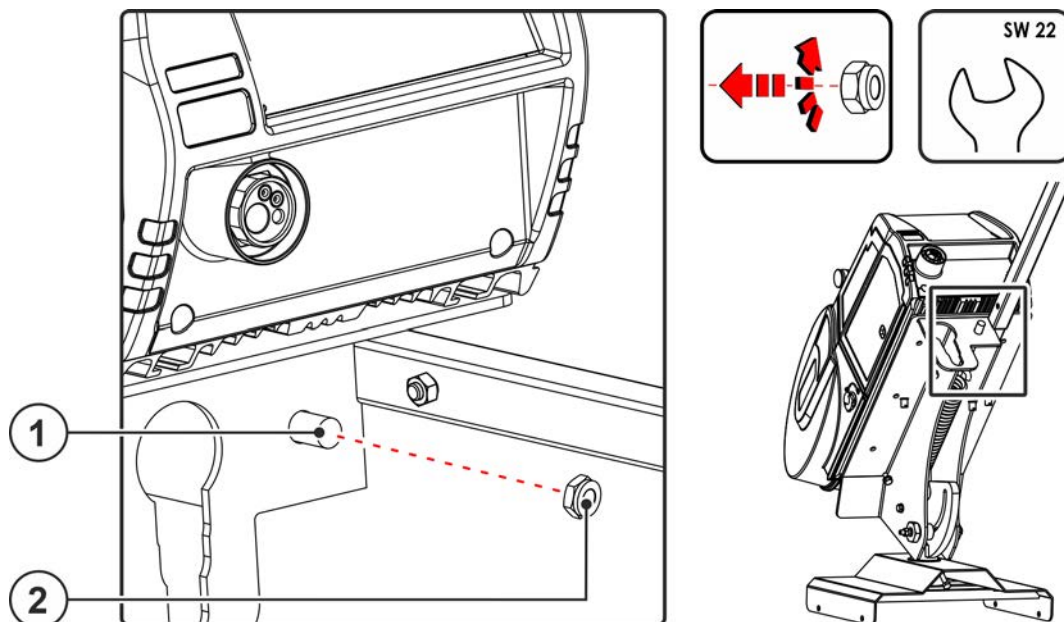


Figure 3-18

Item	Quantity	Description	Item number
1	1	Hexagonal nut	
2	1	Eyelet of the tension spring	

- Lift the support arm to the vertical position and hold it there.
- Guide the eyelet of the tension spring through the bore and secure it with the hexagonal nut.

### 3.6 Final inspection

**⚠ WARNING**

**! Danger due to failure to carry out the final inspection!**  
**Parts that are incorrectly fitted or that become loose are a source of danger.**

- Check all mechanical connections to ensure that they are fitted correctly!
- Carry out the final inspection!
- Carry out the functional test!

**Keep the conversion instructions with the machine documentation!**

**When ordering spare parts, ensure that the item number and serial number of the machine are quoted!**

### 4 Functional characteristics

#### 4.1 Settings

##### 4.1.1 Spring force

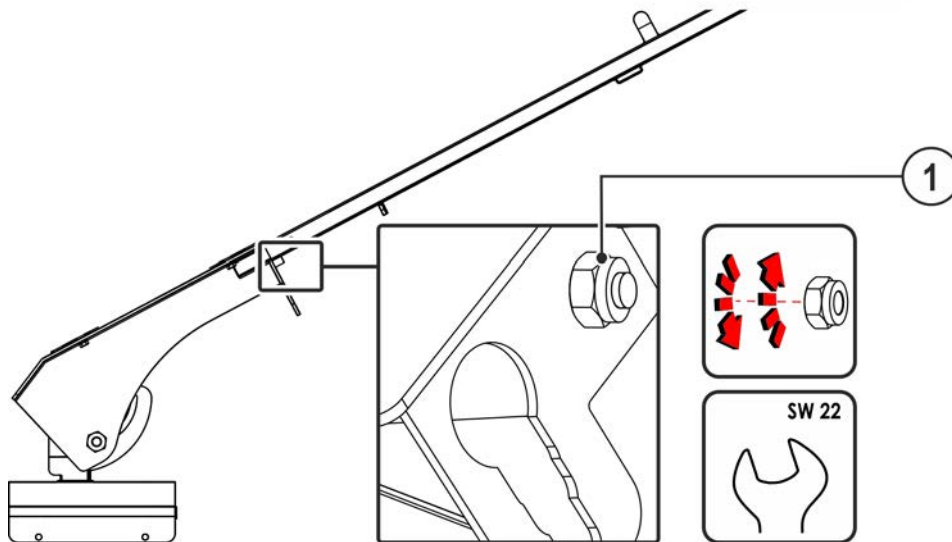


Figure 4-1

Item	Symbol	Description
1		<b>Hexagonal nut (self-locking)</b> For setting the height of the support arm.

- Loosen the hexagonal nut (self-locking) until the desired height is reached.
- Screw the hexagonal nut (self-locking) in until the desired spring force is reached.

## 4.1.2 Braking force

The braking force should be adjusted so that the support arm with the welding torch can be moved by hand and maintains its position.

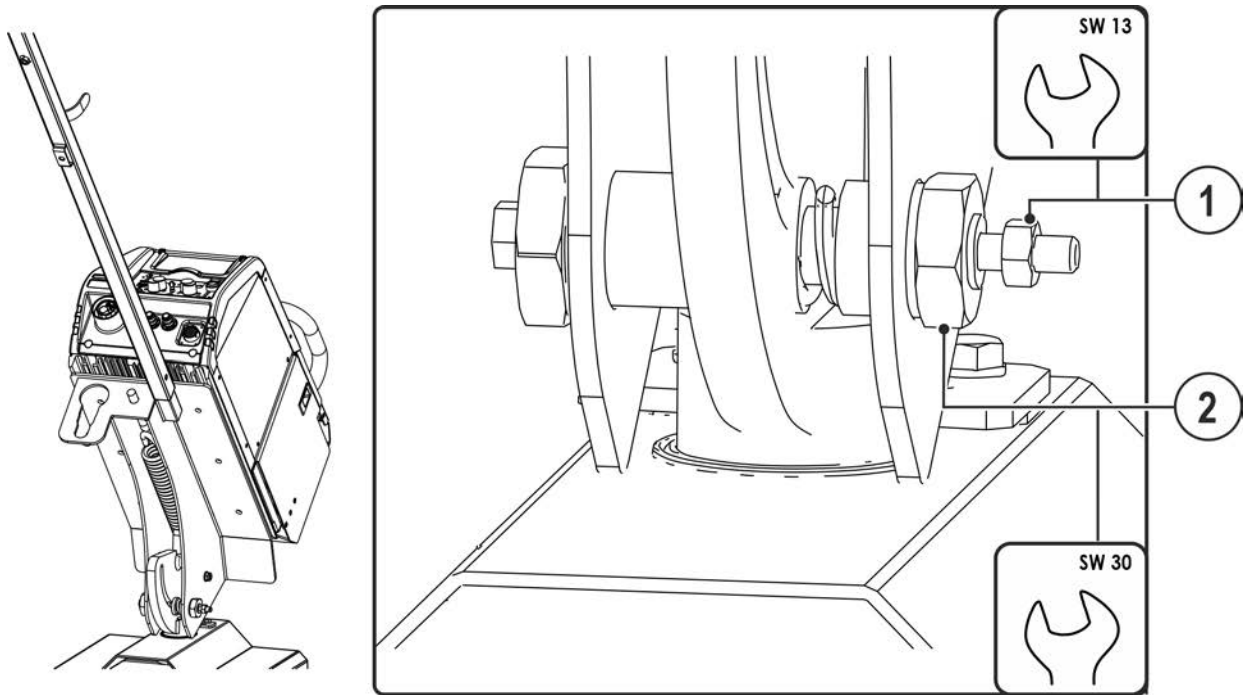


Figure 4-2

Item	Symbol	Description
1		<b>Hexagonal nut (counternut)</b> To prevent the hexagonal nut from loosening (braking force).
2		<b>Hexagonal nut (braking force)</b> For setting the braking force

- Loosen the hexagonal nut (counternut)
- Adjust the hexagonal nut (nut for braking force).
- Tighten the hexagonal nut (counternut).

## 4.1.3 Length

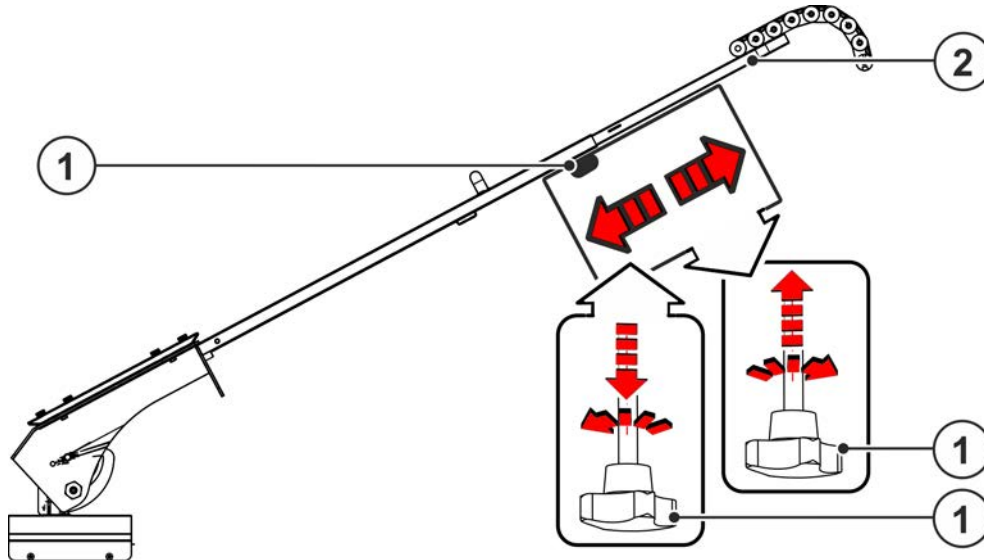


Figure 4-3

Item	Symbol	Description
1		<b>Star handle</b> For securing the telescopic arm.
2		<b>Telescope arm</b> For adjusting the length of the support arm

- Loosen the star handle.
- Set the telescope arm.
- Tighten the star handle.

## 4.2 Lifting by crane

### ⚠ WARNING



**Risk of injury during lifting by crane!**

The support arm has to be taken off the welding machine for lifting. During lifting, persons may be severely injured by falling machines or mount-on components.

- Remove the support arm from the welding machine.
- For notes regarding lifting by crane see the standard operating instructions for the welding machine.

## 5 Technical data

### 5.1 ON HASE XQ

The technical data given here completes or replaces the respective values in the standard operating instructions.

Setting range of the length	1018 - 1768 mm 40.1 - 69.9 inch
Usable angular range	0 - 90 °
Weight	+28 kg +59.5 lb