



WIRE FEEDER

HEFTY® II CC/CV



PROCESS	MIG	FLUX CORED	PULSE MIG		
Part Number	Feed Rolls	Wire Speed Range	Wire Size Range	Dimensions (H x W x D)	Net Weight
100035-001 100035-002 (with Inch / Purge & WFS / Volt Meters) 100035-003	2	50 - 700 (IPM) 1.3 - 17.8 (m/min.)	.024" - 5/64" 0.6 - 2.0 (mm)	14.8" x 9.1" x 23.2" 375 x 230 x 587 (mm)	29 lbs. (13.2 kg)

The Hefty® II CC/CV is a portable, solid state controlled, voltage sensing wire feeder that operates on arc voltage and can be used with most constant voltage (CV) and constant current (CC) DC-type power sources. The unique design of the Hefty® II CC/CV allows operation in a constant wire feed speed mode when used with CV power sources, and in a voltage sensing wire feed speed mode when used with CC power sources.

The Hefty® II CC/CV's rugged steel-reinforced, flame-retardant polyethylene case totally encloses the solid state control circuitry, welding wire, and wire drive system. This portable and lightweight unit is designed with a hinged, latched door allowing quick and easy access to the contactor, welding wire and feedhead assembly. It has an insulated top carrying handle and the control panel is recessed to protect the controls.

Features of the Hefty® II CC/CV include quick change feed rolls allowing the operator to change feed rolls without the use of tools, a hand-operated plastic knob for clamping the welding gun into the feedhead and two gear driven feed rolls which will accommodate wire sizes up to and including 5/64" diameter.

Machine Specifications

Input Voltage Range	15 - 100 VDC
Maximum Input Current	8 Amps
Wire Speed Range	50 - 700 IPM (1.3 - 17.8 m/min.) (Dependent on Arc Voltage)
Wire Size Range	0.024" - 5/64" (0.6 - 2.0 mm)
Maximum Wire Spool Capacity	12" (304.8 mm) 30 lbs. (13.6 kg)
Feed Rolls	2 (Both Gear Driven)
Welding Current (I)	330A at 60% Duty Cycle
Welding Gun Diameter	5/8" (15.9 mm) Nominal
Maximum Shielding Gas Inlet Pressure	75 P.S.I.
Degree of Protection	IP23C
Approvals	IEC 974-5 (CE), CSA NRTL/C, NEMA EW-3

GOT POWER?™

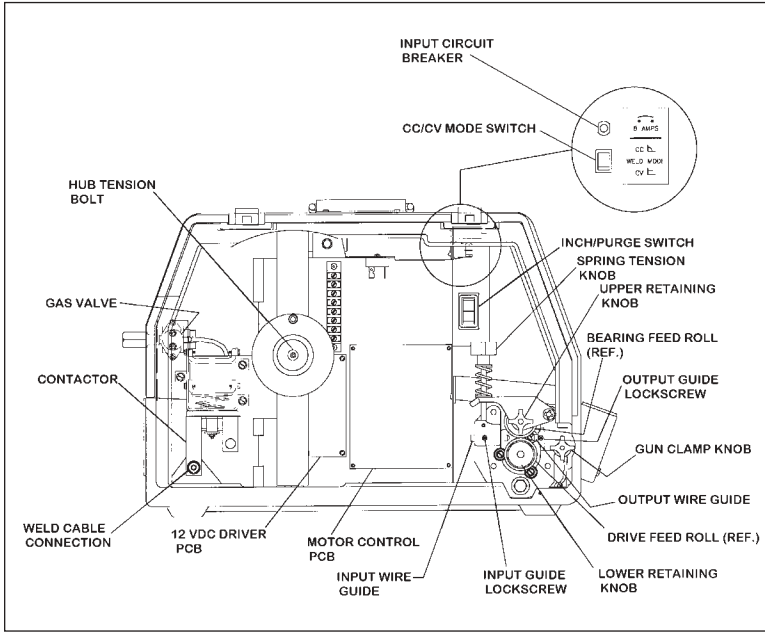
Features	Benefits
Quick Change Feed Rolls	Feed rolls can be changed without the use of tools
Contactor	Allows welding wire to remain electrically "cold" until the gun switch trigger is depressed
Gas Valve	Controls "on/off" flow of shielding gas
Powerful, Permanent Magnet DC Drive Motor	Accommodates fast speed demands of small diameter wire and low speed, high torque demands of large diameter wire
Polarity Insensitive	Weld with straight or reverse polarity
Electronic Controlled Protection Circuitry	Protects against voltage spikes, shorted or locked motor, shorted contactor coil and shorted gas valve coil
Electronic Brake	Solid state control offers precise stopping of the wire
Feed Roll Pressure Release	Allows operator to change feed rolls or wire while retaining preset feed roll pressure
Welding Gun Holder	Extends life of welding gun and contact tips

Compatibility

The Hefty® II CC/CV is designed to operate on arc voltage and will work with most constant current (CC) or constant voltage (CV) DC-type power sources. When connected to a Hefty® II CC/CV, the maximum allowed open circuit voltage of the power source is 100 VDC.

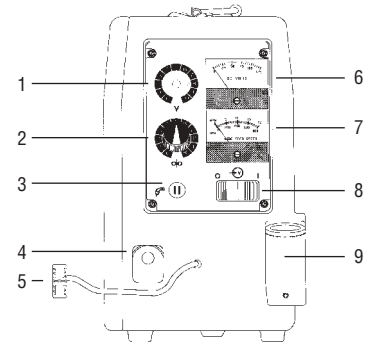
Control Panels

Interior Panel



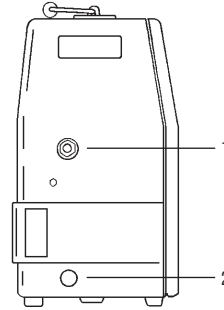
Front Panel

1. Remote Voltage/Current Control (Optional)
2. WFS Control
3. Gun Switch Receptacle
4. Welding Gun Cable Connection
5. Voltage Sensing Lead
6. Arc Voltage Meter
7. WFS Meter
8. Power On/Off Switch
9. Welding Gun Holder



Rear Panel

1. Gas Valve Inlet
2. Input for Welding Cable



Ordering Information

	Part No.
Hefty® II CC/CV, .035 / .045 (CE)	100035-001
Hefty® II CC/CV, .035 / .045 (CE) with inch/purge, wire feed speed meter, arc voltage meter	100035-002
Hefty® II CC/CV, .052 (CE)	100035-003

ACCESSORIES

Adapter Kits

10 lb. Spool	375585
15 lb. Spool	375864-001
14 lb. Coil	375942A

Remote Voltage/Current Control Kits

6 Pin Amphenol, 100' (30.4m)	376620-009
14 Pin Amphenol, 50' (15.2m)	870083
19 Pin Amphenol, 25' (7.6m)	376620-002
19 Pin Amphenol, 100' (30.4m)	376620-005

Feed Roll Kits

171435-XXX

Flowmeter Kit

870062

Control Pot Shaft Friction Lock

402663

Euro-Style Gun Adapter

171449

For Specification Number 100035-001 and 100035-003 only

Inch/Purge Kit

870129

Wire Feed Speed and Arc Voltage Meters

376469A-001

FEED ROLL KITS

		Style 1	Style 2	Style 3	Style 4	Style 5
171435-Series	Top	Flat	Flat Knurled	Double Knurled Vee	Double Cog	Double "U"
	Bottom	Double Smooth Vee	Double Smooth Vee	Double Knurled Vee	Double Cog	Double "U"
Wire Size	Wire Type					
.024"	Hard	171435-001	—	—	—	—
.030", .035"	Hard	171435-002	—	—	—	—
.035"	Hard	171435-003*	—	—	—	—
.045"	Hard & Tubular	171435-004*	171435-010	171435-016	—	—
.035", .045"	Hard	171435-005*	—	—	—	—
.052"	Hard	171435-006*	—	—	—	—
1/16"	Hard & Tubular	171435-007*	—	—	—	—
.030", .035"	Hard	—	171435-009	—	—	—
.052", 1/16", .068"	Hard & Tubular	—	—	171435-011	—	—
5/64"	Tubular	—	—	171435-018	—	—
.045"	Tubular	—	—	—	171435-012	—
.052", 1/16", .068"	Tubular	—	—	—	171435-013	—
.035"	Soft	—	—	—	—	171435-014
3/64"	Soft	—	—	—	—	171435-015
1/16"	Soft	—	—	—	—	171435-017

Notes: 1) One Kit is supplied standard with each wire feeder.

2) Feed Roll Kits include: 2 Feed Rolls, 1 Input Guide, 1 Output Guide.

* Narrow 30° Vee

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