

### Rauchgas-Absaugbrenner Fume-Extraction-Torch



#### Technische Daten: RGA 240 G

Belastung: 250 A C0<sub>2</sub> (nach EN 60 974-7)  
220 A ArC0<sub>2</sub> / M21  
Einschaltdauer: @ 35%  
Draht-ø: 0,8 - 1,2 mm

#### Artikel Nr. / Einzelheiten

|             | 3 m     | 4 m     | 5 m     |
|-------------|---------|---------|---------|
| Standard-ZA | 7030003 | 7030004 | 7030005 |
| Federpin-ZA | 7030203 | 7030204 | 7030205 |

#### Technical Data: RGA 240 G

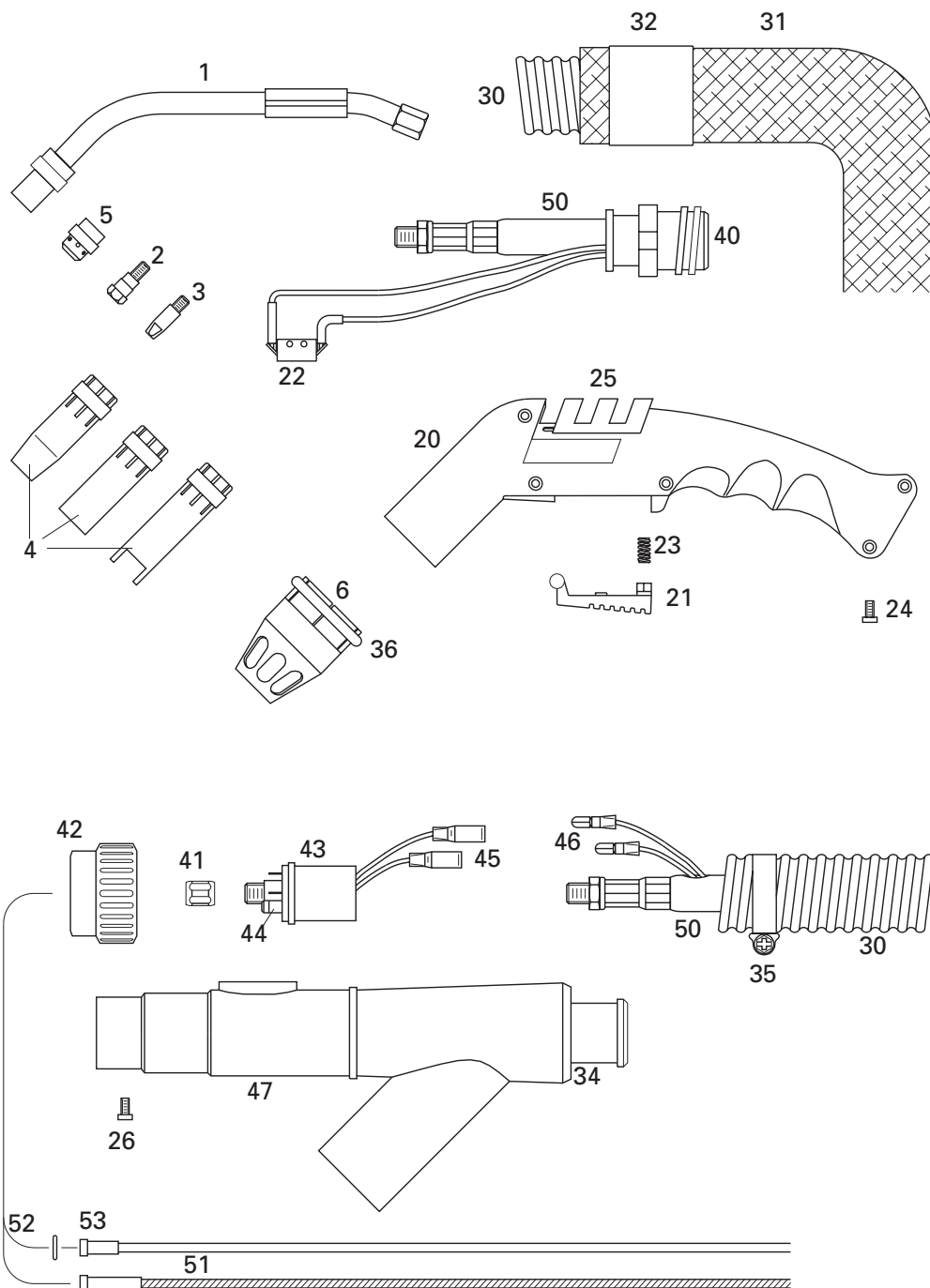
Rating: 250 A C0<sub>2</sub> (accor. to EN 60 974-7)  
220 A ArC0<sub>2</sub> / M21  
Duty Cycle: @ 35%  
Wire Diameter: 0.8 - 1.2 mm

#### Part Number / Details

|                    | 3 m     | 4 m     | 5 m     |
|--------------------|---------|---------|---------|
| Standard Plug      | 7030003 | 7030004 | 7030005 |
| Spring Loaded Pins | 7030203 | 7030204 | 7030205 |

# Rauchgas-Absaugbrenner

## Fume-Extraction-Torch



|                                                                                          |                                     |                                                                                                                                                                                                                                           |                                          |                                              |
|------------------------------------------------------------------------------------------|-------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------|----------------------------------------------|
| 1                                                                                        | Brennerbauteile<br>Torch Components | Brennerhals<br>Swan Neck                                                                                                                                                                                                                  | 7030100                                  |                                              |
| 2                                                                                        |                                     | Düsenstock M 6<br>Tip Adapter M 6                                                                                                                                                                                                         | 2240406                                  | 142.0003                                     |
| 3                                                                                        | Kontaktdüsen<br>Contact Tips        | M 6 x 28, ø in mm / ECu<br>M 6 x 28, ø in mm / CuCrZr<br>M 6 x 28, ø in mm / für / for Alu<br>Stromdüsen erhältlich in ø 0.8/ 0.9/1.0/1.2 mm<br>Bitte bei xx Drahtdurchmesser angeben. Beispiel:<br>ø 1,2 mm ist: 12; Art.-Nr.: = 2250612 | 22506xx<br>22576xx<br>22566xx            |                                              |
| 140.0051, 140.0242, 140.0379, 140.0054, 140.0245, 140.0382, 141.0001, 141.0006, 141.0010 |                                     |                                                                                                                                                                                                                                           |                                          |                                              |
| 4                                                                                        | Gasdüsen<br>Gas Nozzles             | Gasdüse, zylindrisch<br>Gas Nozzle, cylindrical<br>Gasdüse, konisch<br>Gas Nozzle, conical<br>Gasdüse, stark konisch<br>Gas Nozzle, tapered<br>Punktgasdüse<br>Spot Welding Nozzle                                                        | 2240801<br>2240802<br>2240803<br>2240805 | 145.0047<br>145.0080<br>145.0128<br>145.0174 |
| 5                                                                                        |                                     | Gasverteiler, weiß<br>Gas Diffuser, white<br>Gasverteiler, schwarz<br>Gas Diffuser, black                                                                                                                                                 | 2240702<br>2240700                       | 012.0183                                     |
| 6                                                                                        |                                     | Absaugdüse<br>Fume Extraction Nozzle                                                                                                                                                                                                      | 7030800                                  |                                              |
| 20                                                                                       |                                     | Handgriff kpl.<br>Handle cpl.<br>Handgriff, linke & rechte Hälfte<br>Handle left & right Half                                                                                                                                             | 6961000<br>6961001                       |                                              |
| 21                                                                                       |                                     | Drücker<br>Trigger                                                                                                                                                                                                                        | 6961002                                  |                                              |
| 22                                                                                       |                                     | Microschalter<br>Microswitch                                                                                                                                                                                                              | 6161105                                  |                                              |
| 23                                                                                       |                                     | Schalterfeder<br>Trigger Spring                                                                                                                                                                                                           | 6161106                                  |                                              |
| 24                                                                                       |                                     | Schraube<br>Screw                                                                                                                                                                                                                         | 0040801                                  |                                              |

|    |                                                   |         |
|----|---------------------------------------------------|---------|
| 25 | Bypass-Schieber<br>Vent Control                   | 6961003 |
| 26 | Schraube<br>Screw                                 | 0040601 |
| 30 | Wellschlauch 3 m<br>Flexible Cover Hose 3 m       | 2924530 |
|    | Wellschlauch 4 m<br>Flexible Cover Hose 4 m       | 2924540 |
|    | Wellschlauch 5 m<br>Flexible Cover Hose 5 m       | 2924550 |
| 31 | Lederschlauch 1,5 m<br>Leather Hose 1.5 m         | 2921115 |
| 32 | Schrumpfschlauch<br>Heat Shrink Hose              | 2921206 |
| 34 | Verbindungsstück, hinten<br>Rear Swivel Connector | 2921700 |
| 35 | Schlauchklemme<br>Hose Clamp                      | 2911900 |
| 36 | Spannring<br>Ring for Fume Nozzle                 | 2920801 |
| 40 | Verbindungsstück vorne<br>Front Swivel Connector  | 6961200 |
| 41 | Ms-Überwurfmutter<br>Liner Positioner Nut         | 2151501 |

|    |                                 |                                                                     |         |
|----|---------------------------------|---------------------------------------------------------------------|---------|
| 42 | Schlauchpaket<br>Cable Assembly | Anschlußmutter<br>Plug Nut                                          | 2151700 |
| 43 |                                 | ZA-Stecker, Luft<br>Gun Plug Body, air cooled (Euro)                | 2151500 |
|    |                                 | ZA-Stecker, mit Federpins<br>Gun Plug Body with Spring Loaded Pins  | 2151505 |
| 44 |                                 | O - Ring<br>O - Ring                                                | 0041000 |
| 45 |                                 | Rundsteckbuchse, isoliert<br>Female Electrical Connector, insulated | 2155100 |
| 46 |                                 | Rundstecker, isoliert<br>Male Electrical Connector, insulated       | 2155200 |
| 47 |                                 | Verteiler RGA<br>Rear Extraction Chamber                            | 2921600 |

|    |                               |                          |         |
|----|-------------------------------|--------------------------|---------|
| 50 | Koaxialkabel<br>Coaxial Cable | 35 mm <sup>2</sup> , 3 m | 3003530 |
|    |                               | 35 mm <sup>2</sup> , 4 m | 3003540 |
|    |                               | 35 mm <sup>2</sup> , 5 m | 3003550 |

|    |                                                                           |         |          |
|----|---------------------------------------------------------------------------|---------|----------|
| 51 | DF-Spiralen ummantelt und Teflonseelen<br>Coated Steel- and Teflon-Liners |         |          |
|    | DF-Spirale 1,5 x 4,0 mm / 3 m<br>Steel Liner 1.5 x 4.0 mm / 3 m           | 3441530 | 124.0011 |
|    | DF-Spirale 1,5 x 4,0 mm / 4 m<br>Steel Liner 1.5 x 4.0 mm / 4 m           | 3441540 | 124.0012 |
|    | DF-Spirale 1,5 x 4,0 mm / 5 m<br>Steel Liner 1.5 x 4.0 mm / 5 m           | 3441550 | 124.0015 |
|    | Teflonseele 1,5 x 4,0 mm / 3 m<br>Teflon Liner 1.5 x 4.0 mm / 3 m         | 3411530 | 126.0005 |
|    | Teflonseele 1,5 x 4,0 mm / 4 m<br>Teflon Liner 1.5 x 4.0 mm / 4 m         | 3411540 | 126.0008 |
|    | Teflonseele 1,5 x 4,0 mm / 5 m<br>Teflon Liner 1.5 x 4.0 mm / 5 m         | 3411550 | 126.0011 |
|    | DF-Spirale 2,0 x 4,0 mm / 3 m<br>Steel Liner 2.0 x 4.0 mm / 3 m           | 3442030 |          |
|    | DF-Spirale 2,0 x 4,0 mm / 4 m<br>Steel Liner 2.0 x 4.0 mm / 4 m           | 3442040 |          |
|    | DF-Spirale 2,0 x 4,0 mm / 5 m<br>Steel Liner 2.0 x 4.0 mm / 5 m           | 3442050 |          |

|    |                                                 |         |          |
|----|-------------------------------------------------|---------|----------|
| 51 | Teflonseele 2,0 x 4,0 mm / 3 m                  | 3412030 | 126.0021 |
|    | <a href="#">Teflon Liner 2.0 x 4.0 mm / 3 m</a> |         |          |
|    | Teflonseele 2,0 x 4,0 mm / 4 m                  | 3412040 | 126.0026 |
|    | <a href="#">Teflon Liner 2.0 x 4.0 mm / 4 m</a> |         |          |
|    | Teflonseele 2,0 x 4,0 mm / 5 m                  | 3412050 | 126.0028 |
|    | <a href="#">Teflon Liner 2.0 x 4.0 mm / 5 m</a> |         |          |
| 52 | O - Ring                                        | 0031500 |          |
|    | <a href="#">O - Ring</a>                        |         |          |
| 53 | Haltenippel für ummantelte Spirale 4,0          | 2155645 |          |
|    | <a href="#">Collet for coated Liner 4.0</a>     |         |          |
|    | Haltenippel für Teflonseele 4,0                 | 2155740 |          |
|    | <a href="#">Collet for Teflon Liner 4.0</a>     |         |          |

## Fehlerbehebung

- |                                |                                                                                                                                                                                             |
|--------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1.) Schlechter Drahtvorschub:  | Spirale verstopft oder geknickt. Falsche Größe von Spirale oder Stromdüse.<br>Spirale zu kurz und liegt nicht korrekt am Düsenstock an.                                                     |
| 2.) Brennerüberhitzung:        | Lose Verbindung am Zentralanschluß. Brenner wird mit zu hoher Amperezahl geschweißt. Zu gering bemessenes Massekabel.                                                                       |
| 3.) Poröse Schweißnaht:        | Spritzer in der Gasdüse behindern den Gasdurchfluß. Lose Verbindung von Gasschlauch oder Leck im Gasschlauch. O-Ringe am Zentralanschluß sind lose oder beschädigt.                         |
| 4.) Kurze Stromdüsenstandzeit: | Drahtvorschubrollen sind zu eng angezogen und verursachen Riefen am Schweißdraht. Der Schweißdraht ist schmutzig oder rostig. Falsche Stromdüsendurchmesser. Brenner wird zu hoch belastet. |

## Trouble Shooting

- |                      |                                                                                                                                                                                   |
|----------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1.) Poor Wire Feed:  | <a href="#">Liner clogged or kinked. Incorrect liner size or contact tip. Liner cut too short and not seating properly in tip adapter.</a>                                        |
| 2.) Gun Overheating: | <a href="#">Loose connection at the wire feeder. Gun being run beyond its amperage. Insufficient gauge power cable or ground cable.</a>                                           |
| 3.) Weld Porosity:   | <a href="#">Spatter built up in nozzle blocking gas. Leaks in gas hose or improper connection. Conductor tube loose from adapter block or O-Rings at plug are cut or damaged.</a> |
| 4.) Short Tip Life:  | <a href="#">Drive rolls too tight resulting in scoring of weld wire. Welding wire dirty, rusty or too much cast. Wrong tip size. Torch over rated duty cycle.</a>                 |



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**Schneiden - Spannen - Schweißen in Perfektion**