

# INSTRUCTIONS AND PARTS MANUAL

## K-BUG 1200

**K-BUG 1200**  
**K-BUG 1202**  
**K-BUG 1204**

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

Model Number \_\_\_\_\_

Serial Number \_\_\_\_\_

Date of Purchase \_\_\_\_\_

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

LIT-KBUG-1200-IPM-0824

Bug-O Systems is committed to empowering our customers by providing operator controlled mechanized solutions for their welding, cutting and custom applications.

**B U G - O   S Y S T E M S**

A DIVISION OF WELD TOOLING CORPORATION



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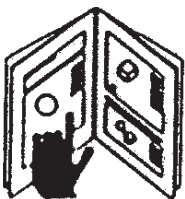
# SAFETY

**PROTECT YOURSELF AND OTHERS FROM SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.**



## **ELECTRIC SHOCK can kill.**

- 1) The equipment is not waterproof. Using the unit in a wet environment may result in serious injury. Do not touch equipment when wet or standing in a wet location.
- 2) The unused connectors have power on them. Always keep the unused connectors covered with the supplied protective panels. Operation of the machine without the protective panels may result in injury.
- 3) Never open the equipment without first unplugging the power cord or serious injury may result.
- 4) Verify the customer-supplied power connections are made in accordance with all applicable local and national electrical safety codes. If none exist, use International Electric Code (IEC) 950.
- 5) Never remove or bypass the equipment power cord ground. Verify the equipment is grounded in accordance with all applicable local and national electrical safety codes. If none exist, use International Electric Code (IEC) 950.



## **READ INSTRUCTIONS.**

Read the instruction manual before installing and using the equipment.



## **EQUIPMENT DAMAGE POSSIBLE.**

- 1) Do not plug in the power cord without first verifying the equipment is OFF and the cord input voltage is the same as required by the machine or serious damage may result.
- 2) Always verify both the pinion and wheels are fully engaged before applying power or equipment damage may occur.
- 3) Do not leave the equipment unattended.
- 4) Remove from the work site and store in a safe location when not in use.



## **FALLING EQUIPMENT can cause serious personal injury and equipment damage.**

Faulty or careless user installation is possible. As a result, never stand or walk underneath equipment.



## **MOVING PARTS can cause serious injury.**

- 1) Never try to stop the pinion from moving except by removing power or by using the STOP control.
- 2) Do not remove any protective panels, covers or guards and operate equipment.

## HIGH FREQUENCY WARNINGS

**SPECIAL PRECAUTIONS ARE REQUIRED WHEN USING PLASMA, TIG OR ANY WELDING PROCESS THAT USES HIGH FREQUENCY TO STRIKE AN ARC.**



**WARNING:** HIGH FREQUENCY CAN EFFECT MACHINE OPERATION AND THEREFORE, WELD QUALITY.

**Read the precautions below before installing and using the equipment.**

### **PRECAUTIONS:**

- 1) Some plasma or welding cables are strong sources of high frequency interference. NEVER lay a plasma or welding cable across the controls of the machine.
- 2) Always physically separate the plasma or welding cable leads from the machine cables. For example, the plasma or welding cable leads should NEVER be bundled with a pendant cable or the machine power cord. Maximize the separation between any machine cables and the plasma or welding cables.
- 3) Strictly follow the grounding procedures specified for the plasma or welding unit.  
NOTE: Some plasma and welding units produce exceptionally large amounts of high frequency noise. They may require a grounding rod be driven into the earth within six feet (2 meters) of the plasma or welding unit to become compatible with an automatic cutting or welding process.
- 4) If the high frequency is produced using a spark gap, adjust the points so the gap is as small as possible. The larger the gap, the higher the voltage and the higher the interference.
- 5) Some plasma or welding units will inject high frequency interference into the AC power line. Use separate power line branches whenever possible to power the plasma or welding source and the machine. Do not plug them into the same outlet box.
- 6) High frequency noise may enter the machine through the plasma or welding supply remote contactor leads. Some plasma and welding sources can produce noise spikes of up to several thousand volts. These sources are not compatible with automated cutting and welding equipment. It is recommended that the remote contactor leads on these plasma or welding sources not be connected to the machine. An alternate solution is to purchase a separate remote contactor isolation box.

# K-BUG 1200

## K-BUG 1200, K-BUG 1202, KBUG-1204

### INSTRUCTIONS AND PARTS MANUAL

#### TABLE OF CONTENTS

#### PAGE

|         |  |
|---------|--|
| 5.....  | Introduction   |
| 5.....  | Features   |
| 5.....  | Technical Data   |
| 5.....  | Dimensions   |
| 6.....  | Illustration of Typical Applications                           |
| 6.....  | User Interface   |
| 7.....  | Welding Modes  |
| 7.....  | Intermittent Welding   |
| 7.....  | Continuous Welding (Intermittent Welding Lock-Out)             |
| 8.....  | Time Settings  |
| 8.....  | Stop Sensor Operation  |
| 9.....  | Global Parameters  |
| 9.....  | Converting Units   |
| 10..... | Installation and Operation                                     |
| 10..... | Cable Interconnect Diagram                                     |
| 11..... | Maintenance  |
| 11..... | Troubleshooting  |
| 12..... | Troubleshooting, Cont'd.                                       |
| 13..... | K-BUG 1200 Assembly View                                       |
| 14..... | K-BUG 1200 Wiring Diagram                                      |
| 15..... | KBUG-1210 Carriage Assembly / Exploded View                    |
| 16..... | KBUG-1210 Carriage Assembly / Parts List                       |
| 17..... | KBUG-1060 Guide Arms / Exploded View / Parts List              |
| 17..... | KBUG-1230 Angle Slide Assembly / Exploded View / Parts List    |
| 18..... | KBUG-1100 Torch Clamp Assembly / Exploded View / Parts List    |
| 18..... | KBUG-1120 Control Panel Assembly / Exploded View / Parts List  |
| 19..... | SBG-450-_-_- Gun & Cable Assembly / Exploded View / Parts List |
| 20..... | Accessories  |
| 21..... | Warranty   |
| 22..... | Addendum   |

## INTRODUCTION

The K-BUG 1200 is a compact, light weight unit designed to mechanize horizontal fillet welding. The machine is capable of performing continuous and intermittent (stitch) welds.

## FEATURES

- Compact - 12.4 x 7.8 x 11.1 in (31.4 x 19.8 x 28.1 cm)
- Lightweight - 13 lb (5.9 kg)
- Continuous and intermittent welds
- Digital speed display
- Precision speed control for consistent weld quality
- User adjustable time settings for puddle build-up, pause time and crater-fill
- Will climb up to a 75° incline
- Drive wheels rated to 400 °F (204 °C)

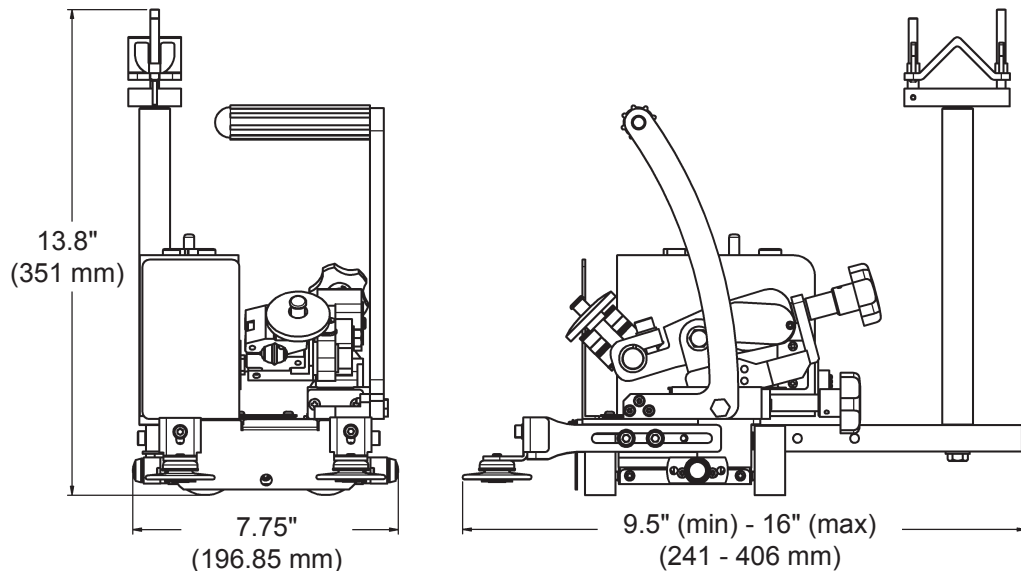
## TECHNICAL DATA

|                       |            |                                    |
|-----------------------|------------|------------------------------------|
| <b>Power Input:</b>   | K-BUG 1200 | 120VAC / 50-60 Hz / 1 Phase        |
|                       | K-BUG 1202 | 240VAC / 50-60 Hz / 1 Phase        |
|                       | K-BUG 1204 | 42VAC / 50-60 Hz / 1 Phase         |
| <b>Weight:</b>        |            | 13 lb (5.9 kg)                     |
| <b>Drive Motor:</b>   |            | 24 VDC, 12 W, 5000 RPM             |
| <b>Travel Speed:</b>  |            | 1.5 - 37 in/min (3 - 95 cm/min)    |
| <b>Torch Holder:</b>  |            | Fits barrels up to 0.75 in (19 mm) |
| <b>Torch Angle:</b>   |            | Adjustable                         |
| <b>Running Angle:</b> |            | 90°                                |

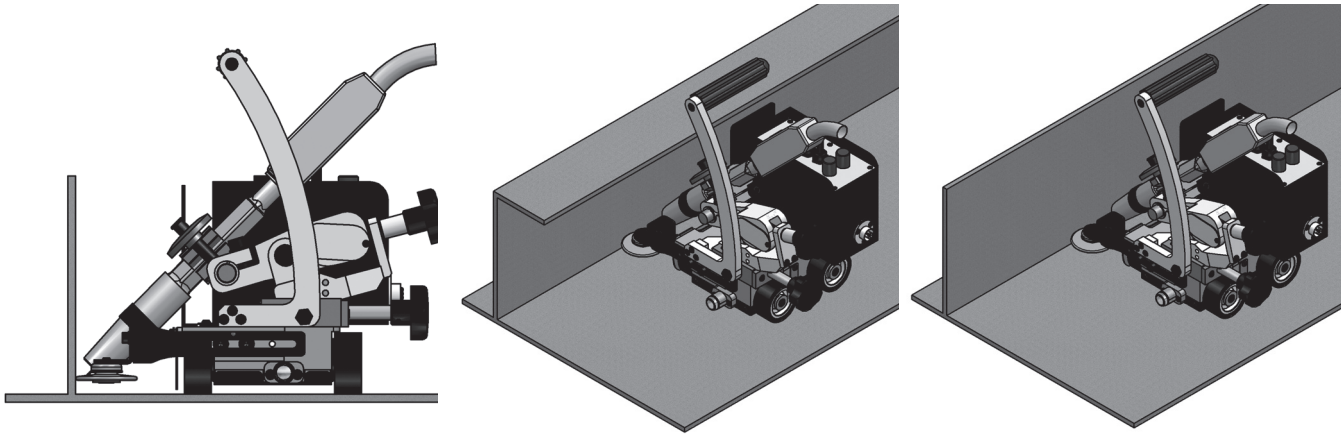


Bug-O Systems has a complete overview video of our K-BUG 1200. To watch this video, scan the qr code or visit: <https://goo.gl/UZvgUp>

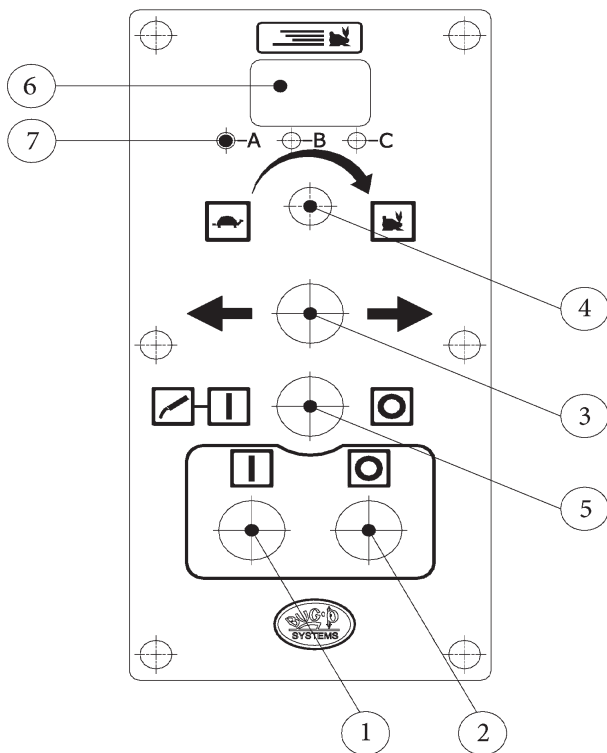
## DIMENSIONS



## ILLUSTRATION OF TYPICAL APPLICATIONS



## USER INTERFACE



1. **Cycle Start Button** - Push button to initiate weld cycle. Weld contact will close, according to time settings, if the Weld Switch is set to Auto, the carriage will travel in the direction selected by the Travel Direction Switch.
2. **Cycle Stop Button** - Push button to stop welding cycle.
3. **Travel Direction Switch** - Set switch to determine direction of carriage travel.
4. **Speed Adjustment Dial** - Rotate knob to adjust carriage travel speed. Turning clockwise (right) will INCREASE speed.  
**NOTE:** Travel Speed Adjustment Knob is also used for setting the INTERMITTENT WELDING function (pg.7) and the time settings.
5. **Weld Auto / Off Contactor** - When switched to AUTO, weld contact will close with cycle start. Switched to the right, weld contact will remain open upon cycle start.
6. **Digital Speed Display** - Numerically displays real-time travel speed in in/min. (cm/min). Also displays parameters during setup of intermittent function and time settings
7. **Indicator LED's** - Indicate active parameter during intermittent welding.
  - A. Weld Length
  - B. Non-Weld Length
  - C. Total Length

## WELDING MODES

The K-BUG 1200 offers three weld modes - Continuous, Total Length Intermittent and User Defined Intermittent. The value shown in the speed display will vary based on what welding mode the machine is operating in. Speed is displayed *only* during Continuous welding.

1. Continuous Welding
  - No LED's lit when Cycle Start button is pressed
  - Displays speed while welding (0.1 in/min)
2. User Defined Intermittent Welding
  - A or B LED lit when Cycle Start button is pressed
  - User sets Welding Speed before pressing Cycle Start button
  - Display will countdown each program parameter in order
    - With A LED lit, the display will countdown Puddle Build-up timer, u, then Weld On distance, A, then Crater Fill timer, n.
    - With B LED lit, the display will countdown Weld Off distance, B
  - **NOTE:** Machine travels at higher speed during Non-Welding travel
  - The intermittent cycle will repeat until the user presses Cycle Stop button or the Stop Sensor is tripped
3. Total Length Intermittent Welding
  - C LED lit when Cycle Start button is pressed
  - User sets Welding Speed before pressing Cycle Start button
  - Display will countdown total distance remaining (1.0)
  - A or B LED will light as appropriate for welding mode
  - **NOTE:** Machine travels at higher speed during Non-Welding travel
  - The intermittent cycle will continue until the Total Length is satisfied or the Stop Sensor is tripped

## INTERMITTENT WELDING

The Travel Speed Adjustment Knob is used for entering the parameters for intermittent or stitch welding. Follow the steps below to enter the welding parameters.

1. Press the Travel Speed Adjustment Knob. The A LED will illuminate.
2. Turn the Travel Speed Adjustment Knob (clockwise + / counterclockwise -) to set the WELD LENGTH. The length adjusts.\*
3. Press the Travel Speed Adjustment Knob again. The B LED will illuminate.
4. Turn the Travel Speed Adjustment Knob to set the NON-WELD LENGTH. The length adjusts.\*
5. Press the Travel Speed Adjustment Knob again. The C LED will illuminate.
6. Turn the Travel Speed Adjustment Knob to set the TOTAL LENGTH. The length adjusts.\*
7. Press the travel Speed Adjustment Knob again. All LEDs are unlit.

\*Note: measurement is in inches or cm. according to your unit setting - refer to Converting Units on p.9.

Intermittent Welding is available in two forms - User Defined and Total Length. With User Defined welding, user enters values for Weld Length and Non-Weld Length. Either A or B LED must be lit when pressing Cycle Start Button. Intermittent Weld continues until user presses Cycle Stop Button.

For Total Length welding, user enters values for all three stitch parameters. C LED must be lit when pressing Cycle Start Button. Intermittent welding ends when Total Length has been met.

## CONTINUOUS WELDING (INTERMITTENT WELDING LOCK-OUT)

To lock out the intermittent (stitch) welding controls, press and hold the Travel Speed Adjustment knob for three (3) seconds. All of the LEDs will flash. To unlock the intermittent welding controls, press and hold the Travel Speed Adjustment Knob for three (3) seconds. While in lockout, the machine will be unable to perform intermittent welding.

## TIME SETTINGS

The K-BUG 1200 offers three adjustable time settings - Puddle Build-Up, Pause Time and Crater Fill. The Travel Speed Adjustment knob is used for setting each of the timers, as described below.

### Puddle Build-up Time (u)

1. While pressing the Cycle Start button, connect the power cord to an appropriate power supply.
2. The Display will show "u0.0" flashing.
3. Turn the Travel Speed Adjustment knob until the desired build-up time is displayed.
4. Default setting is 1.0 seconds. Available range is 0.0 - 9.9 seconds.

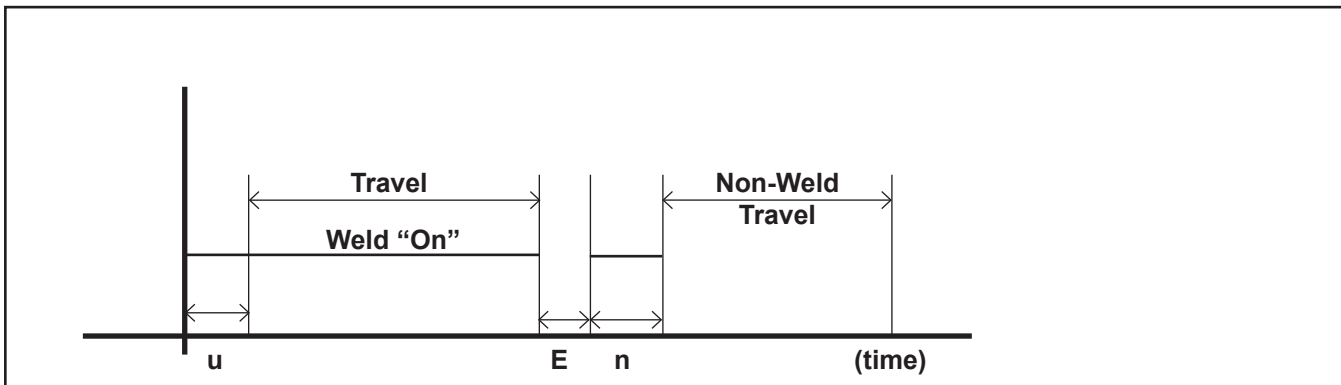
### Crater Fill Time (n)

1. Press Cycle Start button once more.
2. The Display will show "n0.0" flashing.
3. Turn the Travel Speed Adjustment knob until the desired crater fill time is displayed.
4. Default setting is 1.0 seconds. Available range is 0.0 - 9.9 seconds.

Pause Time (E). After welding, a brief rest before Crater Fill.

1. Press the Cycle Start button once more.
2. The Display will show "E0.0" flashing.
3. Turn the Travel Speed Adjustment knob until the desired stop time is displayed.
4. Default setting is 0.5 seconds. Available range is 0.0 - 9.9 seconds.

When finished setting times, press the Cycle Stop button to exit time setup mode. The machine is now ready to be setup for welding.



A graphic display of the user adjustable time settings.

## STOP SENSOR OPERATION

The K-BUG 1200 is equipped with two (2) Stop Sensors. One sensor is placed on the right side of the carriage, the other is placed on the left. The Stop Sensors are normally open switches that engage or close when depressed. If a sensor is tripped during welding, carriage travel will immediately stop and Crater Fill will be performed. Remove the obstacle to reset the Stop Sensor. Press Cycle Start button to begin weld cycle again. **NOTE:** If Stop Sensor is tripped during intermittent welding, program will reset, NOT resume.



## GLOBAL PARAMETERS

A menu of Global Parameters is maintained in the K-BUG 1200. The menu consists of six (6) items as described in Table 1, below. Access to the menu is locked when DIP Switch #1 is in the OFF Position.

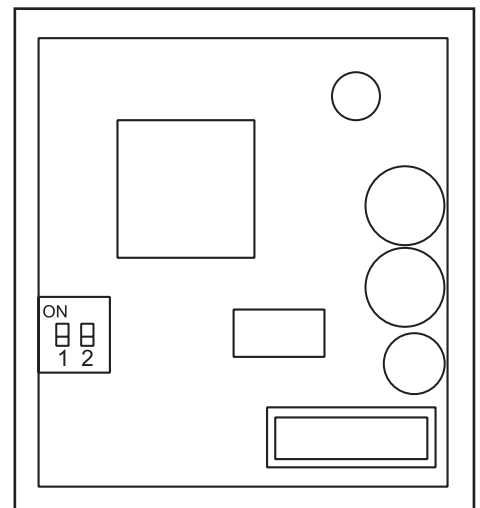
**Table 1: Global Parameters**

| Display | Description               | Default | Range      | Units                    |
|---------|---------------------------|---------|------------|--------------------------|
| n.0*    | Travel Speed Coefficient  | 20.0    | 0.1 - 50   |                          |
| n.1     | Motor Overload Stop Time  | 2       | 0.0 - 9.9  | sec                      |
| n.2*    | Travel Motor Reduce Ratio | 80      | 20 - 200   | base fig x 10 : 1        |
| n.3*    | Diameter of Travel Wheel  | 50      | 0.0 - 99.9 | mm                       |
| n.4     | Show Mode                 | off     | off / on   |                          |
| n.5     | Operating Units           | U2      | U1 / U2    | U1 (cm/min), U2 (in/min) |

\* Indicates parameters NOT to be changed by the User. Changing these parameters can harm machine performance.

### ACCESS THE GLOBAL PARAMETER MENU

1. With machine unplugged from A/C power supply, remove the six (6) screws securing the Control Interface (Legend Plate and Main PCB) to the Control Panel.
2. Remove the Control Interface and turn it over.
3. Locate DIP Switch 1 and 2 on the Main PCB, see illustration at right.
4. Turn DIP Switch 1 to the "ON" position.
5. Turn over Control Interface. And secure to Control panel.
6. Plug in machine to A/C power supply of appropriate voltage.
7. "0" should be shown in the Display.
8. Press and release Cycle Start button to cycle through the six parameters (0, 1, 2, 3, 4, 5).
9. Use the Travel Speed Adjustment knob to change the parameter setting.
10. When finished, unplug machine, remove Control Interface and turn it over.
11. Turn DIP switch 1 to the "OFF" position to lock global parameter menu.
12. Re-assemble Control Panel and plug in machine to begin operation.



Rear of Main PCB. Note DIP switch placement on left hand side. Move Switch 1 up to the ON position.

### CONVERTING UNITS

By default, the K-BUG 1200 will be factory set to operate in English units (in/min) and the K-BUG 1202 will be set to operate in Metric units (cm/min). If it is necessary to change units, follow the steps to access the Global Parameters Menu, above. Use the Cycle Start button until "5" is shown on the Display. Turn the Travel Speed Adjustment knob right or left to select the desired Units. Choose "U1" for Metric (cm/min) or "U2" for English (in/min).

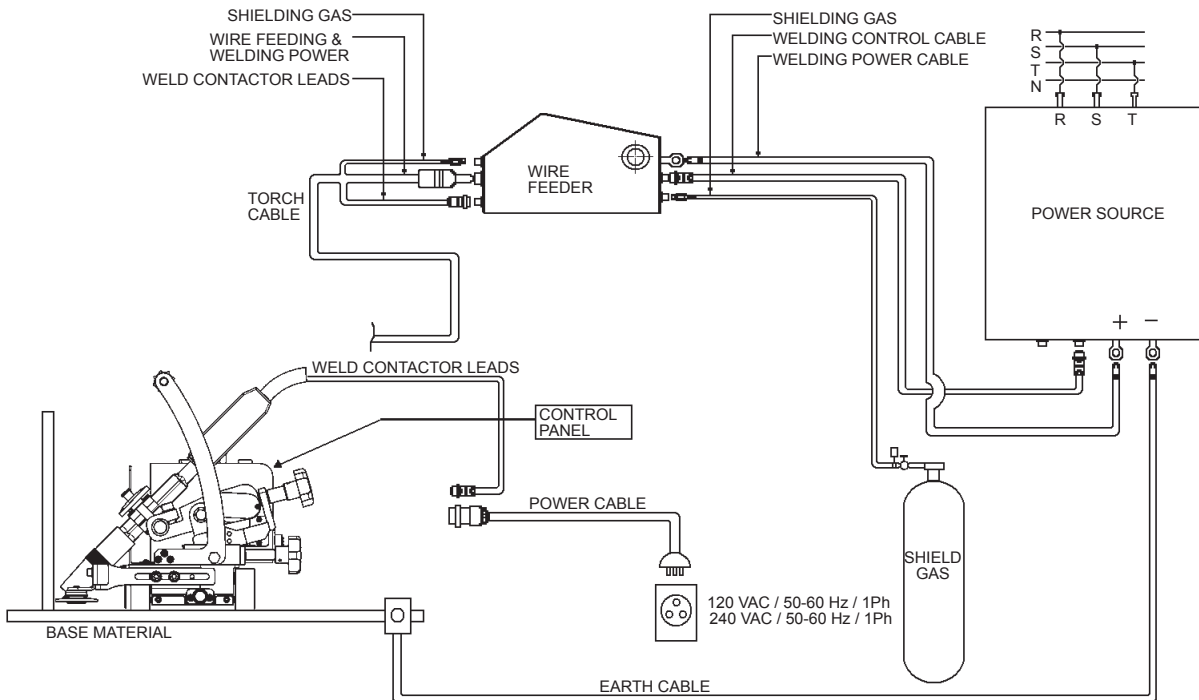
# INSTALLATION AND OPERATION

1. Welding Preparation - Secure the necessary welding supplies
  - Welding Power Source (3 phase, 440/380/220V AC)
  - Wire Feeder
  - Tank of appropriate shielding gas, with pressure and flow regulators and appropriate fittings
  - Torch for gas shielded automated welding
  - Basic Weld Prep Tools
2. Cable Connections
  - Connect welding torch conduit cable to wire feeder
  - Connect Weld Contactor lead from Torch to Main Cable Connector on machine body
  - Connect Control Cable to the Control Box Connector on the machine body
  - Connect Control Power Source Cable to the Welding Power Source

**CAUTION:** Carefully route power cable as it may become entangled during operation, resulting in damage to people or equipment.

3. Welding Process
  - Switch ON the Primary Side Distribution Board of the Welding Power Source
  - Switch ON the Control Power Source on the front panel of the Welding Power Source
  - Equip the Wire Feeder with wire
  - Set the Carriage so the torch is at the weld starting point
  - Install the Guide Arms offset in the direction of travel (leading arm slightly shorter than following arm) for better positioning of the electrode in the joint
  - Adjust the target angle and position of the Torch using the Torch Adjustment Slider
  - Verify machine is in the proper welding mode. Set stitch welding parameters, if needed
  - Verify adequate Shielding Gas Supply
  - Start Welding - Switch Welding Switch to AUTO, verify desired travel direction is set and travel speed is > 0 and press Cycle Start button
  - Press Cycle Stop button when welding is complete. Turn Welding Switch to OFF
  - Confirm Welding End

## CABLE INTERCONNECT DIAGRAM



## MAINTENANCE

The K-BUG carriage should be periodically checked and cleaned to maximize service life.

Before use:

Check all screws in the torch clamp and guide rollers. Tighten as needed. Loose fasteners may cause uneven travel or inconsistent weld quality.

During use:

Monitor wheels, motor and welding torch for abnormal noise or overheating.

After each use:

1. Clean control panel to remove dust and other debris.
2. Inspect carriage base, wheels, guide rollers, slide adjustment, magnets and torch for weld spatter or other debris. Clean as needed.
3. Inspect power cable and torch cable for cracked, cut or damaged insulation. Replace as needed.
4. Inspect connectors for damaged pins or loose connections. Replace as needed.

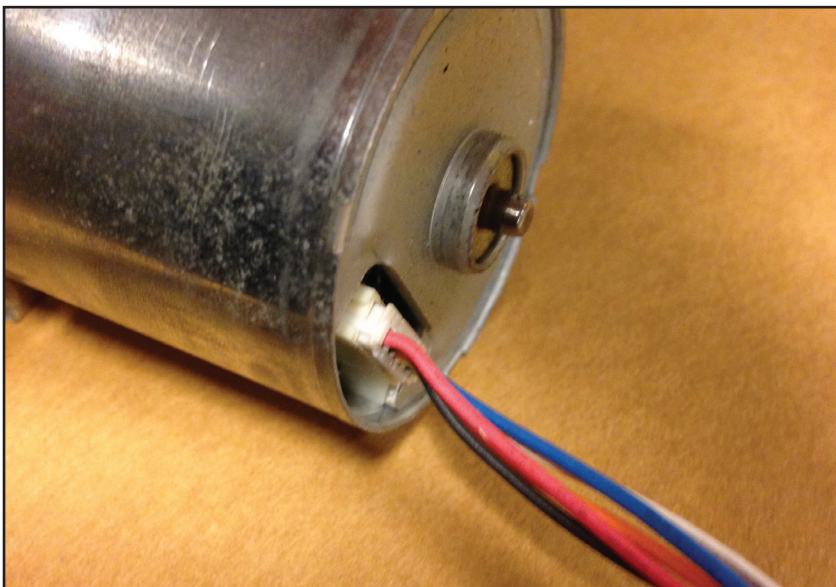
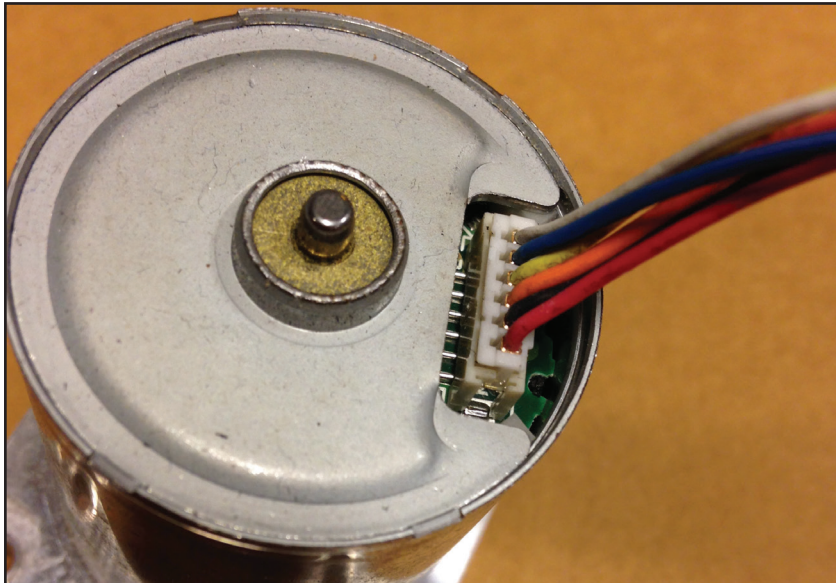
## TROUBLESHOOTING

| Symptom   | Cause  | Repair   |
|---|--|--|
| Control panel Display is not LIT when machine is plugged in | Disconnected Control Cable                               | Verify control cable is properly connected to machine                      |
|   | Faulty Control Cable                                     | Replace Cable  |
|   | Control Box Fuse Tripped or Disconnected                 | Replace fuse. If problem persists, contact service rep.                    |
| No Arc when Welding Auto/Off Switch turned to AUTO          | Weld Auto/Off Switch set to OFF                          | Turn Weld Auto/Off Switch to AUTO  |
|   | Loose contact of Welding Leads                           | Check ground connections. Verify good contact on clean, unpainted surface. |
|   | Faulty or incorrectly wired Welding Auto/Off Switch      | Check Wiring. Replace Switch, if needed                                    |
|   | Stop Sensor Engaged                                      | Disengage Stop Sensor  |
| Carriage does not travel when Cycle Start Button is pushed  | Failed drive component                                   | Check Motor and Gearbox. Replace as needed                                 |
|   | Faulty or incorrectly wired Cycle Start Button           | Check Wiring. Replace button , if needed                                   |
|   | Faulty MAIN PCB  | Replace MAIN PCB   |
| Torch targets wrong position                                | Loose fastener on Torch Clamp or Torch Adjustment Slider | Check and tighten screws, replace if needed.                               |
| Slide is hard to adjust                                     | Dust or other debris on slide parts                      | Clean slide parts. Lubricate with light oil                                |
| Carriage stops during automatic welding                     | Obstacle in carriage path                                | Remove obstacles   |
|   | Stop Sensor engaged                                      | Disengage Stop Sensor  |
|   | Distance traveled exceeds Total Length                   | See "Intermittent Welding" on page 7 for instructions to set Total Length  |
| Arc continues after Welding Auto/Off Switch is set to OFF   | The Welding Auto/Off Switch is still set to Auto         | Turn Weld Auto/Off Switch to OFF   |
|   | Faulty or incorrectly wired Welding Auto/Off Switch      | Check Wiring. Replace Switch, if needed.                                   |
| Unable to perform Intermittent Welding                      | Intermittent Welding is locked                           | Press and hold Travel Speed Adjustment knob for 3 seconds.                 |

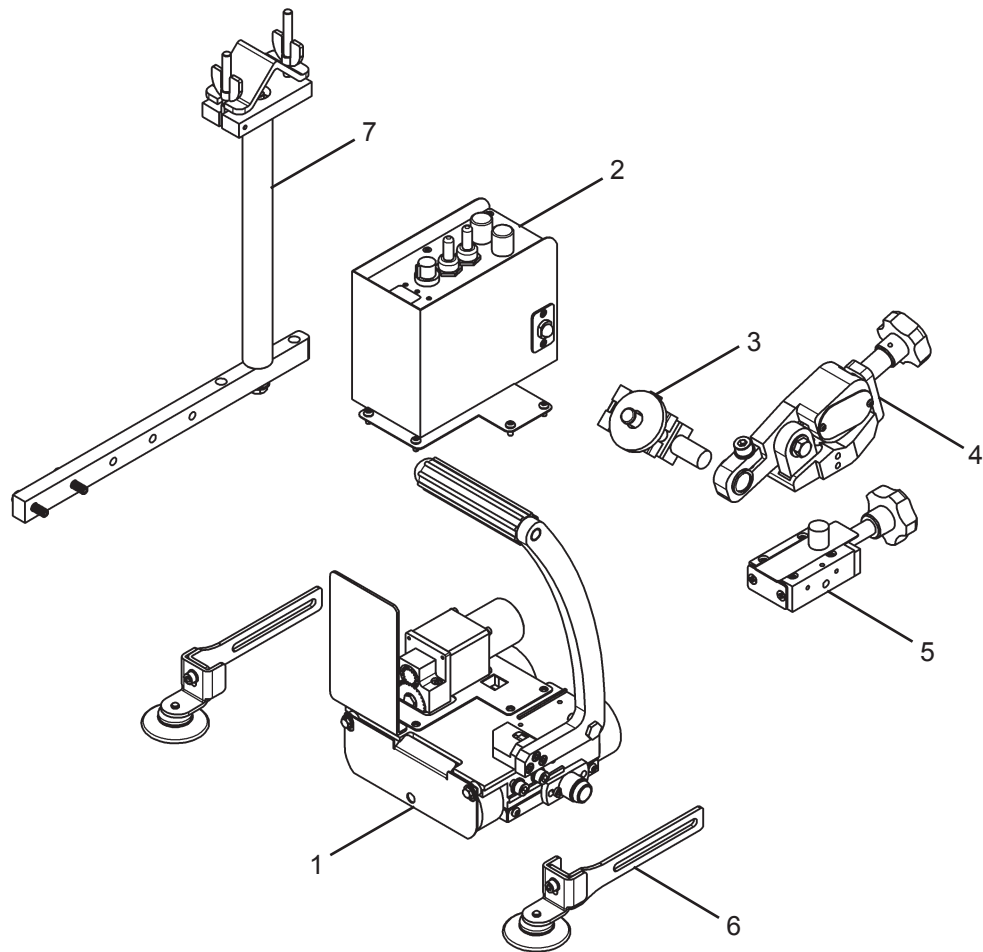
## TROUBLESHOOTING, CONT'D.

### K-BUG ERROR LIST

| NO.  | SYMPTOM         | CAUSE  | SOLUTION   |
|------|-----------------|--|--|
| E-03 | Motion Stop     | Main PCB EET ROM Error                                 | Main PCB Replacement   |
| E-05 | Travelling Stop | Auto-Stop Travelling Motor may be overloaded / shorted | Push and release Stop Button<br><br>IF UNRESOLVED:<br>1. Check for loose wiring connection at drive motor and weave motor if equipped (see below).<br>2. Replace motor or motor reducer<br>3. Replace main PCB |



# K-BUG 1200 ASSEMBLY VIEW

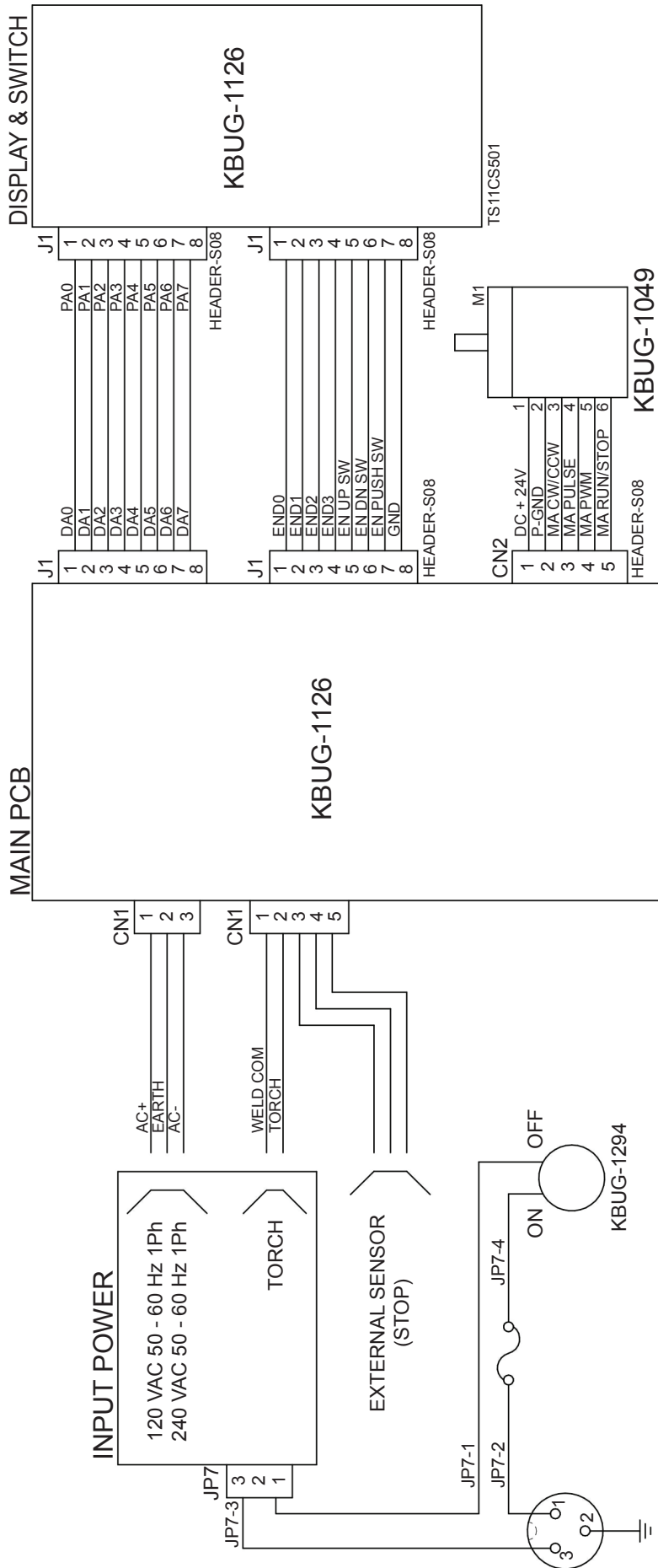


| <u>ITEM</u> | <u>QTY</u> | <u>PART NO.</u> | <u>DESCRIPTION</u>                   |
|-------------|------------|-----------------|--------------------------------------|
| 1           | 1          | KBUG-1210       | Carriage Assembly                    |
| 2           | 1          | KBUG-1120       | Control Panel Assembly               |
| 3           | 1          | KBUG-1100       | Torch Clamp Assembly                 |
| 4           | 1          | KBUG-1230       | Angle Slide Assembly                 |
| 5           | 1          | KBUG-1070       | Y-Slide Assembly                     |
| 6           | 2          | KBUG-1060       | Guide Arm Assembly                   |
| 7           | 1          | KBUG-1290       | Cable Anchor Assembly                |
| 8*          | 1          | KBUG-2274-XX    | 120 VAC Power Cord (KBUG-1200, only) |
| 9*          | 1          | KBUG-2273-XX    | Weld Contact Cable                   |
| 10*         | 1          | KBUG-2272-XX    | 240 VAC Power Cord (KBUG-1202, only) |
| 11*         | 1          | KBUG-1003       | Metric Hex Key Set                   |

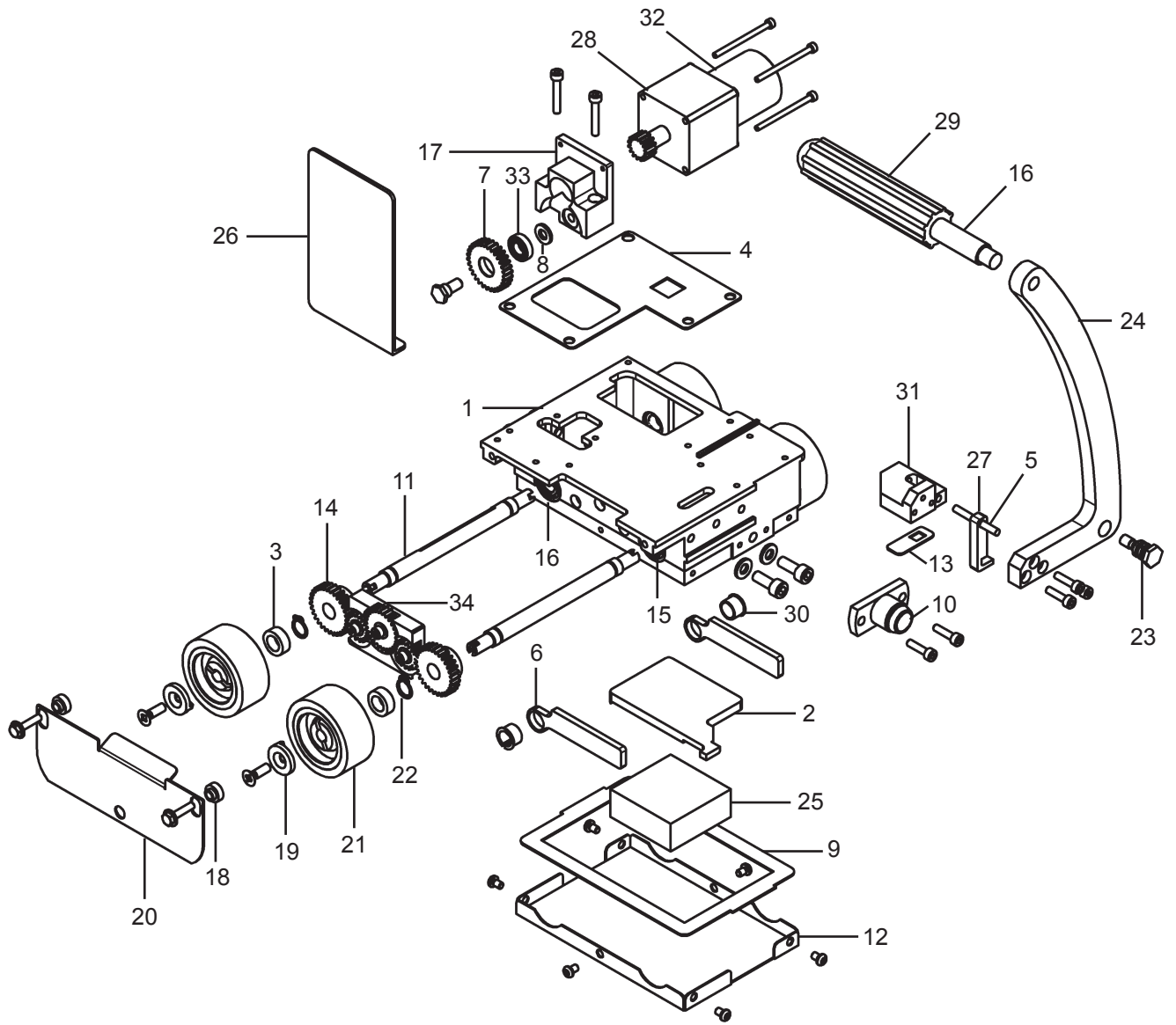
XX= Cable length: 15' is standard, 25' & 50' are optional

\* = Not shown

# K-BUG 1200 WIRING DIAGRAM



# KBUG-1210 CARRIAGE ASSEMBLY / EXPLODED VIEW



## KBUG-1210 CARRIAGE ASSEMBLY / PARTS LIST

| <u>ITEM</u> | <u>QTY</u> | <u>PART NO.</u> | <u>DESCRIPTION</u>                         |
|-------------|------------|-----------------|--|
| 1           | 1          | KBUG-1216       | Body                                       |
| 2           | 1          | KBUG-1012       | Magnet Plate                               |
| ***3        | 4          | KBUG-1013       | Shaft Bushing                              |
| 4           | 1          | KBUG-1222       | Dust Cover -2                              |
| 5           | 1          | KBUG-1218       | Lever Bracket Pin                          |
| 6           | 2          | KBUG-1224       | Magnet Shaft Bracket                       |
| 7           | 1          | KBUG-1018       | Center Gear                                |
| 8           | 1          | KBUG-1019       | Gear Bushing                               |
| 9           | 1          | KBUG-1219       | Dust Cover 1                               |
| *10         | 1          | KBUG-1185-A     | Stop Sensor Assembly (includes 2 switches) |
| ***11       | 2          | KBUG-1023       | Wheel Shaft                                |
| 12          | 1          | KBUG-1024       | Bottom Cover                               |
| 13          | 1          | KBUG-1221       | Dust Cover 4                               |
| 14          | 2          | KBUG-1223       | Shaft Gear                                 |
| 15          | 4          | KBUG-1029       | Shaft Bearing                              |
| 16          | 1          | KBUG-1031       | Grip                                       |
| 17          | 2          | KBUG-1211       | Motor Bk.                                  |
| 18          | 2          | KBUG-1033       | Spatter Cover Bushing                      |
| ***19       | 4          | KBUG-1034       | Wheel Cover                                |
| 20          | 1          | KBUG-1035       | Spatter Cover                              |
| 21          | 4          | KBUG-1036       | Wheel                                      |
| 22          | 4          | KBUG-1037       | Shaft Snap Ring                            |
| 23          | 1          | KBUG-1038       | Lever Bolt                                 |
| 24          | 1          | KBUG-1041       | Lever - 2                                  |
| 25          | 1          | KBUG-1042       | Magnet                                     |
| 26          | 1          | KBUG-1043       | Motor Cover - 1                            |
| 27          | 1          | KBUG-1217       | Lever Guide Key                            |
| 28          | 1          | KBUG-1045       | Gearhead                                   |
| 29          | 1          | KBUG-1046       | Handle Cover                               |
| 30          | 2          | KBUG-1047       | DU Bushing (M)                             |
| 31          | 1          | KBUG-1214       | Lever Bracket -D                           |
| 32          | 1          | KBUG-3038       | DC Brushless Motor                         |
| 33          | 1          | KBUG-1051       | Motor Bearing                              |
| **34        | 1          | KBUG-1220       | 3 Gear Drive Case                          |

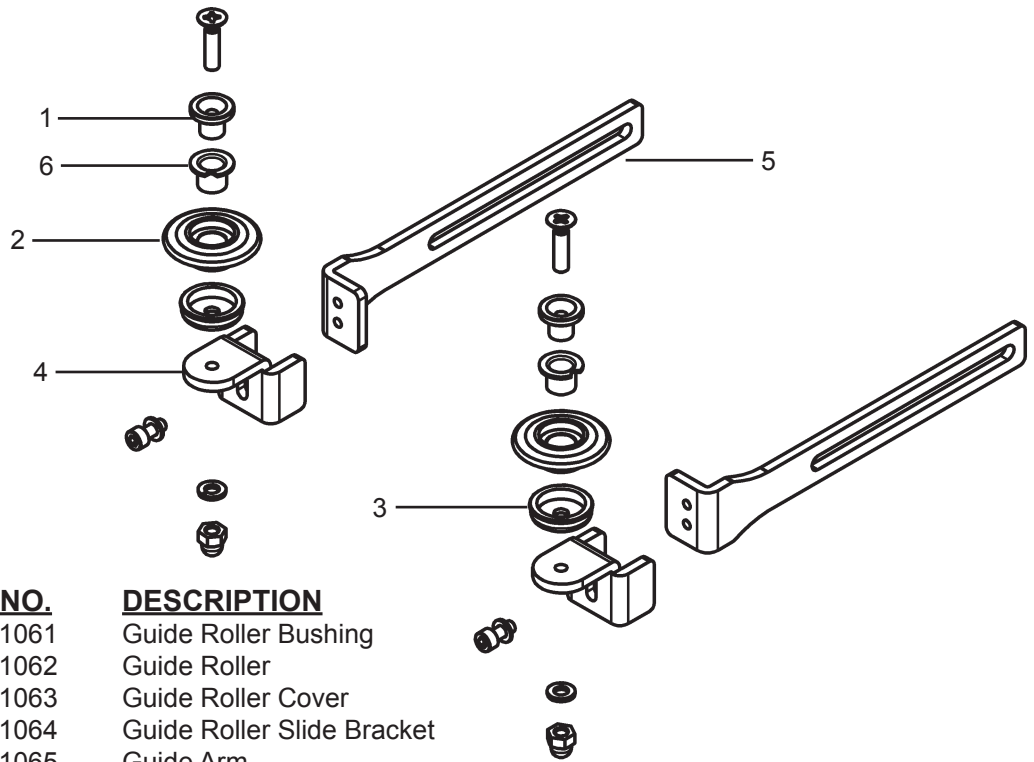
\*An individual sensor can be ordered as KBUG-1185-B

\*\*KBUG-1220 is made up of the following parts: KBUG-1212, KBUG-1213 and KBUG-1215

\*\*\*If replacement parts are required, refer to Addendum on page 22.

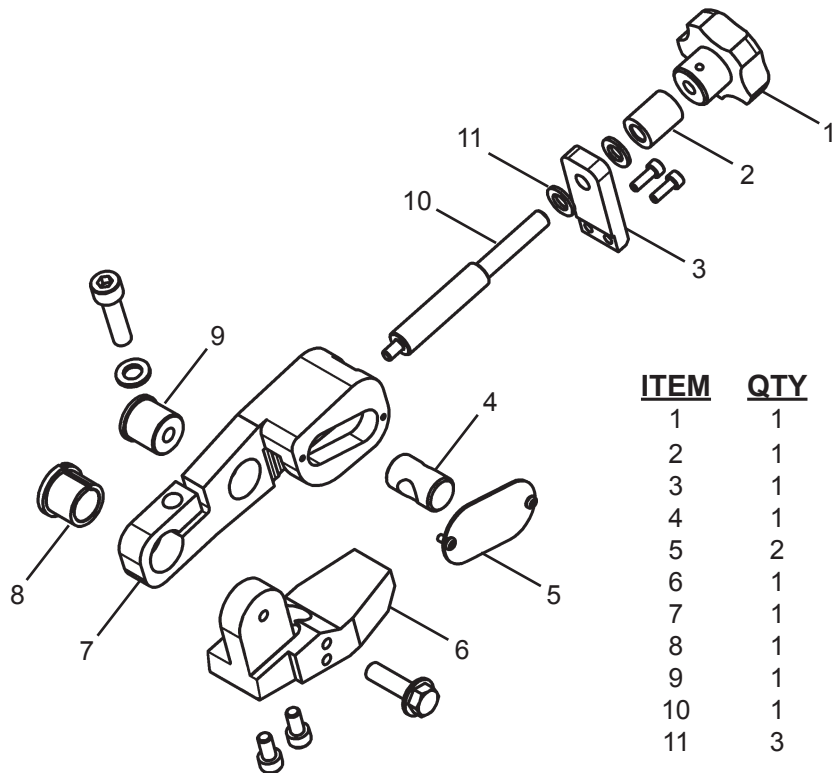


## KBUG-1060 GUIDE ARMS / EXPLODED VIEW / PARTS LIST



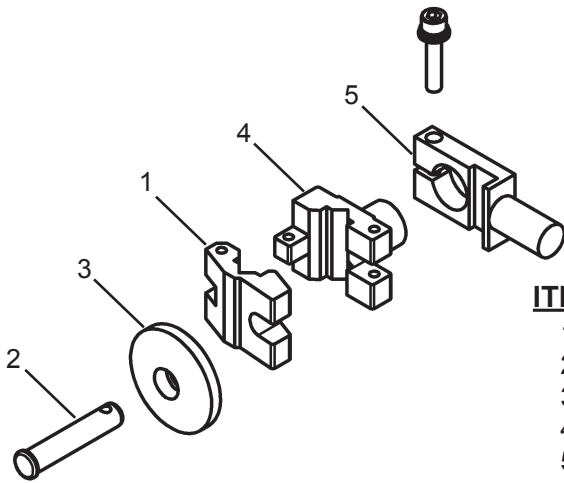
| <u>ITEM</u> | <u>QTY</u> | <u>PART NO.</u> | <u>DESCRIPTION</u>         |
|-------------|------------|-----------------|----------------------------|
| 1           | 2          | KBUG-1061       | Guide Roller Bushing       |
| 2           | 2          | KBUG-1062       | Guide Roller               |
| 3           | 2          | KBUG-1063       | Guide Roller Cover         |
| 4           | 2          | KBUG-1064       | Guide Roller Slide Bracket |
| 5           | 2          | KBUG-1065       | Guide Arm                  |
| 6           | 2          | KBUG-1068       | Guide Roller Sleeve        |

## KBUG-1230 ANGLE SLIDE ASSEMBLY / EXPLODED VIEW / PARTS LIST



| <u>ITEM</u> | <u>QTY</u> | <u>PART NO.</u> | <u>DESCRIPTION</u>     |
|-------------|------------|-----------------|------------------------|
| 1           | 1          | KBUG-1134       | Knob                   |
| 2           | 1          | KBUG-1238       | Angle Slide Bolt Cover |
| 3           | 1          | KBUG-1233       | Shaft Cover            |
| 4           | 1          | KBUG-1235       | Guide Shaft            |
| 5           | 2          | KBUG-1236       | Cover                  |
| 6           | 1          | KBUG-1231       | Angle Base             |
| 7           | 1          | KBUG-1232       | Angle Body             |
| 8           | 1          | KBUG-1237       | Bushing                |
| 9           | 1          | KBUG-1239       | Angle Slide Bushing    |
| 10          | 1          | KBUG-1234       | Slide Bolt             |
| 11          | 3          | KBUG-1241       | Washer                 |

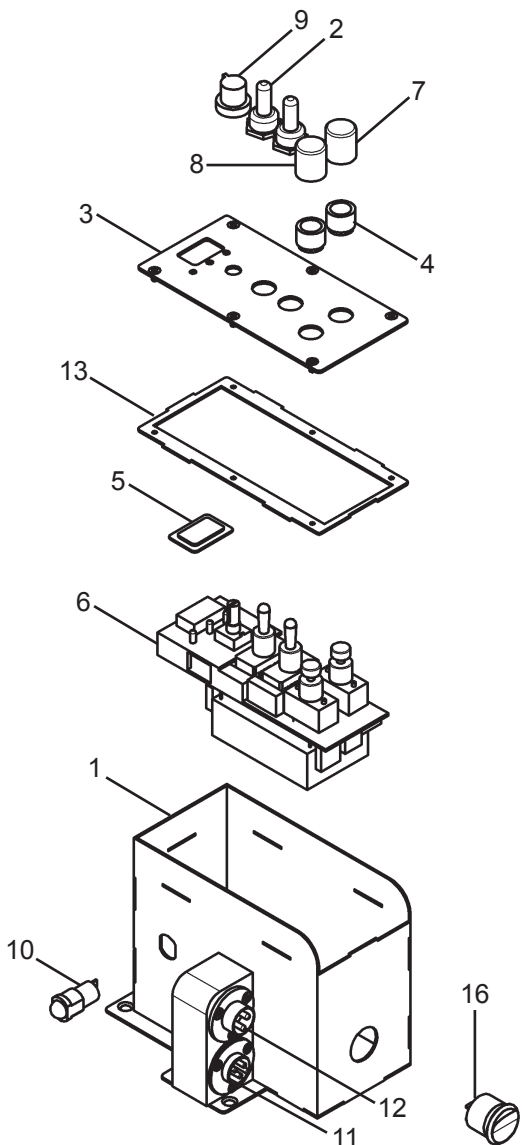
## KBUG-1100 TORCH CLAMP ASSEMBLY / EXPLODED VIEW / PARTS LIST



| <u>ITEM</u> | <u>QTY</u> | <u>PART NO.</u> | <u>DESCRIPTION</u>  |
|-------------|------------|-----------------|---------------------|
| 1           | 1          | KBUG-1111       | Torch Clamp (U)     |
| 2           | 1          | KBUG-1112       | Clamp Fixed Bolt    |
| 3           | 1          | KBUG-1113       | Clamp Fixed Knob    |
| 4           | 1          | KBUG-1114       | Torch Clamp (D)     |
| 5           | 1          | KBUG-1115       | Torch Clamp Bracket |

**Note:** KBUG-1100-1 Torch Holder can be used instead of a KBUG-1100 Torch Clamp Assembly.

## KBUG-1120 CONTROL PANEL ASSEMBLY / EXPLODED VIEW / PARTS LIST

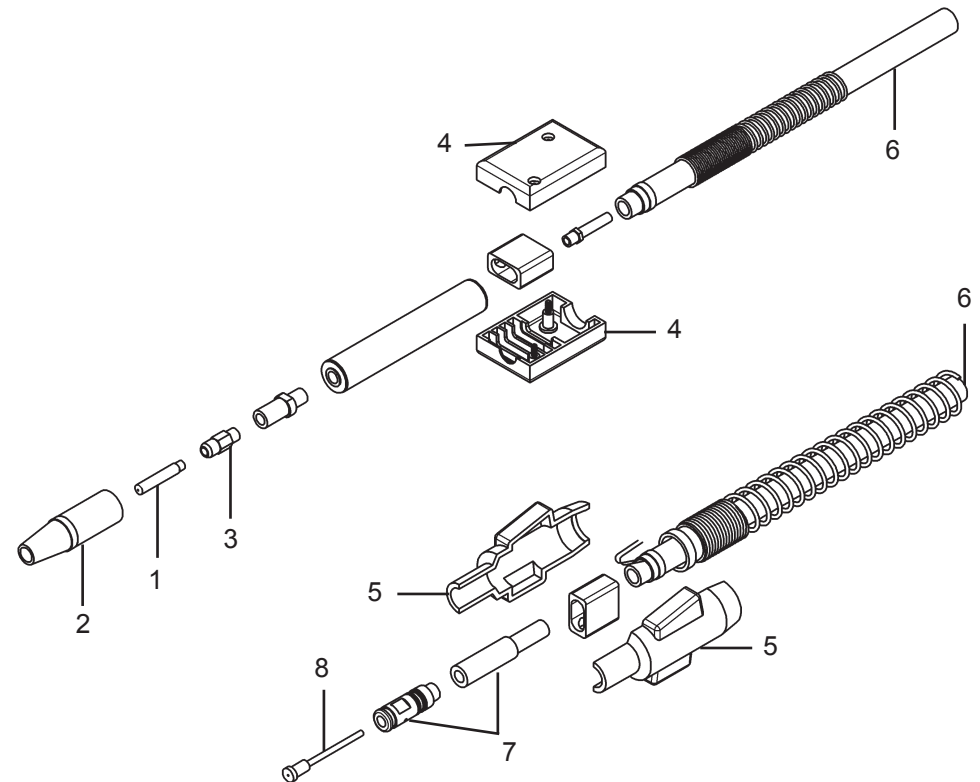


| <u>ITEM</u> | <u>QTY</u> | <u>PART NO.</u> | <u>DESCRIPTION</u>            |
|-------------|------------|-----------------|-------------------------------|
| 1           | 1          | KBUG-1121       | Panel                         |
| 2           | 2          | KBUG-1122       | Toggle Switch Cover           |
| 3           | 1          | KBUG-1123       | Legend Plate                  |
| 4           | 2          | KBUG-1124       | Push Button Cover (BS)        |
| 5           | 1          | KBUG-1125       | Display Lens                  |
| 6           | 1          | KBUG-1126       | Main PCB                      |
| 7           | 1          | KBUG-1127       | Push Button Cover - 2         |
| 8           | 1          | KBUG-1128       | Push Button Cover - 1         |
| 9           | 1          | KBUG-1129       | Volume Knob                   |
| 10          | 1          | KBUG-1131       | Fuse Holder w/ Fuse           |
| 11          | 1          | KBUG-1132       | Power Connector (Female)      |
| 12          | 1          | KBUG-1133       | Torch Connector (Female)      |
| 13          | 1          | KBUG-1225       | Dust Cover                    |
| 14*         | 1          | KBUG-1173       | Weld Contact Connector (Male) |
| 15*         | 1          | KBUG-1174       | Power Connector (Male)        |
| 16          | 1          | KBUG-1294       | Power Switch                  |

\* Not Shown

# SBG-450- - GUN & CABLE ASSEMBLY / EXPLODED VIEW / PARTS LIST

Whip Length: 15 (15 ft / 4.6 m) or 25 (25 ft / 7.6 m)  
 Wire Size: 035, 040, 045, 052, 116, 564  
 Connector Type: E (Euro), L (Lincoln 3/4"), M (Miller), T (Lincoln, small)



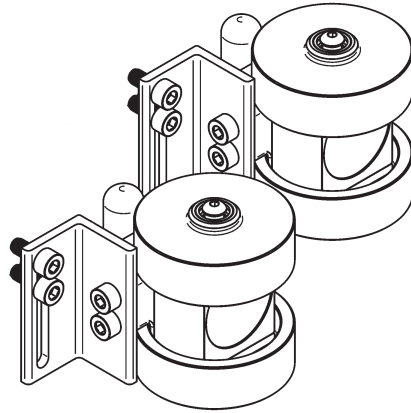
| PARTS LIST |     |              |                               | WIRE SIZE       |               |               |               |               |               |
|------------|-----|--------------|-------------------------------|-----------------|---------------|---------------|---------------|---------------|---------------|
| ITEM       | QTY | PART NO.     | DESCRIPTION                   | .035<br>(.9 mm) | .040<br>(1.0) | .045<br>(1.2) | .052<br>(1.4) | 1/16<br>(1.6) | 5/64<br>(2.0) |
| 1          | 1   | BUG-3159-35  | 16S-35 (.9 mm) Contact Tip    | X               |               |               |               |               |               |
| 1          | 1   | BUG-3159-45  | 16S-45 (1.2 mm) Contact Tip   |                 |               | X             |               |               |               |
| 1          | 1   | BUG-3159-52  | 16S-52 (1.4 mm) Contact Tip   |                 |               |               | X             |               |               |
| 1          | 1   | BUG-3159-116 | 16S-116 (1.6 mm) Contact Tip  |                 |               |               |               | X             |               |
| 1          | 1   | BUG-3159-564 | 16S-564 (2.0 mm) Contact Tip  |                 |               |               |               |               | X             |
| 1          | 1   | PWS-4436-1.0 | 16S-40 (1.0 mm) Contact Tip   |                 | X             |               |               |               |               |
| 2          | 1   | PWS-4447     | 27S62 H.D. Nozzle 5/8"        | X               | X             | X             | X             | X             | X             |
| 3          | 1   | PWS-4449     | PX57HD Gas Diffuser           | X               | X             | X             | X             | X             | X             |
| 4          | 1   | CWO-8017     | Case w/ Binder Screws (Front) | X               | X             | X             | X             | X             | X             |
| 5          | 1   | PWS-4411     | Case w/ Binder Screws (Back)  | X               | X             | X             | X             | X             | X             |
| 6          | 1   | STW-3044     | 450 Amp Cable                 | X               | X             | X             | X             | X             | X             |
| 7          | 1   | R174-T       | Connector, Small Lincoln      |                 |               |               |               |               |               |
| 7          | 1   | R174-L       | Connector, 3/4" Lincoln       |                 |               |               |               |               |               |
| 7          | 1   | R174-M       | Connector, Miller             |                 |               |               |               |               |               |
| 7          | 1   | R174-X       | Connector, Euro               |                 |               |               |               |               |               |
| 8          | 1   | CWO-8009     | 44-3545-15 Cable Liner        | X               | X             | X             |               |               |               |
| 8          | 1   | CWO-8011     | 44-116-15 Cable Liner         |                 |               |               | X             | X             |               |
| 8          | 1   | CWO-8012     | 44-564-15 Cable Liner         |                 |               |               |               |               | X             |
| **         | 1   | SBG-1004     | Gas Hose Assembly             | X               | X             | X             | X             | X             | X             |
| **         | 2   | SBG-1005     | Gas Hose Clamps               | X               | X             | X             | X             | X             | X             |

\*\* Not shown. Required only with standard Lincoln guns (SBG-450-L).

## ACCESSORIES

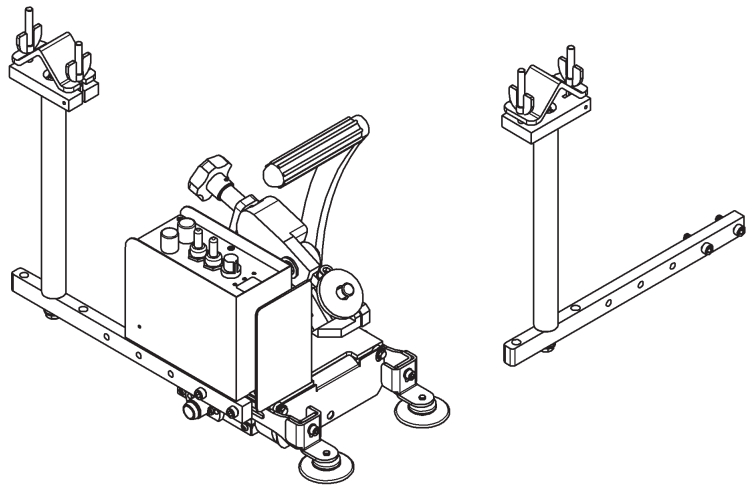
### **KBUG-1067 Magwheel Add-On Kit**

Magnetic guide wheels available for curved or irregular seams.



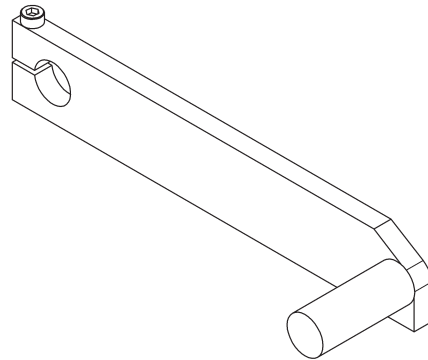
### **KBUG-1290 Cable Anchor**

The cable anchor acts as a strain relief to keep the supply cable from dragging the torch out of position.



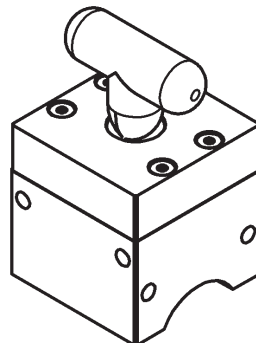
### **KBUG-1170 7" (178 mm) Long Arm Extension Kit**

The long arm extension kit allows the user to relocate the welding torch away from the carriage body for welding special applications.



### **MSQ-150 30mm Magsquare**

The Magsquare is used to activate the limit switch to stop machine travel and welding process.



# WARRANTY

## LIMITED WARRANTY

MODEL \_\_\_\_\_  
SERIAL NO. \_\_\_\_\_  
DATE PURCHASED: \_\_\_\_\_

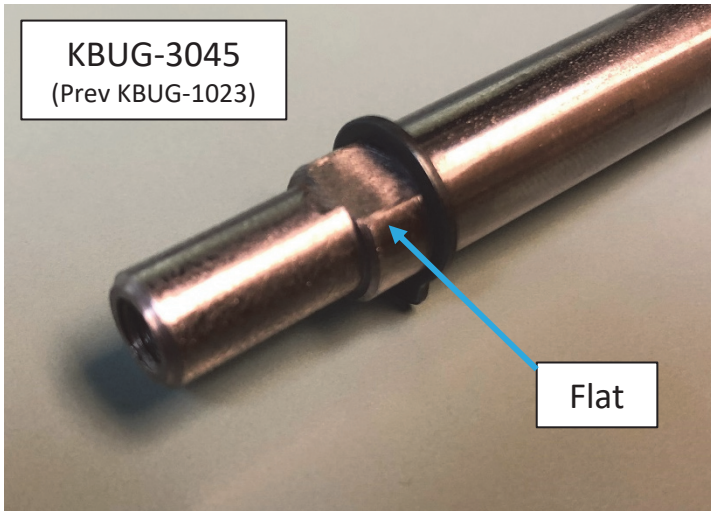
FOR A PERIOD OF TWELVE (12) MONTHS FROM DELIVERY, BUG-O SYSTEMS WARRANTS TO THE ORIGINAL PURCHASER (DOES NOT INCLUDE AUTHORIZED DISTRIBUTORS), THAT A NEW MACHINE IS FREE FROM DEFECTS IN MATERIAL AND WORKMANSHIP AND AGREES TO REPAIR OR REPLACE, AT ITS OPTION, ANY DEFECTIVE PARTS OR MACHINE. THIS WARRANTY DOES NOT APPLY TO MACHINES, WHICH AFTER OUR INSPECTION, ARE DETERMINED TO HAVE BEEN DAMAGED DUE TO NEGLIGENCE, ABUSE, OVERLOADING, ACCIDENT OR IMPROPER USAGE. ALL SHIPPING AND HANDLING CHARGES WILL BE PAID BY CUSTOMER.

BUG-O SYSTEMS MAKES NO WARRANTY OF MERCHANTABILITY AND MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, BEYOND THE WARRANTY EXPRESSLY SET FORTH ABOVE. BUYER'S REMEDY FOR BREACH OF WARRANTY, HEREUNDER, SHALL BE LIMITED TO REPAIR OR REPLACEMENT OF NON-CONFORMING PARTS AND MACHINES. UNDER NO CIRCUMSTANCES SHALL CONSEQUENTIAL DAMAGES BE RECOVERABLE.

**HOW TO OBTAIN SERVICE:**

**IF YOU THINK THIS MACHINE IS NOT OPERATING PROPERLY, RE-READ THE INSTRUCTION MANUAL CAREFULLY, THEN CALL YOUR AUTHORIZED BUG-O DEALER/DISTRIBUTOR. IF HE CANNOT GIVE YOU THE NECESSARY SERVICE, WRITE OR PHONE US TO TELL US EXACTLY WHAT DIFFICULTY YOU HAVE EXPERIENCED. BE SURE TO MENTION THE MODEL AND SERIAL NUMBERS.**

## ADDENDUM



If Flat is present on the KBUG-3045, the KBUG-3030 will be required in place of the KBUG-3044 and KBUG-3029.

If Flat is not present, replacement KBUG-3044 and KBUG-3029 are still able to be ordered.

