

INSTRUCTIONS AND PARTS MANUAL

GO-FER III-0X GO-FER III-PL GO-FER III-WD

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-GO-FER-IPM-0208



BUG-O SYSTEMS

A DIVISION OF WELD TOOLING CORPORATION



PHONE: 1-800-245-3186 <http://www.bugo.com> FAX: 1-412-331-0383
280 TECHNOLOGY DRIVE CANONSBURG, PENNSYLVANIA, USA 15317-9564

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 the equipment when wet or standing in a wet location.
2. Never open the equipment without first unplugging the power cord or serious injury may result.
3. 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.
4. 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 Electrical 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. Do not leave the equipment unattended. Remove from the worksite 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.

CAUTION

DO NOT LEAVE EQUIPMENT UNATTENDED WHEN NOT IN USE!

Remove from work site and store in a safe location.

GO-FER III

INSTRUCTION AND PARTS MANUAL FOR ALL MODELS AND KITS

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**THIS PRODUCT IS COVERED BY ONE OR
MORE PATENTS WORLD WIDE.**

OPERATING INSTRUCTIONS / SETUP

1. TRACK SETUP

Attach two **ARM-2500 "ON-OFF" Magnet Plate Assemblies (M)** one quarter of the length from each end of the track. The magnets hold the rail to a steel workpiece and give all position capability. Mount the **ARM-2505 Spacer Bar Assemblies (N)** between the **Magnet Plate Assemblies (M)** to provide additional rail support. Verify the workpiece is clean and free of contaminants such as rust and oil to insure maximum magnet holding power. The **ARR-1080** and **ARR-1085 Rails (L)** are supplied with a positive rail joining system that enables the user to construct a rail system of any length.

2. POSITIONING AND ADJUSTING THE MACHINE ON THE TRACK

Disengage the clutch by centering the clutch **Knob (A)** over the hole in the cover and pulling the knob out. This disengages the drive pinion. Slide the carriage wheels into the track V-grooves from the end of the track. The carriage will move smoothly along the track if the wheels are properly aligned.

The **GO-FER III** wheels are factory adjusted to fit **ARR-1080** rails. Wheel adjustment should be verified on older machines. Grasp the carriage sides. The wheels are too loose if the carriage can be moved from side to side. Use a finger to keep one of the wheels from rotating while manually pushing the carriage along the track. The wheels are adjusted too tight if firm finger pressure is not enough to prevent wheel rotation.

WHEEL ADJUSTMENT

The wheels along one side of the carriage have **Stainless Shim Washers (C)** underneath. These wheels are adjustable. Readjust these wheels (if necessary) by rotating the **Hex Bolt (B)** with a 1/2" (13 mm) wrench.

Gently push the clutch **Knob (A)** back into the case while gently rocking the machine forward and backward. This will engage the drive pinion. The rocking motion is necessary to insure proper gear mesh.

3. TORCH SET-UP

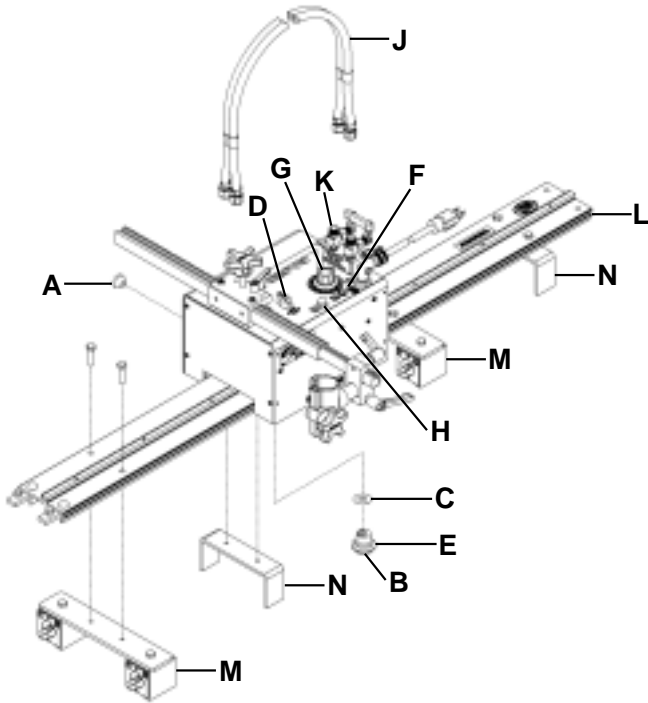
Insert the cutting torch into the torch holder on the rack. Adjust the torch holder, the clamp and the rack to set the torch to the desired position. Connect the **Hose Assembly (J)** to the **Quick Action Manifold (K)** and to the cutting torch. The manifold acts as a strain relief for the supply hoses as well as a quick shut off valve for the gases. Once the torch valves are adjusted, the manifold eliminates the need to readjust the valves after each cut and keeps the supply lines from dragging the torch out of position.

MACHINE OPERATION

Set **Switch (D)** to the center "**STOP**" position. Plug in the power cord. Verify the **Pilot Light (F)** comes on. Set **Switch (D)** to the forward or reverse position to begin forward or reverse travel. Adjust the travel speed using the **Speed Control (G)**.

The **Circuit Breaker (H)** protects the unit against overload or electrical faults. **CAUTION: IF THE CIRCUIT BREAKER OPENS, FIND AND CORRECT THE CAUSE BEFORE RESETTING.**

GO-FER III-OX / TECHNICAL DATA (Oxy-fuel)



Power Requirement: - 60 watts at rated voltage:

GOF-3240-OX	(Oxy-Fuel)	120 VAC/50-60/1
GOF-3242-OX	(Oxy-Fuel)	240 VAC/50-60/1
GOF-3244-OX	(Oxy-Fuel)	42 VAC/50-60/1

Travel Speed: Infinitely variable from
8-100 ipm (200-2500 mm/min)

Load Capacity: 15 lbs. (6.8 kg) vertical or
60 lbs. (27.3 kg) horizontal

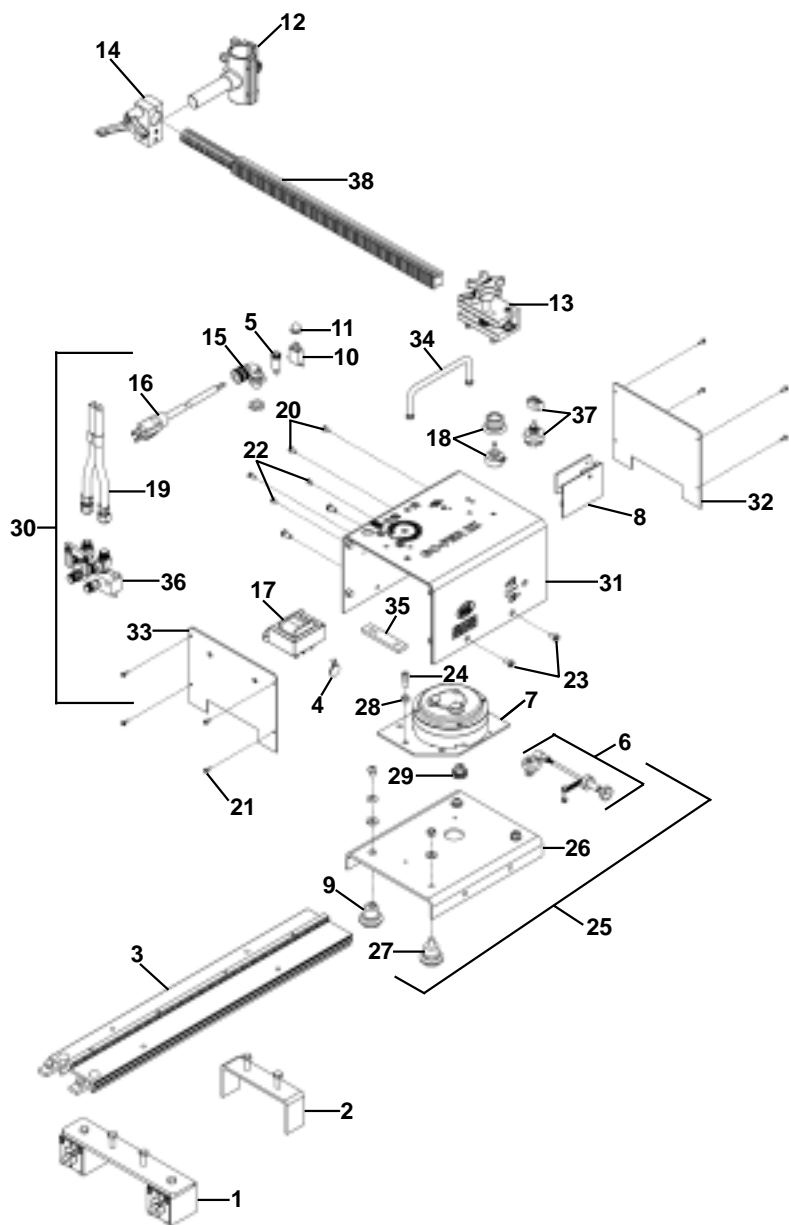
Magnet Holding Capacity: 100 lbs. (45.4 kg)

Net Weight Of Drive Unit: 17 lbs. (7.7 kg)

Dimensions of Drive Unit: 10"L x 8"W x 13"H
(254 mm x 203 mm x 257 mm)

Rail (Ordered Separately) 4' (1.18 m) ARR-1085
8' (2.37 m) ARR-1080

EXPLODED VIEW / GO-FER III-OX



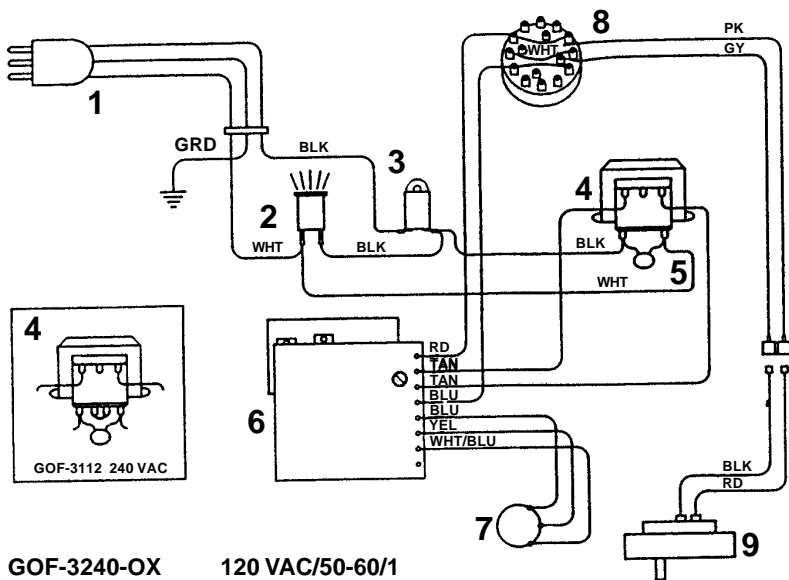
PARTS LIST / GO-FER-OX

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
** 1	ARM-2500	On/Off Magnet Plate Assy.
** 2	ARM-2505	Spacer Bar Assy.
** 3	ARR-1080	H.D. Rigid Rail 93.50" (2.37 m)
* 4	BUG-1393	Volt Trap 120 VAC
* 5	BUG-1415	Pilot Light 120 VAC
6	BUG-1605	Cam Clutch Assy.
7	BUG-1625-D	Drive Unit (80:1) [Includes Item #29]
8	BUG-1725	Speed Control
9	BUG-1982	External Adjustable Leg & Wheel Assy.
* 10	BUG-2923	Circuit Breaker w/Reset .7A
11	BUG-2924	Reset Button Seal
12	BUG-5188	Torchholder Assy.
13	BUG-5451	Rackholder w/Short Handle
14	BUG-5462	Right Angle Clamp
15	BUG-9103	Cord Grip
* 16	BUG-9445	Power Cord 120 VAC
* 17	BUG-9675	Transformer 120 VAC
18	BUG-9686	Potentiometer Control & Knob
19	CIR-1010-3	Twin Hose Assy. 32" (812 mm)
20	FAS-0112	Pan Hd Scr 6-32 x 1/4"
21	FAS-0114	Pan Hd Scr 6-32 x 3/8"
22	FAS-0124	Pan Hd Scr 8-32 x 3/8"
23	FAS-0155	Pan Hd Scr 1/4-20 x 1/2"
24	FAS-0654	Soc Hd Shd Scr 5/16 x 3/8"
25	GOF-3001	Carriage Assy. [Includes Items 6, 9, 24, 26, 27, 28]
26	GOF-3002	Carriage Plate
27	GOF-3003	Fixed Leg & Wheel Assy.
28	GOF-3008	Spacer
29	GOF-3014	Drive Pinion
30	GOF-3015-HS	Enclosure Assy. [Includes Items 4, 5, 8, 10, 11, 13, 15, 16, 17, 18, 20, 21, 22, 31, 33, 34,37]
31	GOF-3016	Cover
32	GOF-3017	End Plate
33	GOF-3018	Rear End Plate
34	GOF-3019	Handle
35	GOF-3022	Back-Up Plate
36	GOF-3025	2-Hose Quick Acting Manifold
37	MUG-1192	Rotary Switch w/Knob 3 Position
38	PAN-1015	Rack 22.63" (574 mm)

*See Electrical Component Chart for 240 VAC and 42 VAC part numbers.

**These items are supplied with GO-FER- OX Deluxe Kits.

WIRING DIAGRAM / GO-FER III-OX

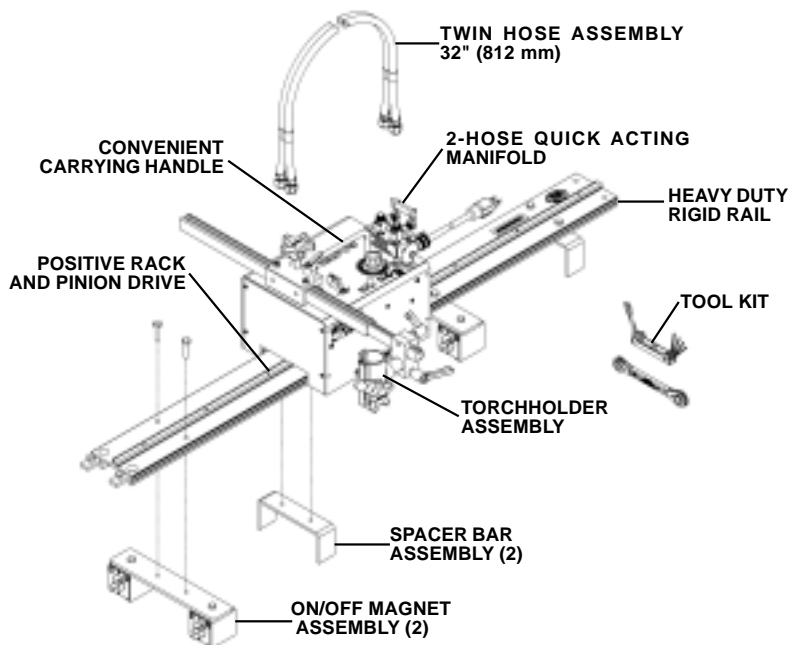


GOF-3240-OX 120 VAC/50-60/1
GOF-3242-OX 240 VAC/50-60/1
GOF-3244-OX 42 VAC/50-60/1

ELECTRICAL COMPONENT CHART

ITEM	DESCRIPTION	PART NUMBER		
		GOF-3240-OX 120 VAC	GOF-3242-OX 240 VAC	GOF-3244-OX 42 VAC
1	Power Cord	BUG-9445	GOF-3115	BUG-9442
2	Pilot Light	BUG-1415	BUG-1428	BUG-1427
3	Circuit Breaker	BUG-2923 (.7A)	BUG-2952 (.5A)	BUG-2933 (2A)
4	Transformer	BUG-9675	GOF-3112	BUG-1466
5	Volt Trap	BUG-1393	BUG-1563	BUG-1393
6	Precision Speed Control	BUG-1725		
7	Potentiometer Control	BUG-9686		
8	Rotary Switch, 3 Position	MUG-1192		
9	Gear Motor	BUG-1590 (80:1)		

GO-FER III-OX / OXY-FUEL KITS



GO-F-3250-OX GO-FER III OXY-FUEL KIT (120/50-60/1)

Includes:

1 GOF-3240-OX	GO-FER III w/Dynamic Brake
Includes:	8-100 ipm (203-2640 mm/min)
1 GOF-3025	2-Hose Q.A. Manifold
1 CIR-1010-3	Twin Hose Assembly 32" (812 mm)
1 BUG-5451	Rackholder with Short Handle
1 PAN- 1015	Rack 22.62" (574 mm)
1 BUG-5462	Right Angle Clamp
1 BUG-5188	Torchholder Assembly
1 BUG-9444	Tool Kit
1 ARR-1080	Heavy Duty Rigid Rail 93.50" (2.37 m)
2 ARM-2500	On-Off Magnet Plate Assembly
2 ARM-2505	Spacer Bar Assembly

GOF-3252-OX Same as above except
w/ 240 VAC GO-FER III
GOF-3242-OX

GOF-3254-OX Same as above except
w/ 42 VAC GO-FER III
GOF-3244-OX

Net Weight of Kit: 39 lbs. (17.7 kg)

Shipping Weight of Kit: 50 lbs. (22.7 kg)

OPERATING INSTRUCTIONS / SETUP

1. TRACK SETUP

Attach two **ARM-2500 "ON-OFF" Magnet Plate Assemblies (M)** one quarter of the length from each end of the track. The magnets hold the rail to a steel workpiece and give all position capability. Mount the **ARM-2505 Spacer Bar Assemblies (N)** between the **Magnet Plate Assemblies (M)** to provide additional rail support. Verify the workpiece is clean and free of contaminants such as rust and oil to insure maximum magnet holding power. The **ARR-1080** and **ARR-1085 Rails (L)** are supplied with a positive rail joining system that enables the user to construct a rail system of any length.

2. POSITIONING AND ADJUSTING THE MACHINE ON THE TRACK

Disengage the clutch by centering the clutch **Knob (A)** over the hole in the cover and pulling the knob out. This disengages the drive pinion. Slide the carriage wheels into the track V-grooves from the end of the track. The carriage will move smoothly along the track if the wheels are properly aligned.

The **GO-FER III** wheels are factory adjusted to fit **ARR-1080** rails. Wheel adjustment should be verified on older machines. Grasp the carriage sides. The wheels are too loose if the carriage can be moved from side to side. Use a finger to keep one of the wheels from rotating while manually pushing the carriage along the track. The wheels are adjusted too tight if firm finger pressure is not enough to prevent wheel rotation.

WHEEL ADJUSTMENT

The wheels along one side of the carriage have **Stainless Shim Washers (C)** underneath. These wheels are adjustable. Readjust these wheels (if necessary) by rotating the **Hex Bolt (B)** with a 1/2" (13 mm) wrench.

Gently push the clutch **Knob (A)** back into the case while gently rocking the machine forward and backward. This will engage the drive pinion. The rocking motion is necessary to insure proper gear mesh.

3. TORCH SET-UP

Insert the cutting torch into the torch holder on the rack. Adjust the torch holder, the clamp and the rack to set the torch to the desired position. Support the supply cable in the **Cable Anchor (J)** provided. The cable anchor acts as a strain relief to keep the supply cable from dragging the torch out of position. Connect the contactor circuit by crimping the two female connectors, (supplied) to a 22-18 gauge, two-conductor cable from the trigger circuit of the Plasma unit and plug them into the leads on the plug of the **Contact Control Box (K)**.

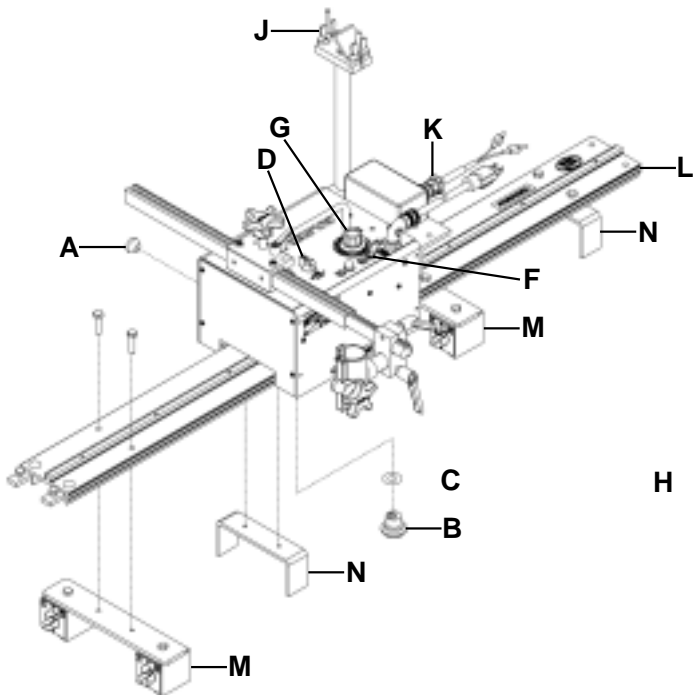
MACHINE OPERATION

Set **Switch (D)** to the center "**STOP**" position. Plug in the power cord. Verify the **Pilot Light (F)** comes on. Set **Switch (D)** to the forward or reverse position to begin forward or reverse travel. Adjust the travel speed using the **Speed Control (G)**.

The **Circuit Breaker (H)** protects the unit against overload or electrical faults. **CAUTION: IF THE CIRCUIT BREAKER OPENS, FIND AND CORRECT THE CAUSE BEFORE RESETTING.**

NOTE: A shielded gun and cable assembly must be used to reduce hi-frequency interference.

GO-FER III-PL / TECHNICAL DATA (Plasma)



Power Requirement: - 60 watts at rated voltage:

GOF-3240-PL	(PLASMA)	120 VAC/50-60/1
GOF-3242-PL	(PLASMA)	240 VAC/50-60/1
GOF-3244-PL	(PLASMA)	42 VAC/50-60/1

Tavel Speed: Infinitely variable from 8-100 ipm (200-2500 mm/min)

Load Capacity: 15 lbs (6.8 kg) vertical
60 lbs (27.3 kg) horizontal

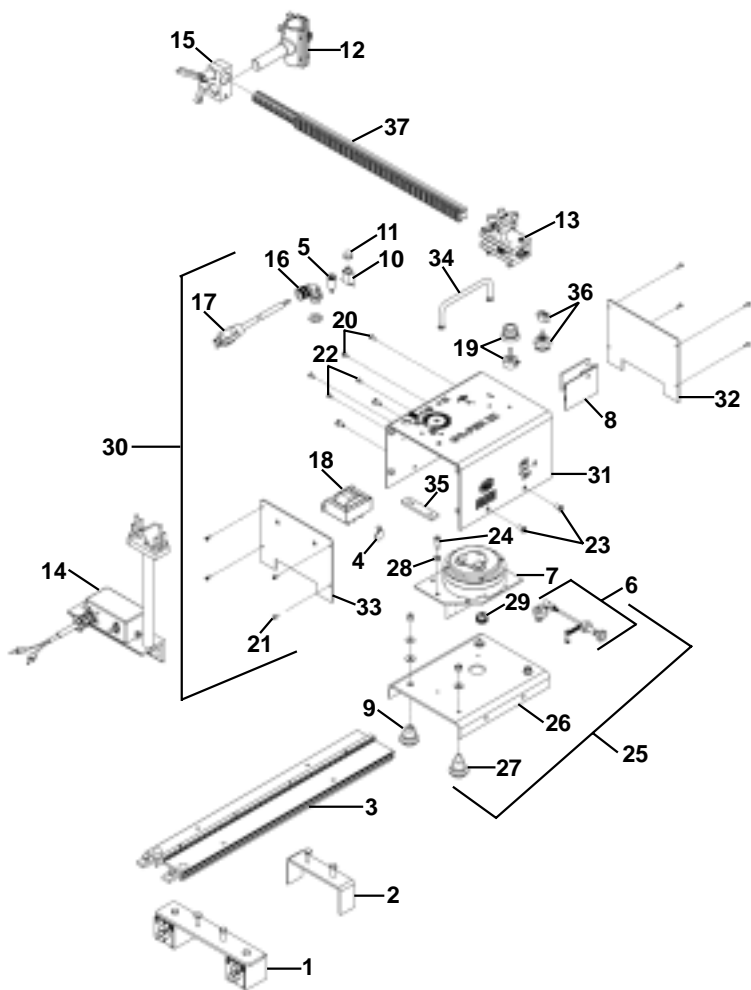
Magnet Holding Power: 100 lbs (45.4 kg)

Net Weight of Drive Unit: 17 lbs (7.7 kg)

Dimensions of Drive Unit: 10"L x 8"W x 13"H
(254 mm x 203 mm x 257 mm)

Rail: (Ordered Separately) 4' (1.8 m) ARR-1085
8' (2.37m) ARR-1080

EXPLODED VIEW / GO-FER III-PL



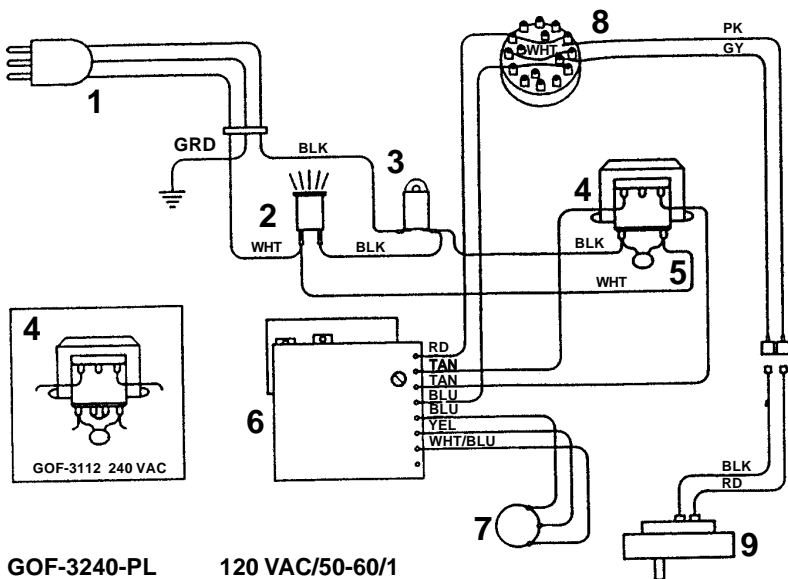
PARTS LIST / GO-FER III-PL

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
** 1	ARM-2500	On/Off Magnet Plate Assy.
** 2	ARM-2505	Spacer Bar Assy.
** 3	ARR-1080	H.D. Rigid Rail 93.50" (2.37 m)
* 4	BUG-1393	Volt Trap 120 VAC
* 5	BUG-1415	Pilot Light 120 VAC
6	BUG-1605	Cam Clutch Assy.
7	BUG-1625-D	Drive Unit (80:1) [Includes Item #29]
8	BUG-1725	Speed Control
9	BUG-1982	External Adjustable Leg & Wheel Assy.
* 10	BUG-2923	Circuit Breaker w/Reset .7A
11	BUG-2924	Reset Button Seal
12	BUG-5188	Torchholder Assy.
13	BUG-5451	Rackholder w/Short Handle
14	BUG-5485	Contactora / Cable Anchor
15	BUG-5462	Right Angle Clamp
16	BUG-9103	Cord Grip
* 17	BUG-9445	Power Cord 120 VAC
* 18	BUG-9675	Transformer 120 VAC
19	BUG-9686	Potentiometer Control & Knob
20	FAS-0112	Pan Hd Scr 6-32 x 1/4"
21	FAS-0114	Pan Hd Scr 6-32 x 3/8"
22	FAS-0124	Pan Hd Scr 8-32 x 3/8"
23	FAS-0155	Pan Hd Scr 1/4-20 x 1/2"
24	FAS-0654	Soc Hd Shd Scr 5/16 x 3/8"
25	GOF-3001	Carriage Assy. [Includes Items 6, 9, 24, 26, 27, 28]
26	GOF-3002	Carriage Plate
27	GOF-3003	Fixed Leg & Wheel Assy.
28	GOF-3008	Spacer
29	GOF-3014	Drive Pinion
30	GOF-3015-HS	Enclosure Assy. [Includes Items 4, 5, 8, 10, 11, 15, 17, 18, 19, 20, 21, 22, 31, 33, 34, 36]
31	GOF-3016	Cover
32	GOF-3017	End Plate
33	GOF-3018	Rear End Plate
34	GOF-3019	Handle
35	GOF-3022	Back-Up Plate
36	MUG-1192	Rotary Switch w/Knob 3 Position
37	PAN-1015	Rack 22.63" (574 mm)

*See Electrical Component Chart for 240 VAC and 42 VAC part numbers.

**These items are supplied with GO-FER-PL Deluxe Kits.

WIRING DIAGRAM / GO-FER III-PL

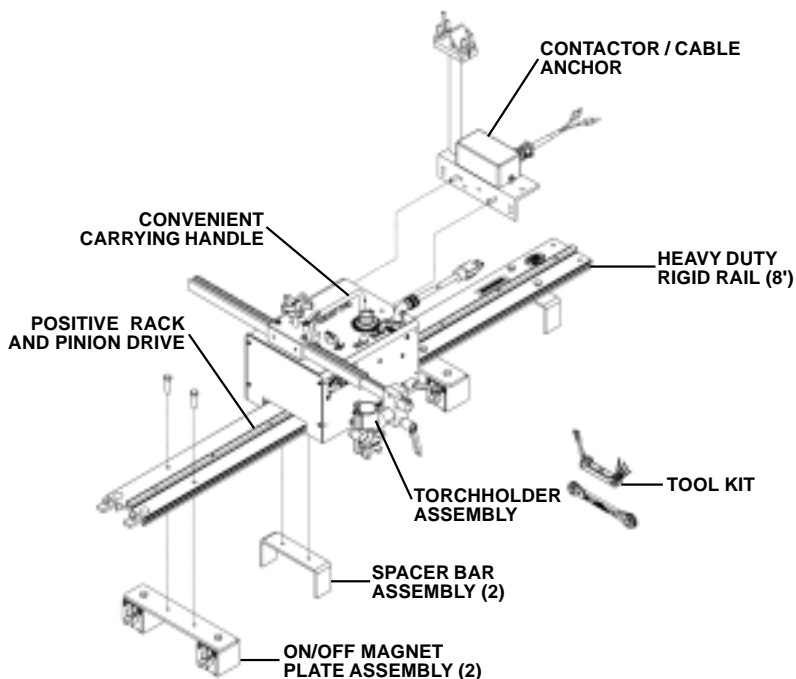


GOF-3240-PL 120 VAC/50-60/1
GOF-3242-PL 240 VAC/50-60/1
GOF-3244-PL 42 VAC/50-60/1

ELECTRICAL COMPONENT CHART

ITEM	DESCRIPTION	PART NUMBER		
		GOF-3240-PL 120 VAC	GOF-3242-PL 240 VAC	GOF-3244-PL 42 VAC
1	Power Cord	BUG-9445	GOF-3115	BUG-9442
2	Pilot Light	BUG-1415	BUG-1428	BUG-1427
3	Circuit Breaker	BUG-2923 (.7A)	BUG-2952 (.5A)	BUG-2933 (2A)
4	Transformer	BUG-9675	GOF-3112	BUG-1466
5	Volt Trap	BUG-1393	BUG-1563	BUG-1393
6	Precision Speed Control	BUG-1725		
7	Potentiometer Control	BUG-9686		
8	Rotary Switch, 3 Position	MUG-1192		
9	Gear Motor	BUG-1590 (80:1)		

GO-FER III-PL / PLASMA KITS



GOF-3250-PL GO-FER III PLASMA KIT (120/50-60/1)

Includes:

1 GOF-3240-PL	GO-FER III w/Dynamic Brake
Includes:	8-100 ipm (203-2640 mm/min)
1 BUG-5485	Contactors / Cable Anchor
1 BUG-5451	Rackholder with Short Handle
1 PAN-1015	Rack 22.62" (574 mm)
1 BUG-5462	Right Angle Clamp
1 BUG-5188	Torchholder Assembly
1 BUG-9444	Tool Kit
1 ARR-1080	Heavy Duty Rigid Rail 93.50" (2.37 m)
2 ARM-2500	On-Off Magnet Plate Assembly
2 ARM-2505	Spacer Bar Assembly

GOF-3252-PL Same as above except
w/240 VAC GO-FER III
GOF-3242-PL

GOF-3254-PL Same as above except
w/42 VAC GO-FER III
GOF-3244-PL

Net Weight of Kit: 39 lbs. (17.7 kg)

Shipping Weight of Kit: 50 lbs. (22.7 kg)

OPERATING INSTRUCTIONS / SETUP

1. TRACK SETUP

Attach two **ARM-2500 “ON-OFF” Magnet Plate Assemblies (M)** one quarter of the length from each end of the track. The magnets hold the rail to a steel workpiece and give all position capability. Mount the **ARM-2505 Spacer Bar Assemblies (N)** between the **Magnet Plate Assemblies (M)** to provide additional rail support. Verify the workpiece is clean and free of contaminants such as rust and oil to insure maximum magnet holding power. The **ARR-1080** and **ARR-1085 Rails (L)** are supplied with a positive rail joining system that enables the user to construct a rail system of any length.

2. POSITIONING AND ADJUSTING THE MACHINE ON THE TRACK

Disengage the clutch by centering the clutch **Knob (A)** over the hole in the cover and pulling the knob out. This disengages the drive pinion. Slide the carriage wheels into the track V-grooves from the end of the track. The carriage will move smoothly along the track if the wheels are properly aligned.

The **GO-FER III** wheels are factory adjusted to fit **ARR-1080** rails. Wheel adjustment should be verified on older machines. Grasp the carriage sides. The wheels are too loose if the carriage can be moved from side to side. Use a finger to keep one of the wheels from rotating while manually pushing the carriage along the track. The wheels are adjusted too tight if firm finger pressure is not enough to prevent wheel rotation.

WHEEL ADJUSTMENT

The wheels along one side of the carriage have **Stainless Shim Washers (C)** underneath. These wheels are adjustable. Readjust these wheels (if necessary) by rotating the **Hex Bolt (B)** with a 1/2" (13 mm) wrench.

Gently push the clutch **Knob (A)** back into the case while gently rocking the machine forward and backward. This will engage the drive pinion. The rocking motion is necessary to insure proper gear mesh.

3. TORCH SET-UP

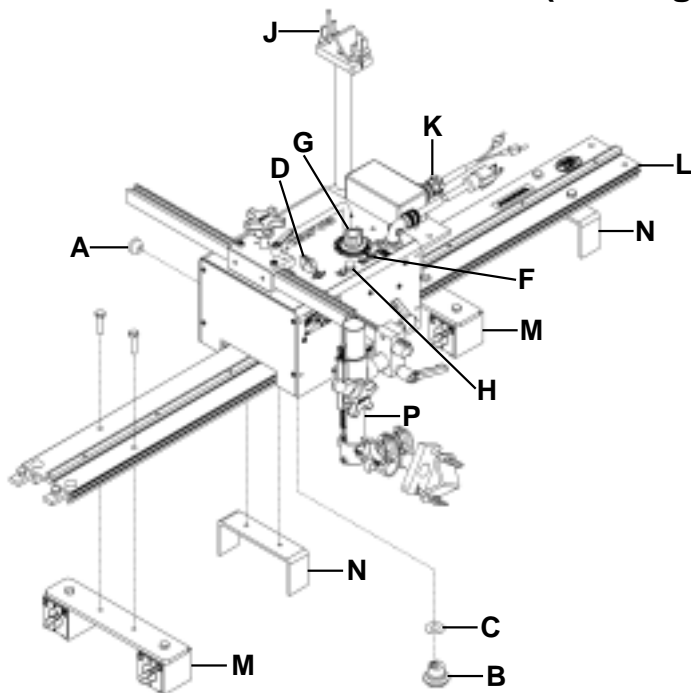
Insert the **Racking Group (P)** into the torch holder on the rack. Attach the rod, the clamp and the gun to the end of the vertical tube rack. Clamp welding gun into gun clamp. Adjust the racking system to set the gun to the desired position. Support the gun cable in the **Cable Anchor (J)** provided. The cable anchor acts as a strain relief to keep the supply cable from dragging the gun out of position. Connect the contactor circuit by crimping the two female connectors (supplied) to a 22-18 gauge, two-conductor cable from the trigger circuit of the feeder and plug them into the two leads on the plug of the **Contactor Control Box (K)**.

MACHINE OPERATION

Set **Switch (D)** to the center “**STOP**” position. Plug in the power cord. Verify the **Pilot Light (F)** comes on. Set **Switch (D)** to the forward or reverse position to begin forward or reverse travel. Adjust the travel speed using the **Speed Control (G)**.

The **Circuit Breaker (H)** protects the unit against overload or electrical faults. **CAUTION: IF THE CIRCUIT BREAKER OPENS, FIND AND CORRECT THE CAUSE BEFORE RESETTING.**

GO-FER III-WD / TECHNICAL DATA (Welding)



Power Requirement: - 60 watts at rated voltage:

GOF-3240-WD	(WELDING)	120 VAC/50-60/1
GOF-3242-WD	(WELDING)	240 VAC/50-60/1
GOF-3244-WD	(WELDING)	42 VAC/50-60/1

Tavel Speed: Infinitely variable from 2-50 ipm (50-1250 mm/min)

Load Capacity: 30 lbs (14 kg) vertical
100 lbs (45 kg) horizontal

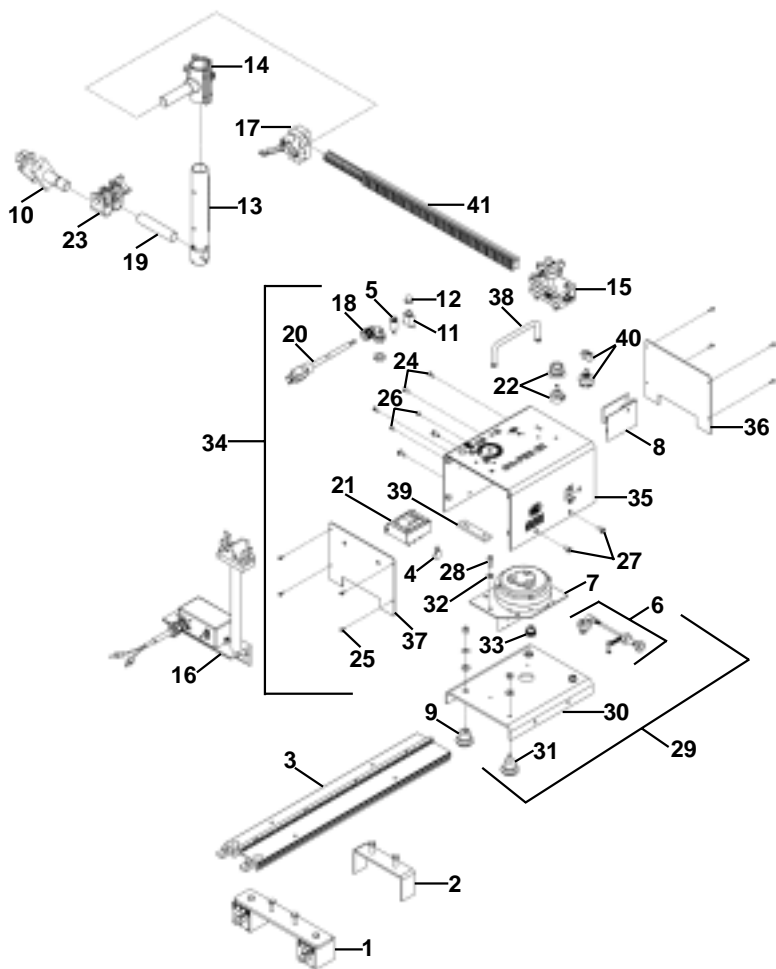
Magnet Holding Power: 100 lbs (45.4 kg)

Net Weight of Drive Unit: 17 lbs (7.7 kg)

Dimensions of Drive Unit: 10"L x 8"W x 13"H
(254 mm x 203 mm x 257 mm)

Rail: (Ordered Separately) 4' (1.8 m) ARR-1085
8' (2.37m) ARR-1080

EXPLODED VIEW / GO-FER III-WD



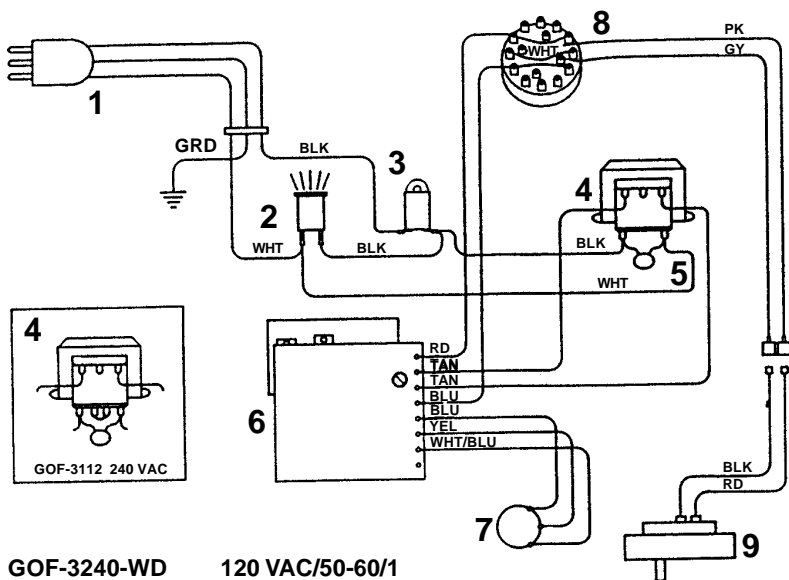
PARTS LIST / GO-FER-WD

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
** 1	ARM-2500	On/Off Magnet Plate Assy.
** 2	ARM-2505	Spacer Bar Assy.
** 3	ARR-1080	H.D. Rigid Rail 93.50" (2.37 m)
* 4	BUG-1393	Volt Trap 120 VAC
* 5	BUG-1415	Pilot Light 120 VAC
6	BUG-1605	Cam Clutch Assy.
7	BUG-1625-F	Drive Unit (150:1) [Includes Item #33]
8	BUG-1725	Speed Control
9	BUG-1982	External Adjustable Leg & Wheel Assy.
10	BUG-2708	Fits All Clamp
* 11	BUG-2923	Circuit Breaker w/Reset .7A
12	BUG-2924	Reset Button Seal
13	BUG-5166-8	H.D. Tube Rack w/Clamp
14	BUG-5188	Torchholder Assy.
15	BUG-5451	Rackholder w/Short Handle
16	BUG-5485	Contactors / Cable Anchor
17	BUG-5462	Right Angle Clamp
18	BUG-9103	Cord Grip
19	BUG-9180-4	Rod 7/8" x 4"
* 20	BUG-9445	Power Cord 120 VAC
* 21	BUG-9675	Transformer 120 VAC
22	BUG-9686	Potentiometer Control & Knob
23	CON-1020	Swivel Clamp
24	FAS-0112	Pan Hd Scr 6-32 x 1/4"
25	FAS-0114	Pan Hd Scr 6-32 x 3/8"
26	FAS-0124	Pan Hd Scr 8-32 x 3/8"
27	FAS-0155	Pan Hd Scr 1/4-20 x 1/2"
28	FAS-0654	Soc Hd Shd Scr 5/16 x 3/8"
29	GOF-3001	Carriage Assy. [Includes Items 6, 9, 28, 30, 31, 32]
30	GOF-3002	Carriage Plate
31	GOF-3003	Fixed Leg & Wheel Assy.
32	GOF-3008	Spacer
33	GOF-3014	Drive Pinion
34	GOF-3015-HS	Enclosure Assy. [Includes Items 4, 5, 8, 10, 11, 18, 20, 21, 22, 24, 25, 26, 35, 37, 38, 40]
35	GOF-3016	Cover
36	GOF-3017	End Plate
37	GOF-3018	Rear End Plate
38	GOF-3019	Handle
39	GOF-3022	Back-Up Plate
40	MUG-1192	Rotary Switch w/Knob 3 Position
41	PAN-1015	Rack 22.63" (574 mm)

*See Electrical Component Chart for 240 VAC and 42 VAC part numbers.

**These items are supplied with GO-FER-WD Deluxe Kits.

WIRING DIAGRAM / WELDING

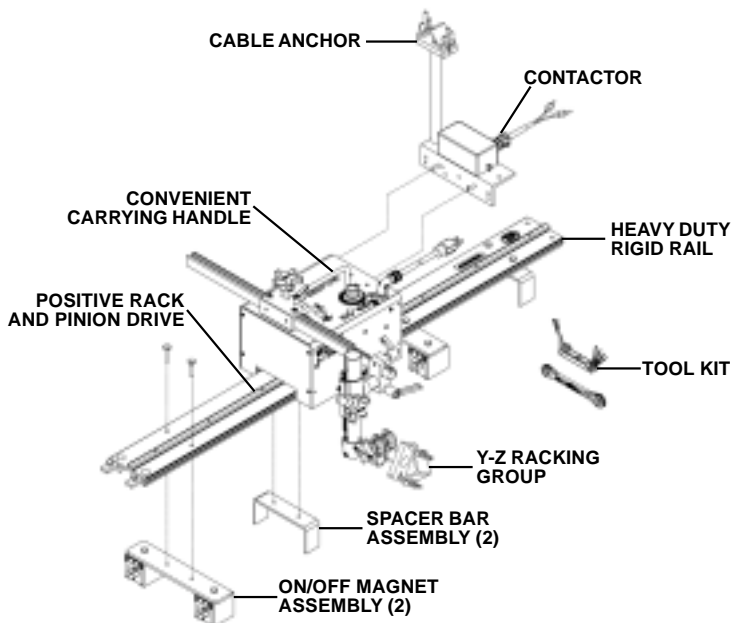


GOF-3240-WD 120 VAC/50-60/1
 GOF-3242-WD 240 VAC/50-60/1
 GOF-3244-WD 42 VAC/50-60/1

ELECTRICAL COMPONENT CHART

ITEM	DESCRIPTION	PART NUMBER		
		GOF-3240-WD 120 VAC	GOF-3242-WD 240 VAC	GOF-3244-WD 42 VAC
1	Power Cord	BUG-9445	GOF-3115	BUG-9442
2	Pilot Light	BUG-1415	BUG-1428	BUG-1427
3	Circuit Breaker	BUG-2923 (.7A)	BUG-2952 (.5A)	BUG-2933 (2A)
4	Transformer	BUG-9675	GOF-3112	BUG-1466
5	Volt Trap	BUG-1393	BUG-1563	BUG-1393
6	Precision Speed Control	BUG-1725		
7	Potentiometer Control	BUG-9686		
8	Rotary Switch, 3 Position	MUG-1192		
9	Gear Motor	BUG-1550 (150:1)		

GO-FER-WD / WELDING KITS



GOF-3250-WD GO-FER III WELDING KIT (120/50-60/1)

Includes:

- | | |
|------------------|---------------------------------------|
| 1 GOF-3240-WD | GO-FER III w/Dynamic Brake |
| Includes: | 2-50 ipm (50-1270 mm/min) |
| 1 BUG-5485 | Contactors / Cable Anchor |
| 1 BUG-5451 | Rackholder with Short Handle |
| 1 PAN- 1015 | Rack 22.62" (574 mm) |
| 1 BUG-5462 | Right Angle Clamp |
| 1 BUG-5188 | Torchholder Assembly |
| 1 BUG-9444 | Tool Kit |
| 1 BUG-5166-8 | 8" Tube Rack w/ Clamp |
| 1 BUG-2708 | Fits-All Clamp |
| 1 BUG-9180-4 | Rod 7/8" x 4" |
| 1 CON-1020 | Swivel Clamp |
| 1 ARR-1080 | Heavy Duty Rigid Rail 93.50" (2.37 m) |
| 2 ARM-2500 | On-Off Magnet Plate Assembly |
| 2 ARM-2505 | Spacer Bar Assembly |

GOF-3252-WD Same as above except
w/240 VAC GO-FER III
GOF-3242-WD

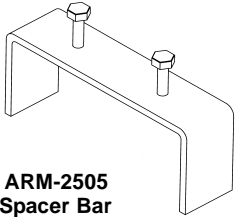
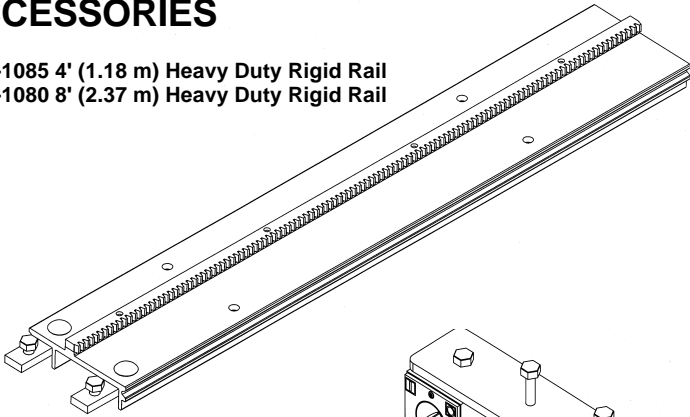
GOF-3254-WD Same as above except
w/42 VAC GO-FER III
GOF-3244-WD

Net Weight of Kit: 39 lbs. (17.7 kg)

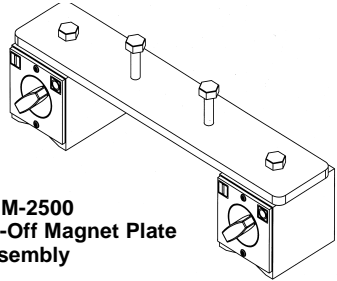
Shipping Weight of Kit: 50 lbs. (22.7 kg)

ACCESSORIES

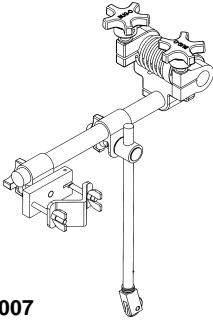
ARR-1085 4' (1.18 m) Heavy Duty Rigid Rail
ARR-1080 8' (2.37 m) Heavy Duty Rigid Rail



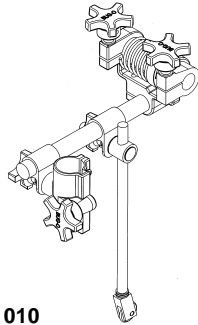
ARM-2505
Spacer Bar



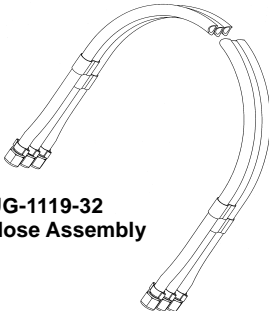
ARM-2500
On-Off Magnet Plate
Assembly



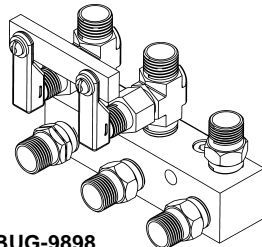
PAN-1007
Panograph Assembly With
Fits-All Clamp (For Other Torches)



PAN-1010
Panograph Assembly With
Torchholder (For U.S.A. Torches)

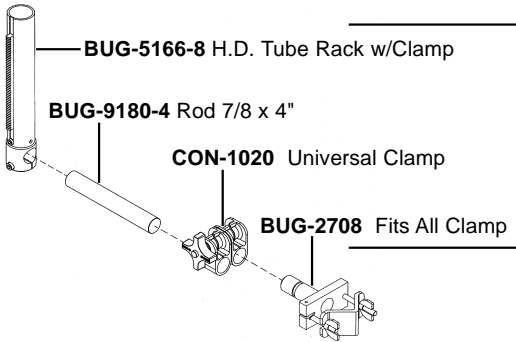


MUG-1119-32
3-Hose Assembly



BUG-9898
3-Hose Quick-Acting
Manifold

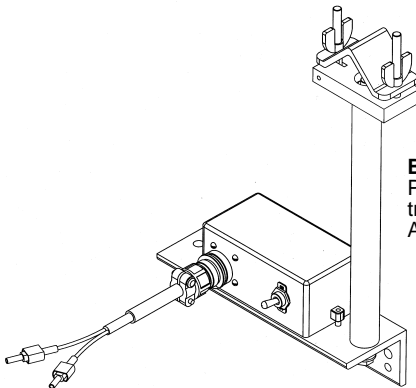
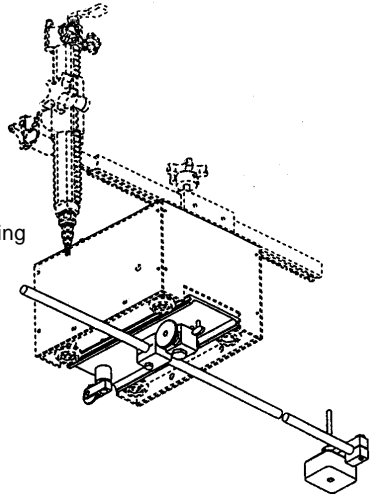
ACCESSORIES



**GOF-3255
Welding Support Kit**
The addition of this item provides a vertical racking motion for hand held guns.

GOF-3142 Radius Cutting Attachment:
Enables GO-FER III H.S. to be quickly changed from a straight line to a circle-cutting machine.

Size Range: 8" to 96"
(203 mm to 2438 mm) diameter.



BUG-5485 Contactor/Cable Anchor:
Provides built-in contactor switch to control plasma or welding process. The Cable Anchor provides strain relief for all cables.

TROUBLESHOOTING GUIDE

PROBLEM	CAUSE	REMEDY
Does not run, indicator light off.	No power to machine.	Check power line supply voltage. Plug in line cord firmly.
Does not run, indicator light off. Circuit breaker tripped.	Wiring shorts. Shorted motor. Faulty speed control board. Burned out transformer.	Disconnect machine and examine internally; rewire at fault. If none found, throw direction switch to "OFF", reset breaker and plug in: If breaker does not trip, replace drive unit. If breaker trips again, replace control board. (OR) Replace transformer.
Does not run, indicator light on.	Bad connection. control board. Faulty speed control board.	Check wiring connections, 12 VAC should appear across secondary of transformer. Tighten terminal screws on speed If DC Volts = 0 across leads to motor; replace control board.
Unit runs, but no control over speed.	Faulty speed control board.	Replace control board. (Check connection first).

NOTE: Make sure unit is plugged into correct voltage, (120 VAC, 240 VAC, 42 VAC) corresponding to Model No. rating.

12 VAC should appear across secondary of transformer in all GO-FER III Drive Units.

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.

NOTES