



## **FEED UNIT MANUAL**

**FASTFEED**

**POWERFEED**

**XL FEED**

**BU40**

**SITE FEEDER**

## This range of feed units

We have modulated our range of feed units to allow you to add optional extras to the unit to the specific operational needs required. In the range we offer from the economy unit through to the top model having Parvalux motors supplying the driving power to the drive system. They will fit most standard power sources. Having worked with Parvalux for a number of years our collaboration has allowed us to provide the best drive system in a feed unit. Below is a statement provided by Parvalux .



Parvalux as a renowned international producer of electric drive motors is pleased to be associated with Butters UK in supplying motors for their feed units. For over forty years we have supplied Butters with different types of motors and gearboxes. We are aware of our motors lasting over seven years in feed units which more than compensate the user for buying a quality feed unit from Butters UK. Both Parvalux and Butters UK are British companies so are able to give you first class back up service by UK people employed here in the UK. Good cooperation between our companies allows us to give you the best drive system available. We fit roller bearings in the motors and gearboxes for long life and smooth running. Easy access to change the motor brushes as and when they wear. At Parvalux we are confident that you will have excellent service from the Butters feed units with our motors and gearboxes for many years.

Parvalux Electric Motors Ltd

# XL FEED



This is the smallest in performance as it has four roll drive system which is driven by a 24volt 50 watt motor. Wire sizes range from 0.6 to 1.2mm. Wire speed is 0 to 22mpm. It has two controls wire speed and burnback. Input voltages available are 110-42-24vac. The frame case and pcb are all common to these feedunits.

Input voltage	Wire size mm	Wire speed	latch	Gas purge	Wire inch	Burn back	Reel size	Net weight	H W L
110 42 24	0.6-1.2	0-22 m/min	NO	NO	NO	YES	300M M	12KGS	240 245 480

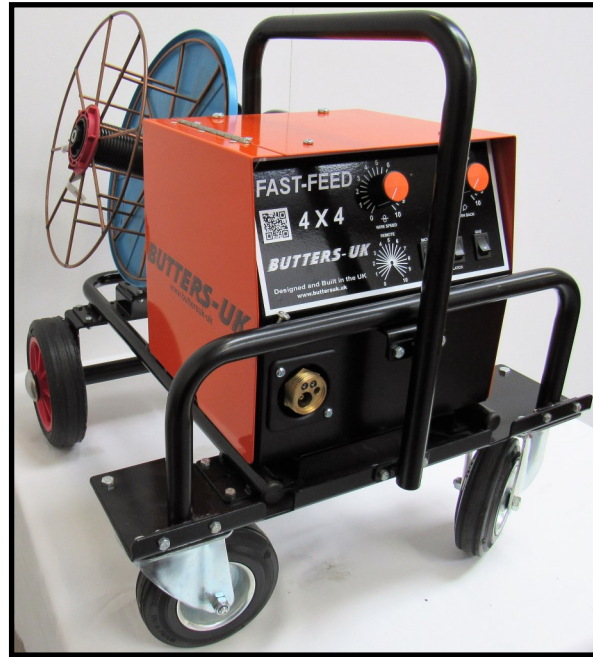
## POWER FEED



This unit is the next model up from the XL feed. With this unit it has the same case and frame as the others but has the 4 roll heavy duty drive system. Wire speed is 0-24mpm. The motor power is 24vdc 75watts. Front panel controls are wire speed, burnback, gas purge, inch, and latch. All drive rolls are gear driven and have two wire sizes on the drive roll.

Input voltage	Wire size mm	Wire speed	latch	Gas purge	Wire inch	Burn back	Reel size	Net weight	H W L
110 42 24	0.6-1.6	0-24 m/min	YES	YES	YES	YES	300MM	12KGS	240 245 480

## FAST FEED



This unit is the top model in the feed unit range. With this unit it has the same case and frame as the others but has the 4 roll heavy duty drive system with a British made Parvalux motor. Wire speed is 0-26mpm. The motor power is 24vac 110watts 5000RPM. The motor has changeable brushes and roller bearings at the front and rear of the motor. It is the best motor fitted to any feed unit. Front panel controls are wire speed, burnback, gas purge, inch, and latch. All drive rolls are gear driven and have two wire sizes on the drive roll. Options shown on this unit are RTW wheels, crash bars, and wire reel protection.

Input voltage	Wire size mm	Wire speed	latch	Gas purge	Wire inch	Burn back	Reel size	Net weight	H W L
110 42 24	0.6-2.4	0-26 m/min	YES	YES	YES	YES	300 MM	12KGS	240 245 480

## BU-40



This unit has been designed to fit the Kemppi 3500 and 5000 power sources. With this unit it has the same case and frame as the others but has the 4 roll heavy duty drive system with a 24vac 75watt motor. Wire speed is 0-24mpm. Front panel controls are wire speed, burnback, gas purge, inch, and latch. All drive rolls are gear driven and have two wire sizes on the drive roll. This unit is different by having a 10 pin panel plug fitted to allow the old Kemppi feed unit being disconnected and this one being connected with the same connections. Inside is a small pcb fitted to the standard pcb which is used in the other feedunits. Optional extras include 50mm or 160mm wheels, water cool adaptor, reel cover, and crash bars. Built to last.

Input voltage	Wire size mm	Wire speed	latch	Gas purge	Wire inch	Burn back	Reel size	Net weight	H W L
24	0.6-1.6	0-24 m/min	YES	YES	YES	YES	300MM	12KGS	240 245 480

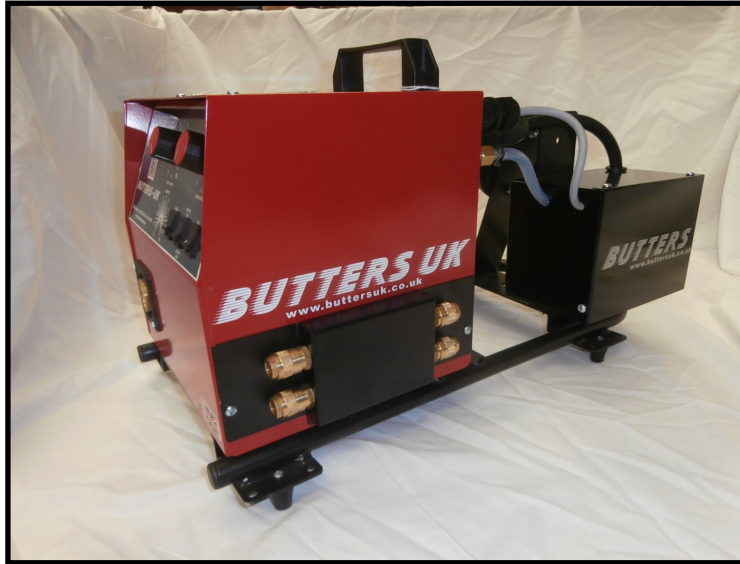
## BU-MIL



This unit has been designed to fit the Miller power sources. With this unit it has the same case and frame as the others but has the 4 roll heavy duty drive system with a 24vac 75watt motor. Wire speed is 0-24mpm. Front panel controls are wire speed, burnback, gas purge, inch, latch and remote. All drive rolls are gear driven and have two wire sizes on the drive roll. This unit is different by having a 14 pin panel plug fitted to allow the old Miller feed unit being disconnected and this one being connected with the same connections.

Input voltage	Wire size mm	Wire speed	latch	Gas purge	Wire inch	Burn back	Reel size	Net weight	H W L
24	0.6-1.6	0-24 m/min	YES	YES	YES	YES	300MM	12KGS	240 245 480

## SITE FEED UNIT



This unit has been designed to work with welder generator power sources. With this unit it has the same case and frame as the others but has the 4 roll heavy duty drive system with a 24vac 75watt motor. Wire speed is 0-24mpm. Front panel controls are wire speed, burnback, gas purge, inch, and latch. All drive rolls are gear driven and have two wire sizes on the drive roll. This unit is different by having a control box fitted. It works from the 110v aux take off, thus it is not affected by the ocv voltage varying the motor speed. The welding cable fits to the positive output on the generator. It can be used with gas or gas-less wires. When the welding stops the wire is non live. The standard pcb which is used in the other feed units is also used in this unit.

Input voltage	Wire size mm	Wire speed	latch	Gas purge	Wire inch	Burn back	Reel size	Net weight	H W L
110 42 24	0.6-1.6	0-24 m/ min	YES	YES	YES	YES	300MM	12KGS	240 245 480



01/01/2016

ISSUE A

POT FROM BACK POT

WHITE RIGHT	W/SPEED
PINK CENTER	1K W/SPEED
ORANGE LEFT	W/SPEED

RED RIGHT	10K BURNBACK
WHITE CENTER	BURNBACK

BLACK REAR	SPOTWELD
BROWN CENTER	100K SPOTWELD
WHITE LEFT	SPOTWELD
WHITE/ORANGE REAR LEFT TOP	

LATCH SWITCH TOP

BLUE	LATCH
PINK	LATCH
BLACK	LATCH
CUT LINK ON BACK	
FOR LATCH OPERATION	

CUT LINK ON BACK BETWEEN 3 AND 4 FOR FLOW SWITCH OPERATION

## BUTTERS - UK

NBC-1 PCB CONNECTION

24V / 42V  
TO TO

LEFT SIDE	RIGHT SIDE
1 PCB PINK	1 PCB WHITE
2 PCB WHITE	2 PCB WHITE
3 PCB ORANGE	3 PCB YELLOW
	4 PCB YELLOW
4 PCB RED	
5 PCB WHITE	5 PCB BLUE
	6 PCB BLUE
6 PCB BLACK	
7 PCB BROWN	7 PCB GREY
8 PCB ORANGE	8 PCB GREY
9 PCB BLACK	9 PCB RED
10 PCB BLUE	10 PCB BLACK
11 PCB PINK	COMMON
12 EMPTY	11 PCB PURPLE
	12 PCB PURPLE
1 PCB GUN	BLACK
2 PCB GUN	BLACK
3 PCB FLOW-	BLACK
4 PCB FLOW-	BLACK
5 PCB AC/DC ! 24V 42V*	RED
6 PCB AC/DC ! 24V 42V*	BLUE
<b>BOTTOM</b>	<b>* DEPENDS ON PCB INPUT VOLTAGE</b>
6 WAY	

! DEPENDS ON PCB LINK SELECTION \* DEPENDS ON PCB INPUT VOLTAGE

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AUX TRANS AC IN 0V  
AUX TRANS AC IN 24V /42V  
GAS SOL  
GAS SOL

GAS PURGE  
GAS PURGE

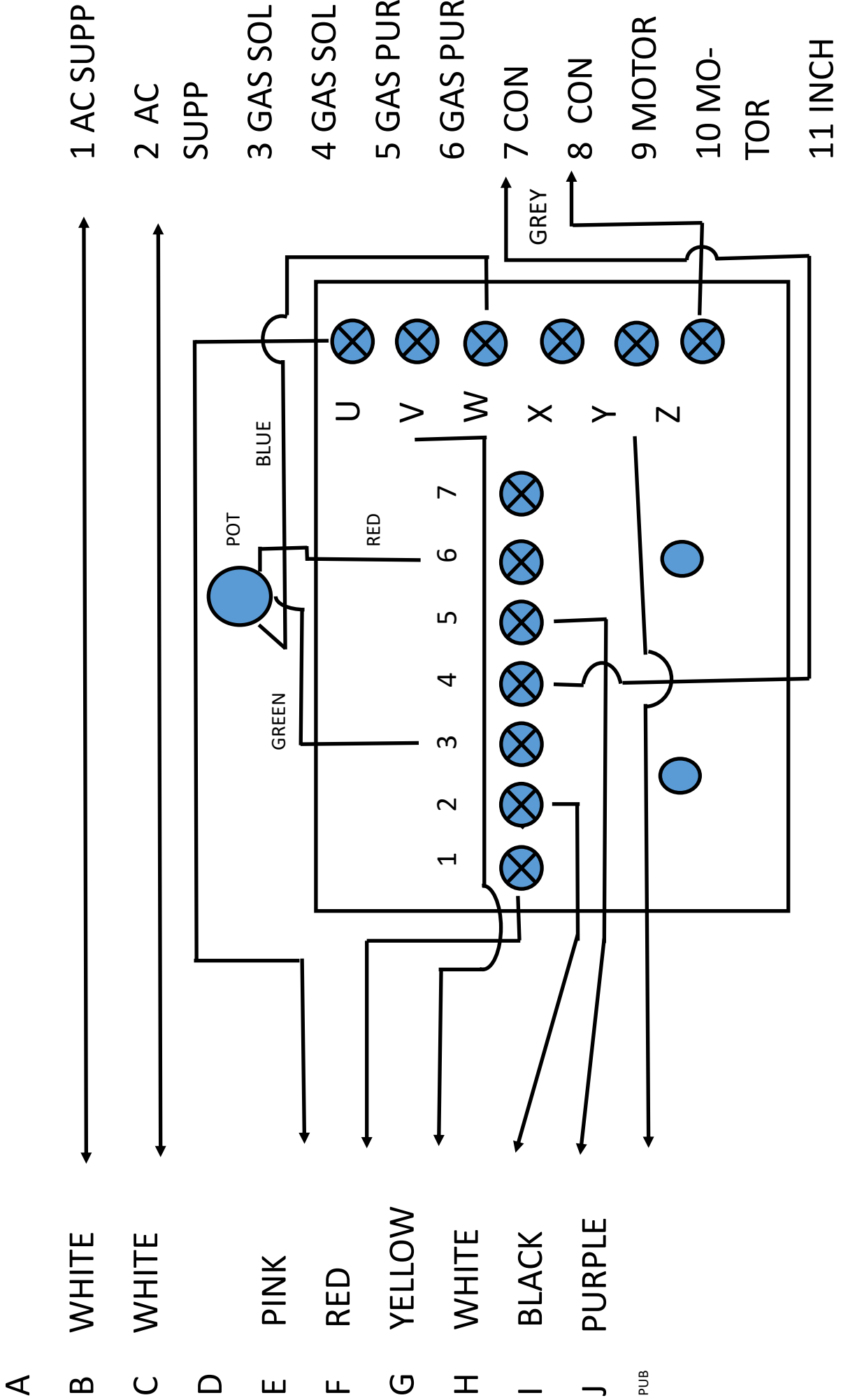
CONTACTOR  
AUX TRANS MAIN TRANS,  
RECTIFIER, CONTACTOR

MOTOR  
MOTOR

INCH  
INCH

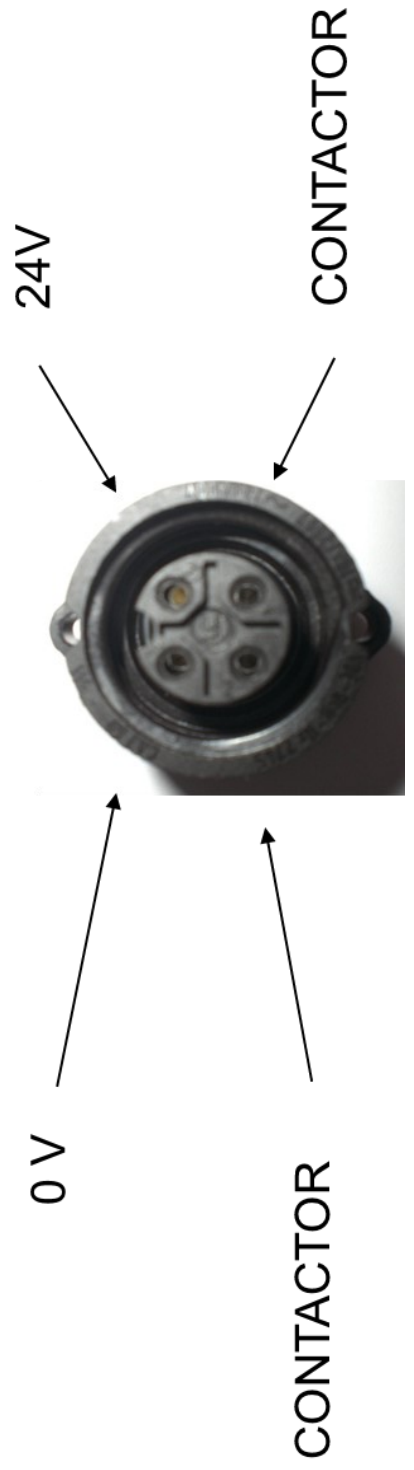
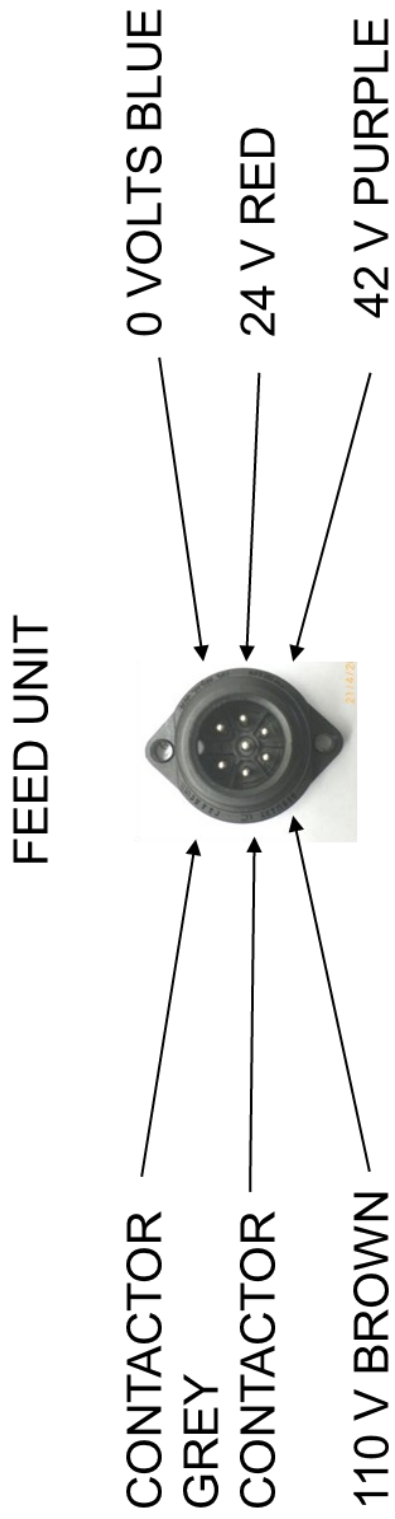
10 PIN INPUT SOCKET

PCB NBC-5-2



BUTTERS-UK FEED UNIT BU 40 CONNECTION DETAILS

# BUTTERS-UK PIN CONNECTIONS CLOCKWISE





UNIT 8 PRIMROSE HILL TRADING ESTATE

CRADLEY Rd NETHERTON DUDLEY

DY2 9SA

## EC Declaration of Conformity

### Standard Route to Compliance

Declare under our sole responsibility that the product

Mig Feed Unit

To which this declaration relates is in conformity with the following transposing  
harmonised standards

Directive	Test Name	Standard	Year
EMC Directive 89/336/EEC	Generic Emissions	EN50081-1	1992
	Generic Immunity	EN50082-2	1995

And therefore is in conformity with the production requirement of council directive  
89/336/EEC on the approximation of laws of the member states relating to  
Electromagnetic compatibility

Signed 

Date 01/12/1996