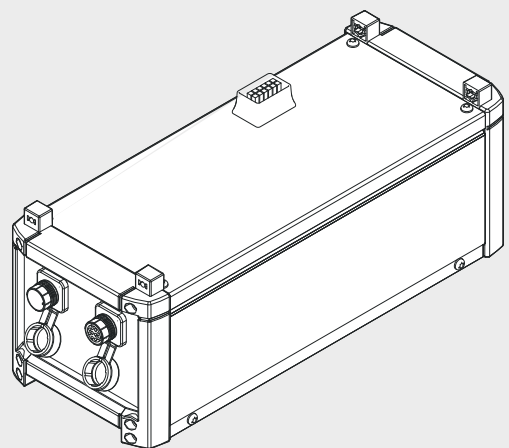




KD Supply 2500



Operating instructions



42,0426,0049,EN 002-09112021

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General

Introduction

Thank you for the trust you have placed in our company and congratulations on buying this high-quality Fronius product. These instructions will help you familiarise yourself with the product. Reading the instructions carefully will enable you to learn about the many different features it has to offer. This will allow you to make full use of its advantages.

Please also note the safety rules to ensure greater safety when using the product. Careful handling of the product will repay you with years of safe and reliable operation. These are essential prerequisites for excellent results.

Explanation of safety notices

DANGER!

Indicates immediate danger.

- ▶ If not avoided, death or serious injury will result.
-

WARNING!

Indicates a potentially hazardous situation.

- ▶ If not avoided, death or serious injury may result.
-

CAUTION!

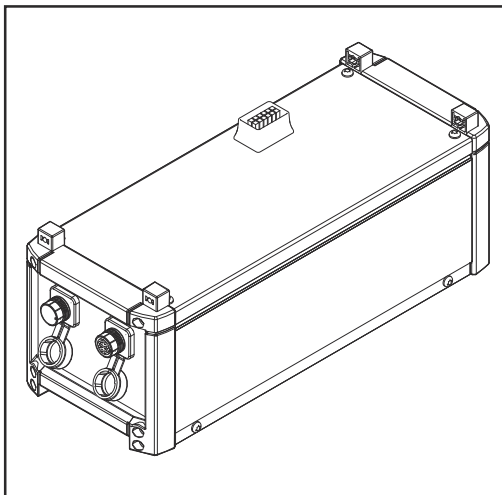
Indicates a situation where damage or injury could occur.

- ▶ If not avoided, minor injury and/or damage to property may result.
-

NOTE!

Indicates a risk of flawed results and possible damage to the equipment.

Machine concept



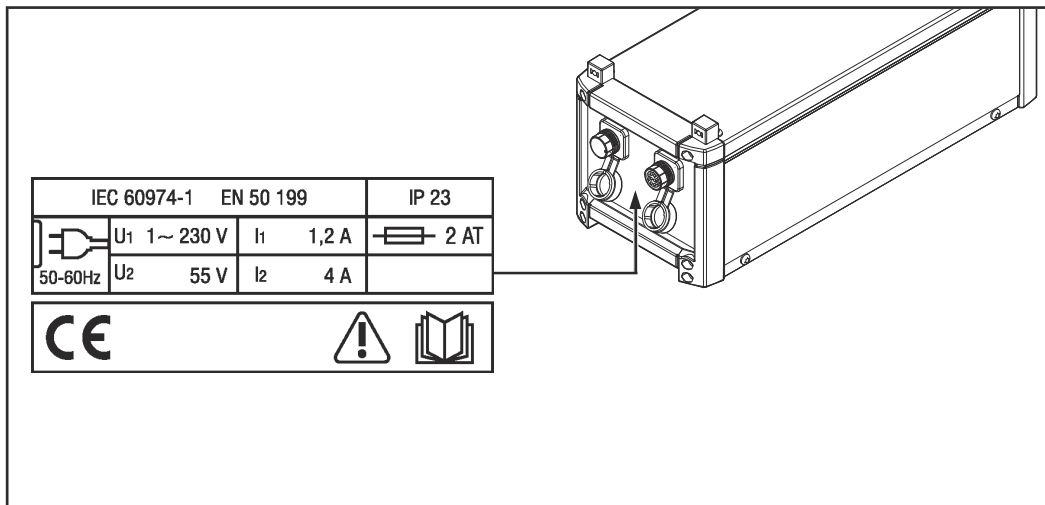
KD Supply 2500

The KD Supply 2500 enables the TIG power sources TT 2500 / 3000 Job and MW 2500 / 3000 Job to be used with a cold wire feeder. The built-in switched-mode power supply supplies the feeder motor.

The KD Supply 2500 simultaneously functions as an active LocalNet distributor. In addition to providing an interface to the cold wire feeder, the KD Supply 2500 also has an additional LocalNet interface, e.g. for a remote control unit.

Safety symbols on the rating plate

The KD Supply 2500 has safety symbols on the rating plate. The safety symbols must NOT be removed or painted over. The symbols warn against operating the equipment incorrectly, which can cause serious injury and damage.



Welding is dangerous. The following basic requirements must be met:

- Welders must be sufficiently qualified
- Suitable protective equipment
- Keep all persons not involved in the welding process at a safe distance

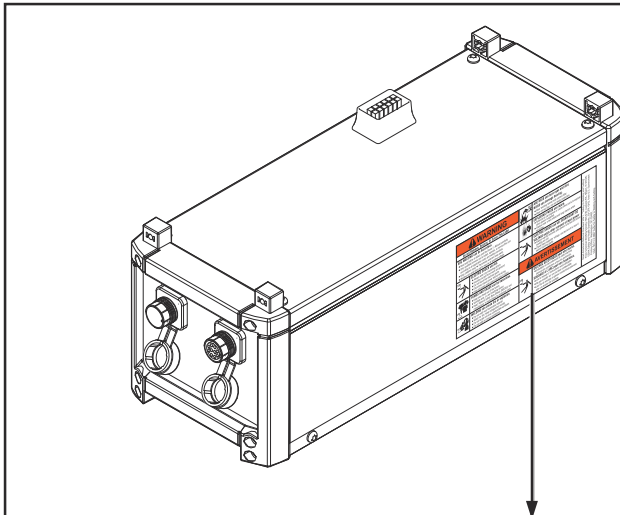






Do not use the functions described here until you have read and completely understood all of the following documents:

- these Operating Instructions
- all the Operating Instructions for the system components, especially the safety regulations

Warning notices affixed to the machine

Machines destined for the USA have additional warning notices. The warning notices must NOT be removed or painted over.



| | | | |
|--|--|---|--|
| ! WARNING | |  <p>ARC RAYS can burn eyes and skin; NOISE can damage hearing.</p> <ul style="list-style-type: none"> • Wear welding helmet with correct filter. • Wear correct eye, ear and body protection. | <p>Do not Remove, Destroy, Or Cover This Label</p> |
| <p>ARC WELDING can be hazardous.</p> <ul style="list-style-type: none"> • Read and follow all labels and the Owner's Manual carefully • Only qualified persons are to install, operate, or service this unit according to all applicable codes and safety practices. • Keep children away. • Pacemaker wearers keep away. • Welding wire and drive parts may be at welding voltage. | | | |
|  | <p>ELECTRIC SHOCK can kill.</p> <ul style="list-style-type: none"> • Always wear dry insulating gloves. • Insulate yourself from work and ground. • Do not touch live electrical parts. • Disconnect input power before servicing. • Keep all panels and covers securely in place. | |  |
| | <p>EXPLODING PARTS can injure.</p> <ul style="list-style-type: none"> • Failed parts can explode or cause other parts to explode when power is applied. • Always wear a face shield and long sleeves when servicing. | | |
| ! AVERTISSEMENT | |  | <p>ELECTRIC SHOCK can kill; SIGNIFICANT DC VOLTAGE exists after removal of input power</p> <ul style="list-style-type: none"> • Always wait 60 seconds after power is turned off before working on unit. • Check input capacitor voltage, and be sure it is near 0 before touching parts. |
| <p>FUMES AND GASES can be hazardous.</p> <ul style="list-style-type: none"> • Keep your head out of the fumes. • Ventilate area, or use breathing device. • Read Material Safety Data Sheets (MSDSs) and manufacturer's instructions for materials used. | | | |
| <p>WELDING can cause fire or explosion.</p> <ul style="list-style-type: none"> • Do not weld near flammable material. • Watch for fire: keep extinguisher nearby. • Do not locate unit over combustible surfaces. • Do not weld on closed containers. | | <p>UN CHOC ELECTRIQUE peut etre mortel.</p> <ul style="list-style-type: none"> • Installation et raccordement de cette machine doivent etre conformes a tous les pertinents. <p>SOUDAGE A L'ARC peut etre hasardeux.</p> <ul style="list-style-type: none"> • Lire le manuel d'instructions avant utilisation. • Ne pas installer sur une surface combustible. • Les fils de soudage et pieces conductrices peuvent etre a la tension de soudage. | |

Read American National Standard Z49.1, "Safety in Welding and Cutting"
 From American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126;
 OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Government
 Printing Office, Washington, DC 20402.
 CSA, W117-2, MB7 Code for Safety in Welding and Cutting.

US machine with additional warning notices

Controls, connections and mechanical components

Safety



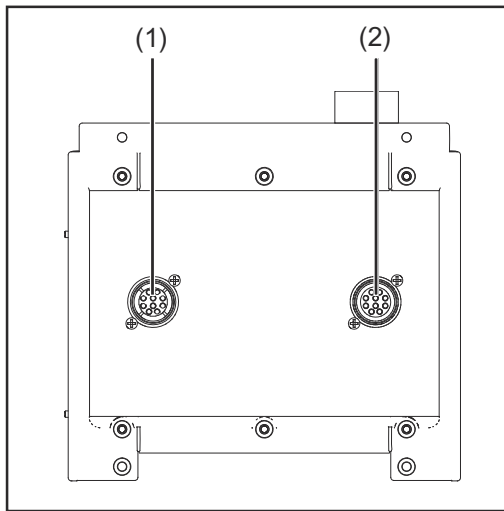
WARNING!

Danger from incorrect operation and work that is not carried out properly.

This can result in serious personal injury and damage to property.

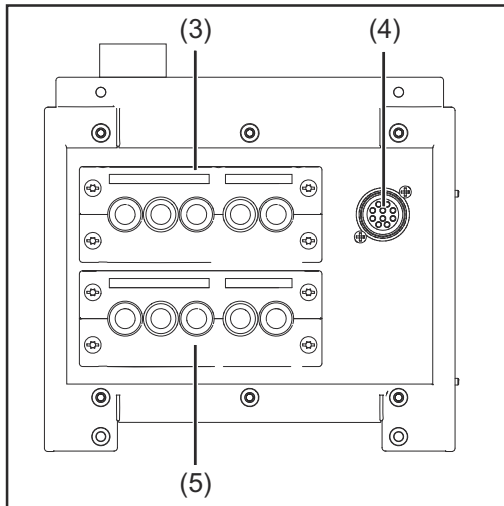
- ▶ All the work and functions described in this document must only be carried out by technically trained and qualified personnel.
- ▶ Read and understand this document in full.
- ▶ Read and understand all safety rules and user documentation for this device and all system components.

KD Supply 2500 - front



- (1) **LocalNet X9.1 interface**
Standard connection socket for the power source
- (2) **LocalNet X9.2 interface**
Standard connection socket for system add-ons (e.g. KD 4000-D, KD 7000-D, remote control, etc.)

KD Supply 2500 - rear



- (3) **Blanking cover**
- (4) **LocalNet X9.3 interface**
Standard connection socket for system add-ons (e.g. KD 4000-D, KD 7000-D, remote control, etc.)
- (5) **Blanking cover**

Fitting the KD Supply 2500 to the trolley

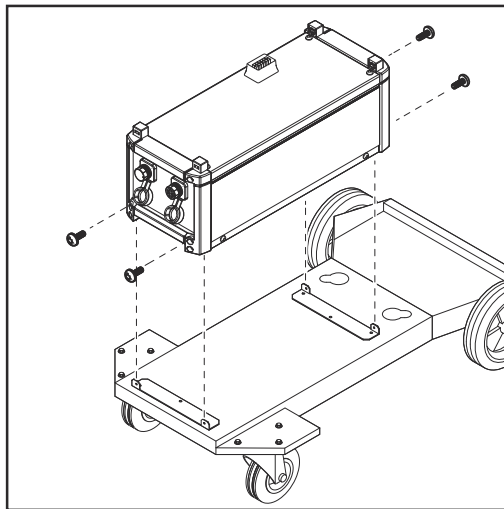
General remarks The welding system can be fitted to a trolley to increase the mobility of the system.

IMPORTANT!

If the welding system is not equipped with an auto-transformer or a cooling unit, the KD Supply 2500 must be installed right at the bottom.

- If a cooling unit is present, fit it right at the bottom and place the KD Supply on top of it.

Fitting the KD Supply 2500 to the base of the trolley



- 1** If there are no fastening brackets on the trolley:
Attach two fastening brackets to the base of the trolley and secure each one using three „Extrude-Tite“ screws.
- 2** Place the KD Supply 2500 on the base of the trolley.
- 3** Using „Extrude-Tite“ screws, fasten the KD Supply 2500 at the front and back to the fastening brackets on the base of the trolley.

Connecting the KD Supply 2500 to the cooling unit and power source

Safety

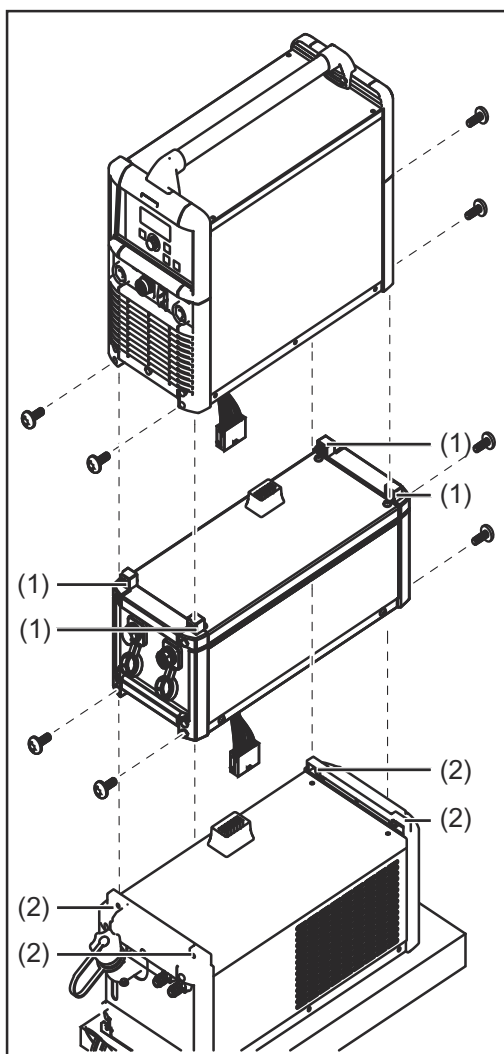
WARNING!

Danger from electrical current.

This can result in serious personal injury and damage to property.

- ▶ Before starting work, switch off all devices and components involved and disconnect them from the grid.
- ▶ Secure all devices and components involved so they cannot be switched back on.
- ▶ After opening the device, use a suitable measuring instrument to check that electrically charged components (such as capacitors) have been discharged.

Connecting the KD Supply 2500 to the cooling unit and power source



- 1 Turn the power source mains switch to the „O“ position
- 2 Unplug power source mains plug
- 3 Remove protective cover from the underside of the power source
- 4 Firmly press four M5 hexagonal nuts (supplied with the KD Supply 2500) from the inside into the hexagonal recesses (1) in the fastening bars

If a cooling unit is present:

- 5 Remove the protective cover from the underside of the KD Supply 2500
- 6 Firmly press four M5 hexagonal nuts (supplied with cooling unit) from the inside into the hexagonal recesses (2) in the fastening bars
- 7 Hold the KD Supply 2500 over the cooling unit
- 8 Pull the KD Supply 2500 connector as far as possible through the opening on the underside of the power source
- 9 Establish connection between KD Supply 2500 and cooling unit

CAUTION!

Risk of short circuit from kinked or damaged cables.

This can result in serious personal injury and damage to property.

- ▶ When positioning the KD Supply 2500, ensure that the cables are not kinked.

- 10 Carefully place the KD Supply 2500 on the cooling unit
- 11 Using two „Extrude-Tite“ screws, fasten the KD Supply to the fastening bars (2) on the front and back of the cooling unit
- 12 Position the power source over the KD Supply 2500 using a suitable hoisting device
- 13 Pull the power source connector as far as possible through the opening on the underside of the power source
- 14 Make connection between power source and cooling unit

⚠ CAUTION!

Risk of short circuit from kinked or damaged cables.

This can result in serious personal injury and damage to property.

- ▶ When positioning the KD Supply 2500, ensure that the cables are not kinked.

- 15 Carefully place power source on KD Supply 2500
- 16 Using two „Extrude-Tite“ screws, fasten the power supply to the fastening bars (1) on the front and back of the KD Supply 2500.

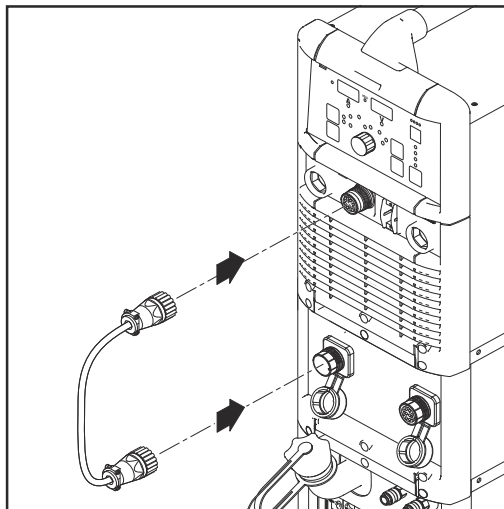
⚠ CAUTION!

Danger from machines falling or toppling over.

This can result in serious personal injury and damage to property.

- ▶ Ensure that all screw connections are secure.

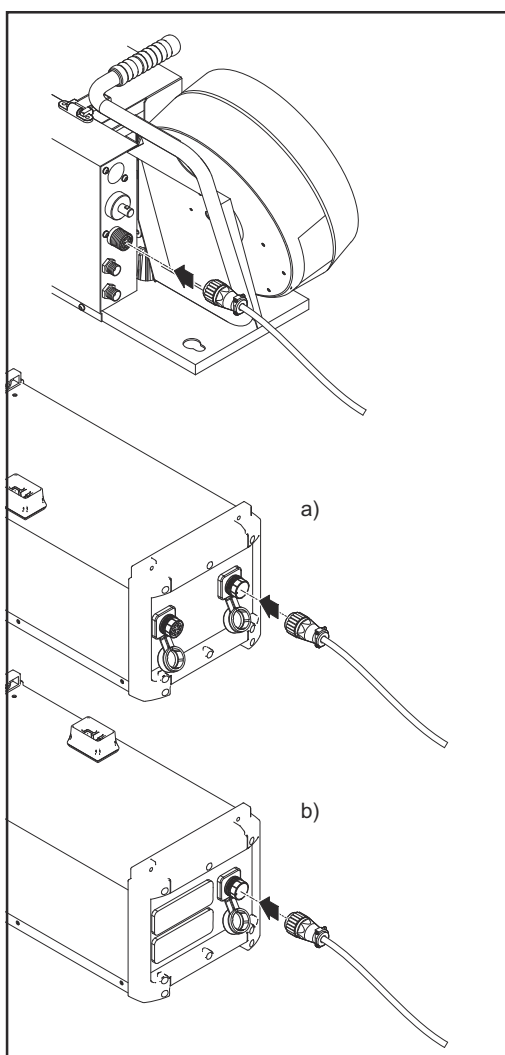
Establishing a LocalNet connection between the KD Supply 2500 and the power source



- 1 Connect the power source and the KD Supply 2500 using the LocalNet cable supplied with the KD Supply 2500:
 - Power source: LocalNet interface
 - KD Supply 2500: LocalNet X9.1 interface (front)

Connecting the KD Supply 2500 to the cold wire feeder, commissioning

Connecting the KD Supply 2500 to the cold wire feeder, commissioning



- 1 Connect the LocalNet cable or the LocalNet cable from the interconnecting hosepack to the LocalNet interface of the cold wire feeder
- 2 Connect the LocalNet cable or the LocalNet cable from the interconnecting hosepack to the KD Supply 2500:
 - a) LocalNet X9.2 interface (front) or
 - b) LocalNet X9.3 interface (rear)

Commissioning

Power for the KD Supply 2500 is supplied by the power source

- 1 Connect the power source and the cold wire feeder using the interconnecting hosepack
- 2 Connect the welding torch

Carry out steps 1 and 2 as described in the power source and cold wire feeder operating instructions

- 3 Plug in the power source mains lead
- 4 Turn power source mains switch to position „I“

The KD Supply 2500 is now ready.

Care, maintenance and disposal

General remarks Under normal operating conditions the KD Supply 2500 requires only a minimum of care and maintenance. However, it is vital to observe some important points to ensure the welding system remains in a usable condition for many years.



WARNING!

Danger from electrical current.

This can result in serious personal injury and damage to property.

- ▶ Before starting work, switch off all devices and components involved and disconnect them from the grid.
 - ▶ Secure all devices and components involved so they cannot be switched back on.
 - ▶ After opening the device, use a suitable measuring instrument to check that electrically charged components (such as capacitors) have been discharged.
-

Every start-up

- Check welding torch, interconnecting hosepack and ground earth connection for signs of damage
- Perform a visual check on the feed rollers and inner liners for signs of damage
- Check contact pressure of feed rollers and adjust if necessary
- Check brake and adjust if necessary

Every 6 months

- Dismantle device side panels and clean inside of device with dry, reduced compressed air



CAUTION!

Danger due to the effect of compressed air.

This can result in damage to property.

- ▶ Do not bring the air nozzle too close to electronic components.
-

Disposal Dispose of in accordance with the applicable national and local regulations.

Technical data

| | | |
|-----------------------|-------------------------|---|
| KD Supply 2500 | Mains voltage | 230 / 460 V |
| | Mains frequency | 50 / 60 Hz |
| | Primary current I_1 | 2,4 / 1,3 A |
| | Secondary voltage U_2 | 55 V |
| | Secondary current I_2 | 4 A |
| | Protection | IP 23 |
| | Measurements l x w x h | 625 x 240 x 225 mm 24.61 x 9.45 x 8.86 in. |
| | Weight | 4,7 kg 10.36 lb. |



Fronius International GmbH

Froniusstraße 1
4643 Pettenbach
Austria
contact@fronius.com
www.fronius.com

Under www.fronius.com/contact you will find the addresses
of all Fronius Sales & Service Partners and locations.