



WIRE FEEDER

MIJIT® 1000



PROCESS	MIG	FLUX CORED	PULSE MIG		
Part Number	Feed Rolls	Wire Speed Range	Wire Size Range	Dimensions (H x W x D)	Net Weight
100037	2	70 - 660 (IPM) 1.8 - 16.8 (m/min.)	.024" - 5/64" 0.6 - 2.0 (mm)	12.2" x 9.2" x 23.3" 309 x 233 x 593 (mm)	29 lbs. (13 kg)

The Mijit® 1000 is a semiautomatic constant speed, solid state controlled wire feeder, capable of 100% duty cycle. This unit, designed to meet a wide variety of industrial applications, offers both load and line voltage compensation helping to maintain constant wire feed speed even with changes in the input voltage and load.

The Mijit® 1000's rugged steel-reinforced, flame-retardant polyethylene case totally encloses the solid state control circuitry, welding wire, and wire drive system. Portable and lightweight, the unit is designed with a hinged, latched door allowing quick and easy access to the welding wire and feedhead assembly.

Features of the Mijit® 1000 include quick change feed rolls allowing the operator to change feed rolls without the use of tools, a hand operated plastic knob for clamping the welding gun into the feedhead, a ground fault circuit to prevent weld current from disabling the ground wiring, 2 step / 4 step gun switch operation and a feed monitor display allowing the operator to monitor the feed system components (tips, liners, feed rolls, etc.) which helps to determine when these components should be checked and/or replaced.

Machine Specifications

Input Voltage	115 VAC
Input Frequency	50 / 60 Hz
Maximum Input Current	4 Amps
Wire Speed Range (For all Filler Wire Sizes)	70 - 660 IPM (1.8 - 16.8 m/min.)
Wire Size Range	0.024" - 5/64" (0.6 - 2.0 mm)
Spool Diameter	4", 8", 10"
Feed Rolls	2 (Both Gear Driven)
Welding Current (I)	475A at 60% Duty Cycle 425A at 100% Duty Cycle
Welding Gun / Torch Size	5/8" (15.9 m) Nominal
Maximum Shielding Gas Inlet Pressure	100 P.S.I.
Connection	19 Pin Amphenol
Approvals	CSA NRTL/C, NEMA EW-3

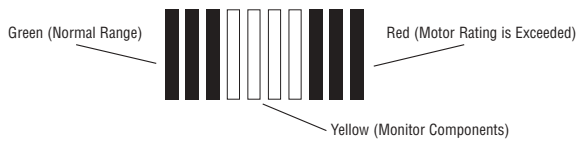
GOT POWER?™

Features	Benefits
Quick Change Feed Rolls	Feed rolls can be changed without the use of tools
LED Meter	Clearly displays wire feed speed or arc voltage information
Remote Voltage	Allows adjustment of power source arc voltage from the wire feeder
Gas Valve	Controls "on/off" flow of shielding gas
Run-In Time Adjustment	Allows adjustment of wire run-in time to improve arc starting
Inch/Purge	Allows "cold" inching of wire at set wire feed speed and purging of gas without running wire
Ground Fault Protection	Protects the ground wiring from weld current
Polarity Insensitive	Weld with straight or reverse polarity
Electronic Brake	Solid state control offers precise stopping of the wire
In-Line Motor Fuse	Provides protection against a locked motor condition
A/B Contactor Protection	Provides self-reset protection against overload conditions

Compatibility

The Mijit® 1000 wire feeder is designed to work with any Thermal Arc® CV or CC/CV power source with a 19 pin amphenol. Cable adapters are available to connect the Mijit® 1000 to a power source that only offers a 5 pin amphenol connector and AC voltage outlets or a 14 pin amphenol connector. These cable adapters must be used in conjunction with the 19 pin control cable. When using the cable adapters with the Mijit® 1000, the remote voltage, 4 step (trigger hold) and volt meter features will not function.

Special Features

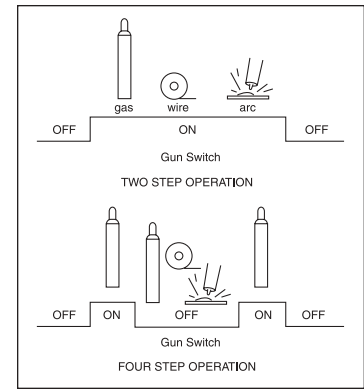


Feed Monitor Display

The Mijit® 1000 is equipped with a Feed Monitor Display, a visual tool designed to alert the user to potential feeding problems. Through a LED bar graph indicator on the front of the wire feeder, information on the stability and consistency of wire feeding is communicated to the user to assist in determining when it is time to replace tips, liners, wire guides, or feed rolls. As these items become dirty or worn due to normal operating conditions, the user will see an increase in the number of lighted LED's on the feed monitor display.

2 Step / 4 Step Operation

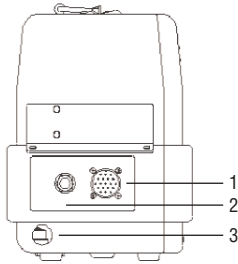
The Mijit® 1000 features a 2 step / 4 step trigger hold. The operator may select either normal trigger operation (2 step), in which weld functions are all initiated upon trigger activation, or trigger hold operation (4 step), in which the initial trigger activation puts the machine in a preflow state. Upon release of the trigger, weld contactor and wire feed are energized, beginning the weld cycle. To complete the weld, the operator activates the trigger again causing the system to enter a postflow condition. When the trigger is again released, the weld cycle is complete and ready for the next weld sequence.



Control Panels

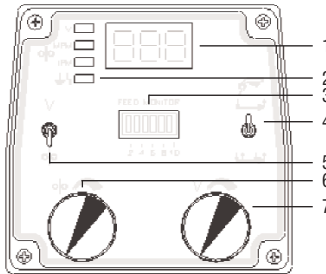
Rear Panel

1. Power Source Receptacle
2. Gas Valve Inlet
3. Input for Welding Cable

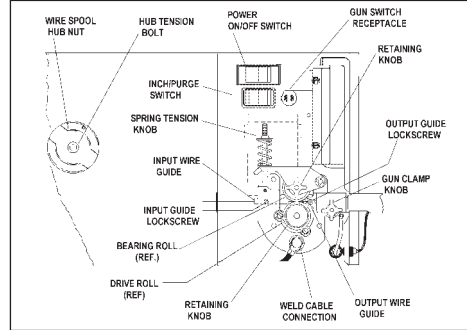


Front Panel

1. LED Meter
2. Ground Fault Indicator
3. Feed Monitor Display
4. Trigger Hold Switch
5. WFS / Volts Display Switch
6. WFS Control
7. Arc Voltage Control



Interior Panel



Ordering Information

	Part No.
Mijit® 1000	100037
ACCESSORIES	
Control Cable – 19 Pin to 19 Pin (1 required)	
6 ft. (1.8m)	374878-006
15 ft. (4.5m)	374878-015
25 ft. (7.6m)	374878-025
50 ft. (15.2m)	374878-050
100 ft. (30.5m)	374878-100
Adapter Kits	
10 lb. Spool	375585
15 lb. Spool	375864-001
14 lb. Coil	375942A
Feed Roll Kits	171435-X
Dual Amphenol Splitter Kit	204395A
Dual Feeder Interlock	870008-001
Flowmeter Kit	870062
Control Pot Shaft Friction Lock	402663
Adapter Cable	
19 Pin Wire Feeder to 5 Pin Power Source	870000-001
19 Pin Wire Feeder to 14 Pin Power Source	870093A-001

FEED ROLL KITS		Style 1	Style 2	Style 3	Style 4	Style 5
171435-Series	Top	Flat	Flat Knurled	Double Knurled Vee	Double Cog	Double "U"
	Bottom	Double Smooth Vee	Double Smooth Vee	Double Knurled Vee	Double Cog	Double "U"
Wire Size	Wire Type					
.024"	Hard	171435-001	—	—	—	—
.030", .035"	Hard	171435-002	—	—	—	—
.035"	Hard	171435-003*	—	—	—	—
.045"	Hard & Tubular	171435-004*	171435-010	171435-016	—	—
.035", .045"	Hard	171435-005*	—	—	—	—
.052"	Hard	171435-006*	—	—	—	—
1/16"	Hard & Tubular	171435-007*	—	—	—	—
.030", .035"	Hard	—	171435-009	—	—	—
.052", 1/16", .068"	Hard & Tubular	—	—	171435-011	—	—
5/64"	Tubular	—	—	171435-018	—	—
.045"	Tubular	—	—	—	171435-012	—
.052", 1/16", .068"	Tubular	—	—	—	171435-013	—
.035"	Soft	—	—	—	—	171435-014
3/64"	Soft	—	—	—	—	171435-015
1/16"	Soft	—	—	—	—	171435-017

Notes: 1) One Kit is supplied standard with each wire feeder. * Narrow 30° Vee
2) Feed Roll Kits include: 2 Feed Rolls, 1 Input Guide, 1 Output Guide.

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