

INSTRUCTIONS AND PARTS MANUAL

GO-FER III-OX 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-0113

Bug-O Systems is guided by honesty, integrity and ethics in service to our customers and in all we do.



B U G - O S Y S T E M S

A DIVISION OF WELD TOOLING CORPORATION



280 TECHNOLOGY DRIVE CANONSBURG, PENNSYLVANIA 15317-9564 USA
PHONE: 412-331-1776 <http://www.bugo.com> FAX: 412-331-0383

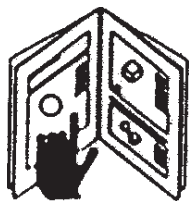
SAFETY

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 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.

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.

GO-FER III INSTRUCTION AND PARTS MANUAL FOR ALL MODELS AND KITS

TABLE OF CONTENTS

PAGE

5.....	Introduction / Features
6.....	Operating Instructions / Setup
6.....	GO-FER III-WD / Setup (Welding)
7.....	GO-FER III-PL / Setup (Plasma)
7.....	GO-FER III-OX / Setup (Oxy-fuel)
8.....	GOF-3250-WD GO-FER III Welding Kit (120VAC/50-60Hz/1Ph) / Technical Data
9.....	GOF-3250-PL GO-FER III Plasma Kit (120VAC/50-60Hz/1Ph) / Technical Data
10.....	GOF-3250-OX GO-FER III Oxy-Fuel Kit (120VAC/50-60Hz/1Ph) / Technical Data
11.....	GO-FER III / Wiring Diagram / Electrical Component Chart
12.....	GOF-3240-WD / Exploded View
13.....	GOF-3240-WD / Parts List
14.....	GOF-3240-PL / Exploded View
15.....	GOF-3240-PL / Parts List
16.....	GOF-3240-OX / Exploded View
17.....	GOF-3240-OX / Parts List
18-20	... Accessories
21.....	Troubleshooting Guide
22.....	Warranty



Patents Pending

INTRODUCTION

The **GO-FER III** is a versatile tractor for use in cutting or welding applications. There are three models/kits to choose from, each designated for the intended application; “OX” for Oxy-Fuel cutting, “PL” for Plasma cutting and “WD” for Welding applications. All models are all position machines, with positive rack and pinion drive. They feature a wide range solid state speed control.

The **GO-FER III Welding Kit** is an economical straight-line welding travel carriage. The all position fits-all clamp will accept and accommodate any hand held welding gun and allow the operator to position the torch at any angle they desire. The racking group allows for in process torch adjustment of the vertical and horizontal plane. A built in torch trigger contactor allows the operator to activate the wire feeder from a switch on the top of the unit.

The **GO-FER III Plasma Kit** is specifically designed to work in conjunction with a plasma cutting system. Its travel speed of 8-100 inches per minute (203-2540 mm/min) and its direct rack and pinion drive make it ideal as an all position portable cutting machine for a plasma torch. The torch holder will accept any standard 1-3/8" (35 mm) diameter machine torch that has a 32 pitch gear rack. A built in trigger contactor for initiating the cut makes the GO-FER a convenient self contained package.

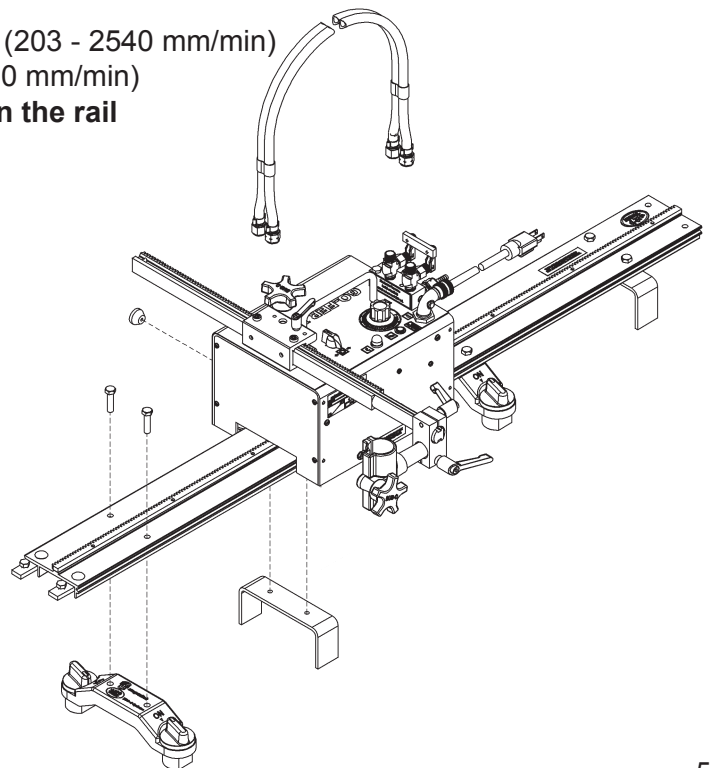
The **GO-FER III Oxy-Fuel Kit** is used for straight line cuts and weld preparation beveling. The kit comes complete with the exception of a torch. The Bug-O torch holder will accept any standard 1-3/8" (35 mm) diameter machine torch with a 32 pitch gear rack. The quick-action gas manifold mounted to the rear of the machine is used as a strain reliever for the torch and also gives the operator the ability to turn on and off the gases without having to readjust the gas flow of the torch.

FEATURES

The **GO-FER III** is a lightweight machine that makes straight line cuts or welds. The consistent quality produced is capable in all positions with portable drive and track.

GO-FER III features:

- **Infinitely variable speed control,**
 - OX and -PL unit speed range: 8 – 100 ipm (203 - 2540 mm/min)
 - WD unit speed range: 2 – 50 ipm (50 - 1270 mm/min)
- **Positive Clutch enables quick positioning on the rail**
- **Circuit Breaker**
- **Power Indicator Light**
- **Forward – Off – Reverse Switch**
- **Carrying Handle**



OPERATING INSTRUCTIONS / SETUP

TRACK SETUP

Attach two **ARM-2010 “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-2015 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.

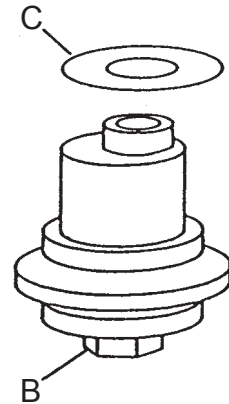
POSITIONING AND ADJUSTING THE MACHINE ON THE TRACK

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 (**E**) 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.



GO-FER III-WD / SETUP (Welding)

TORCH SET-UP

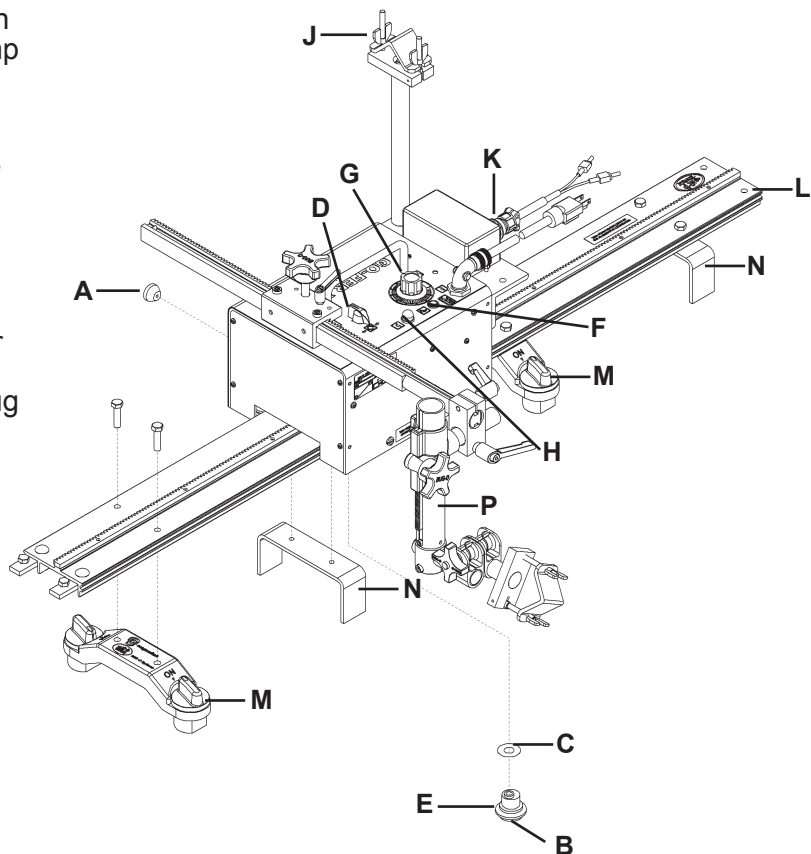
Insert the **Racking Group (P)** into the torch holder on the rack. Attach the rod, the clamp and the gun to the end of the vertical tube rack. Clamp welding gun into gun clamp. Adjust the racking system to set the gun to the desired position. Support the gun cable in the **Cable Anchor (J)** provided. 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.



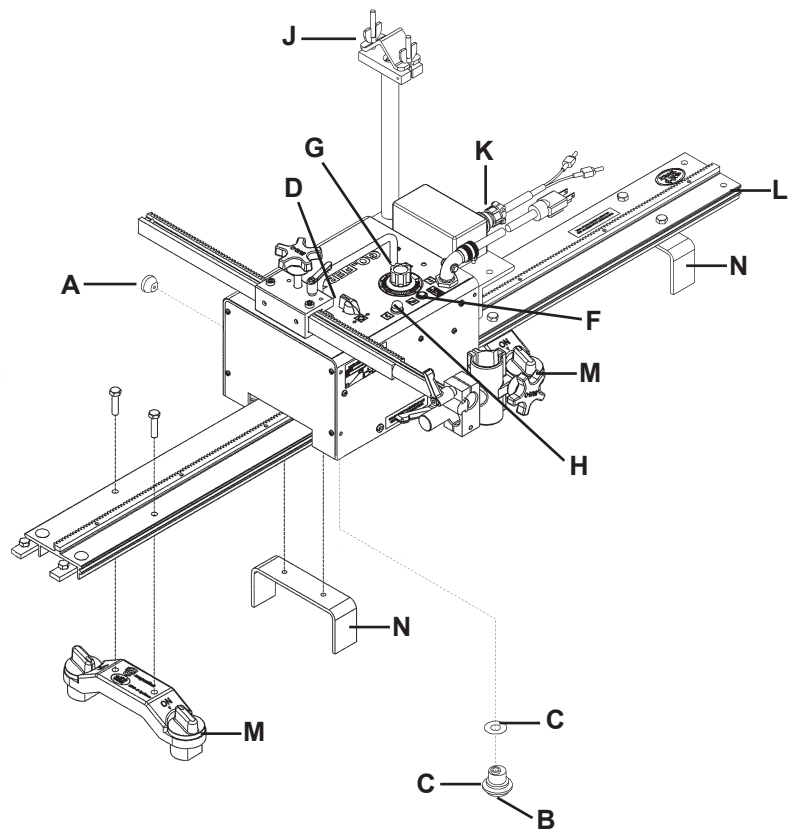
GO-FER III-PL / SETUP (Plasma)

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 **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.**



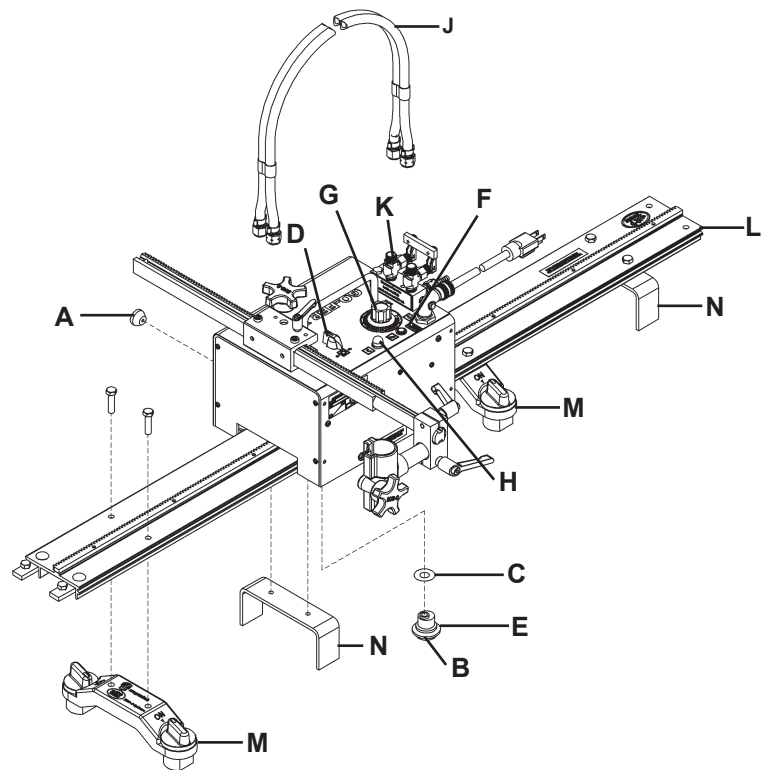
GO-FER III-OX / SETUP (Oxy-fuel)

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.**



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

Includes:

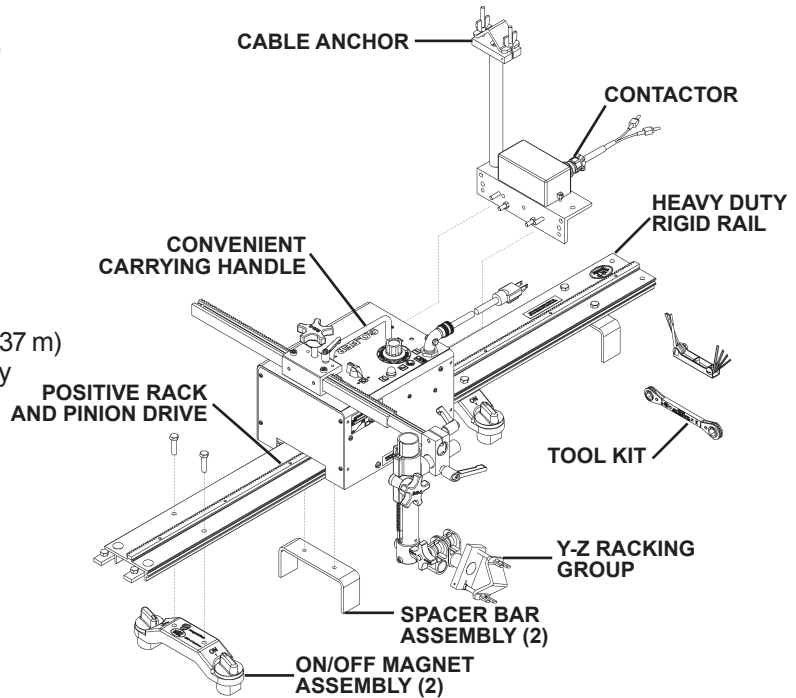
1 GOF-3240-WD GO-FER III w/ Dynamic Brake

Includes:

- 2-50 ipm (50-1270 mm/min)
- 1 BUG-5485 Contactor / 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 GOF-3255 Welding Support Kit
- 1 ARR-1080 Heavy Duty Rigid Rail 93.5" (2.37 m)
- 2 ARM-2010 On-Off Magnet Plate Assembly
- 2 ARM-2015 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



TECHNICAL DATA (Welding)

Power Requirement: - 60 watts at rated voltage:

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

Travel Speed: Infinitely variable from 2-50 ipm (50-1270 mm/min)

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

Magnet Holding Power: 250 lbs (113 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 330 mm)

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

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

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

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

Includes:

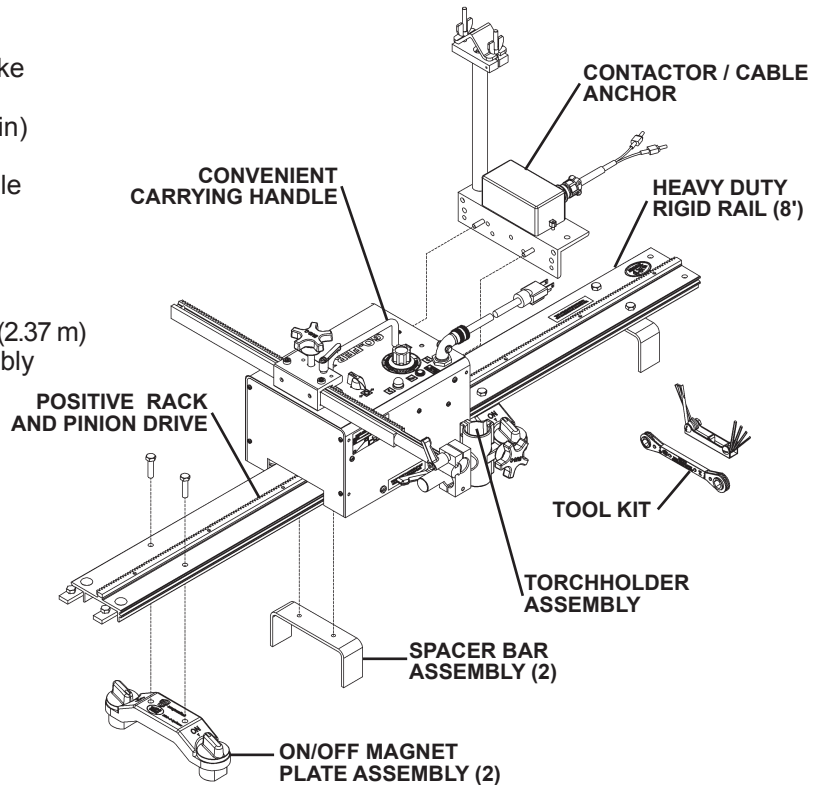
1 GOF-3240-PL GO-FER III w/ Dynamic Brake

Includes:

- 1 BUG-5485 Contactor / 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 93.5" (2.37 m)
- 2 ARM-2010 On-Off Magnet Plate Assembly
- 2 ARM-2015 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



TECHNICAL DATA (Plasma)

Power Requirement: - 60 watts at rated voltage:

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

Travel Speed: Infinitely variable from 8-100 ipm (203-2540 mm/min)

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

Magnet Holding Power: 250 lbs (113 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 330 mm)

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

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

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

GOF-3250-OX GO-FER III OXY-FUEL KIT (120VAC/50-60Hz/1Ph)

Includes:

1 GOF-3240-OX GO-FER III w/ Dynamic Brake

Includes:

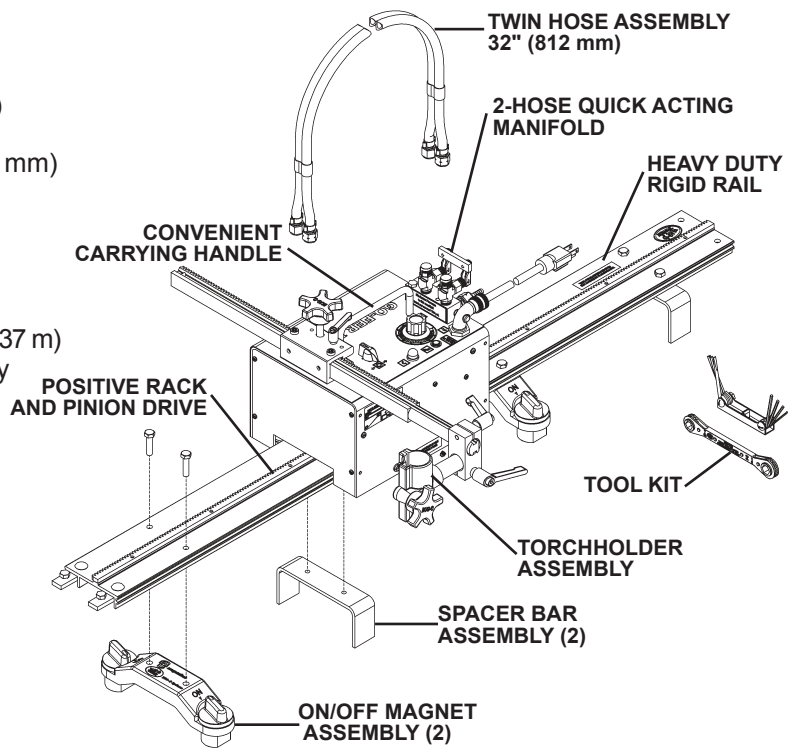
1 GOF-3025 8-100 ipm (203-2540 mm/min)
 1 CIR-1010-3 2-Hose Q.A. Manifold
 1 BUG-5451 Rackholder with Short Handle
 1 PAN- 1015 Rack 22.62" (574 mm)
 1 BUG-5462 Right Angle Clamp
 1 BUG-5188 Torchholder Assembly
 1 BUG-9444 Tool Kit
 1 ARR-1080 Heavy Duty Rigid Rail 93.5" (2.37 m)
 2 ARM-2010 On-Off Magnet Plate Assembly
 2 ARM-2015 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



TECHNICAL DATA (Oxy-fuel)

Power Requirement: - 60 watts at rated voltage:

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

Travel Speed: Infinitely variable from 8-100 ipm (203-2540 mm/min)

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

Magnet Holding Capacity: 250 lbs. (113 kg)

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

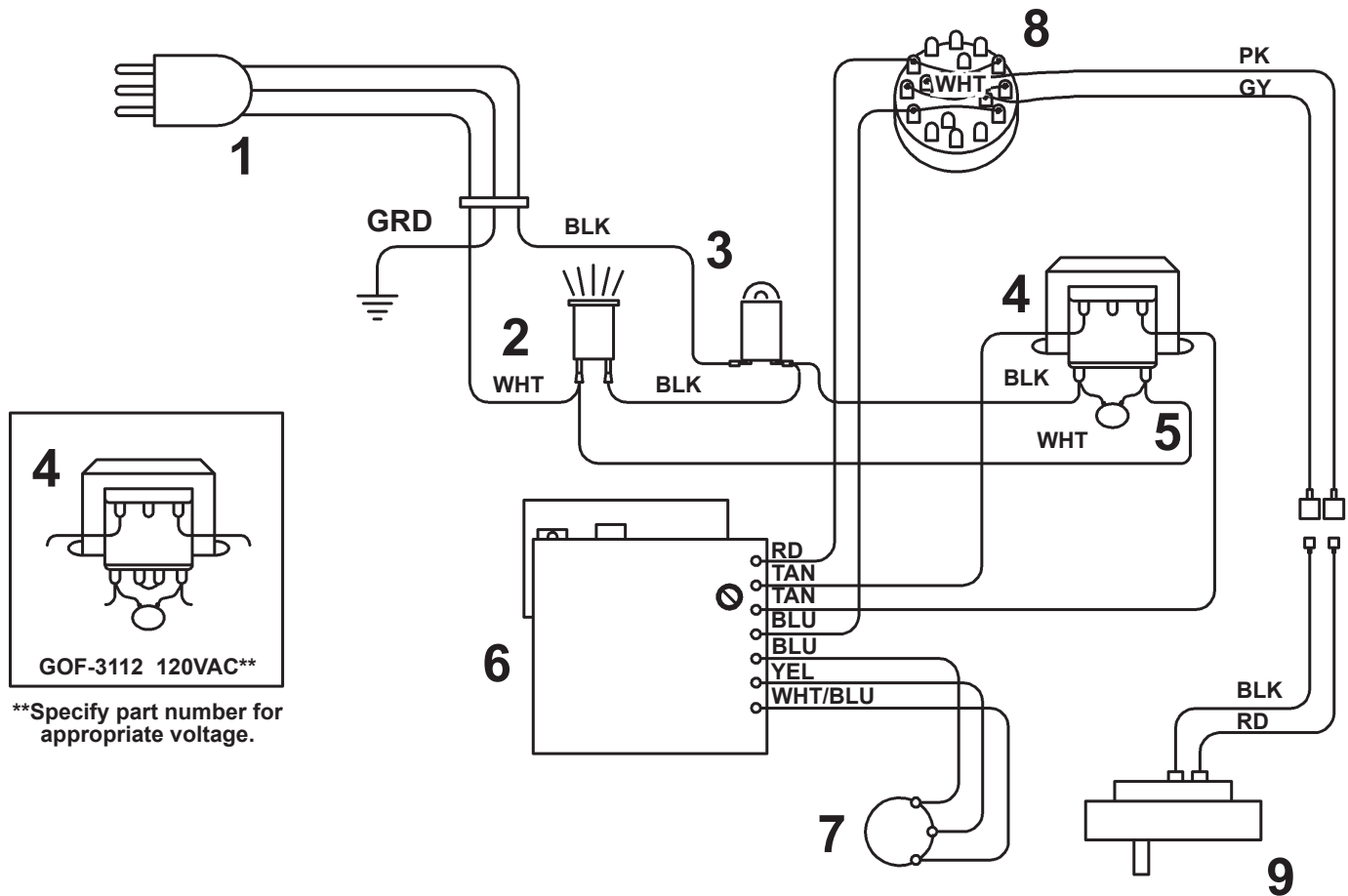
Dimensions of Drive Unit: 10" L x 8" W x 13" H (254 mm x 203 mm x 330 mm)

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

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

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

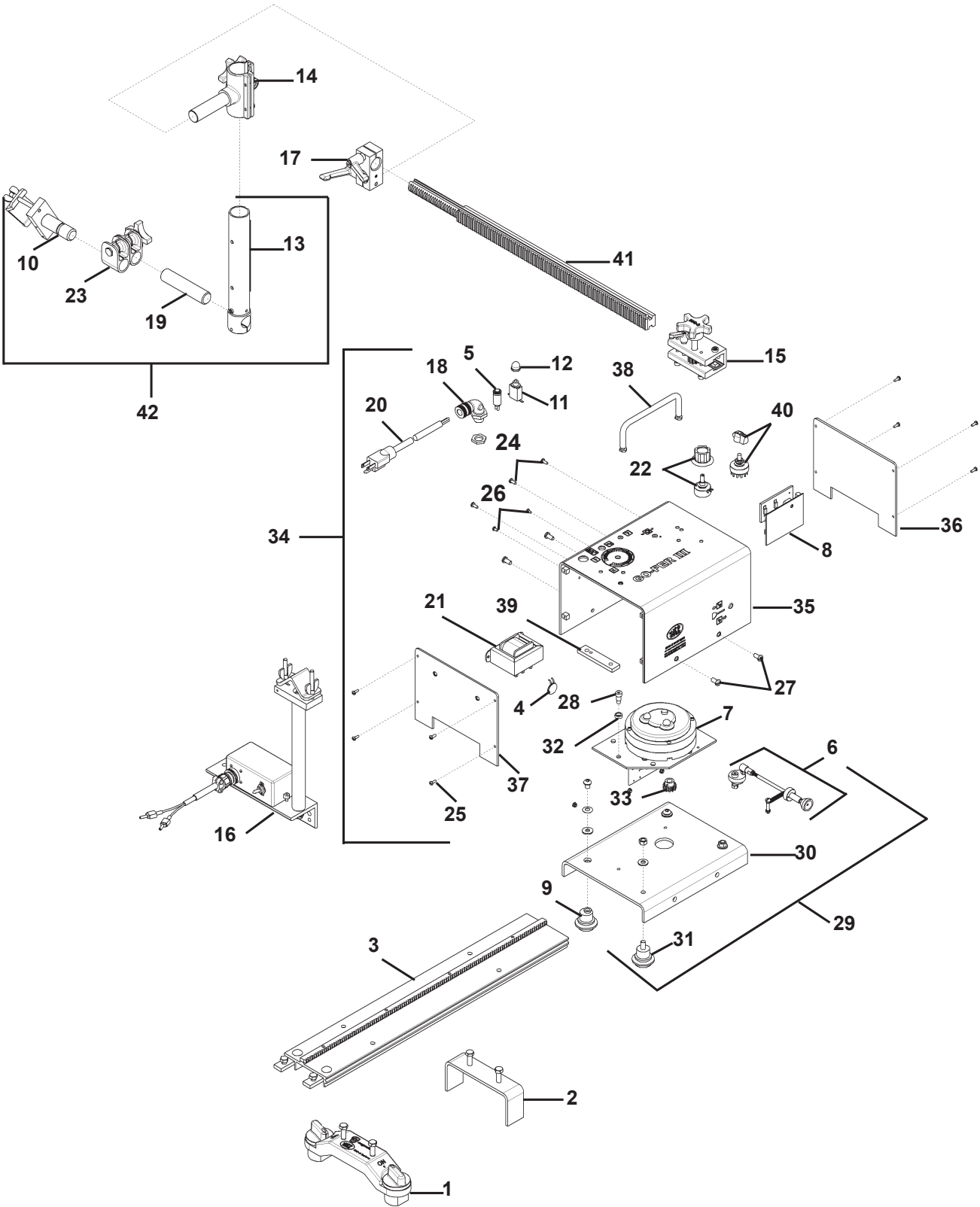
GO-FER III / WIRING DIAGRAM



ELECTRICAL COMPONENT CHART

ITEM	DESCRIPTION	PART NUMBER		
		GOF-3240-XX 120 VAC	GOF-3242-XX 240 VAC	GOF-3244-XX 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	Fwd Off Rev Switch	MUG-1258-GOF		
9	Gear Motor	PL / OX BUG-1590 (80:1) WD BUG-1550 (150:1)		

GOF-3240-WD / EXPLODED VIEW



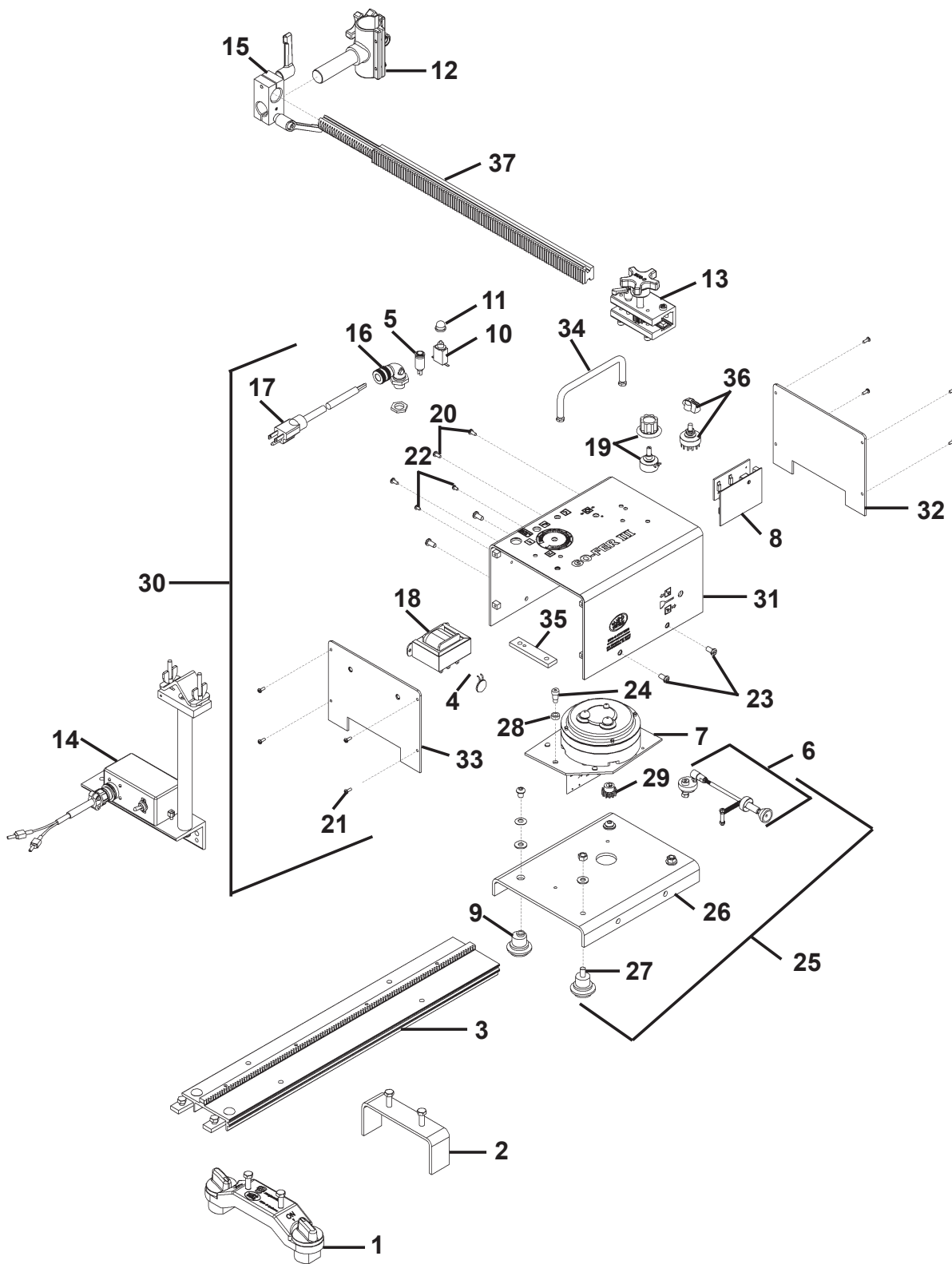
GOF-3240-WD / PARTS LIST

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
** 1	ARM-2010	On/Off Magnet Plate Assy.
** 2	ARM-2015	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" x 1/4-20
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 w/ Key & Set Screw
34	GOF-3015	Enclosure Assy. [Includes Items 4, 5, 8, 10, 11, 18, 20-22, 24-26, 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-1258-GOF	Forward/Off/Rev Switch
41	PAN-1015	Rack 22.63" (574 mm)
42	GOF-3255	Welding Support Kit

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

**These items are supplied with GO-FER-WD Kit.

GOF-3240-PL / EXPLODED VIEW



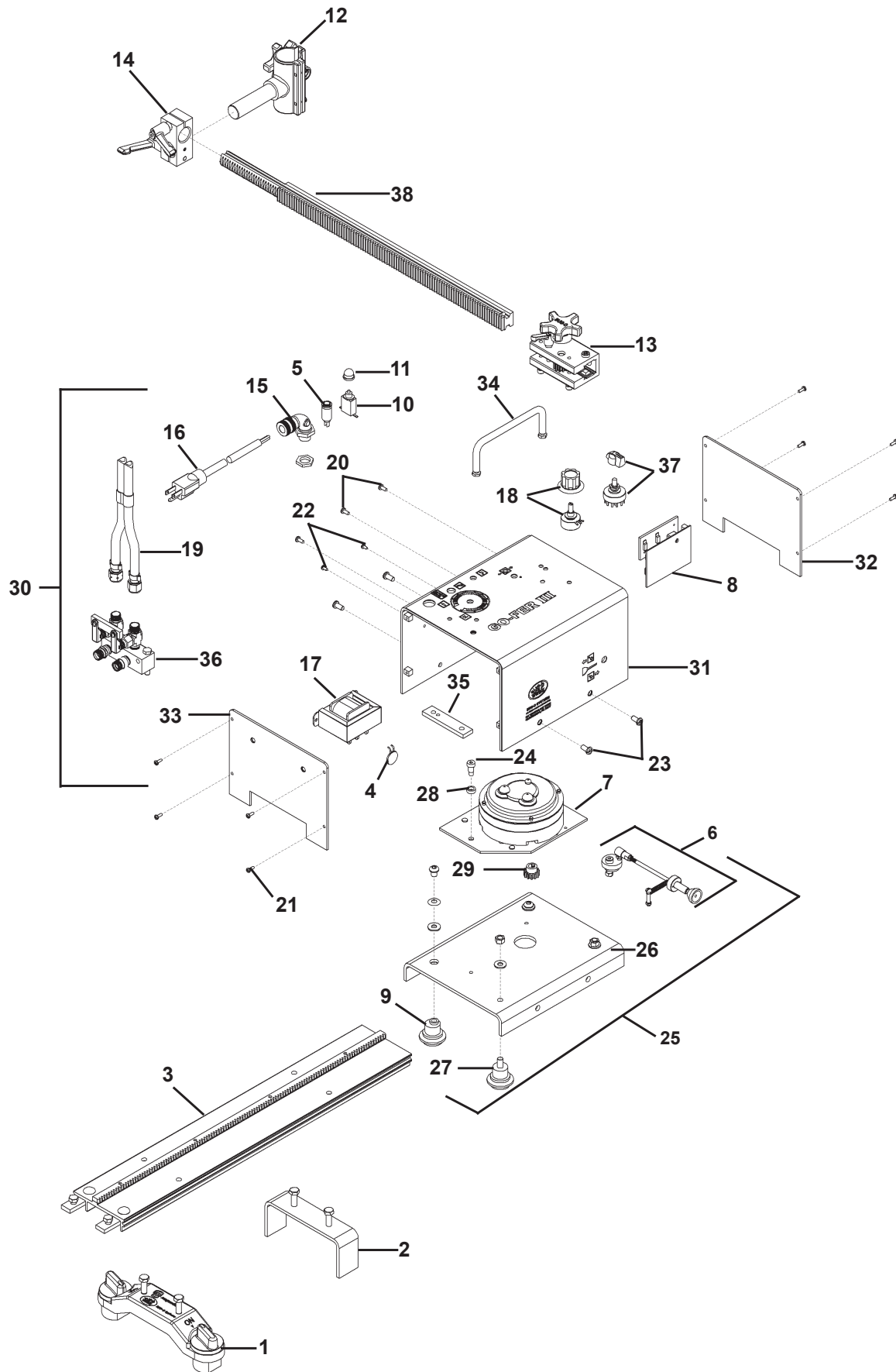
GOF-3240-PL / PARTS LIST

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
** 1	ARM-2010	On/Off Magnet Plate Assy.
** 2	ARM-2015	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	Contacto / 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" x 1/4-20
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 w/ Key & Set Screw
30	GOF-3015	Enclosure Assy. [Includes Items 4,5,8,10, 11,15, 17-19, 20-22, 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-1258-GOF	Forward/Off/Rev Switch
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 Kit.

GOF-3240-OX / EXPLODED VIEW



GOF-3240-OX / PARTS LIST

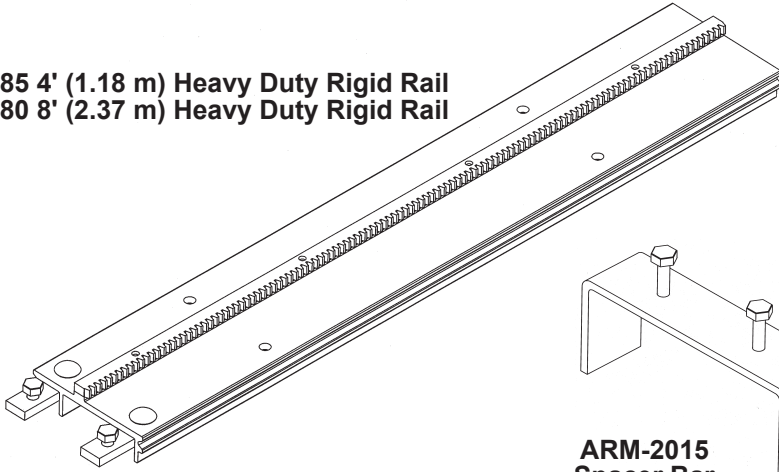
<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
** 1	ARM-2010	On/Off Magnet Plate Assy.
** 2	ARM-2015	Spacer Bar Assy.
** 3	ARR-1080	H.D. Rigid Rail 93.50" (2.37 m)
* 4	BUG-1393	Volt Trap 120 VAC
* 5	BUG-1415	Pilot Light 120 VAC
6	BUG-1605	Cam Clutch Assy.
7	BUG-1625-D	Drive Unit (80:1) [Includes Item 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" x 1/4-20
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 w/ Key & Set Screw
30	GOF-3015	Enclosure Assy. [Includes Items 4, 5, 8, 10, 11, 13, 15-18, 20-22, 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-1258-GOF	Forward/Off/Rev Switch
38	PAN-1015	Rack 22.63" (574 mm)

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

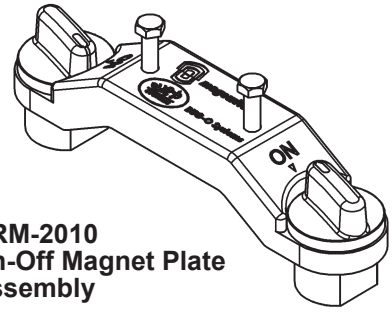
**These items are supplied with GO-FER-OX Kit.

ACCESSORIES

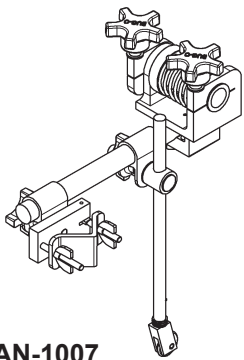
ARR-1085 4' (1.18 m) Heavy Duty Rigid Rail
 ARR-1080 8' (2.37 m) Heavy Duty Rigid Rail



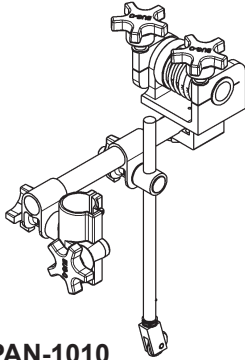
ARM-2010
 On-Off Magnet Plate
 Assembly



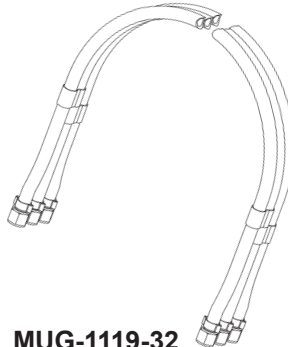
ARM-2010
 On-Off Magnet Plate
 Assembly



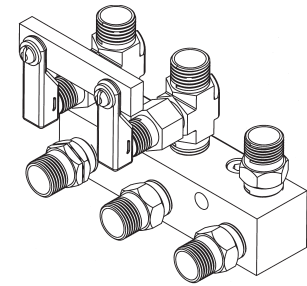
PAN-1007
 Panograph Assembly
 W/ Fits-All Clamp
 (For Other Torches)



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

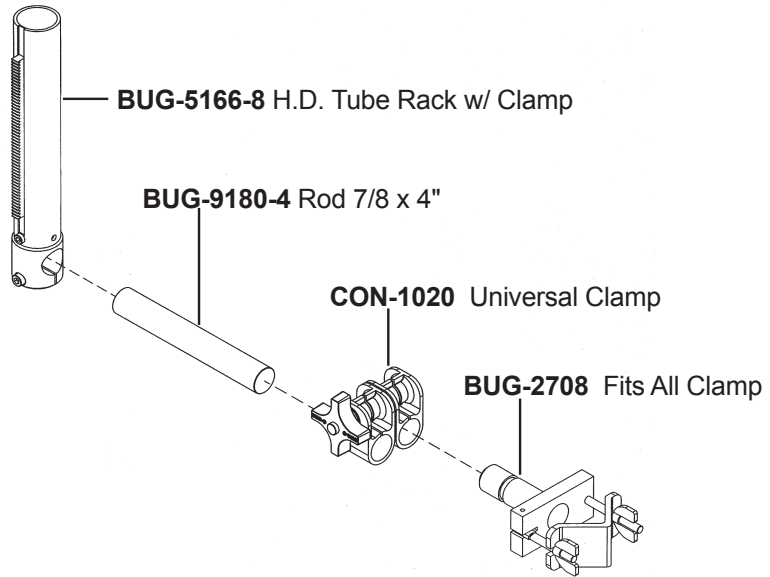


MUG-1119-32
 3-Hose Assembly



BUG-9898
 3-Hose Quick-Acting
 Manifold

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



BUG-5166-8 H.D. Tube Rack w/ Clamp

BUG-9180-4 Rod 7/8 x 4"

CON-1020 Universal Clamp

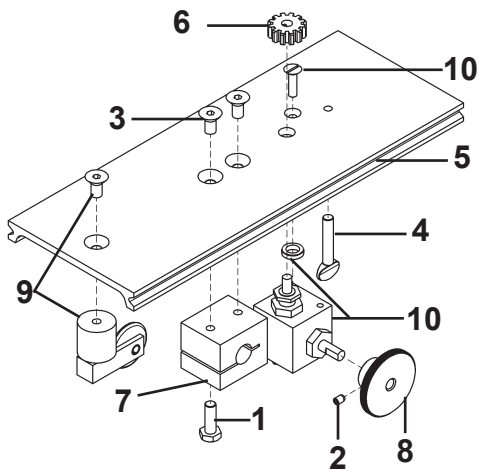
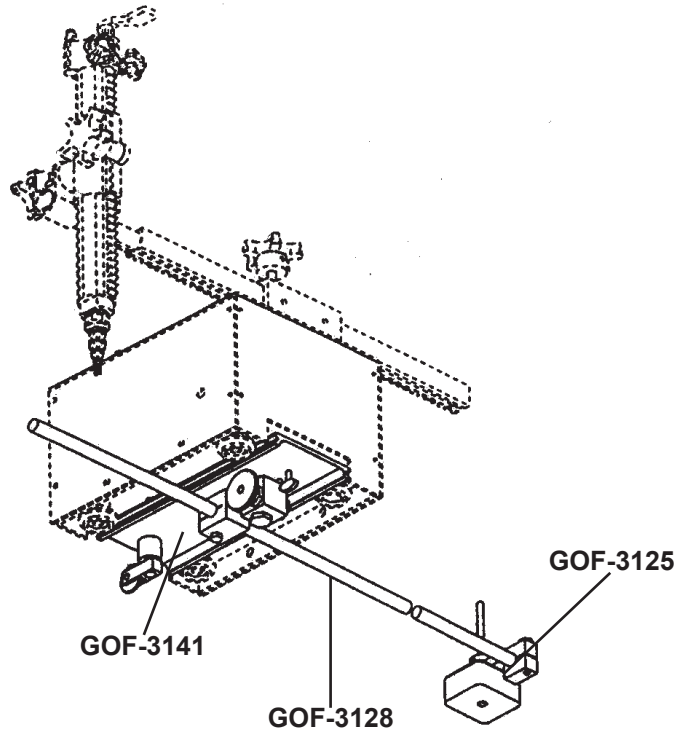
BUG-2708 Fits All Clamp

ACCESSORIES CONT'D.

GOF-3142 RADIUS CUTTING ATTACHMENT

Enables GO-FER III H.S. to be quickly changed from a straight line to a circle-cutting machine.

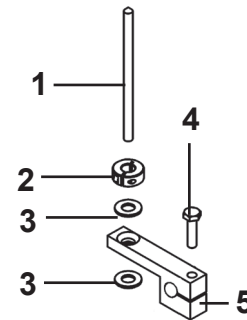
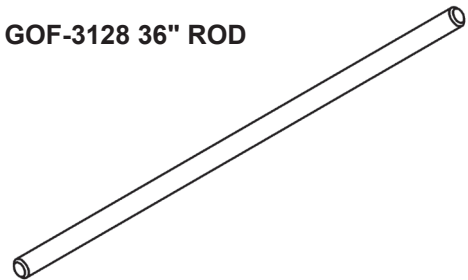
Size Range: 8" to 96" (203 mm to 2438 mm) diameter.



GOF-3141 RAIL ASSEMBLY

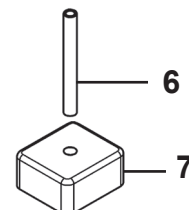
ITEM	PART NO.	DESCRIPTION	QTY
1	FAS-0357	Hex Hd Cap Scr 1/4-20 x 3/4"	1
2	FAS-0422	Set Scr #8-32 x 1/4"	1
3	FAS-0955	Flt Hd Soc Scr 1/4-20 x 1/2"	2
4	GOF-3121	Thumb Screw	1
5	GOF-3126	Rail	1
6	GOF-3129	Pinion & Set Screw	1
7	GOF-3134	Support	1
8	GOF-3134	Drive Wheel	1
9	GOF-3135	Leg Assembly	1
10	GOF-3140	Right Angle Drive	1

GOF-3128 36" ROD



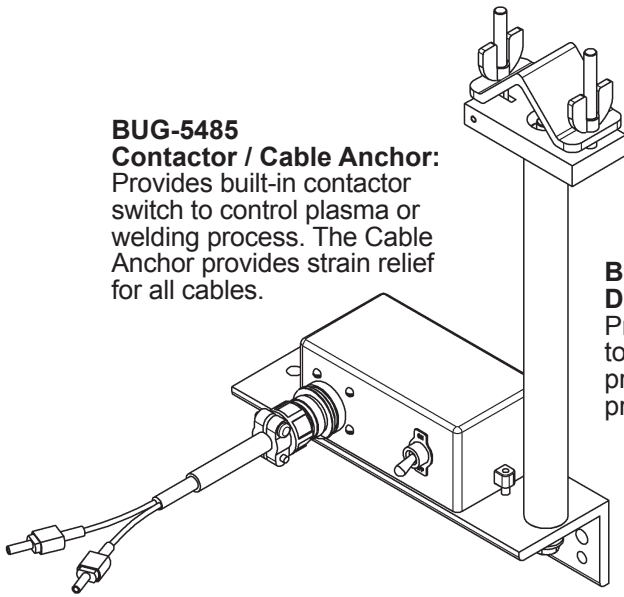
GOF-3125 Magnet Pivot

ITEM	PART NO.	DESCRIPTION	QTY
1	GOF-3137	Pivot Point	1
2	BUG-9012	Locking Collar	1
3	BUG-2034	Teflon Washer	2
4	FAS-0359	Hex Hd Cap Scr 1/4-20 x 1"	1
5	GOF-3138	Offset Link	1
6	GOF-3136	Sleeve	1
7	GOF-3133	Magnet	1

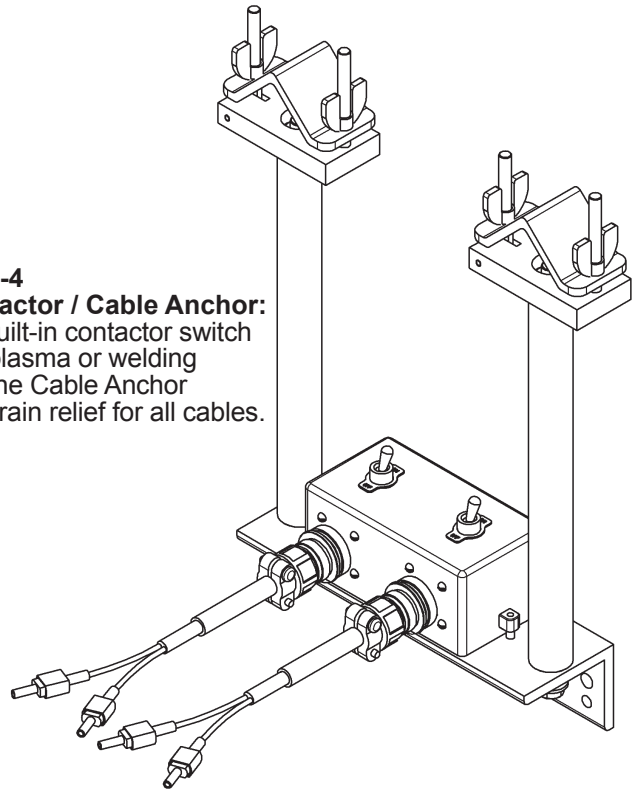


ACCESSORIES CONT'D.

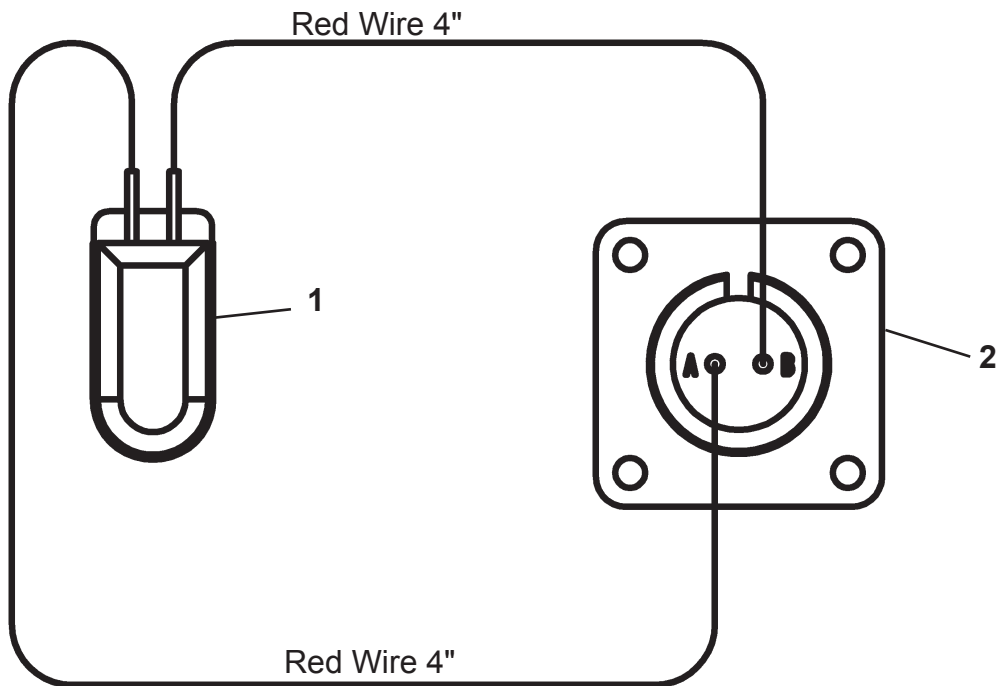
**BUG-5485
Contactor / Cable Anchor:**
Provides built-in contactor switch to control plasma or welding process. The Cable Anchor provides strain relief for all cables.



**BUG-5485-4
Dual Contactor / Cable Anchor:**
Provides built-in contactor switch to control plasma or welding process. The Cable Anchor provides strain relief for all cables.



BUG-5485 CONTACTOR / WIRING DIAGRAM



ELECTRICAL COMPONENT CHART

ITEM	DESCRIPTION	PART NUMBER
1	Toggle Switch	ABP-1069
2	Panel Connector, 2T, M	BUG-9486

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.	Wiring shorts. Circuit breaker tripped. 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. Faulty speed control board.	Check wiring connections, 12 VAC should appear across secondary of transformer. Tighten terminal screws on speed control board. 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 3-Year Warranty

Model _____
Serial No. _____
Date Purchased: _____
Where Purchased: _____

For a period ending one (1) year from the date of invoice, Manufacturer warrants that any new machine or part is free from defects in materials and workmanship and Manufacturer agrees to repair or replace at its option, any defective part or machine. HOWEVER, if the invoiced customer registers the Product Warranty by returning the Warranty Registration Card supplied with the product within 90 days of the invoice date, or by registering on-line at www.bugo.com, Manufacturer will extend the warranty period an additional two (2) years which will provide three (3) total years from the date of original invoice to customer. This warranty does not apply to machines which, after Manufacturer's inspection are determined by Manufacturer to have been damaged due to neglect, abuse, overloading, accident or improper usage. All shipping and handling charges will be paid by the customer.

The foregoing express warranty is exclusive and Manufacturer makes no representation or warranty (either express or implied) other than as set forth expressly in the preceding sentence. Specifically, Manufacturer makes no express or implied warranty of merchantability or fitness for any particular purpose with respect to any goods. Manufacturer shall not be subject to any other obligations or liabilities whatsoever with respect to machines or parts furnished by Manufacturer.

Manufacturer shall not in any event be liable to Distributor or any customer for any loss of profits, incidental or consequential damages or special damages of any kind. Distributor's or customer's sole and exclusive remedy against Manufacturer for any breach of warranty, negligence, strict liability or any other claim relating to goods delivered pursuant hereto shall be for repair or replacement (at Manufacturer's option) of the machines or parts affected by such breach.

Distributor's Warranty:

In no event shall Manufacturer be liable to Distributor or to any customer thereof for any warranties, representations or promises, express or implied, extended by Distributor without the advance written consent of Manufacturer, including but not limited to any and all warranties of merchantability or fitness for a particular purpose and all warranties, representations or promises which exceed or are different from the express limited warranty set forth above. Distributor agrees to indemnify and hold Manufacturer harmless from any claim by a customer based upon any express or implied warranty by Distributor which exceeds or differs from Manufacturer's express limited warranty set forth above.

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 they 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.