

# SANFEED Sky 4HD

## Wire Feeder

### Processes

MIG (GMAW), Pulse MIG (PGMAW), Flux Cored (FCAW)

### Product Number

WF1300

### Approvals

CSA (Pending); IP23S, IEC 60974-1

### Input Voltage

24 VAC 1Phase, 50/60 Hz.

### Rated Output

500A @ 100% Duty Cycle

### Dimensions (HxWxD)

13.38" x 12.60" x 21.65"  
(340 x 320 x 550 mm)

### Wire Speed Range

58 - 850 IPM (1.5 - 22 m/min)

### Wire Size Range

.024" - 5/64" (0.6 - 2.0 mm)

### Weight

35.27 lb (16 kg)

### Industrial Applications:

Heavy- or light-duty fabrication shops, Trailer manufacturers, Furniture manufacturers, Automotive products, Educational institutions.

### Features:

- **Gun Plug:** Offered with Tweco, Miller, EURO and PPI for Binzel Push Pull MIG Gun.
- **Inch Purge Switch:** 'Cold' wire inch and gas purge.
- **Gun Trigger Hold (2T/4T):** Allows for standard or latched gun trigger.
- **Remote Voltage Control:** Allows adjustment of power source voltage from the wire feeder.
- **Machined feed head & tension arms:** Heavy Duty, precision, ensures wire alignment tolerances of +/- .002. Large 4 driven drive roll system. Optimized wire traction for improved feedability.
- **Electronic speed control & dynamic breaking:** Optimized speed control with line voltage and load compensation.
- **Coax Interface cables:** Easy fit, plug-in, includes control, power and gas in one cable.
- **TWECO®, Miller®, Euro Style Welding Gun Connections:** Quick and easy connection and disconnection for welding guns.
- **Digital Meters:** Weld Current and adjustable controls.
- **Wire Spool Size:** 8" and 12" Spools.
- **Welding Wire Spool Cover:** Heavy Duty cover protects wire from the elements.
- 3 Year Warranty



### Coaxial Interconnect Cable

Gas, Power and Control cable in one heavy duty one piece easy to connect coax cable.

**SanRex**

Customer Care  
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SANFEED SKY4HD  
Form No.:040125SKY4HD

## Features



### Spool Wire Cover

Heavy Duty Cover to protect welding wire.

### Digital Meters

Weld Current and adjustment controls.

### Wire Feed / Voltage Control Knobs

Operator control of Wire Feed & Voltage.

### 2T/4T Switch

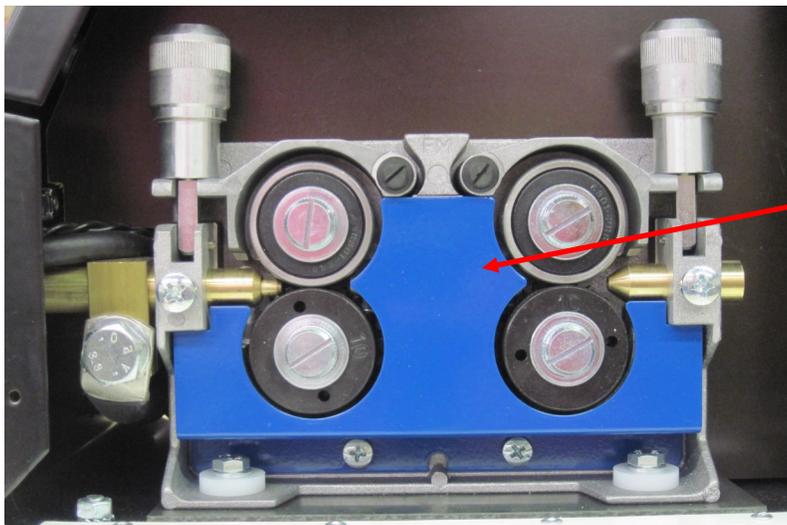
Standard or latched trigger.

### Inch Purge Switch

"Cold" wire inch and gas purge.

### Heavy Duty Gun Connection

Quick and easy connection and disconnection for welding guns. Tweco®, Miller® or Euro Style.



### Machined feed head & Tension arms

Heavy Duty, precision, ensures wire alignment tolerances of +/- 0.002. Large 4 driven drive rolls. Optimized wire traction for improved feedability.

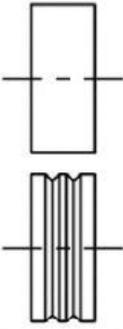
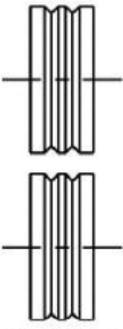
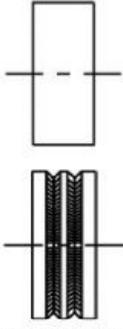
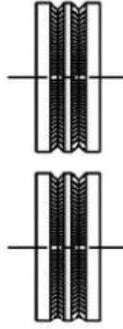
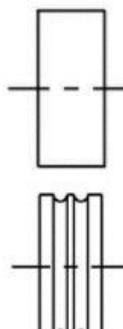
## Ordering Information

Product	Part Number	Description
SANFEED Sky 4HD	WF1300T WF1300M WF1300E WF1300TPPI	Sky 4HD with Tweco Gun Receptacle. Sky 4HD with Miller Gun Receptacle. Sky 4HD with EURO Gun Receptacle. Sky 4HD with Binzel PPI Push-Pull MIG Gun control circuitry added.  <b>Note: Coaxial Interconnect Cable not included. Order below.</b>
Binzel PPI Push Pull MIG Gun	MGT2842921	Binzel 25ft. PPI Push Pull MIG Gun to be used with WF1300TPPI Wire Feeder.  

### Accessories

Caster Kit	WFW001	Four swivel caster set.
Control Cable	FC1008	Wire Feeder Control cable only, 10ft.
Coaxial Interconnect Cable - Complete assembly from wire feeder to power source.		
4ft. Coaxial Cable	WFC004	Coaxial Interconnect Assembly
8 ft. Coaxial Cable	WFC008	Coaxial Interconnect Assembly
15 ft. Coaxial Cable	WFC015	Coaxial Interconnect Assembly
25 ft. Coaxial Cable	WFC025	Coaxial Interconnect Assembly
50 ft. Coaxial Cable	WFC050	Coaxial Interconnect Assembly
Drive Rolls (Sold individually, 2 smooth required per feeder)		
Drive Roll	WFR001	0.023", 0.030" (0.6, 0.8 mm) Hard Wire (V Grooved)
Drive Roll	WFR003	0.035", 0.045" (0.9, 1.2 mm) Hard Wire (V Grooved)
Drive Roll	WFR006	0.052", 1/16" (1.3, 1.6 mm) Hard Wire (V Grooved)
Drive Roll	WFR007	0.035", 0.045" (0.9, 1.2 mm) Flux Cored Wire (Knurled)
Drive Roll	WFR010	0.045", 1/16" (1.2, 1.6 mm) Flux Cored Wire (Knurled)
Drive Roll	WFR013	5/64" (2.0 mm) Flux Cored Wire (Knurled)
Drive Roll	WFR014	0.035", 3/64" (0.9, 1.2 mm) Aluminum Wire (U Grooved)
Drive Roll	WFR020	Smooth

## Drive Roll Selection Chart

Drive Roll Selection Chart		FLAT	DOUBLE SMOOTH VEE	FLAT	DOUBLE KNURLED VEE	FLAT
						
		DOUBLE SMOOTH VEE	DOUBLE SMOOTH VEE	DOUBLE KNURLED VEE	DOUBLE KNURLED VEE	DOUBLE "U"
Style		1	2	3	4	5
Top		Flat	Double Smooth "V"	Flat	Double Knurled "V"	Flat
Bottom		Double Smooth "V"	Double Smooth "V"	Double Knurled "V"	Double Knurled "V"	Double "U"
Wire Type		Hard	Soft/Hard/Tubular	Hard/Tubular	Hard/Tubular	Soft (Aluminum)
Wire Size						
0.6 mm (.023/.025)	Top	WFR101	-	-	-	-
	Bottom	WFR001 (0.6)	-	-	-	-
0.8 mm (.030)	Top	WFR101	-	-	-	-
	Bottom	WFR001 (0.8)	-	-	-	-
0.9 mm (.035)	Top	WFR101	WFR001 (0.8)	WFR101	-	-
	Bottom	WFR003 (0.9)	WFR001 (0.8)	WFR007 (0.9)	-	-
1.2 mm (.045)	Top	WFR101	WFR003 (0.9)	WFR101	WFR007 (0.9)	WFR101
	Bottom	WFR003 (1.2)	WFR003 (0.9)	WFR007 (1.2)	WFR007 (0.9)	WFR016 (1.2)
1.6 mm (1/16")	Top	WFR101	WFR005 (1.2)	WFR101	WFR007 (1.2)	WFR101
	Bottom	WFR005 (1.6)	WFR005 (1.2)	WFR010 (1.6)	WFR007 (1.2)	WFR016 (1.6)
2.0 mm (5/64")	Top	-	WFR005 (2.0)	WFR101	WFR010 (1.6)	-
	Bottom	-	WFR005 (2.0)	WFR013 (2.0)	WFR010 (1.6)	-

Style 1 & 3:	Standard Preferred for general fabrication.	WFR204	Center Guide 0.030 - 5/64
Style 2 & 4:	Alternative for poor wire feedability.	WFR205	Inlet Guide 0.030 - 5/64
Style 5:	Aluminum Applications.		

WFRxxx (x.x) Denotes Drive Roll groove to use.