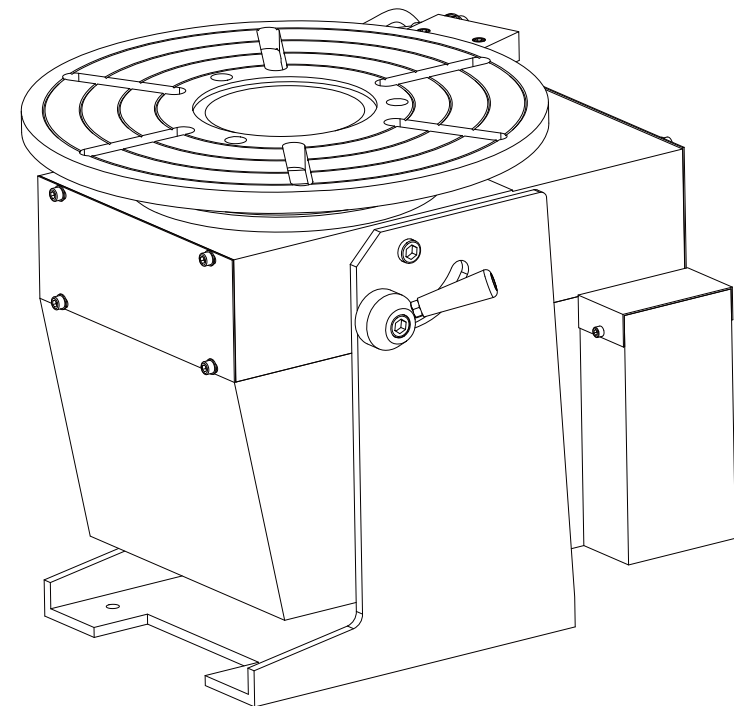
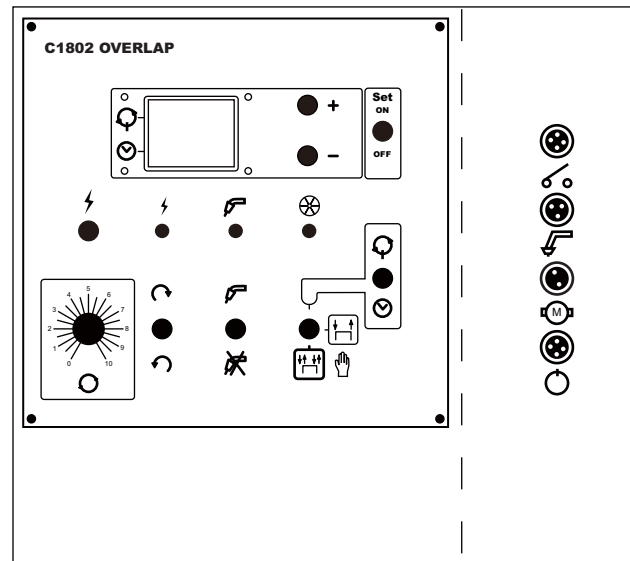


Owner's Operating Manual

Models
PRO4



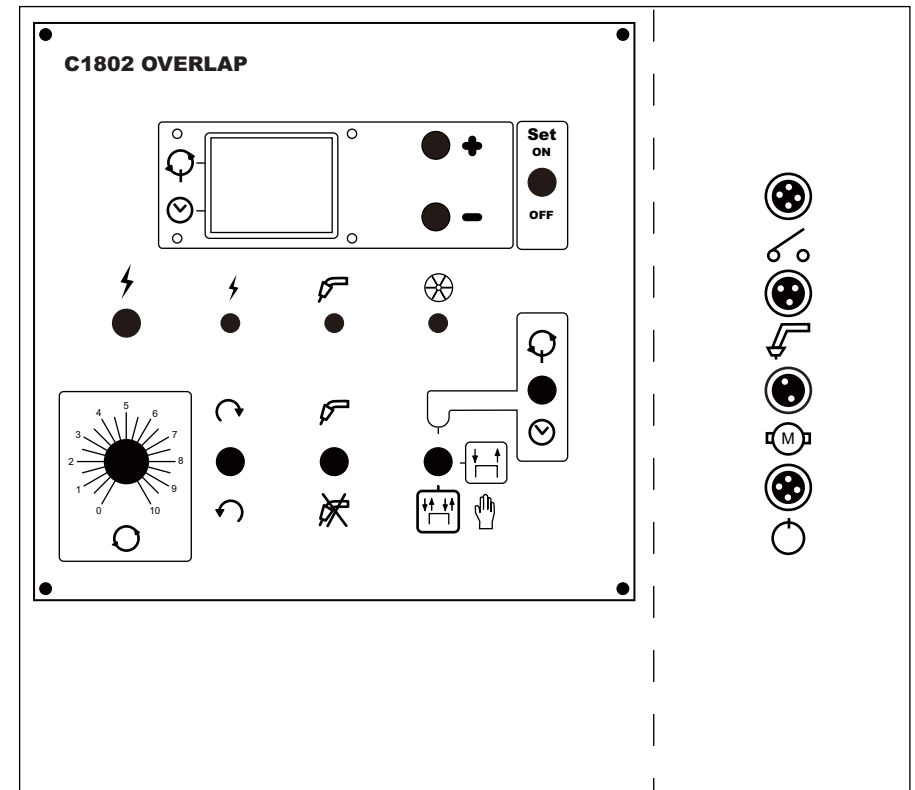
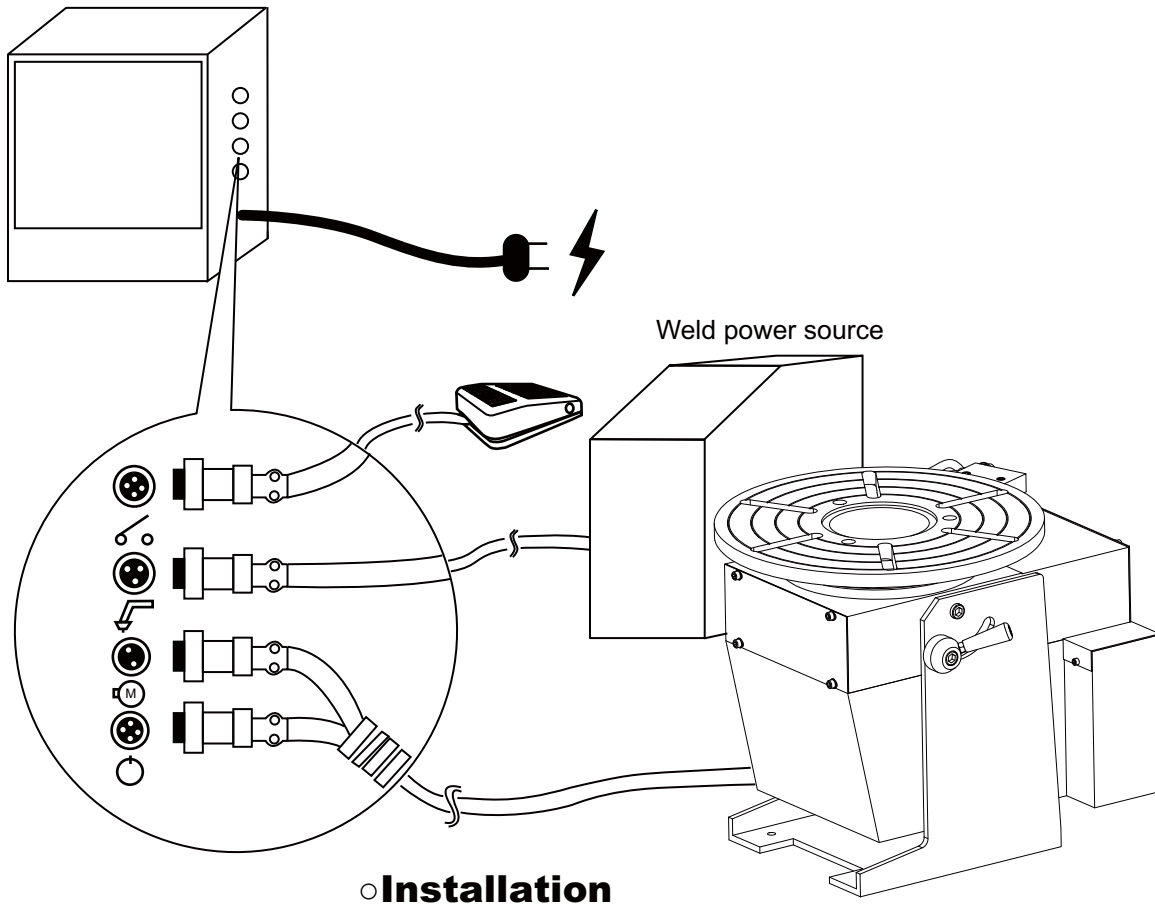
○ Structural Characteristics

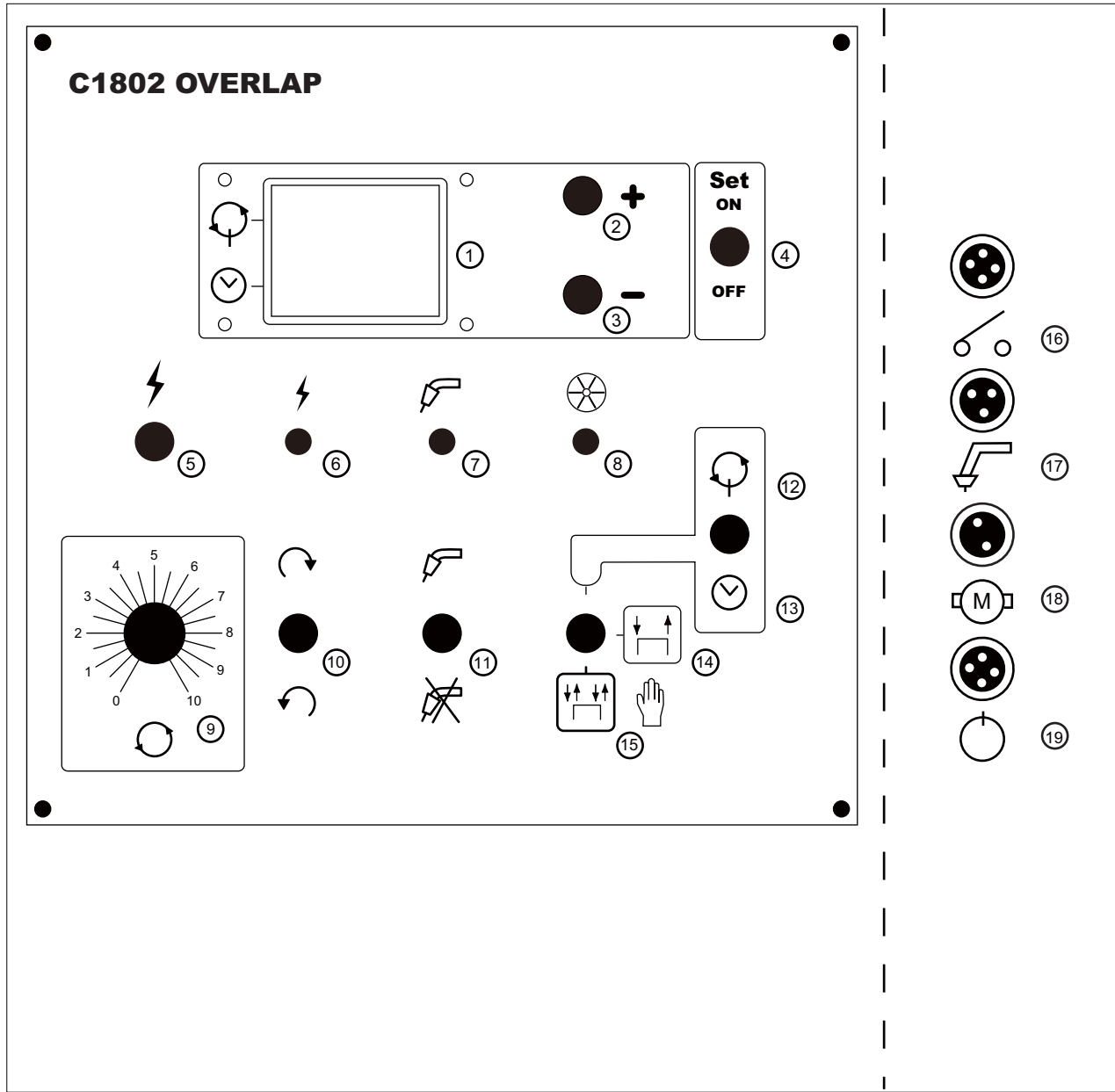
○ Welding method that can be matched

- MIG/MAG
- TIG
- Wire-TIG
- Plasma weld
- SAW

○ Duty Cycle

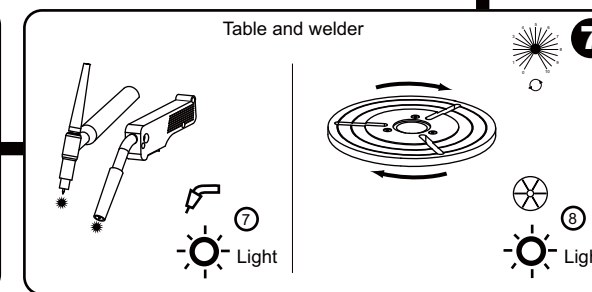
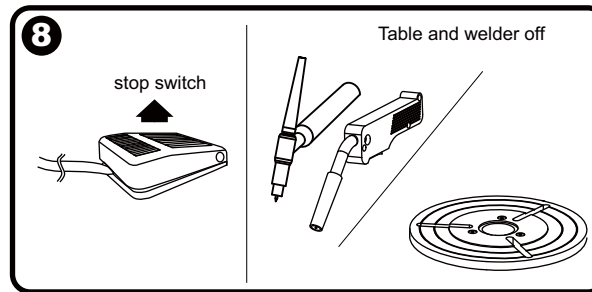
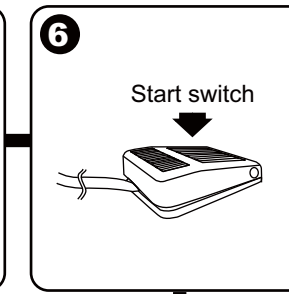
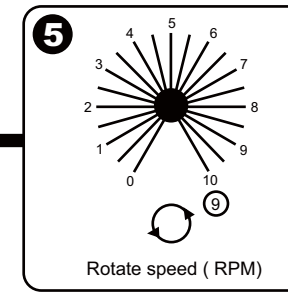
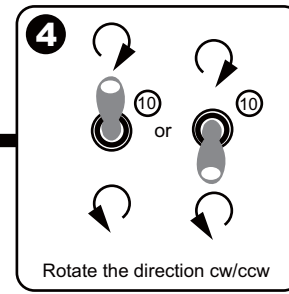
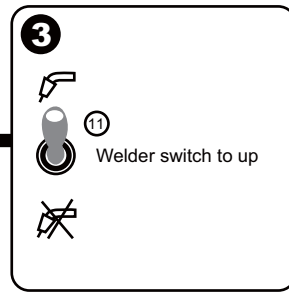
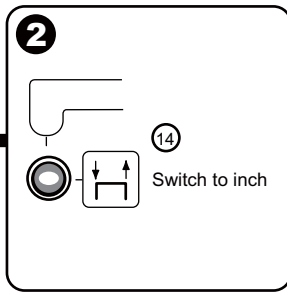
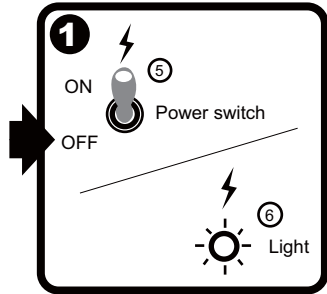
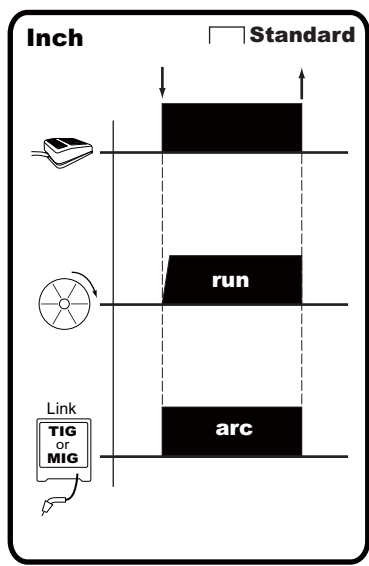
- Can operate in succession 100%
- Weld electric current 300A



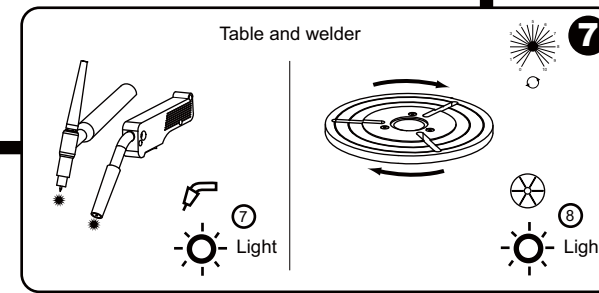
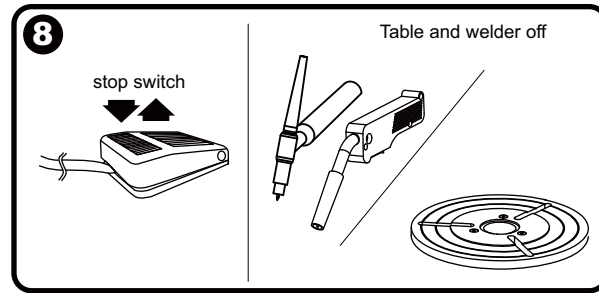
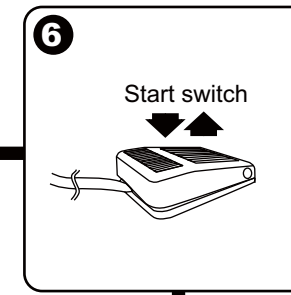
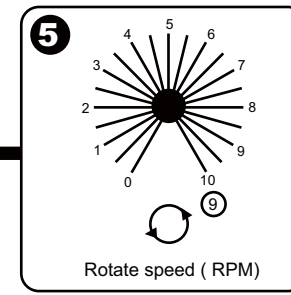
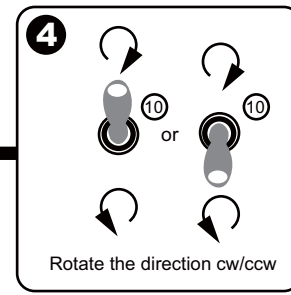
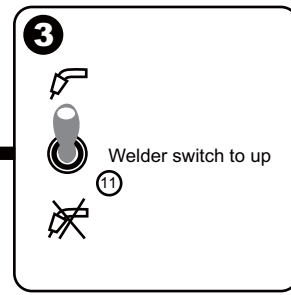
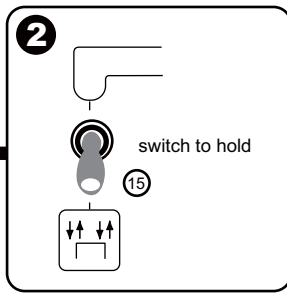
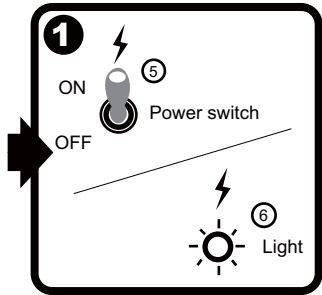
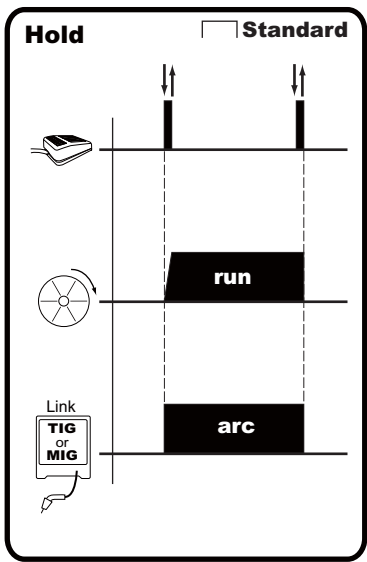


1. Time data (Unit : 0.1sec)
2. Set button (+)
3. Set button (-)
4. Time setting switch
5. Power switch
6. Power light
7. Welder light
8. Table light
9. Table speed (RPM)
10. Table cw/ccw switch
11. Welder switch
12. overlap
13. timer
14. Inch
15. Hold
16. Foot switch socket(4P)
17. Welder switch socket(3P)
18. Table motor socket(2P)
19. Limit switch socket(4P)

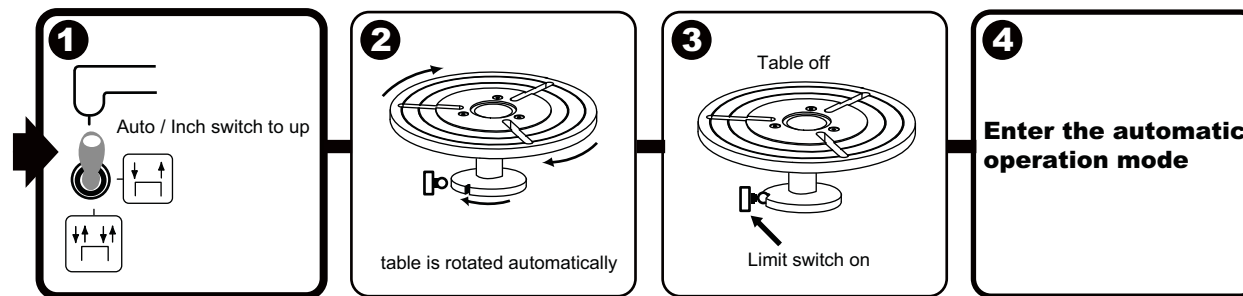
Specification / No.	C1802
Power	AC230V/1Ø
Power of the motor	DC 90V/150W
Rotate the direction	cw/ccw
Lap well timer(Fixing point)	0-99.9sec (Digital display , unit:0.1sec)
Timer(Fixing point)	0-999sec (Digital display , unit:1sec)
Arc way of the welder	<input type="checkbox"/> Standard
Line welder	1st
Stop the brake	Magnetism brake
H.F. Protect	92%
Start the device	Foot switch (Line 2M)

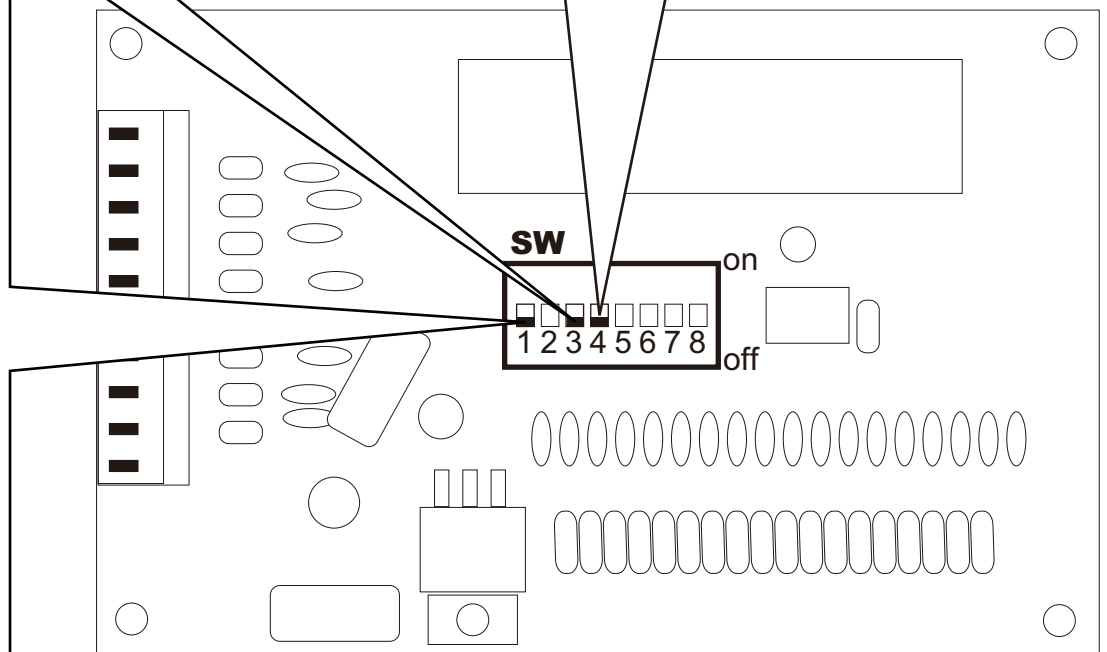
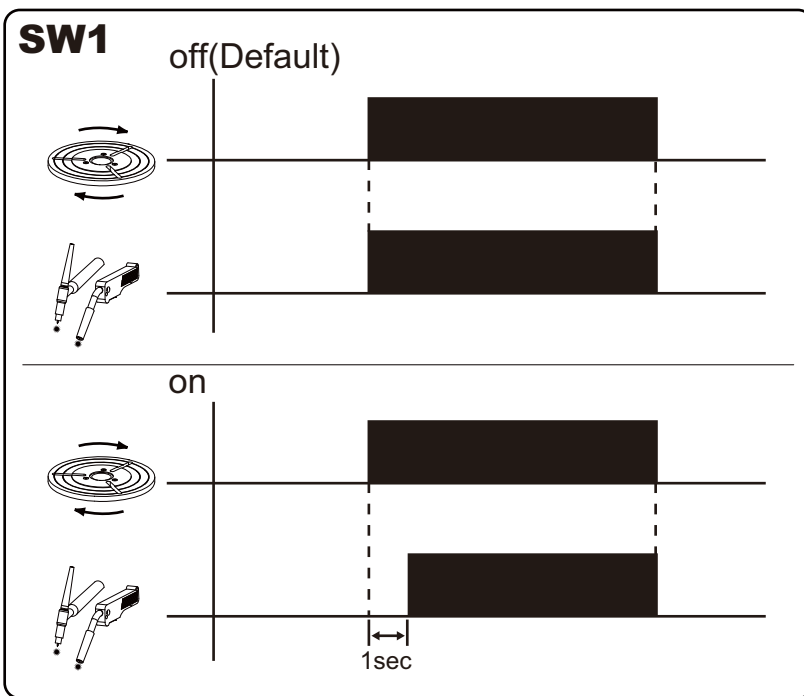
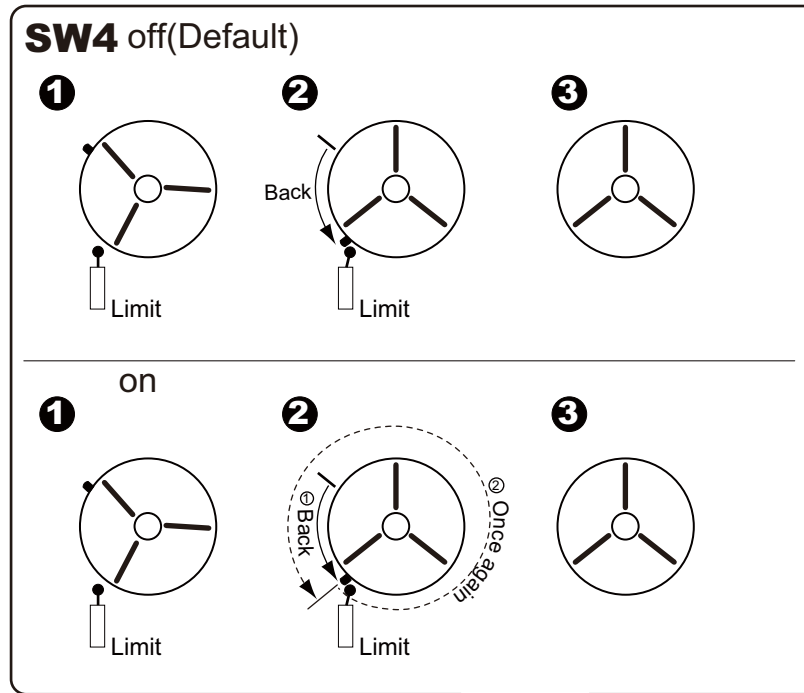
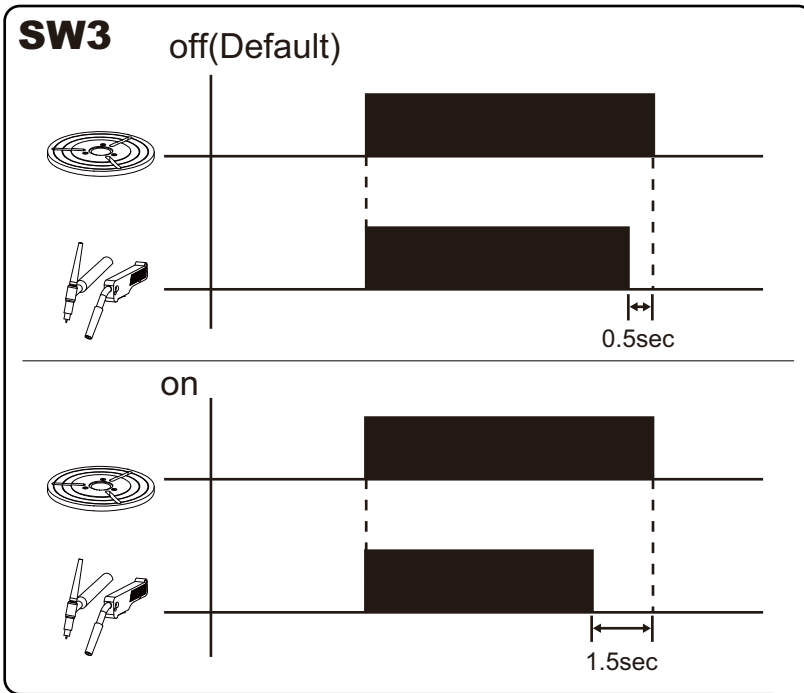


○ Automatic Hold (□ Standard)

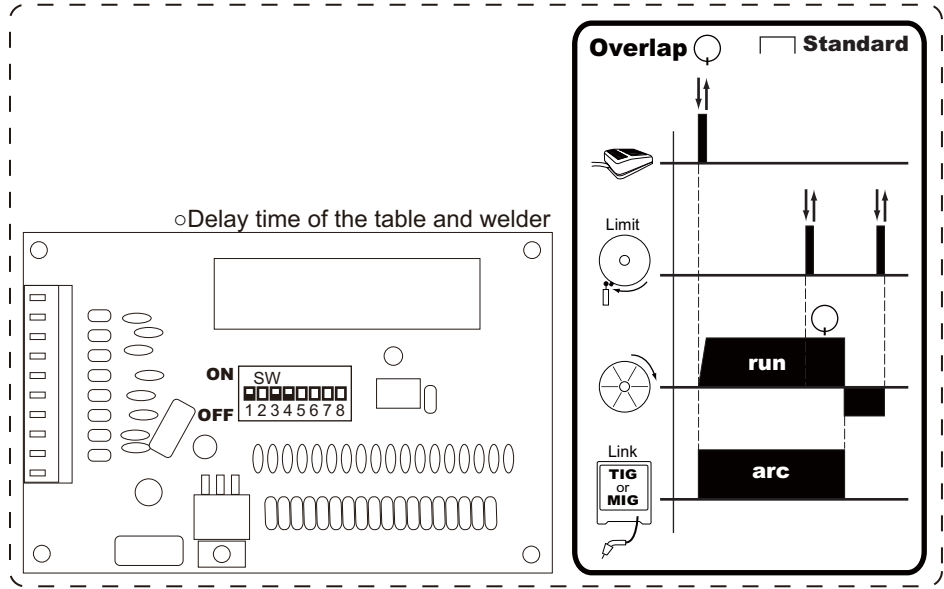
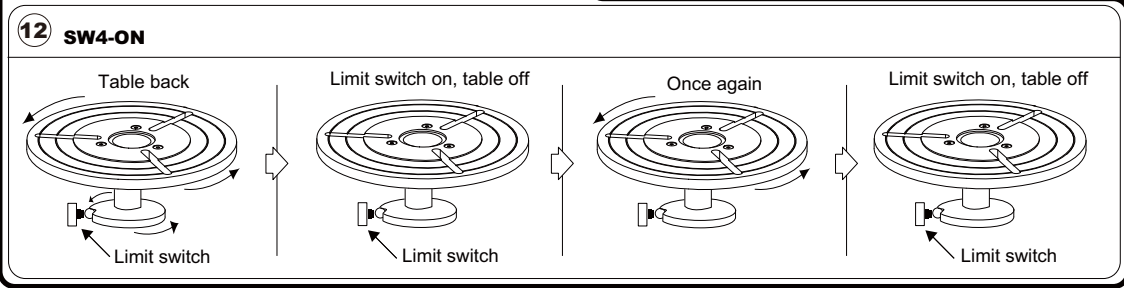
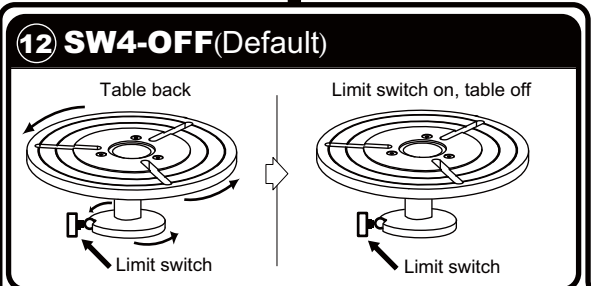
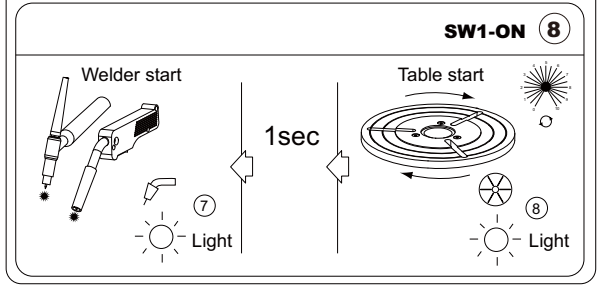
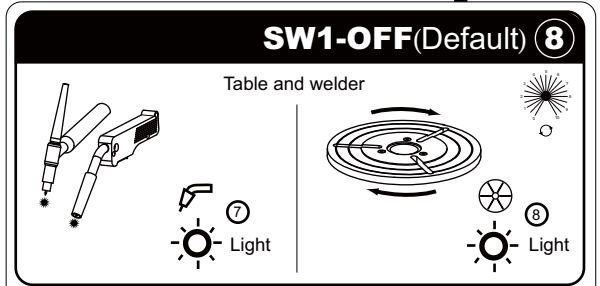
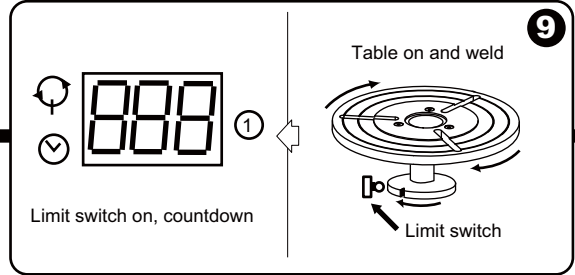
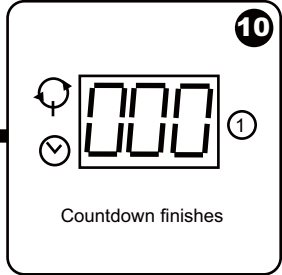
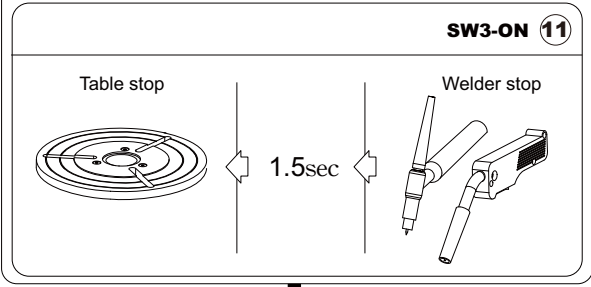
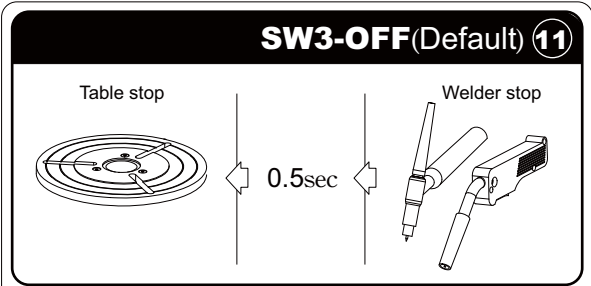
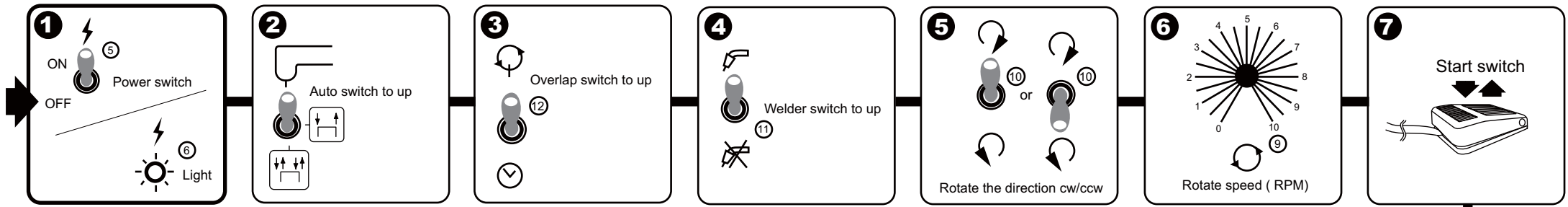


○The automatic operation mode





○Weld the overlap operating(□Standard)



○Weld the timing operating (Standard)

1

ON **5**
Power switch

OFF

6
Light

2

Auto switch to up

3

12
Timer switch to down

4

Welder switch to up

11

5

10 or **10**

Rotate the direction cw/ccw

6

Rotate speed (RPM)

7

Start switch

SW3-OFF(Default) 11

Table stop

0.5sec

Welder stop

SW3-ON 11

Table stop

1.5sec

Welder stop

12

Table back

Limit switch on, table off

Limit switch

10

Countdown finishes

9

Limit switch on, countdown

SW1-OFF(Default) 8

Table and welder

Light

Light

SW1-ON 8

Welder start

1sec

Table start

Light

Light

○Delay time of the table and welder

Timer Standard

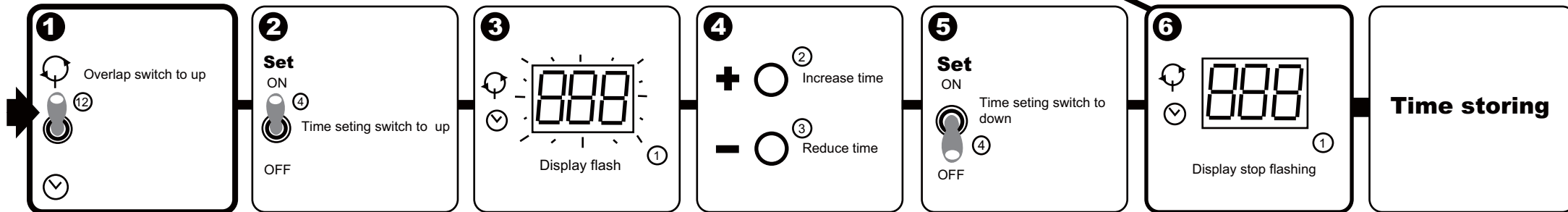
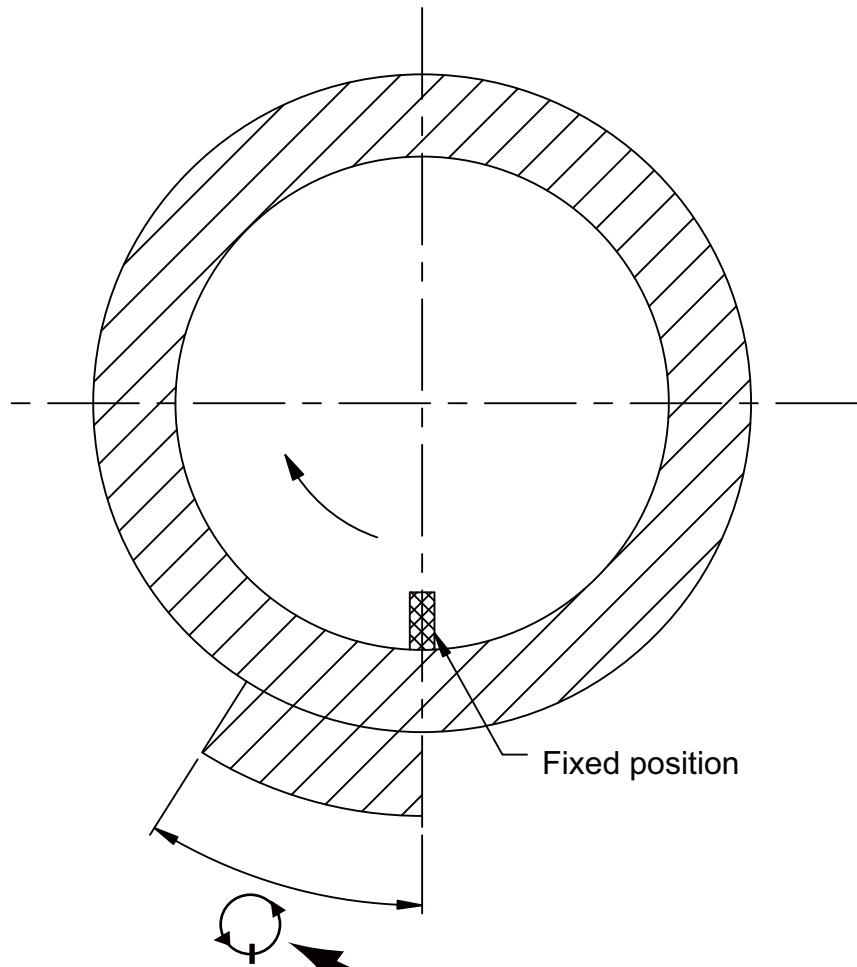
Limit

run

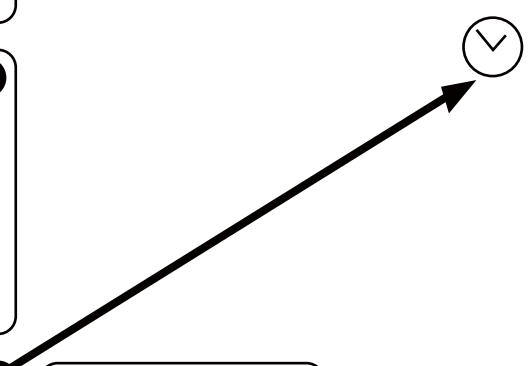
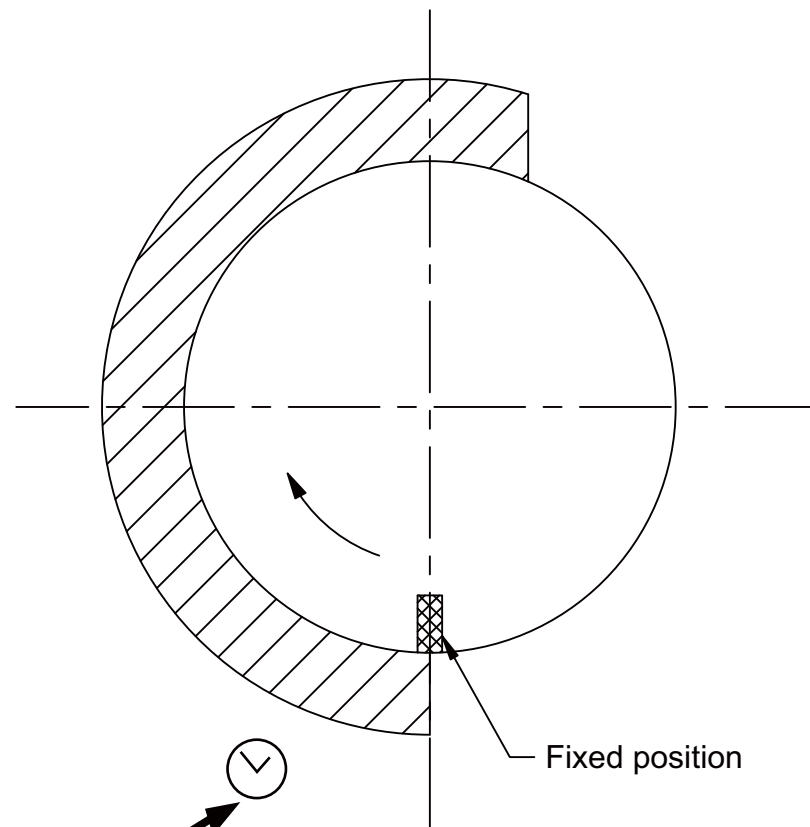
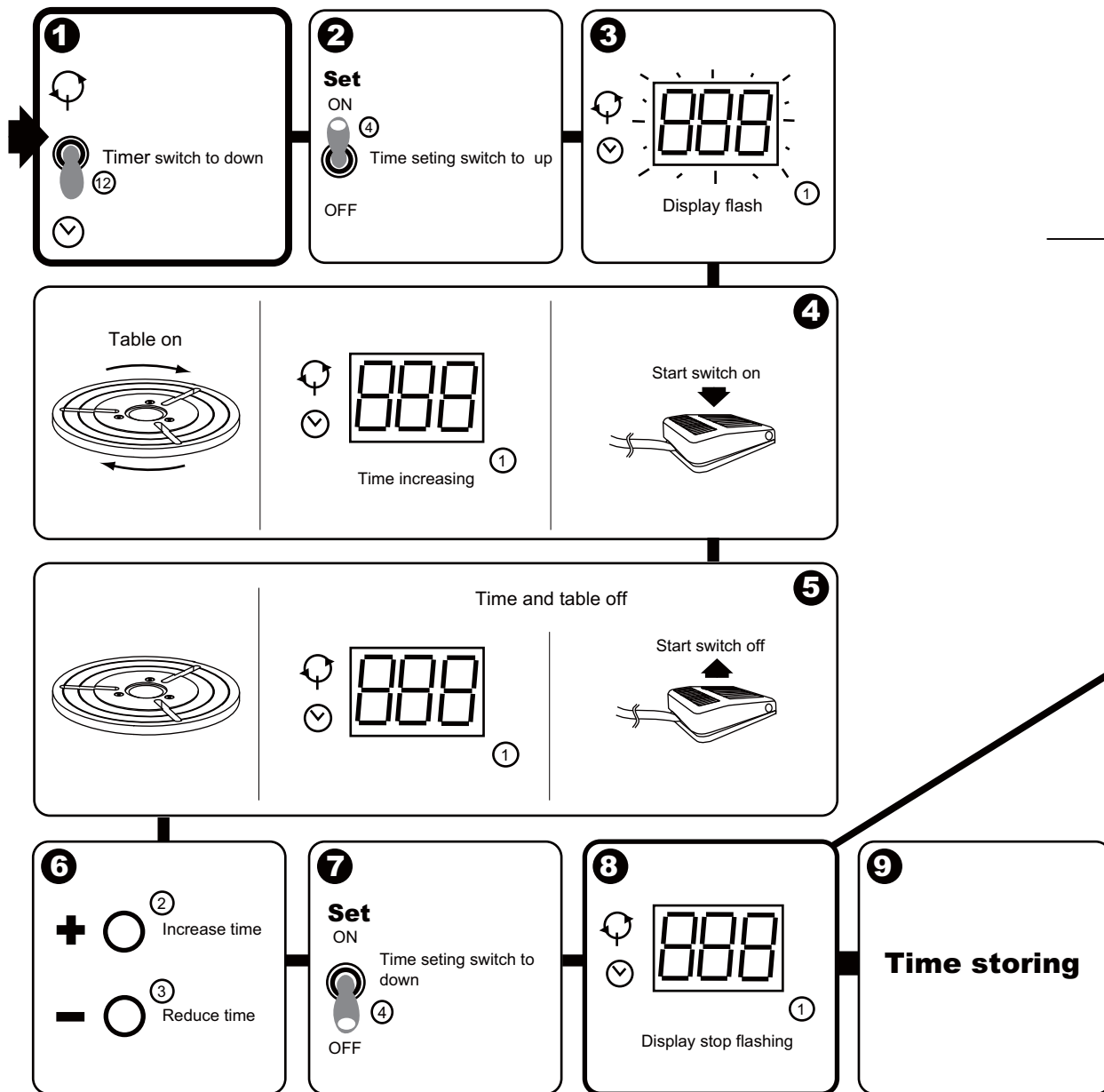
arc

Link TIG or MIG

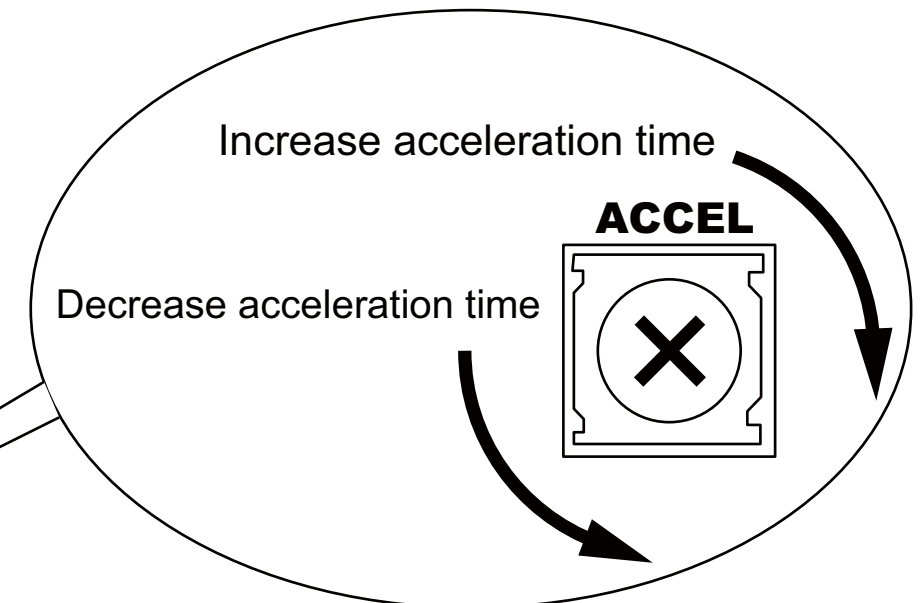
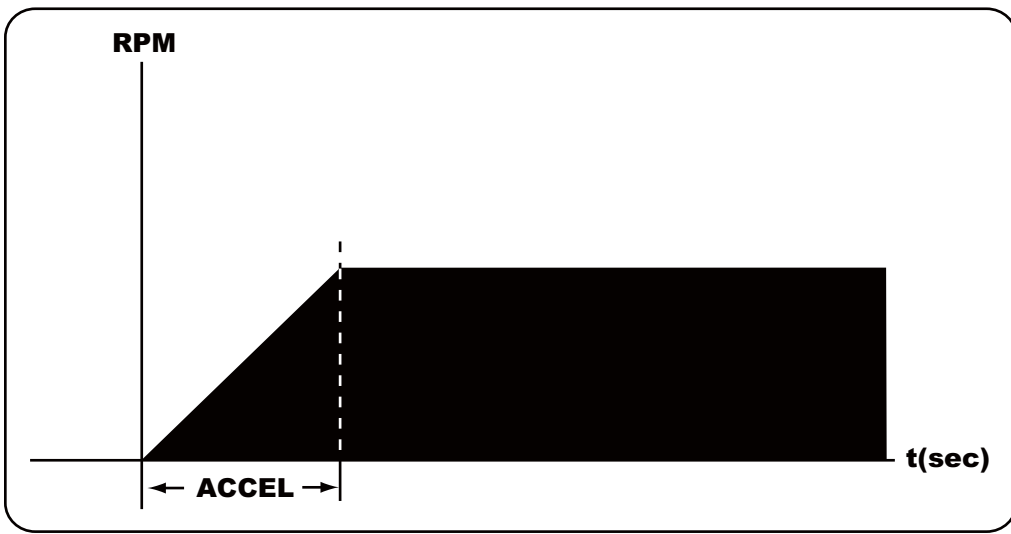
○Weld the overlap time establishing operating



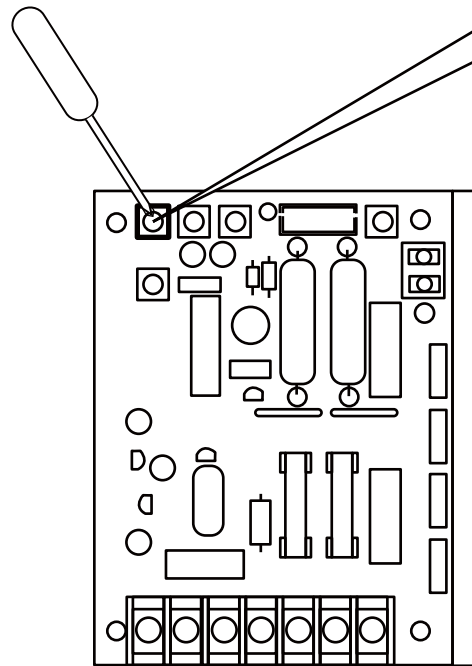
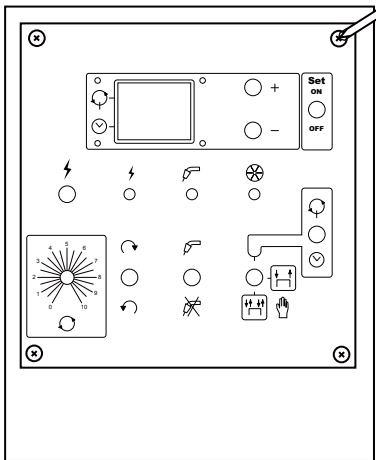
○ **Weld the overlap time establishing operating**



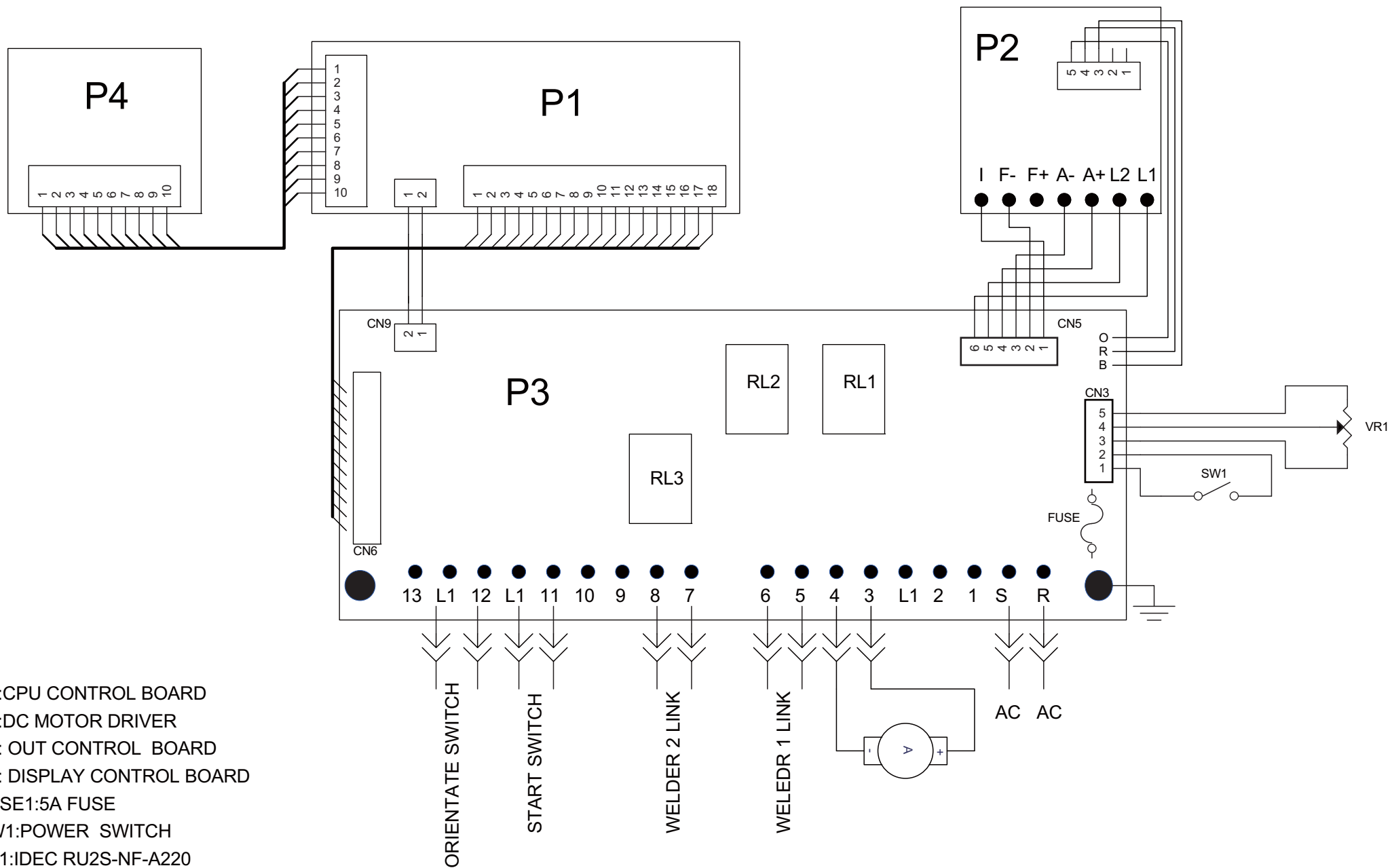
○ **Table start and accelerate time to adjust**



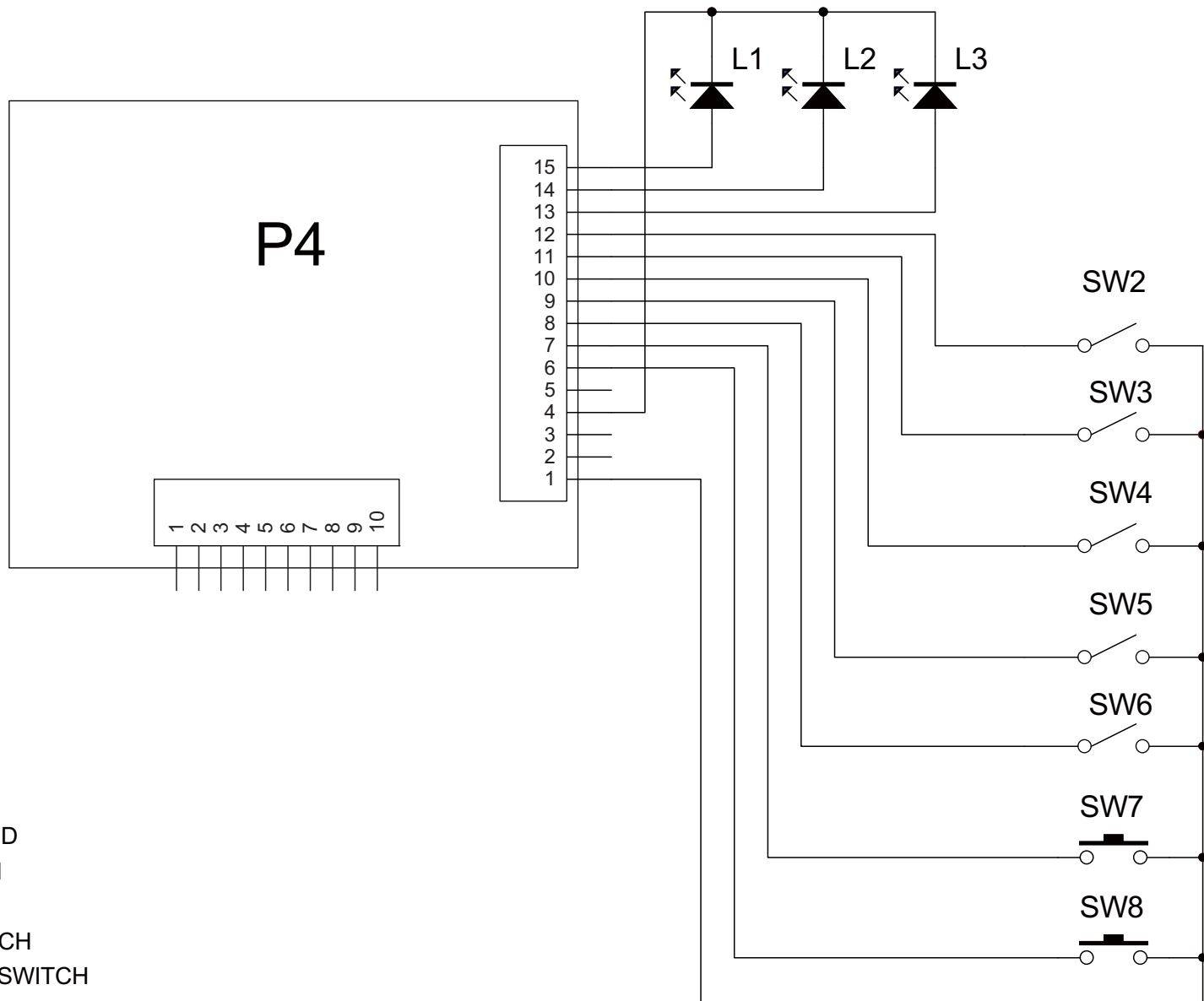
Open the control panel



DC motor driver



- P1:CPU CONTROL BOARD
- P2:DC MOTOR DRIVER
- P3: OUT CONTROL BOARD
- P4: DISPLAY CONTROL BOARD
- FUSE1:5A FUSE
- SW1:POWER SWITCH
- RL1:IDEC RU2S-NF-A220
- RL2:IDEC RU2S-NF-A220
- RL3:IDEC RU2S-NF-A220
- VR1:5Kohm RATATIONAL SPEED



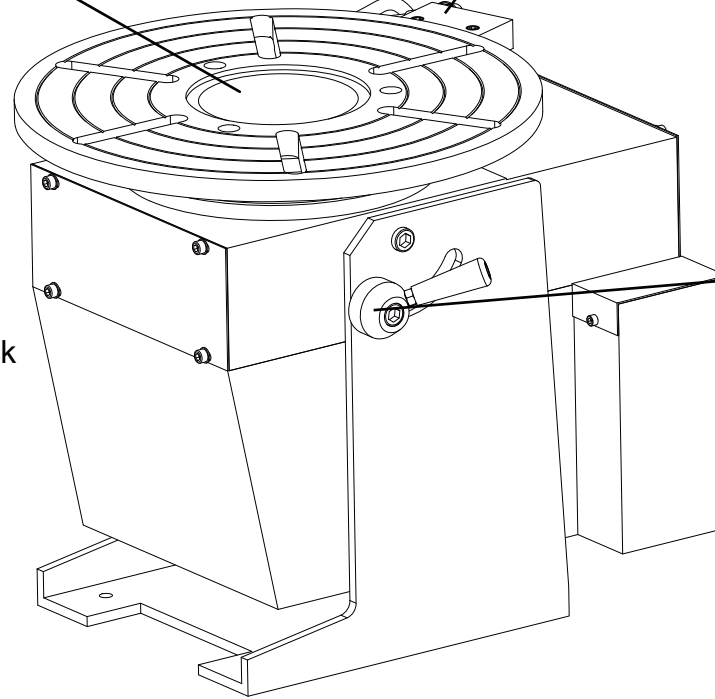
- L1: POWER LED
- L2:ACTINO LED
- L3:WELDER LINK LED
- SW2: AUTO SWITCH
- SW3:MODE SWITCH
- SW4:CW/CCW SWITCH
- SW5:WELDER LINK SWITCH
- SW6:TIMER SET SWITCH
- SW7: TIMER SET TO ADD SWITCH
- SW8:TIMER SET TO REDUCE

○ Structural Characteristics and Specification

● Internal diameter 120mm. Pass through holes

● Carbon brush electric conduction, the copper alloy outer cover dispels the heat.
● Air cooling, duty cycle 300A / 100%

● The table is electroplated, it is not apt to stick dregs.
● All right use of two sides of the table.
● Level nick and the standard lathe uses the 9" 3- chuck flange.



● The screw locks the regular angle
● Table angle range : -5° to 95°

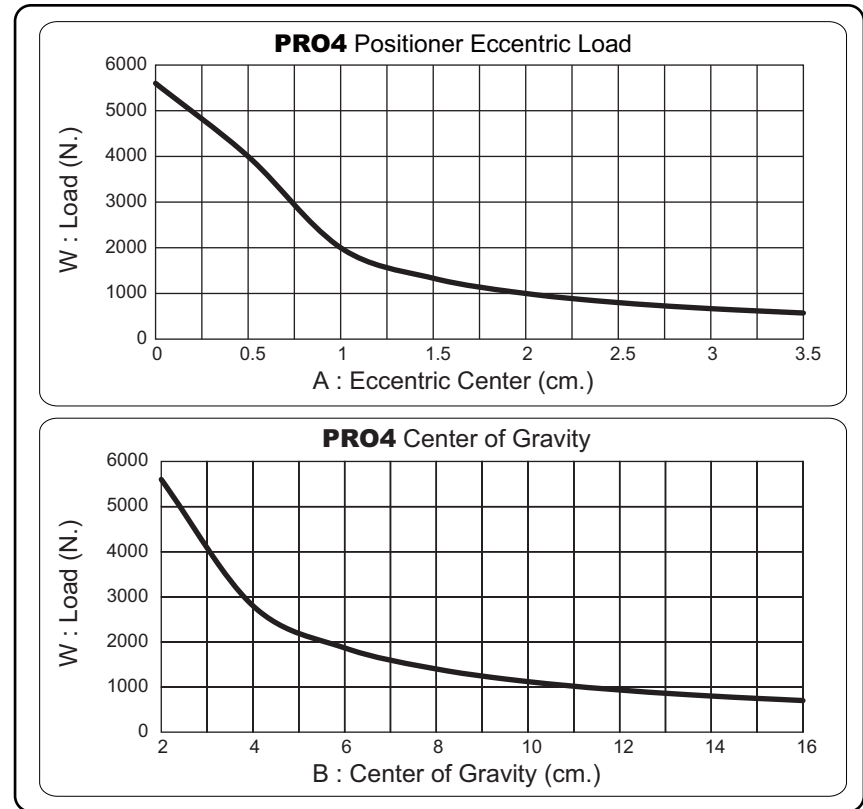
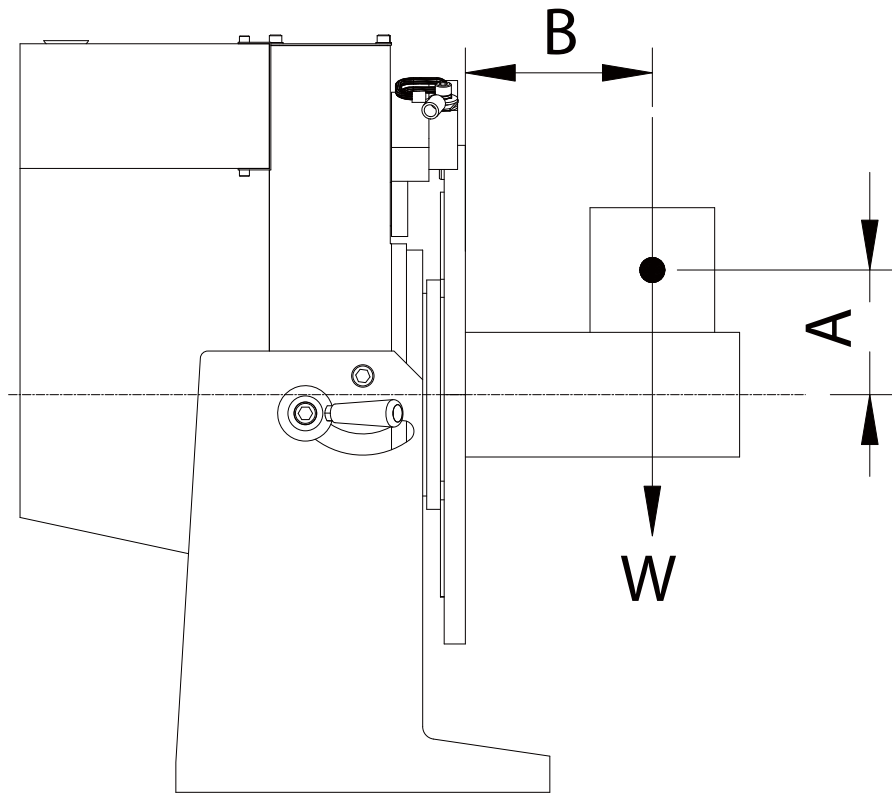
○ Welding methods

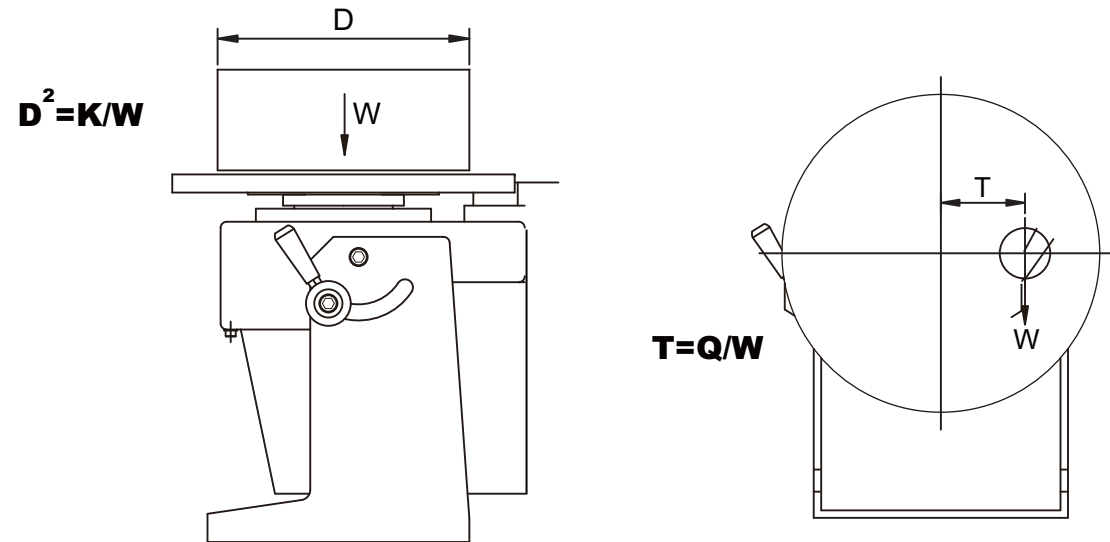
- MIG/MAG
- TIG
- Wire-TIG
- Plasma weld
- SAW

○ Duty Cycle

- Can operate in succession 100%
- Weld electric current 300A

modell	PRO 4
Netzspannung	AC 230 V/50 Hz
Masseanschluss	300 A/100 %
Kippbereich	0° - 90°
Drehtellerdurchmesser	400 mm
Hohlwelle	120 mm
Drehzahl	0,2 - 2 rpm
Drehrichtungen	rechtsdrehend/ linksdrehend
Max. Belastung A	400 kg
H. F. Schutz	92 %
Maße (LxBxH)	480x400x425 mm
Gewicht	69 kg





Calculate

1. Before needing to know the diameter of the work piece, Please according to the (K) value shown of the model performance form of the rotary table [Diameter / weight], Calculate according to the formula. Formula $D^2 = K/W$ Unit D=cm W=kg

Example:

Take rotary table of POS1C as an example, The weight of the work piece is 100kg. The formula calculating:

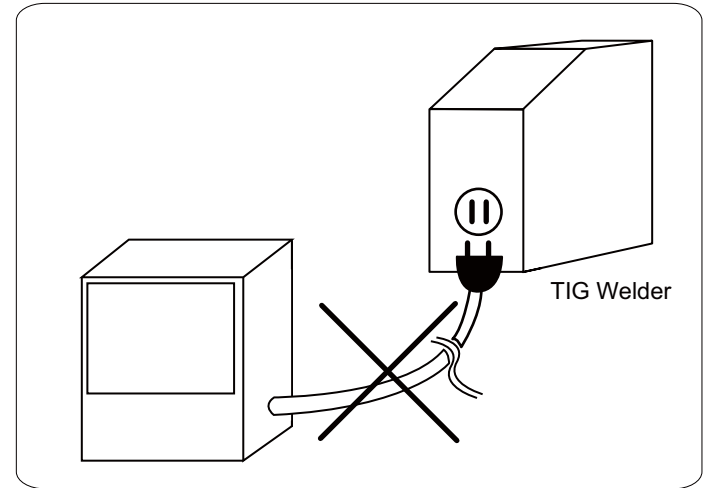
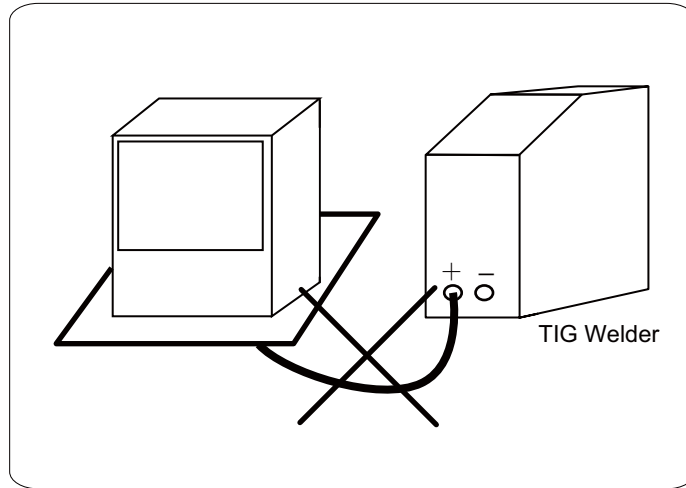
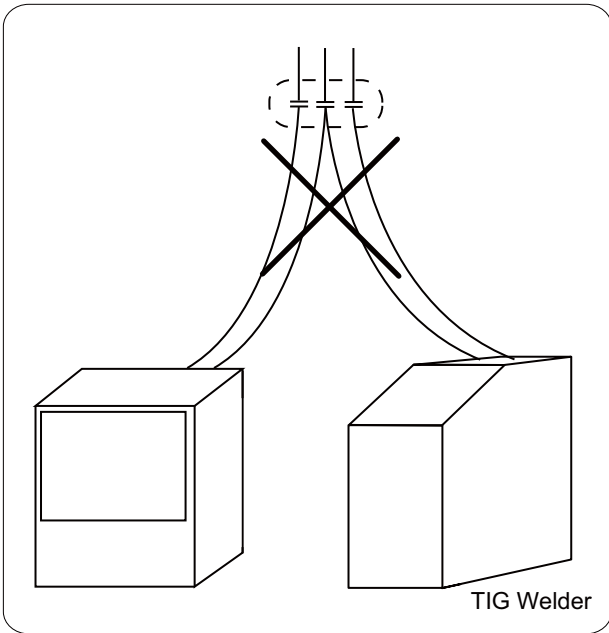
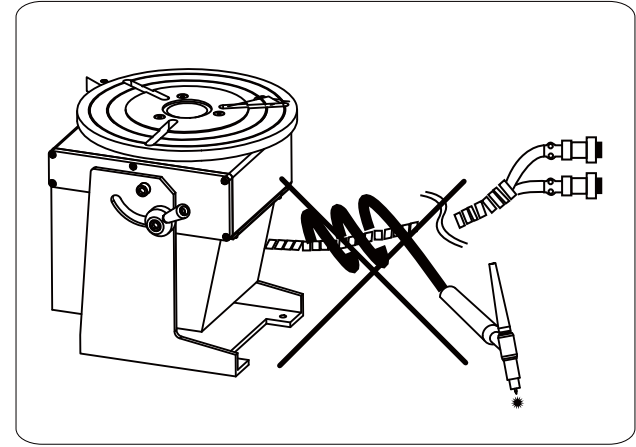
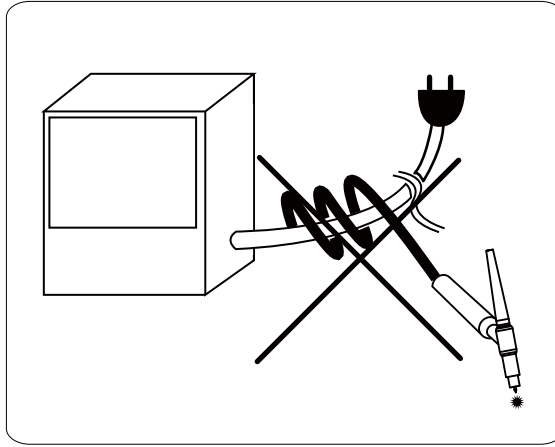
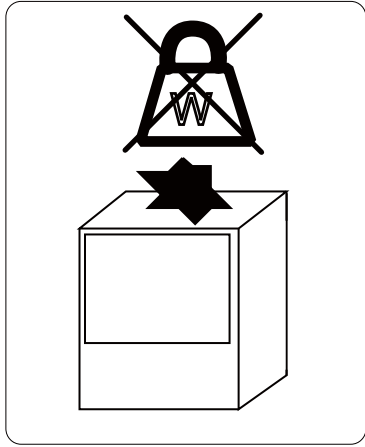
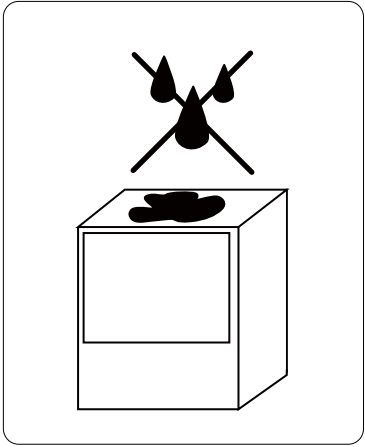
$D^2 = 297108/100 = 2971.08$ Know after calculating D=54.5cm (Work piece diameter)

2. Before needing to know the Center skew of the work piece, Please according to the (Q) value shown of the model performance form of the rotary table [Skew / weight], Calculate according to the formula. Formula $T = Q/W$ Unit T=cm W=kg

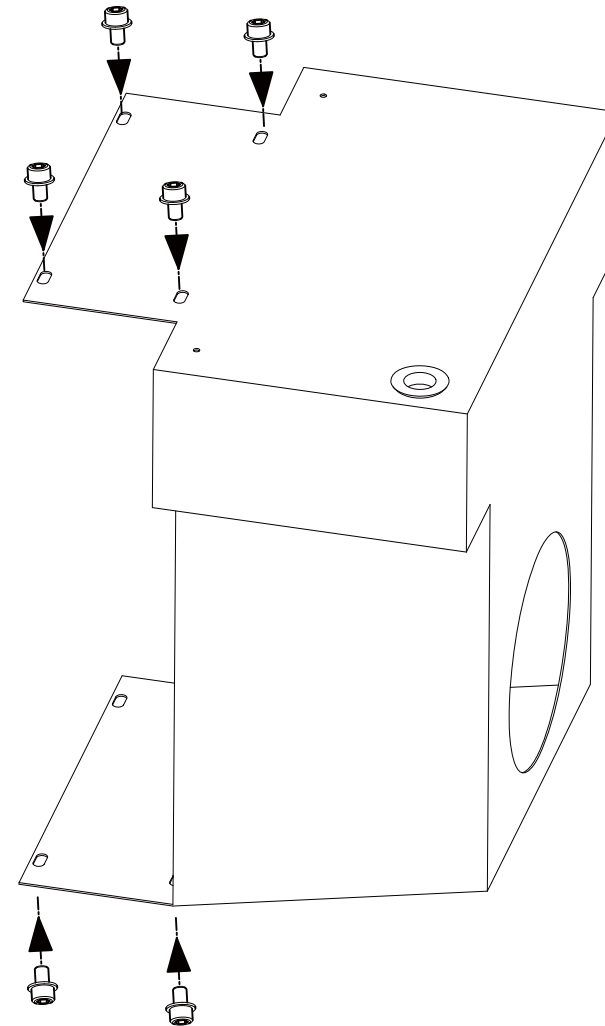
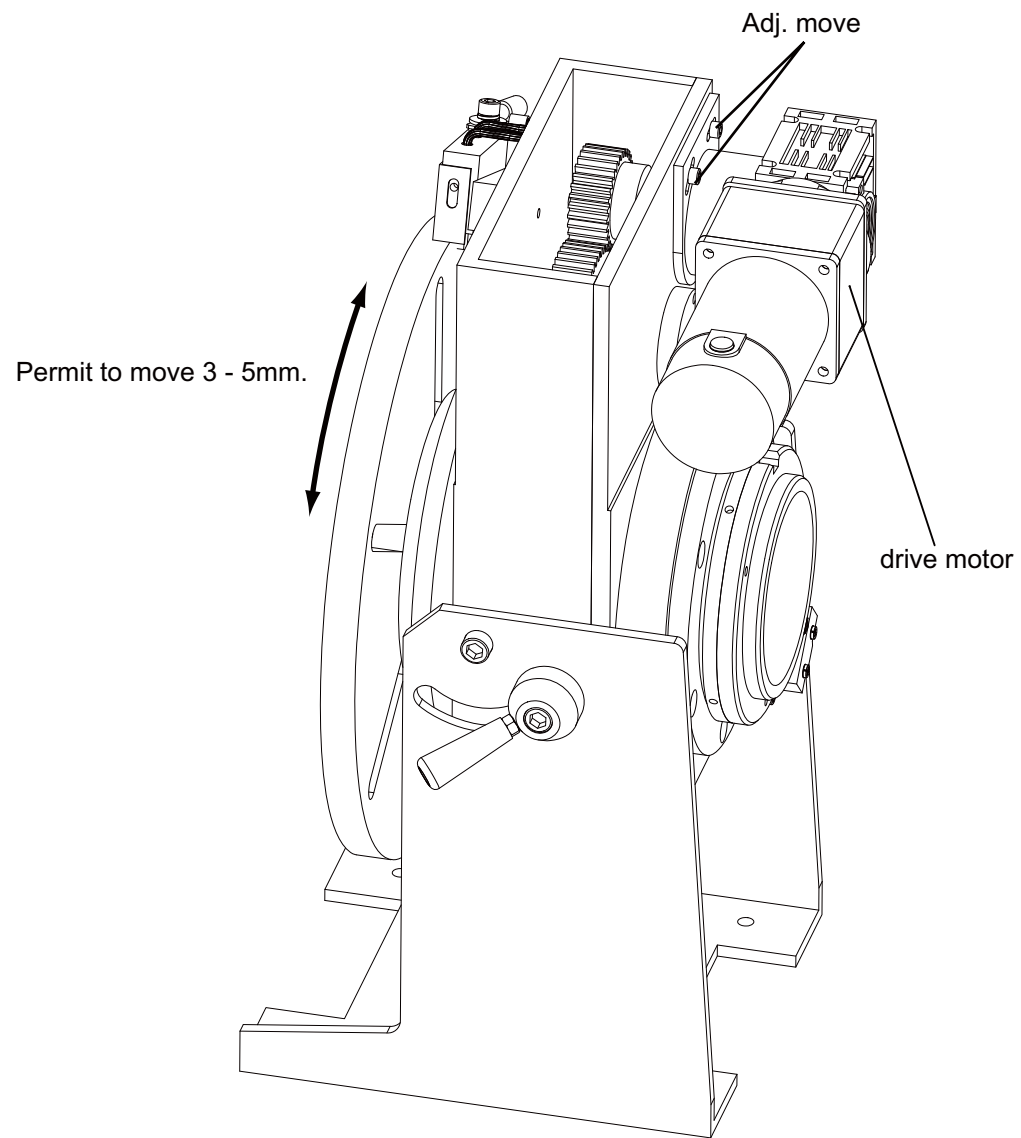
Example:

Take rotary table of POS2B as an example, The weight of the work piece is 120kg. The formula calculating:

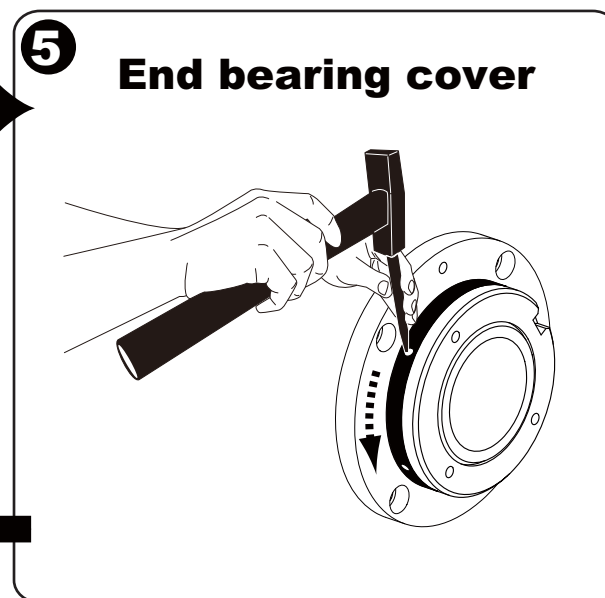
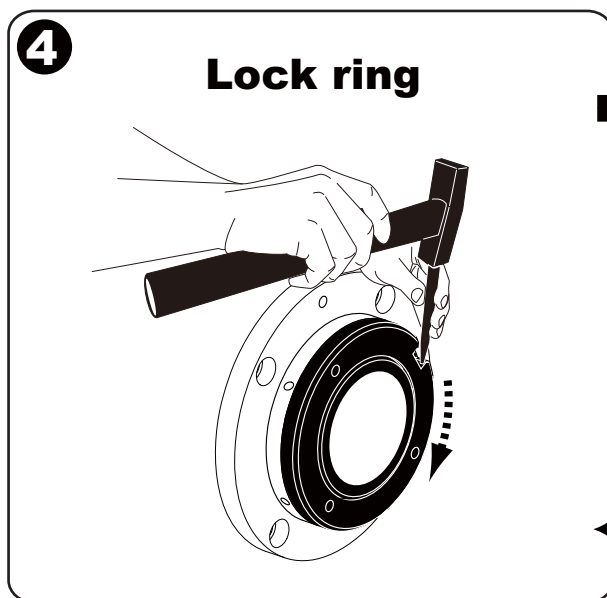
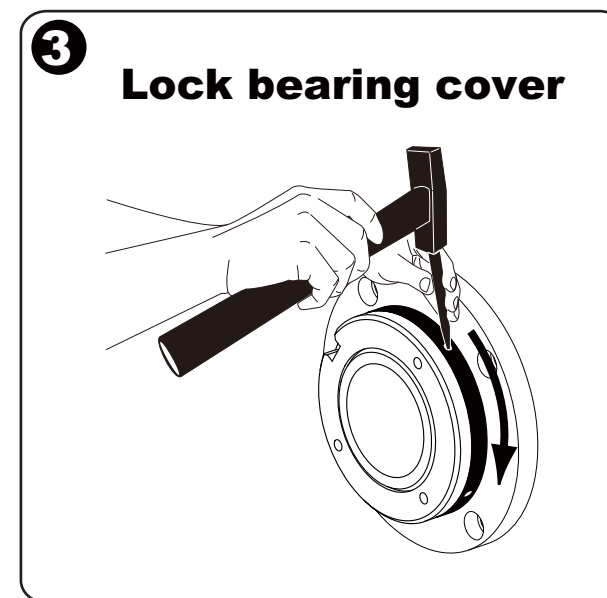
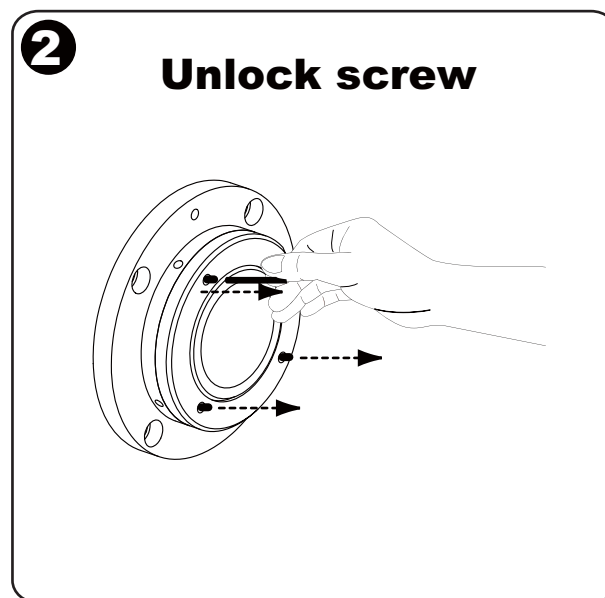
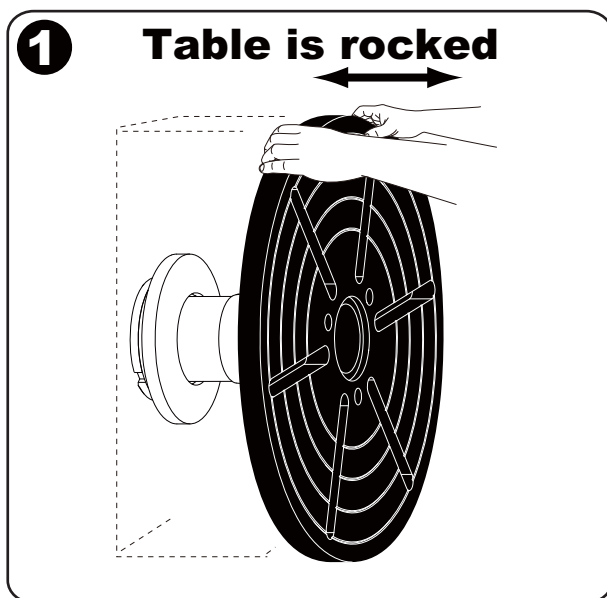
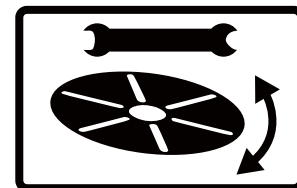
$T = 175/120$ Know after calculating T=1.45cm (Work piece center skew)



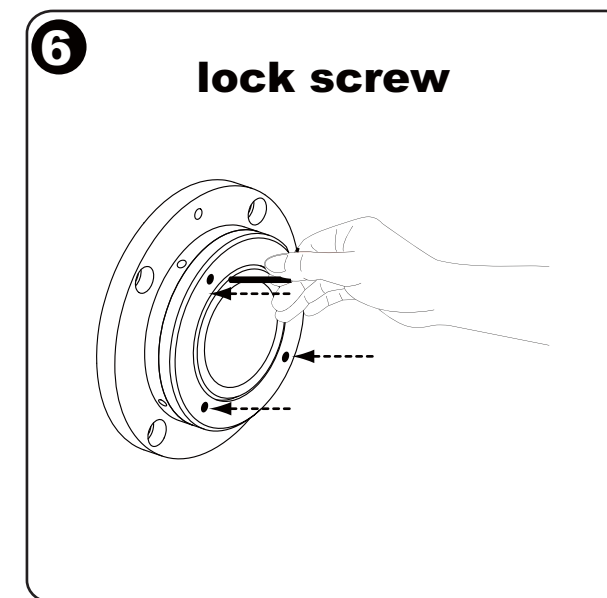
○ Install the method of the drive motor

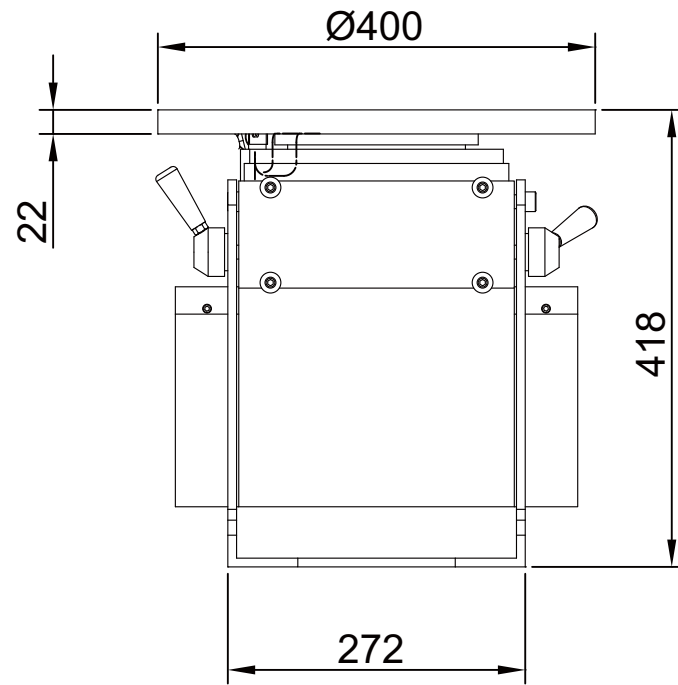
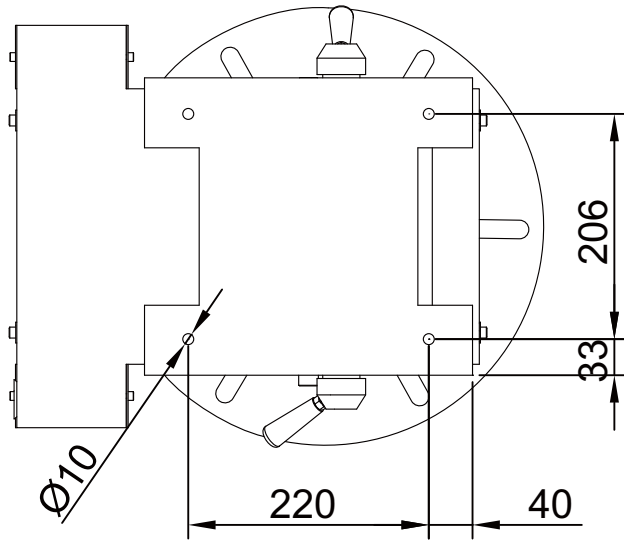
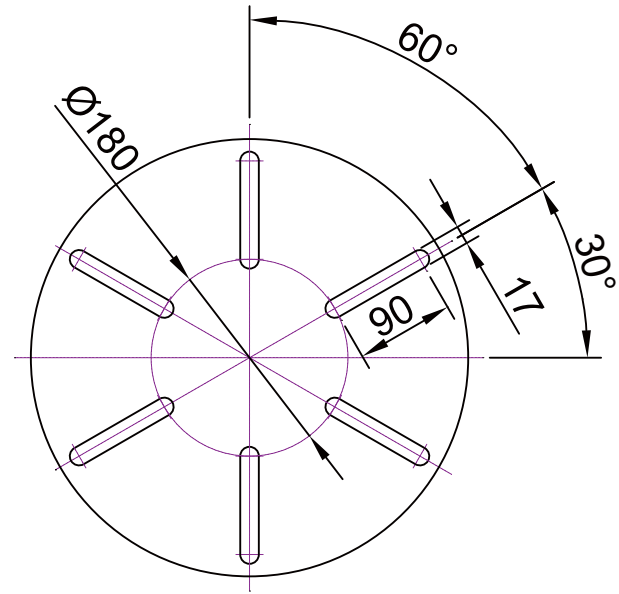
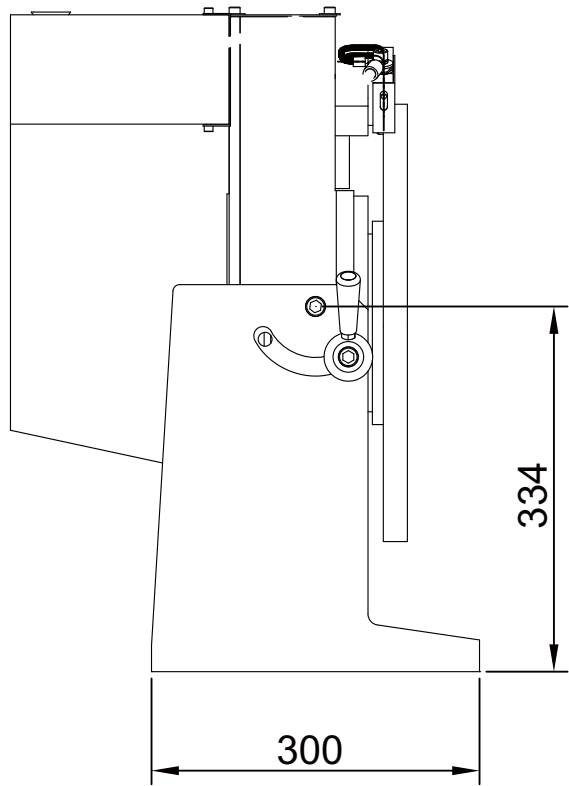


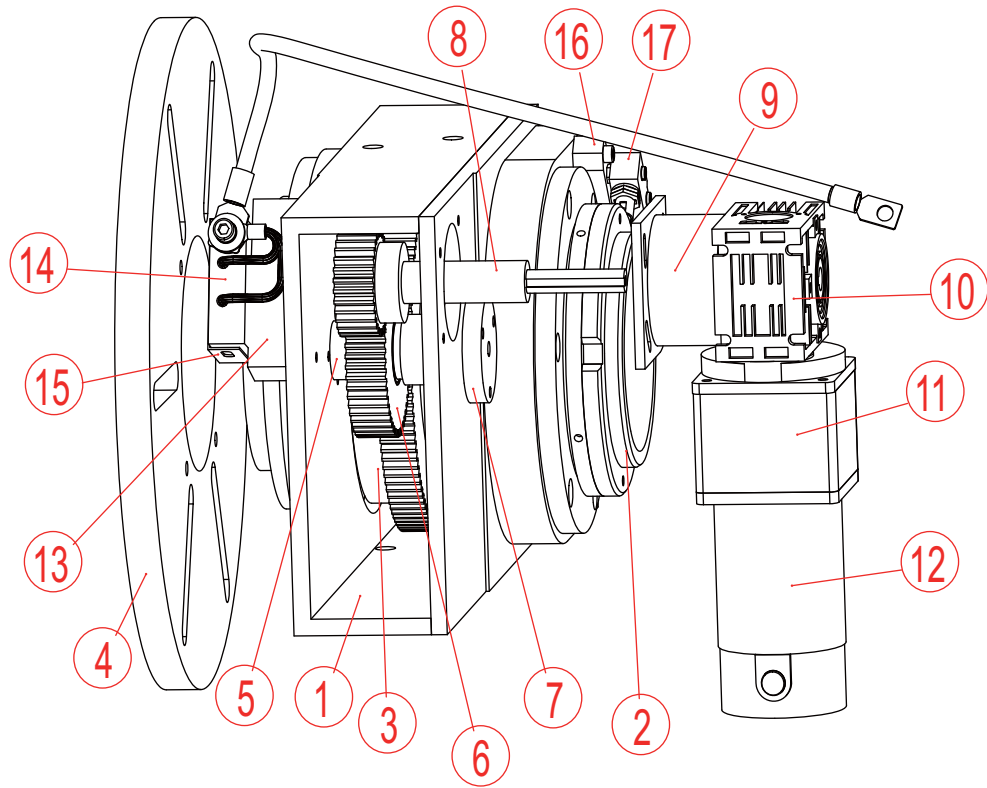
Rotate the table and confirm moving the distance(3 - 5 mm) with hands, lock the drive motor



Repeat 3-5 times

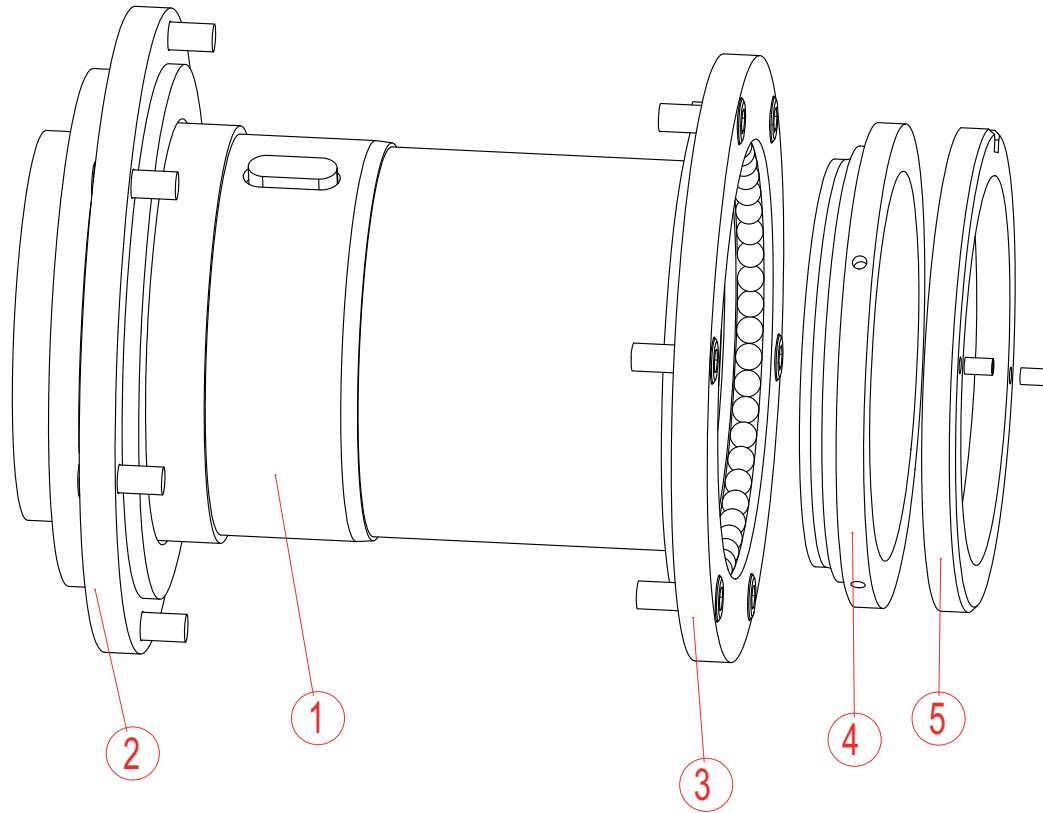




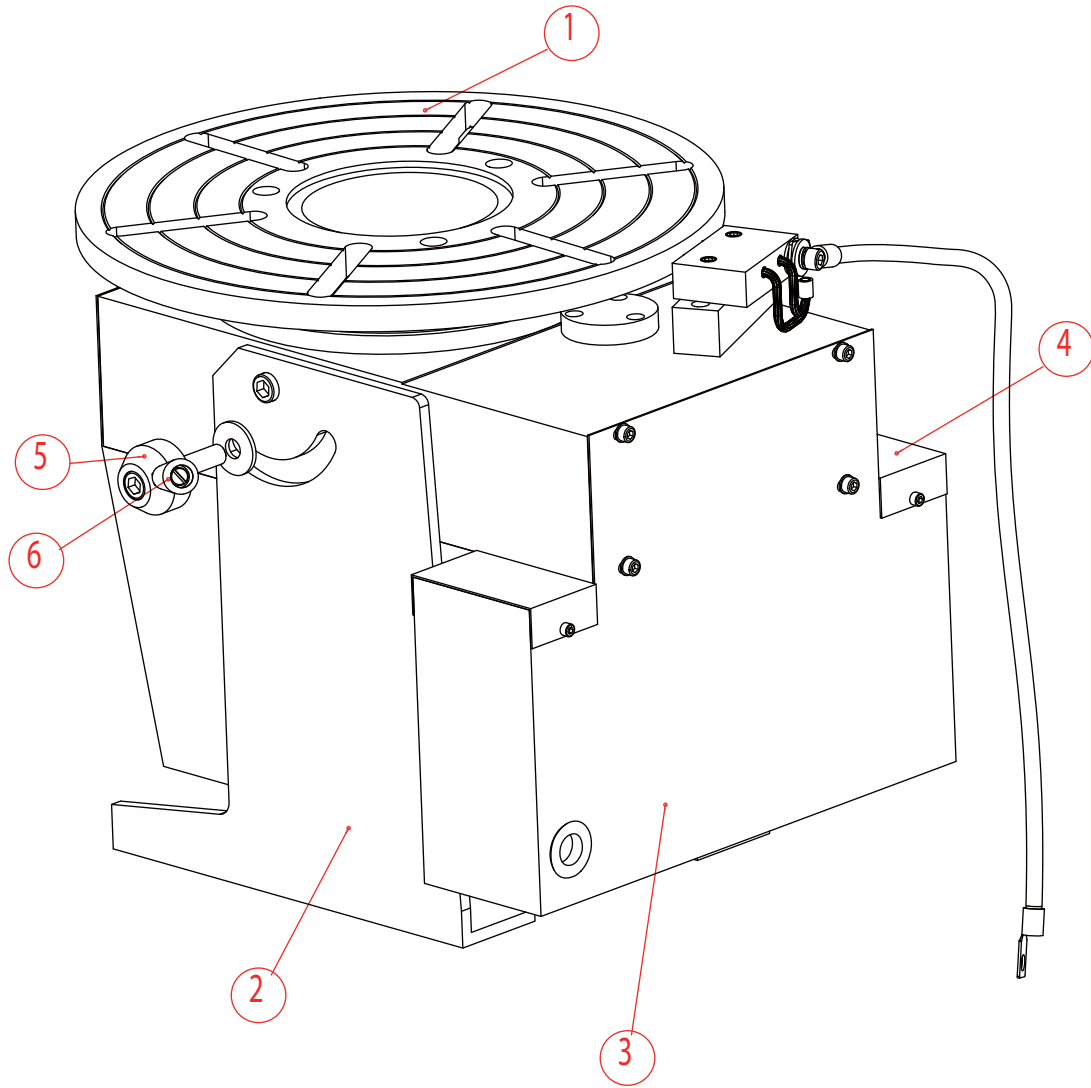


Item	Part No.	Part Name	Q'TY
1	P120D-01	Table case	1
2	P120D-A1-1	Table axis group	1
3	P120D-08	Table gear	1
4	P120D-07	Table	1
5	P120D-09	movable gear axle	1
6	P120D-10	gear	1
7	P120D-11	Ring	1
8	P120D-12	Drive gear	1
9	P120D-14	axle	1
10	FO32	Worm Gear Reducer	1
11	5GN	Gear Reducer	1
12	DC65W	DC Motor	1
13	P120D-15	Block	1
14	P100A3	Welding ground	1
15	P1008-4(A)	Cover	1
16	P1010	Limit one	1
17	TM1308	Limit Switch	1

•Table axis group(P120D-A1-1)



Item	Part No.	Part Name	Q`TY
1	P120D-02	Table axis	1
2	P120D-03	Front bearing	1
2-1	OD-3	Steel ball 3/8"	53
3	P120D-04	End bearing	1
4	P120D-05	End bearing cover	1
5	P120D-06	Lock ring	1



Item	Part Name	Part No	Quantity
1	Table case group	P120D-A1	1
2	Table shelf	P2001	1
3	Motor cover	P120D-16	1
4	cover	P120D-17	1
5	Angle fixed screw	P1006	2
6	Handle	PH-W5/16	2