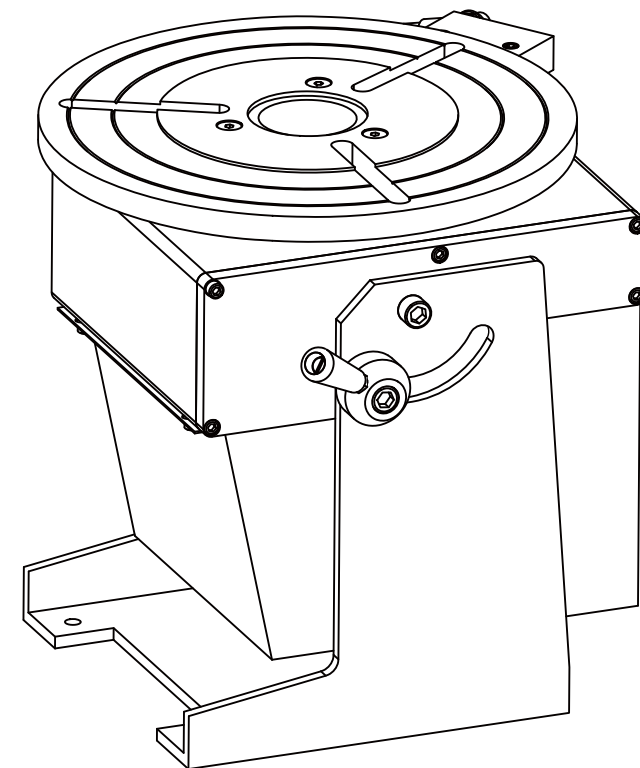
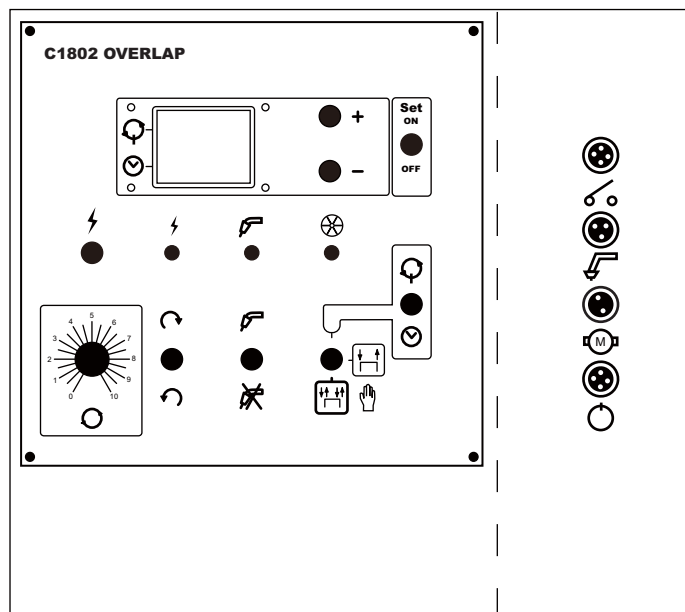


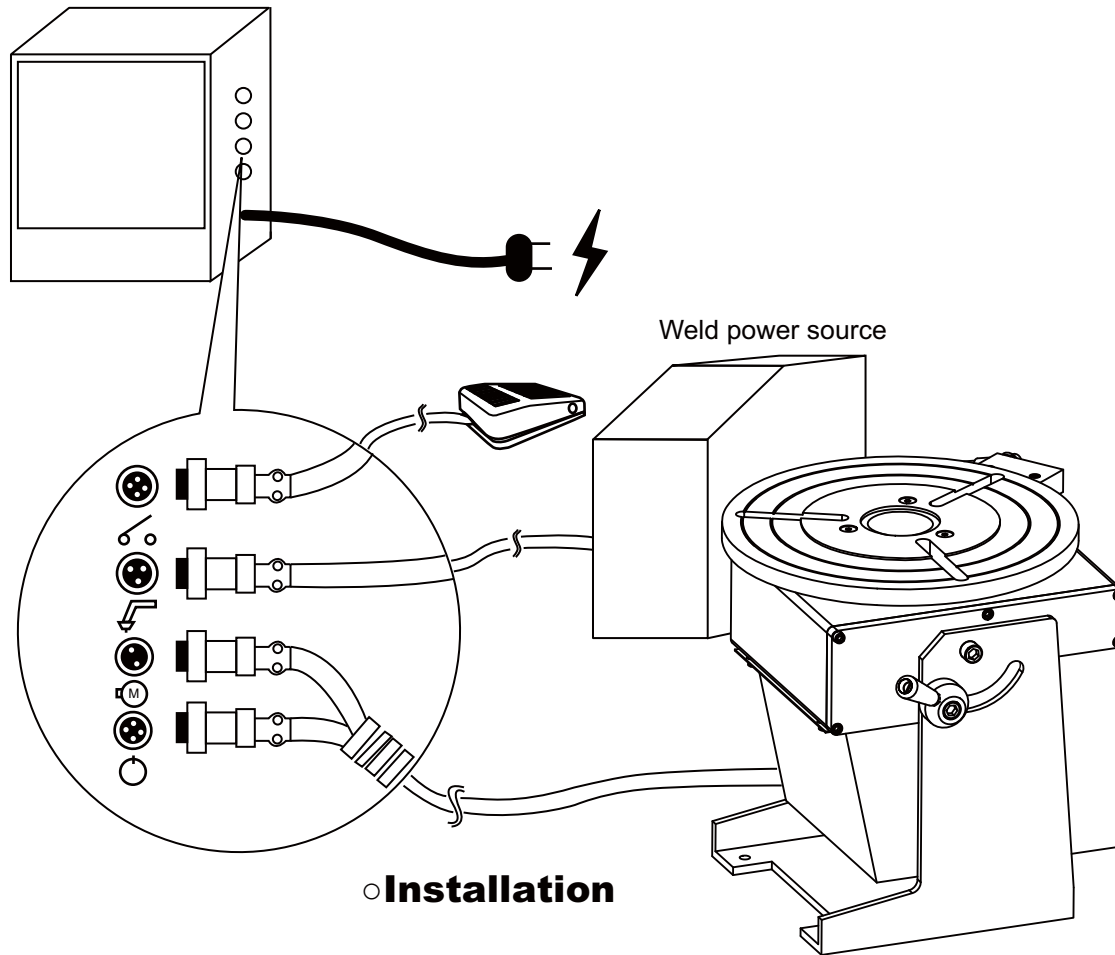
Owner's Operating Manual

Models

PRO3



○ Structural Characteristics

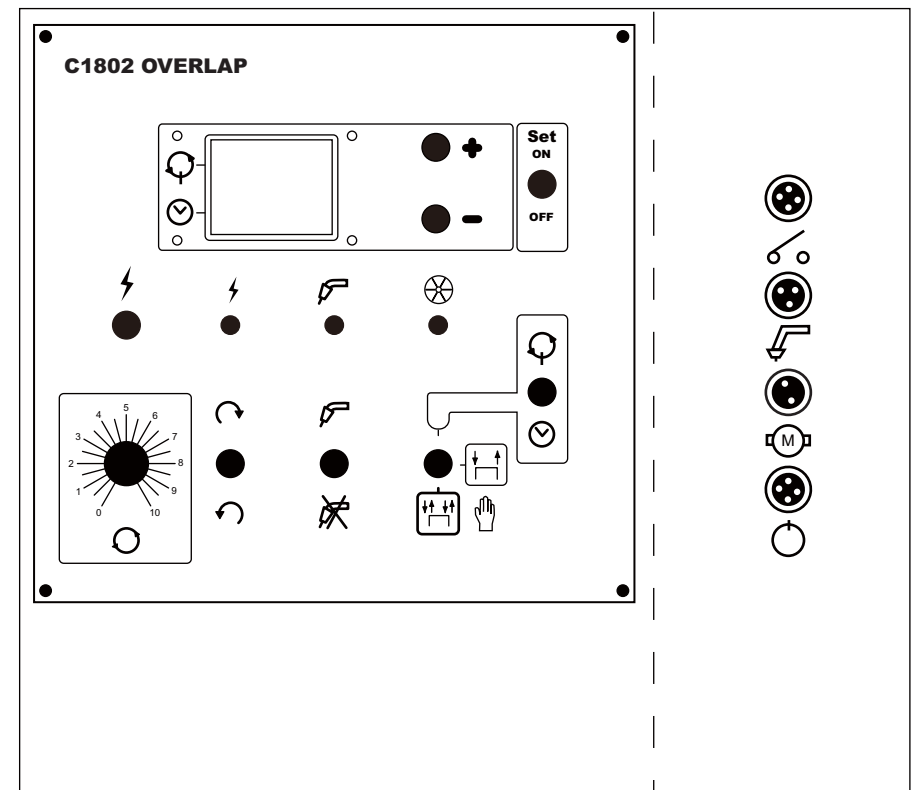


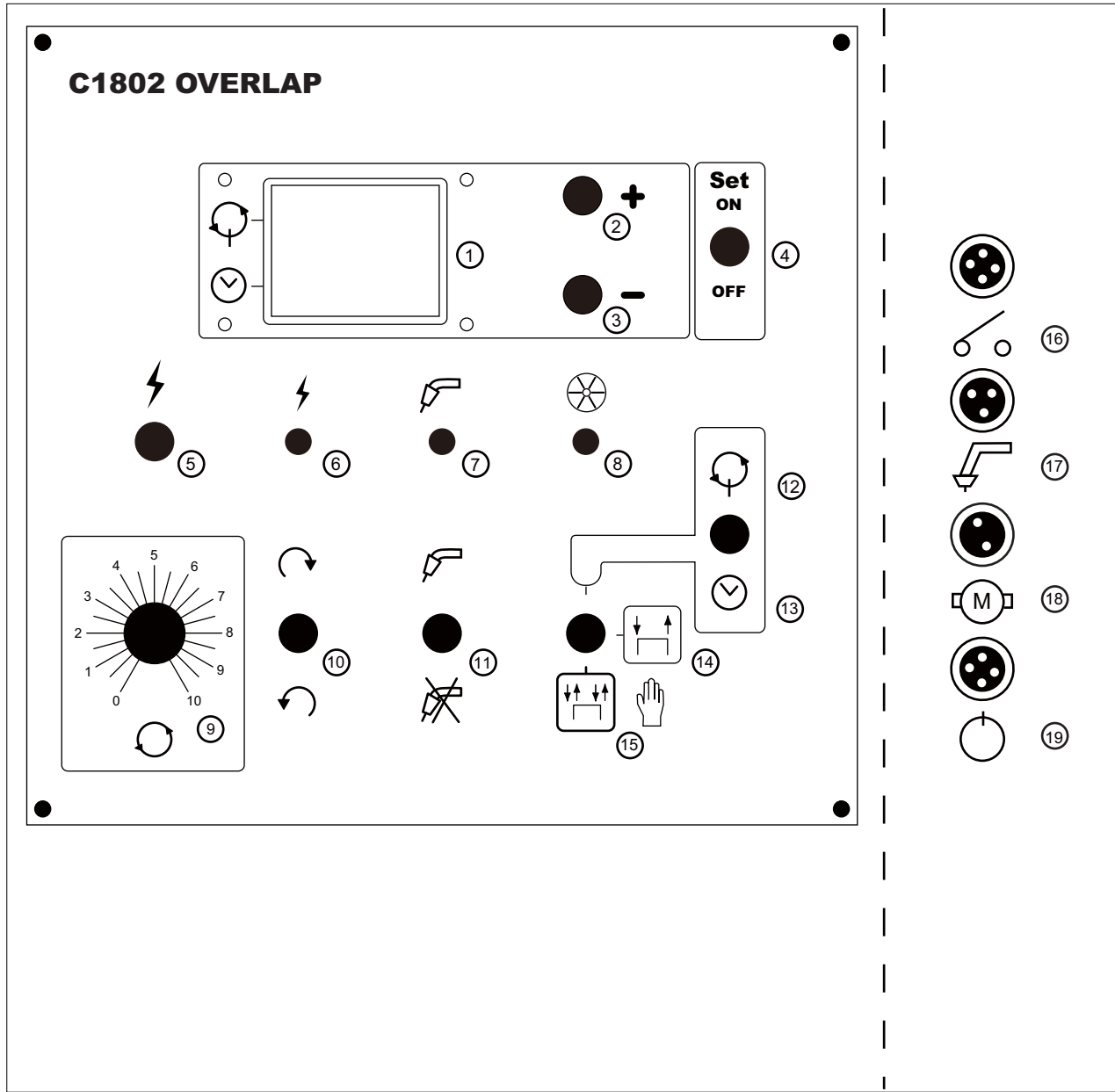
○ Welding method that can be matched

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

○ Duty Cycle

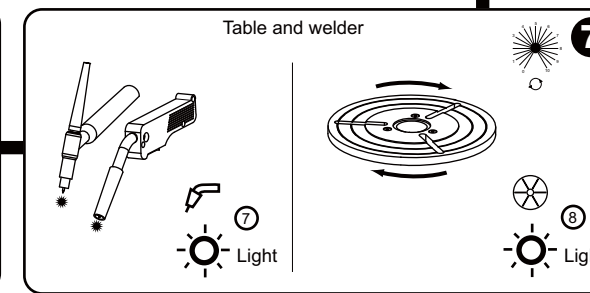
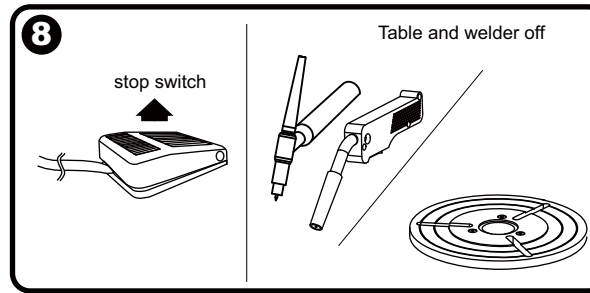
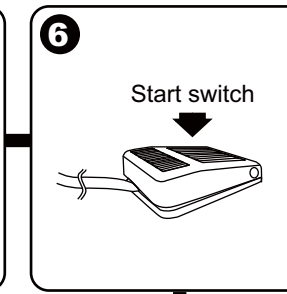
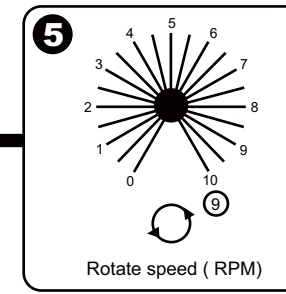
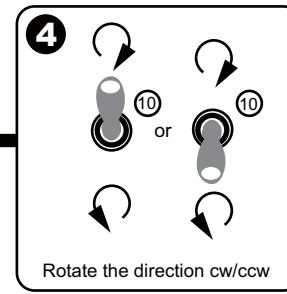
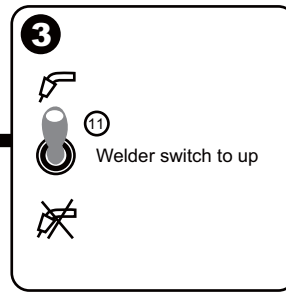
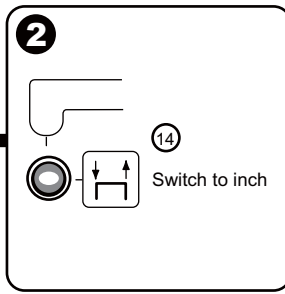
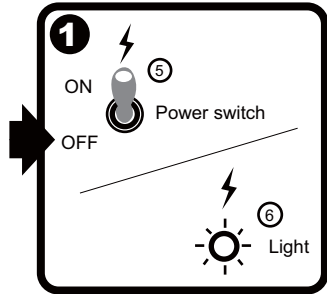
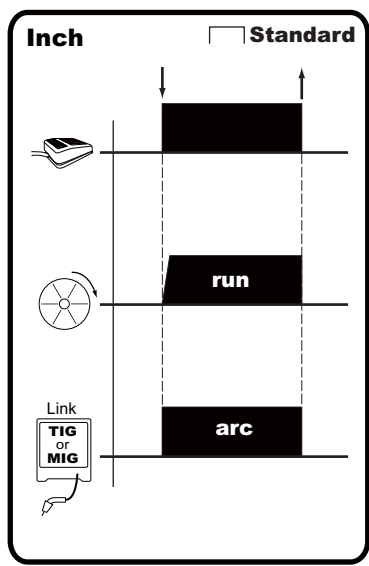
- Can operate in succession 100%
- Weld electric current 300A



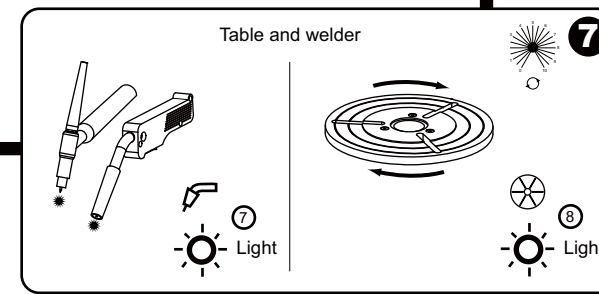
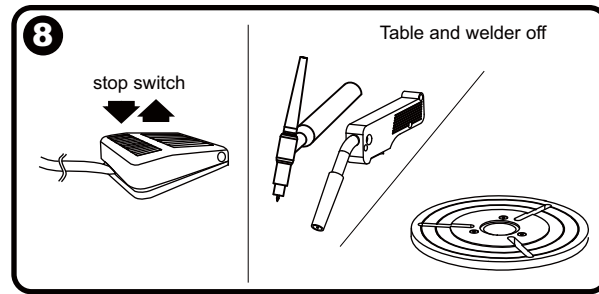
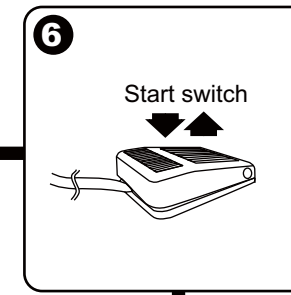
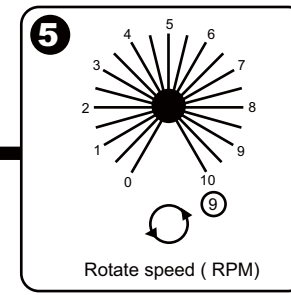
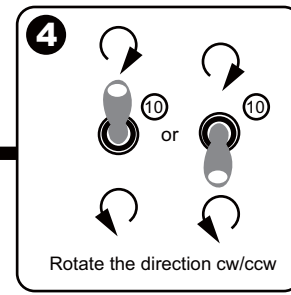
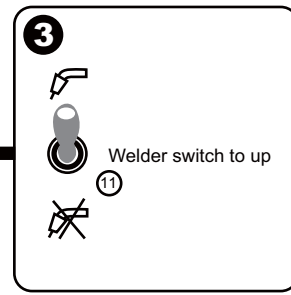
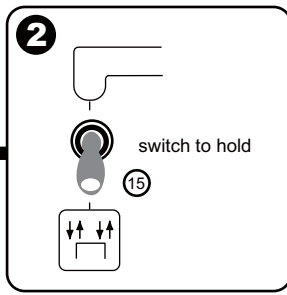
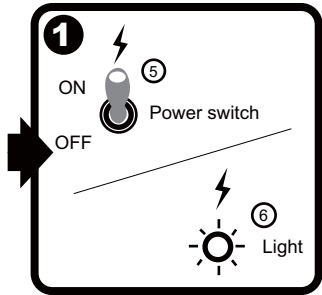
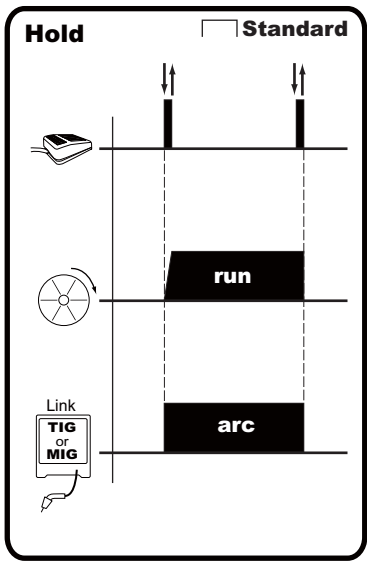


1. Time data (Unit : 0.1sec)
2. Set button (+)
3. Set button (-)
4. Time setting switch
5. Power switch
6. Power light
7. Welder light
8. Table light
9. Table speed (RPM)
10. Table cw/ccw switch
11. Welder switch
12. overlap
13. timer
14. Inch
15. Hold
16. Foot switch socket(4P)
17. Welder switch socket(3P)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

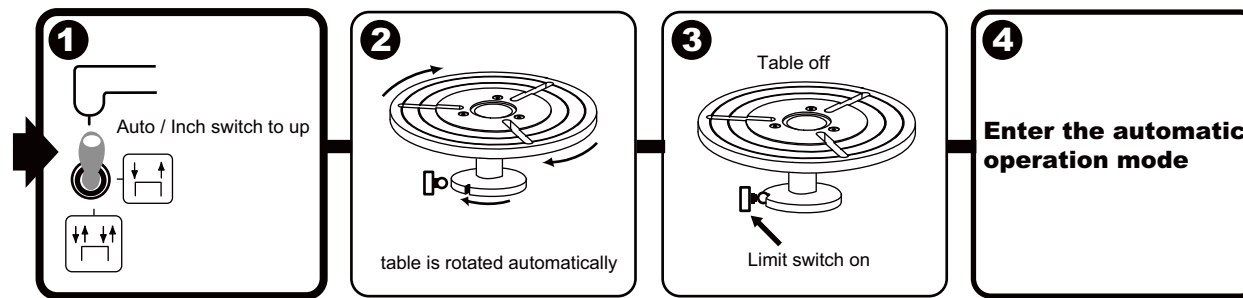
Specification / No.	C1802
Power	AC230V/1Ø
Power of the motor	DC 90V/150W
Rotate the direction	cw/ccw
Lap well timer(Fixing point)	0-99.9sec (Digital display , unit:0.1sec)
Timer(Fixing point)	0-999sec (Digital display , unit:1sec)
Arc way of the welder	<input type="checkbox"/> Standard
Line welder	1st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

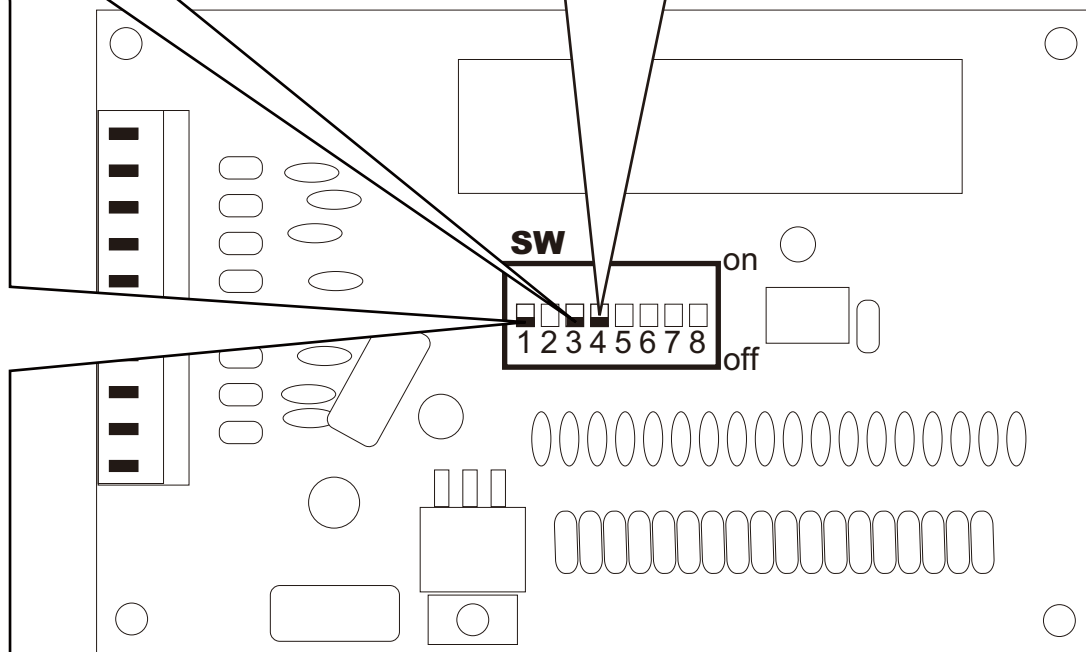
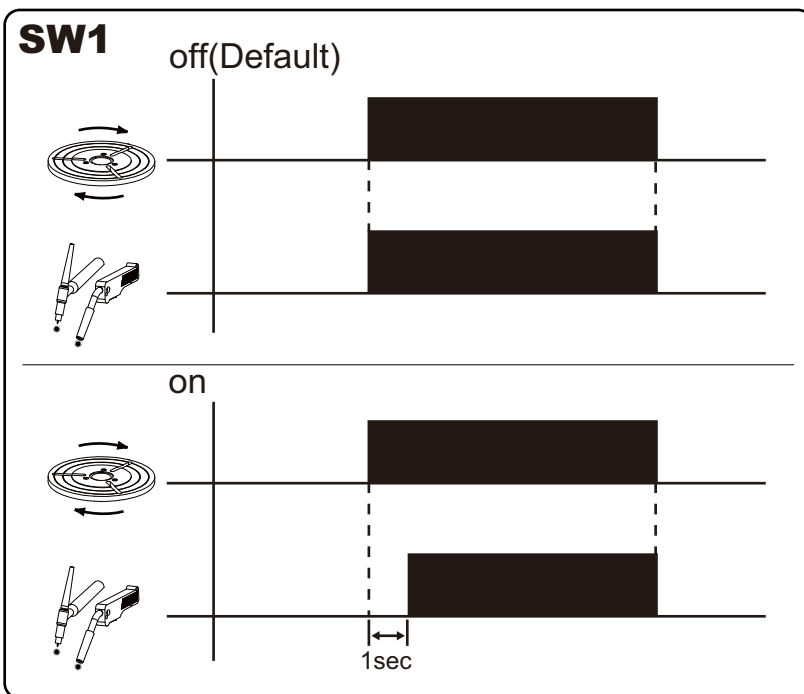
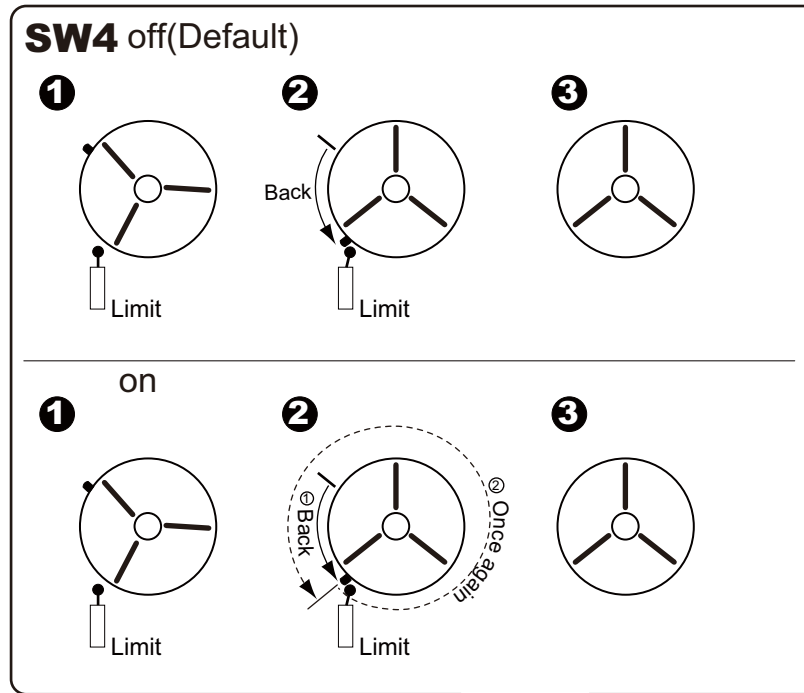
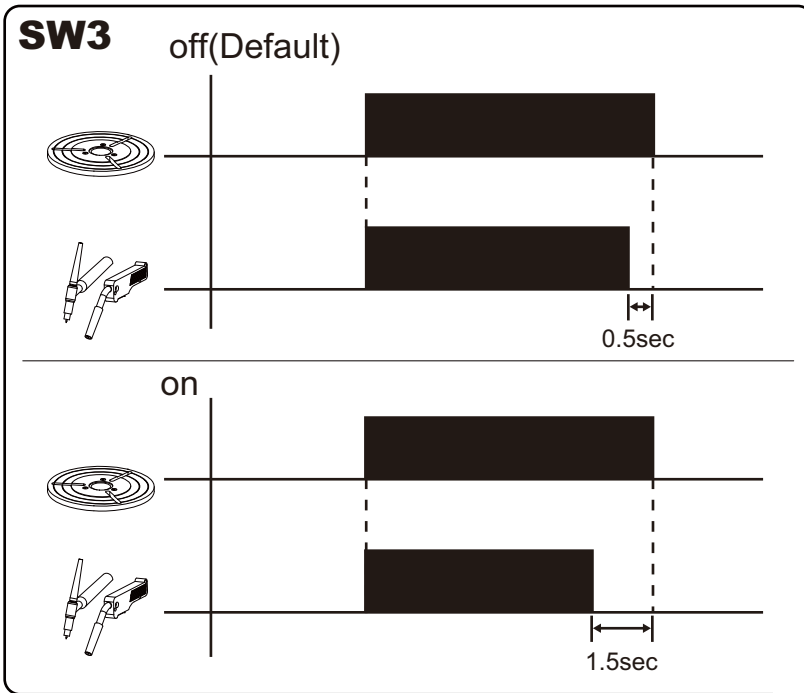


○ Automatic Hold (□ Standard)

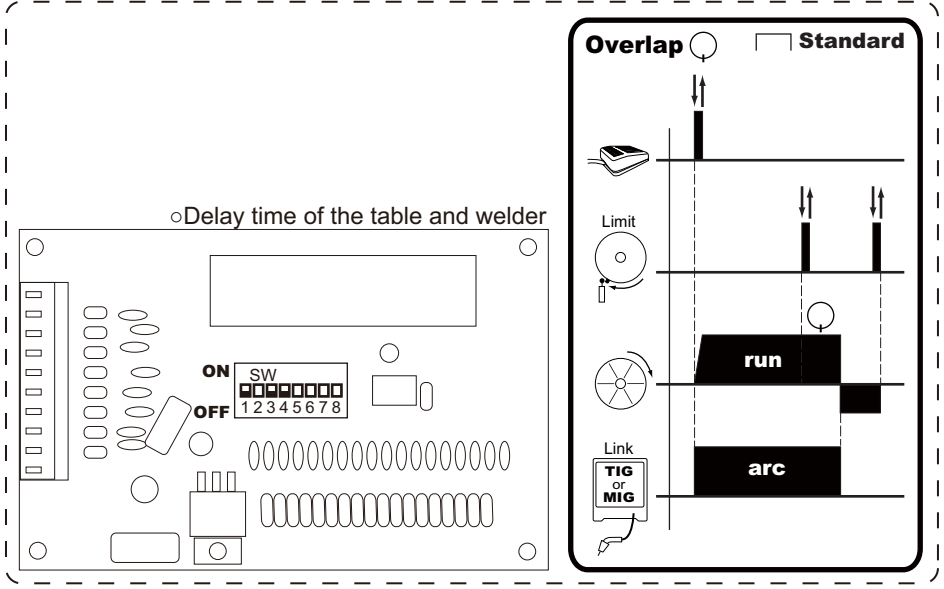
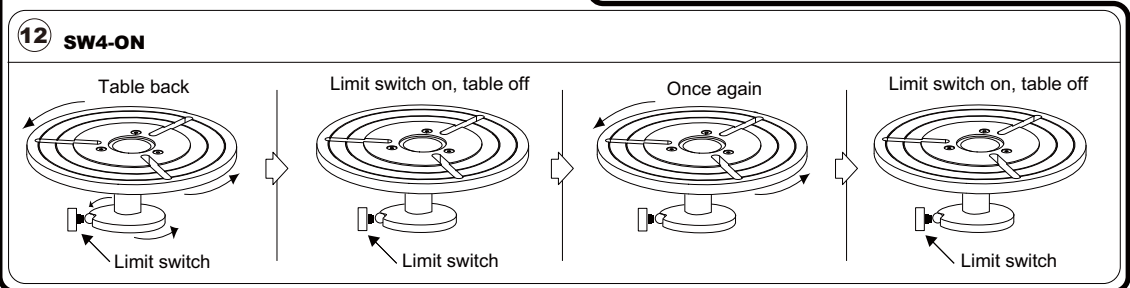
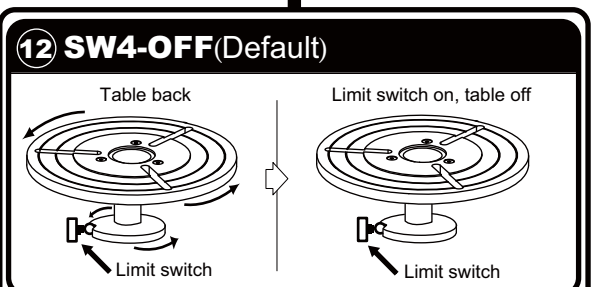
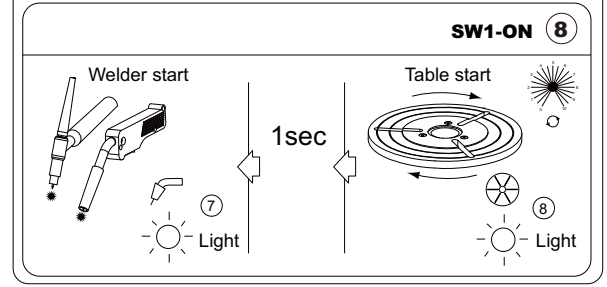
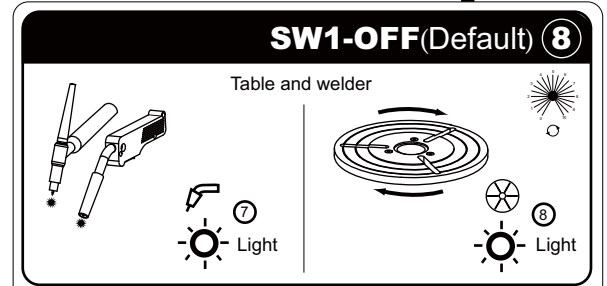
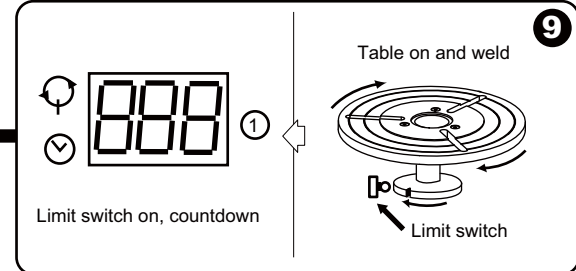
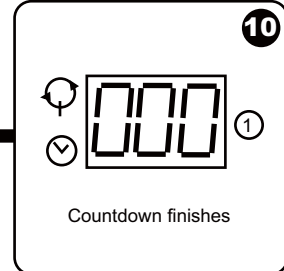
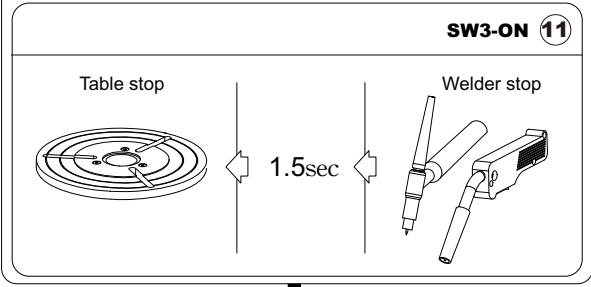
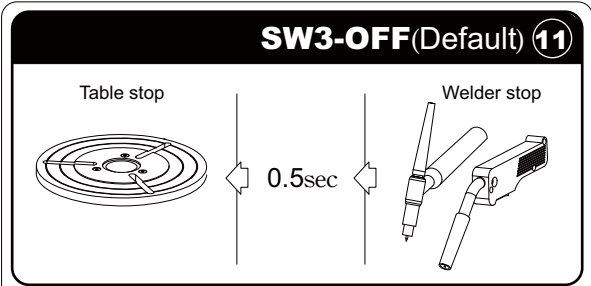
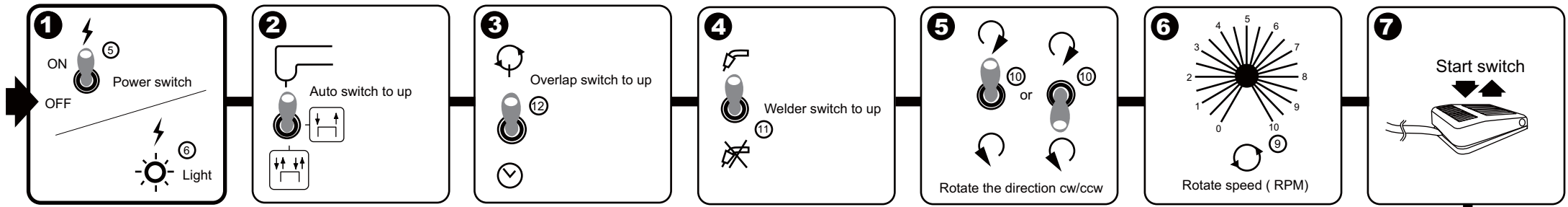


○The automatic operation mode





○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

10

Countdown finishes

9

Limit switch on, countdown

SW1-OFF(Default) 8

Table and welder

Light **7**

Light **8**

SW1-ON 8

Welder start

1sec

Table start

Light **7**

Light **8**

12

Table back

Limit switch on, table off

Limit switch

Limit switch

○Delay time of the table and welder

Timer Standard

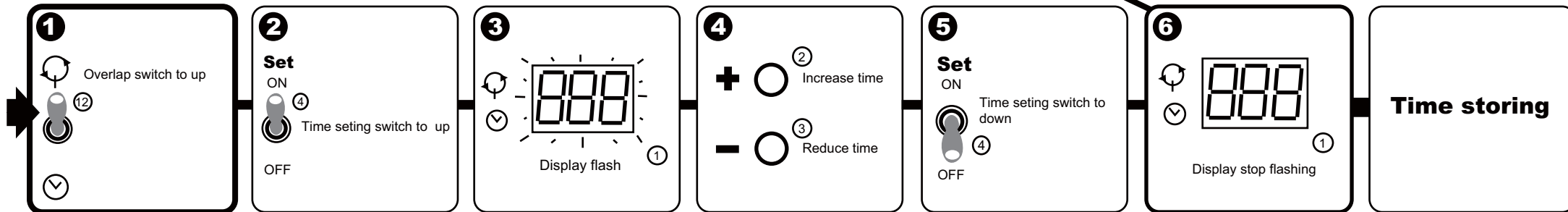
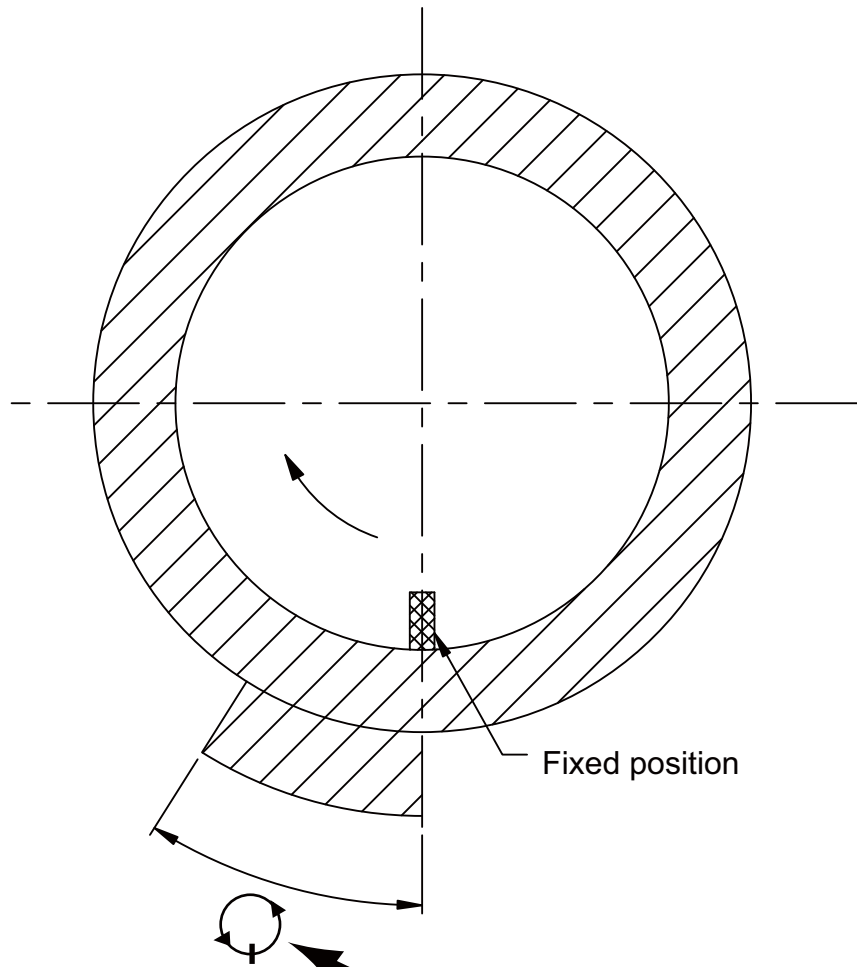
Limit

run

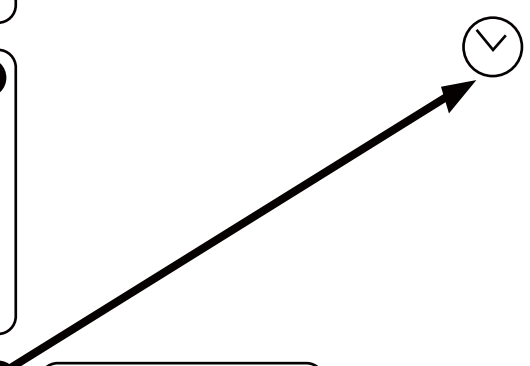
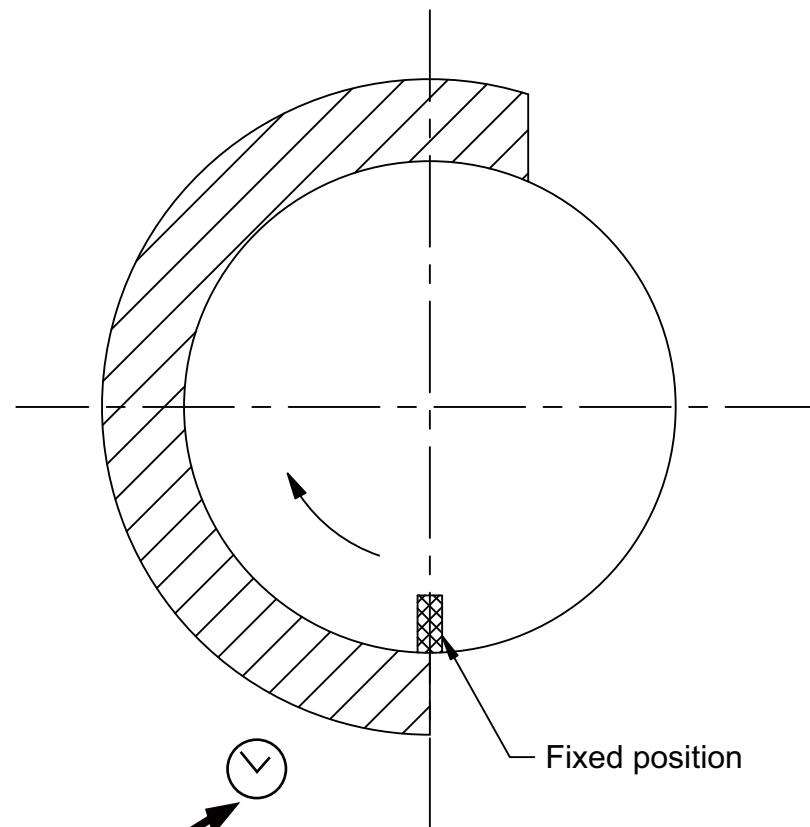
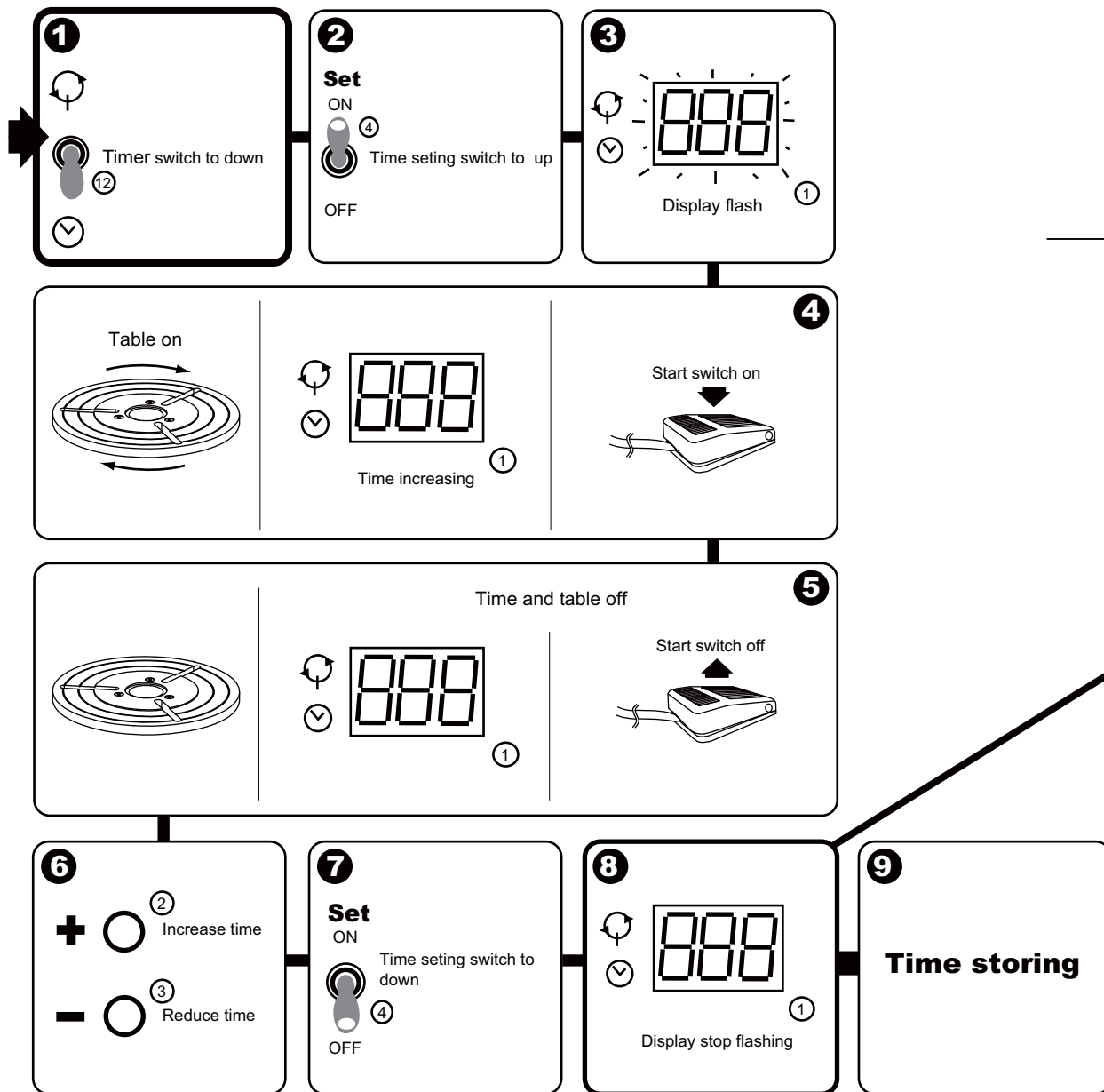
arc

Link TIG or MIG

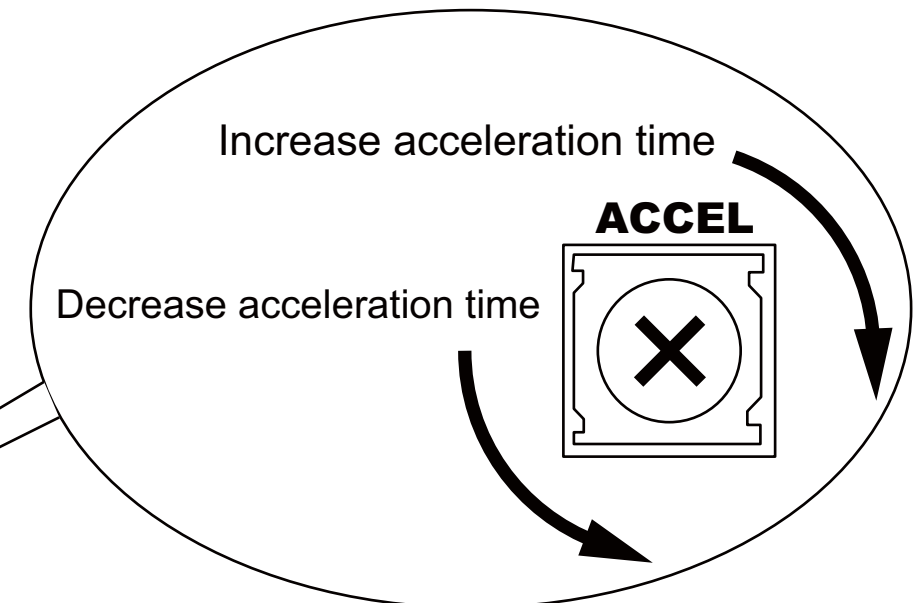
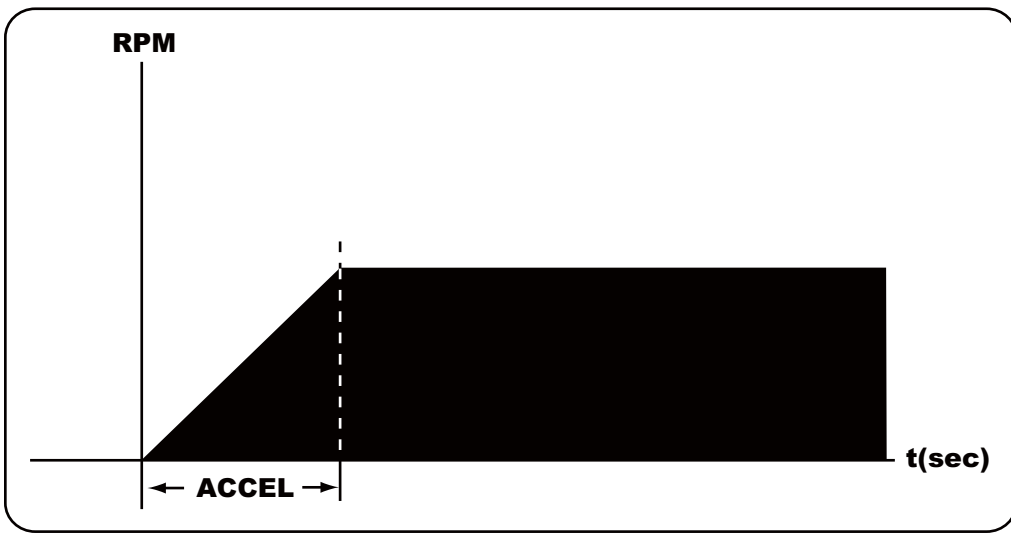
○Weld the overlap time establishing operating



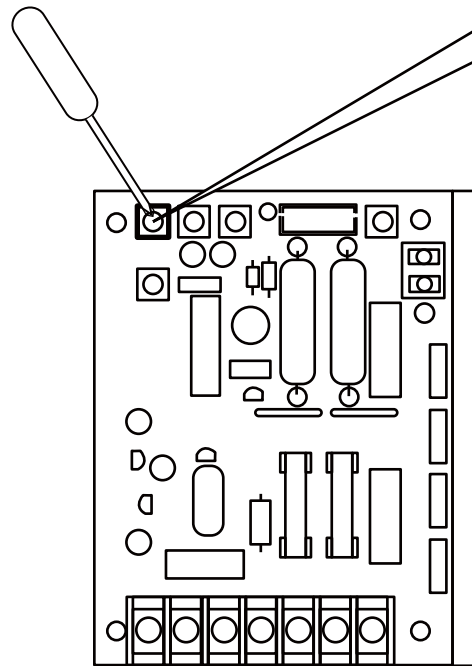
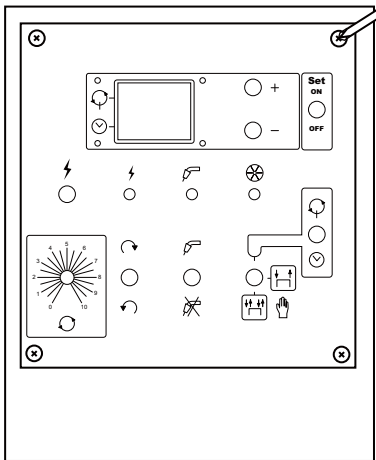
○ **Weld the overlap time establishing operating**



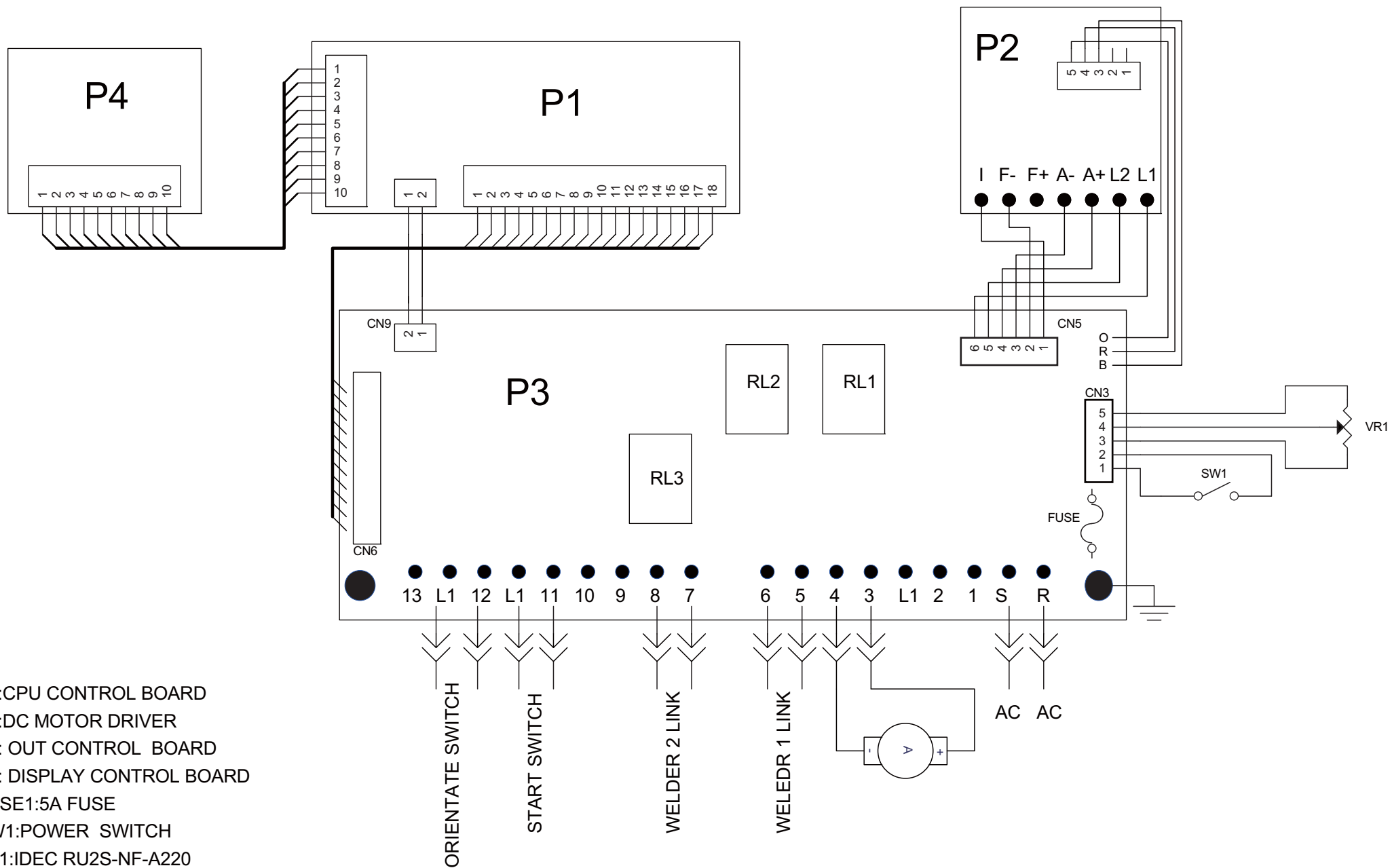
○ **Table start and accelerate time to adjust**



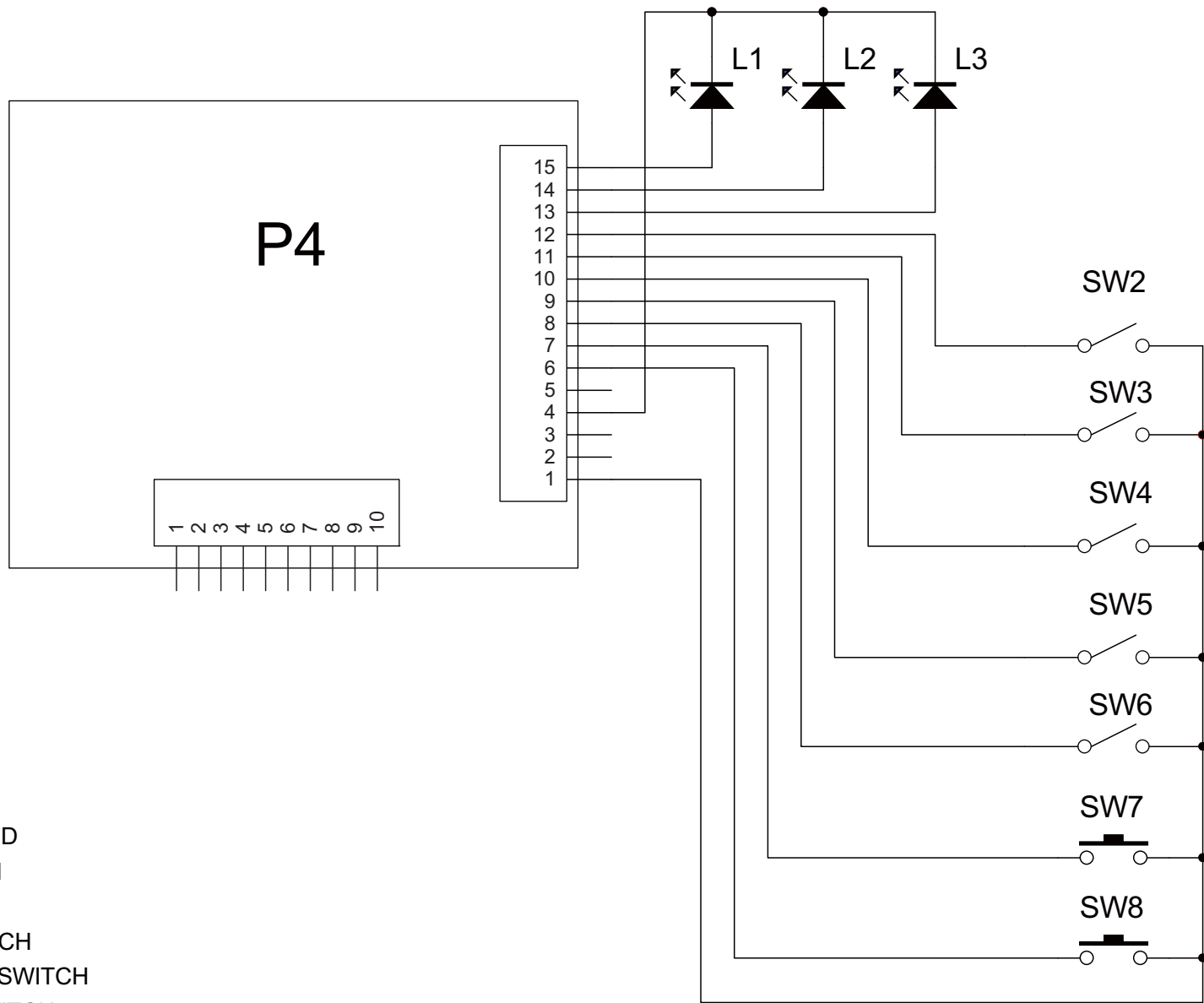
Open the control panel



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



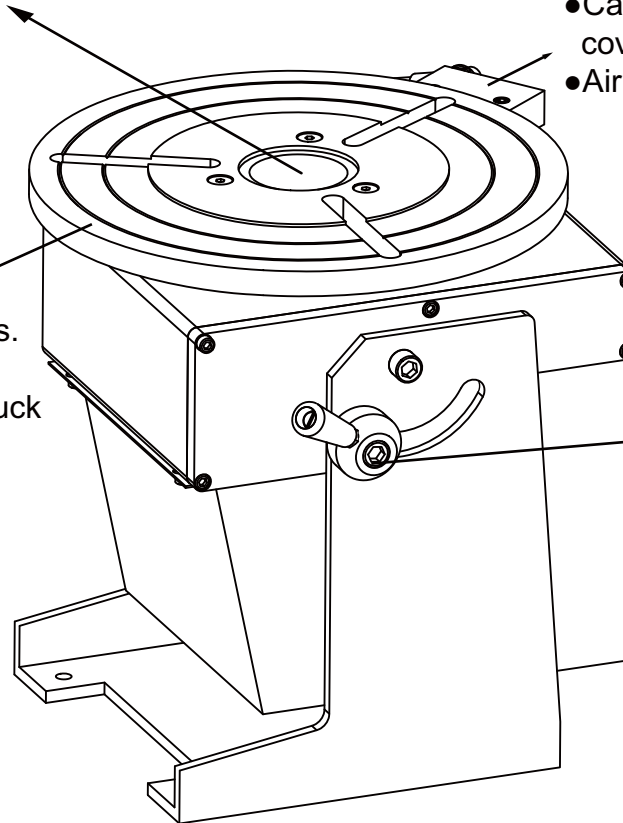
- L1: POWER LED
- L2:ACTINO LED
- L3:WELDER LINK LED
- SW2: AUTO SWITCH
- SW3:MODE SWITCH
- SW4:CW/CCW SWITCH
- SW5:WELDER LINK SWITCH
- SW6:TIMER SET SWITCH
- SW7: TIMER SET TO ADD SWITCH
- SW8:TIMER SET TO REDUCE

○PRO3 Structural Characteristics and Specification

●Internal diameter 60mm. 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°

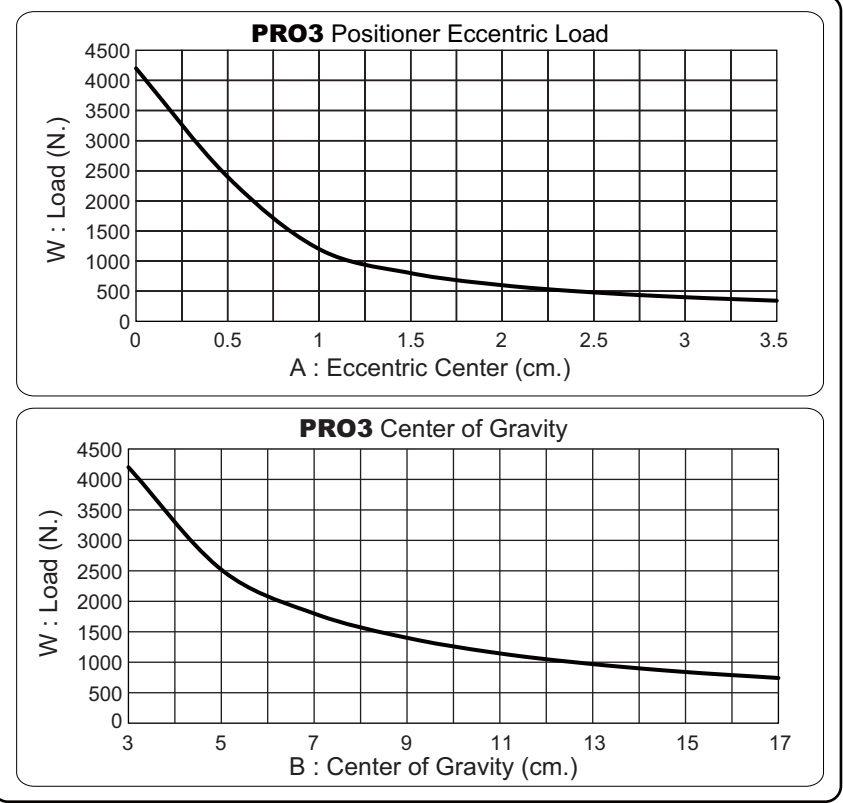
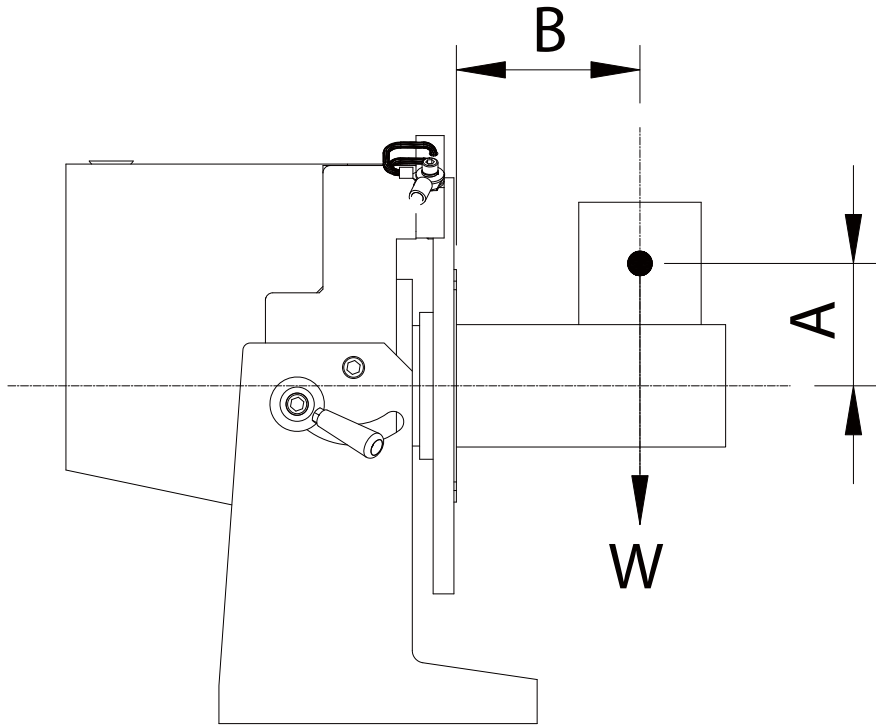
○Welding methods

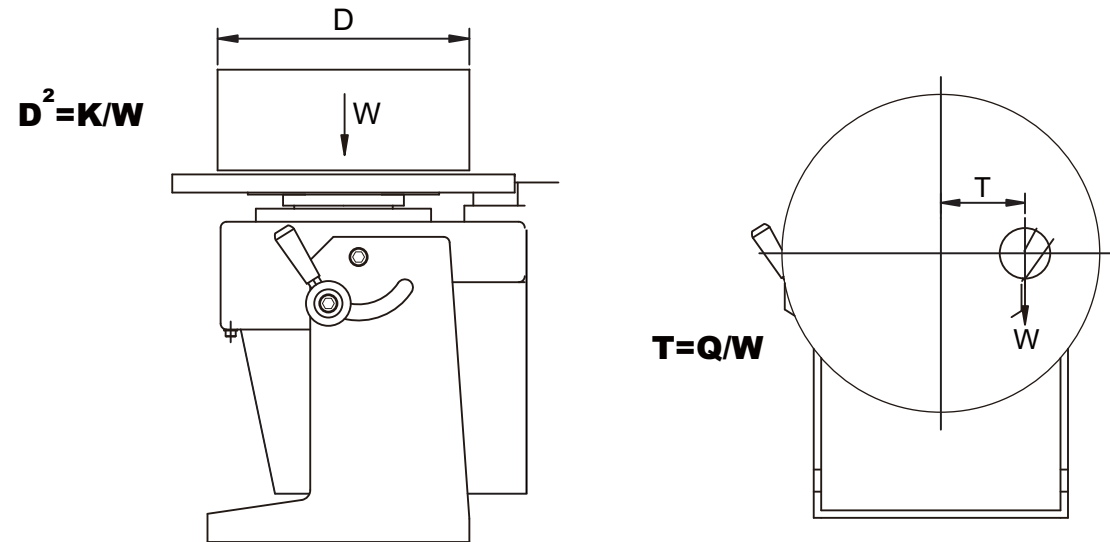
- MIG/MAG
- TIG
- Wire-TIG
- Plasma weld
- SAW

○Duty Cycle

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

Specification / model	PRO3
Motor	DC90V/100W
Table axis centre hole	I.D 60mm
Table Dia	O.D. 340mm
Table angle	0°- 90°
Welding current	300A/100%
Table speed	0.6 - 6 rpm
Rotate load	290 Kg
Rotate torque	120 Kg-cm.
Size	L:322mm W:403mm H:418mm
N.W. / G.W.	75Kg / 98Kg





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:

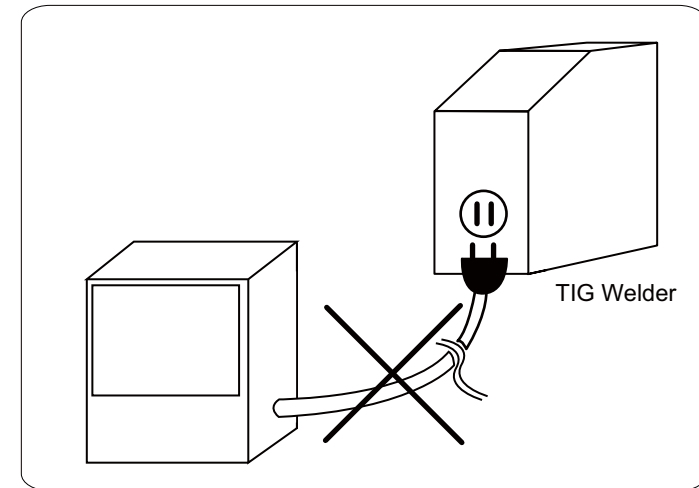
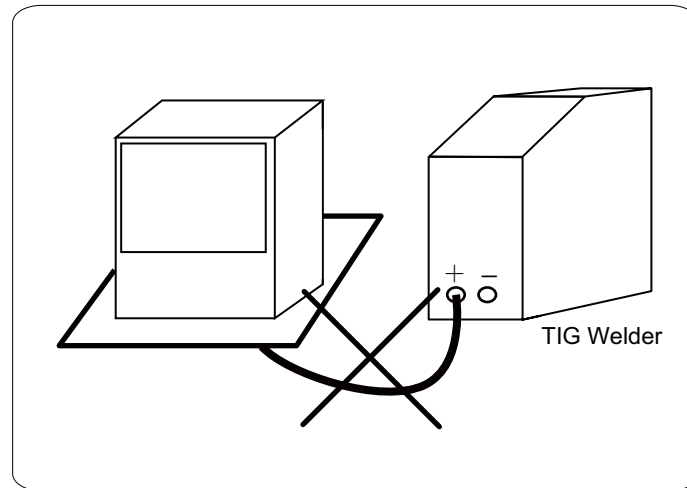
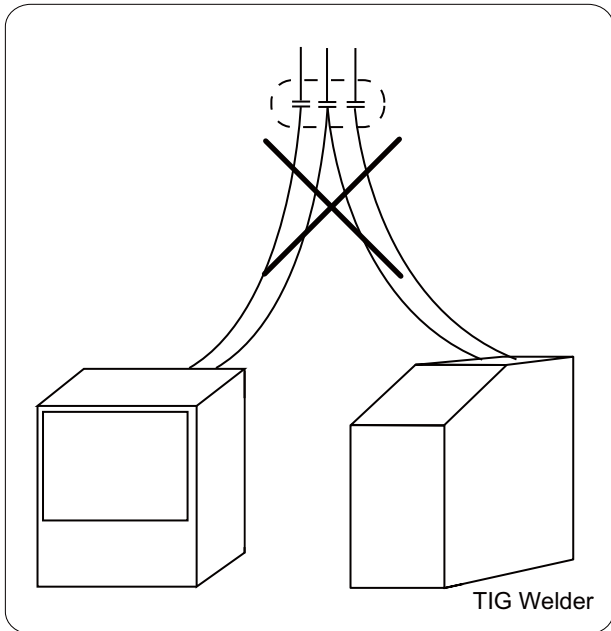
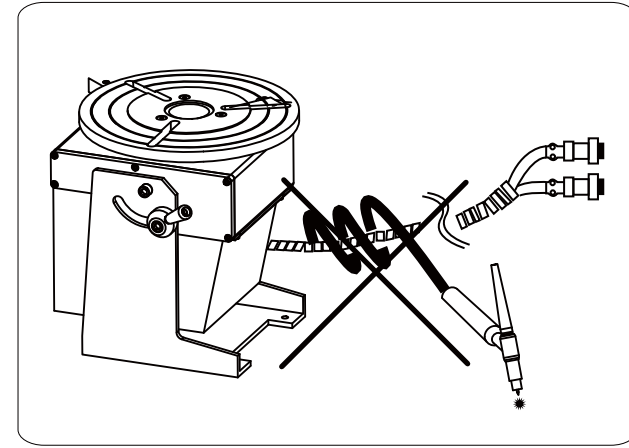
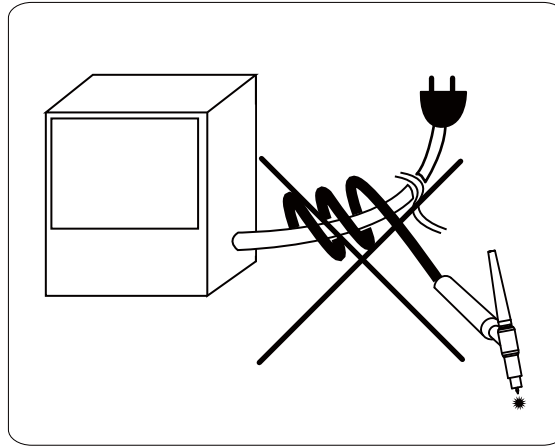
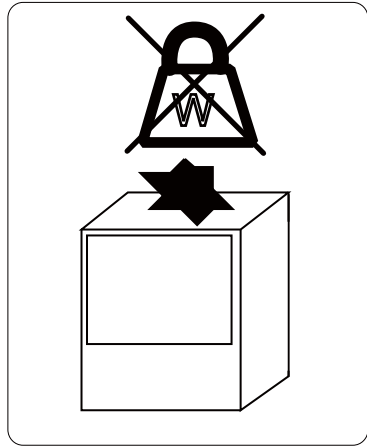
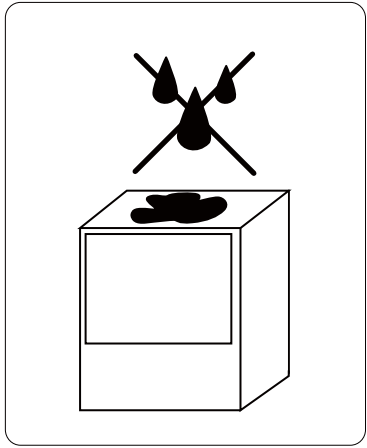
$D^2 = 297108/100 = 2971.08$ Know after calculating D=54.5cm (Work piece diameter)

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

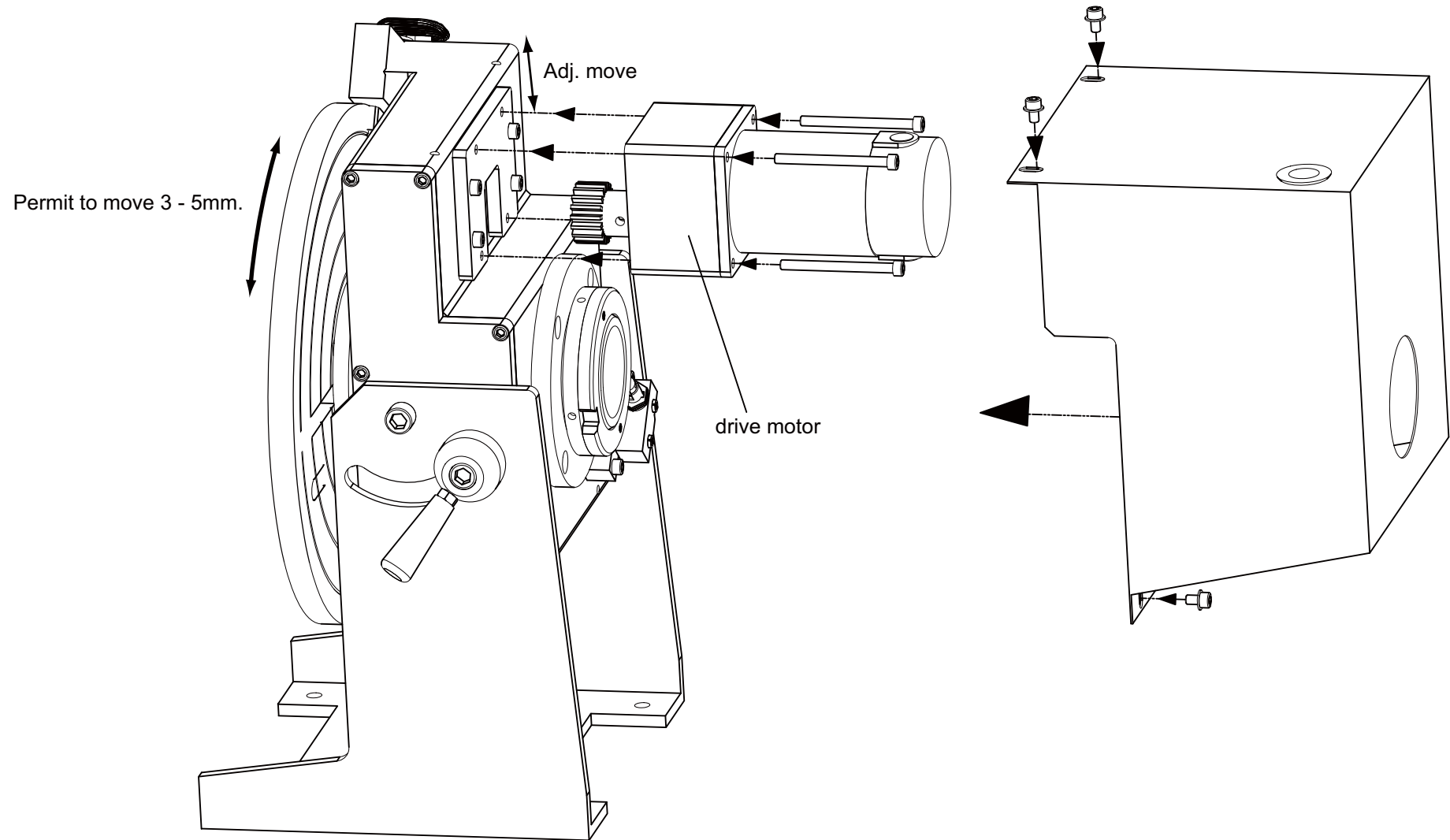
Example:

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

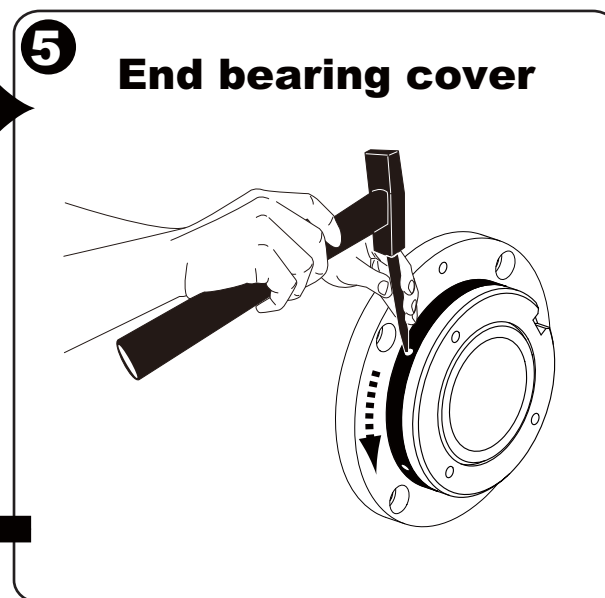
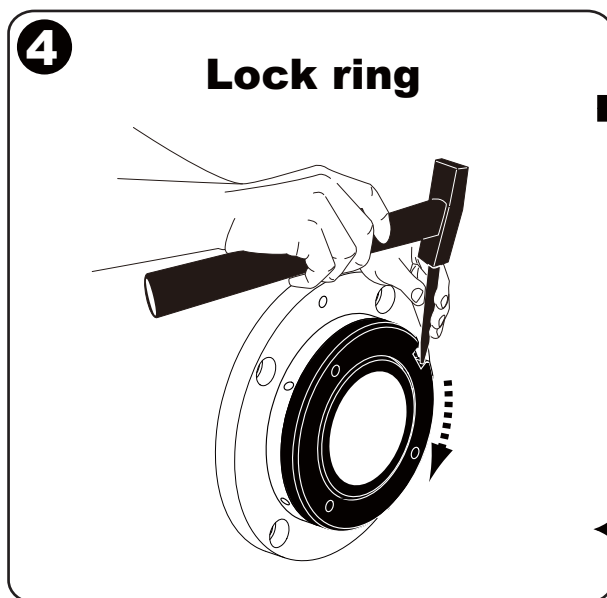
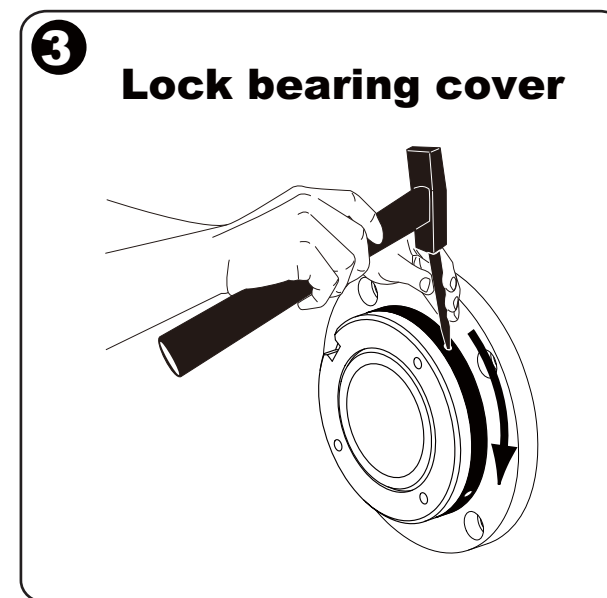
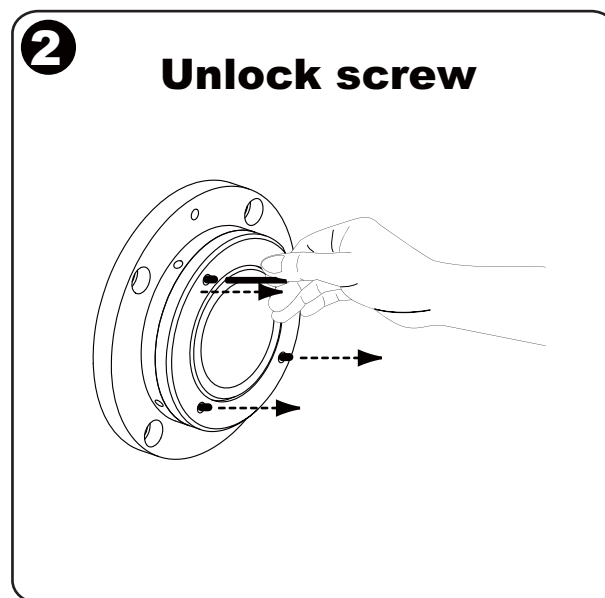
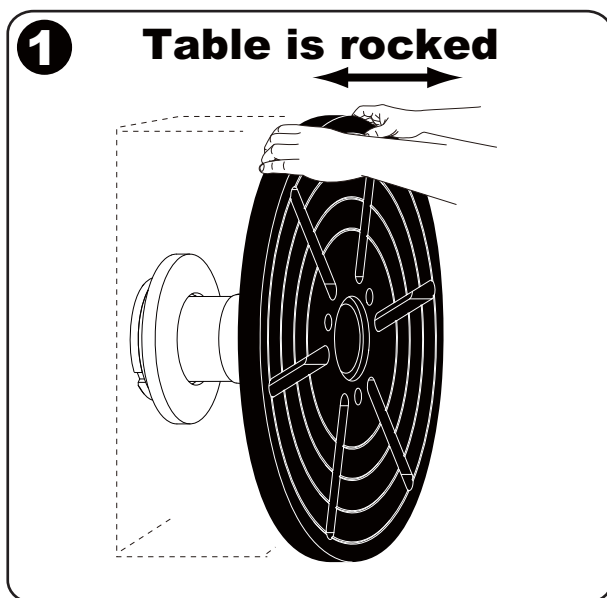
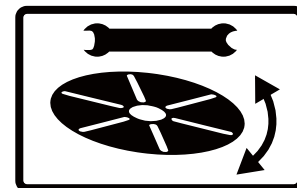
$T = 175/120$ Know after calculating T=1.45cm (Work piece center skew)



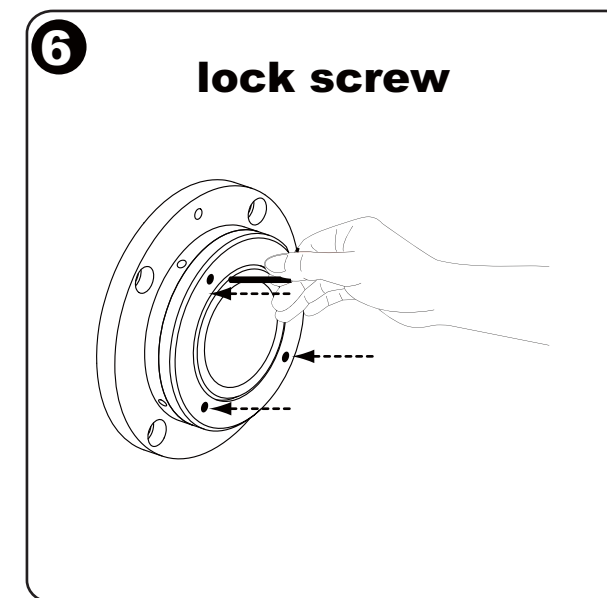
○ Install the method of the drive motor

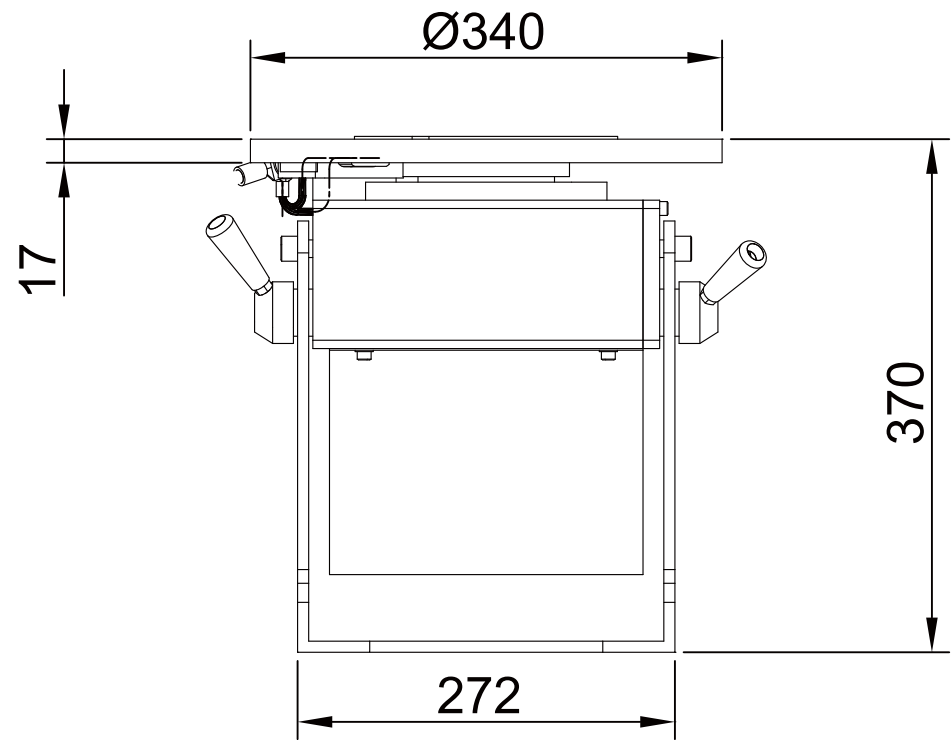
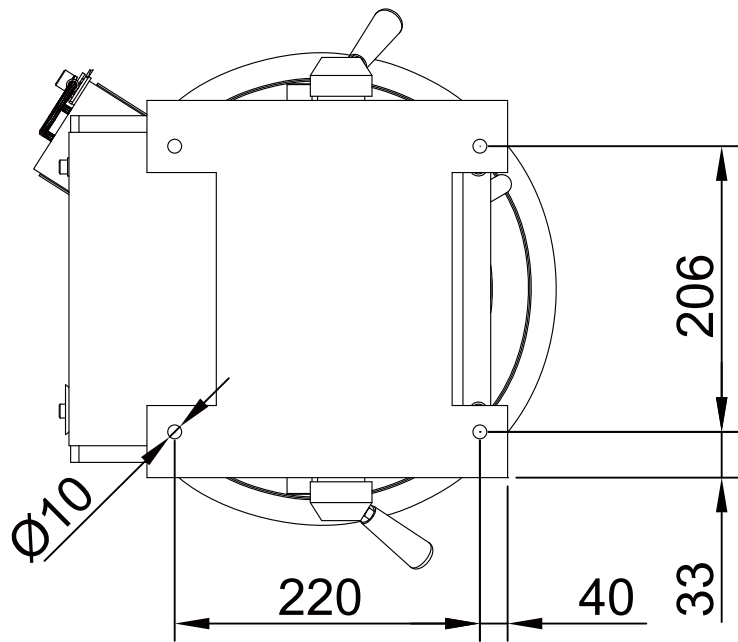
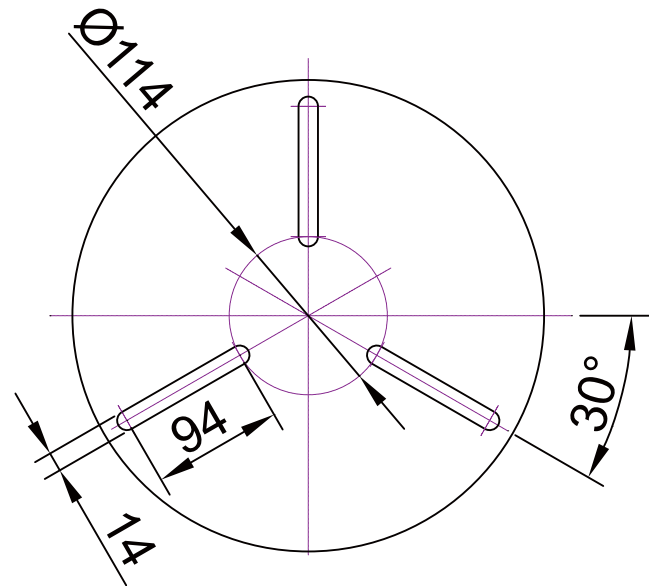
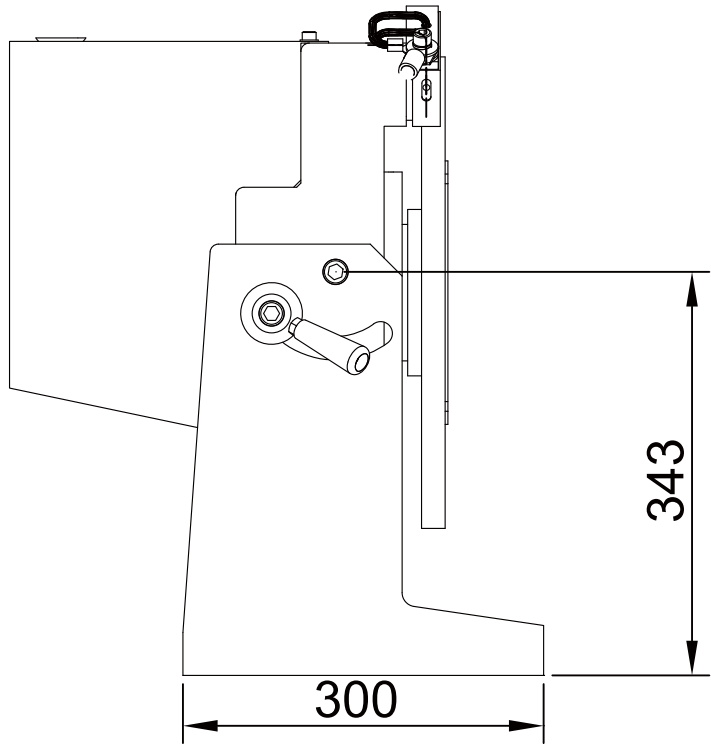


Rotate the table and confirm moving the distance(3 - 5 mm) with hands, lock the drive motor

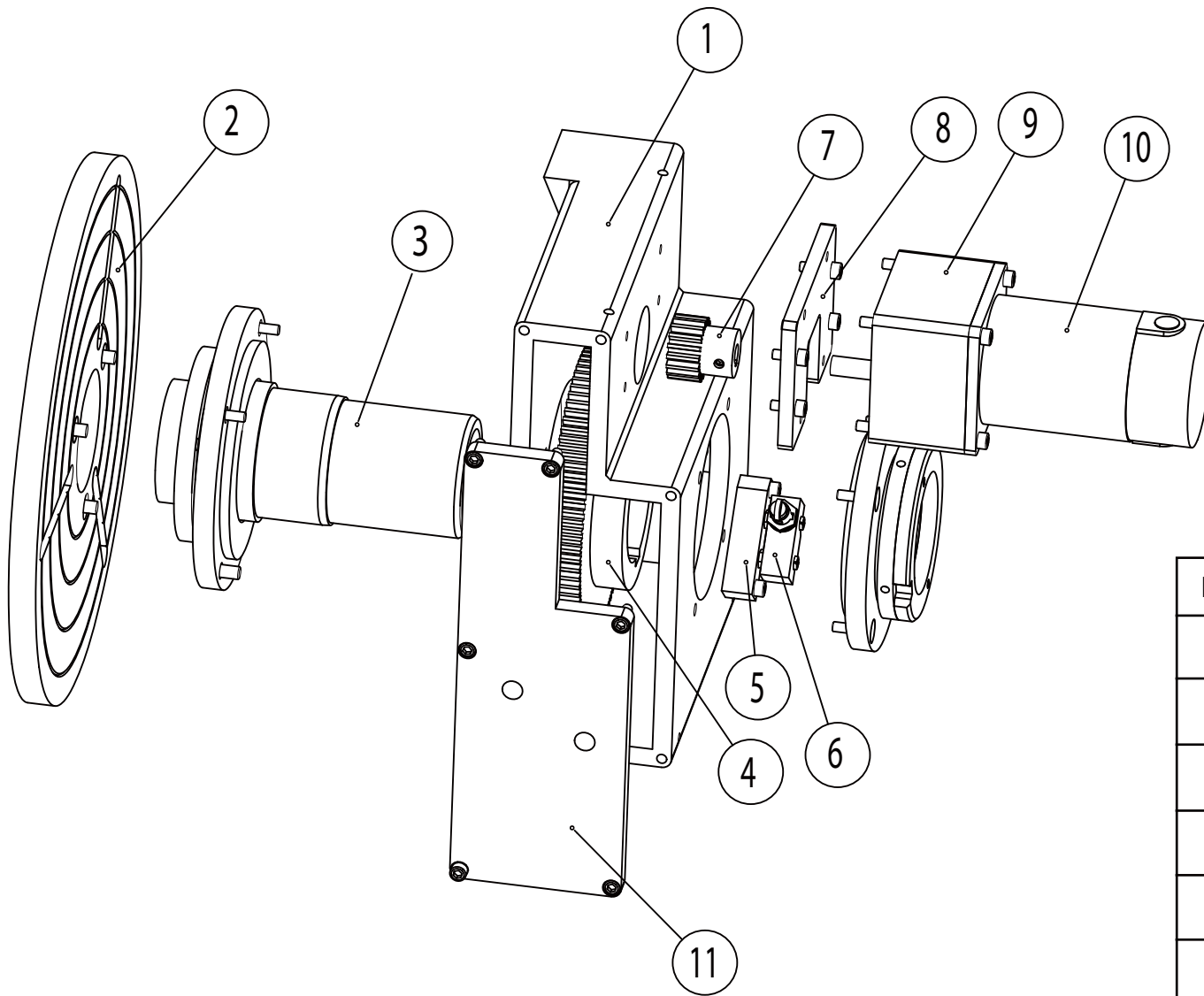


Repeat 3-5 times



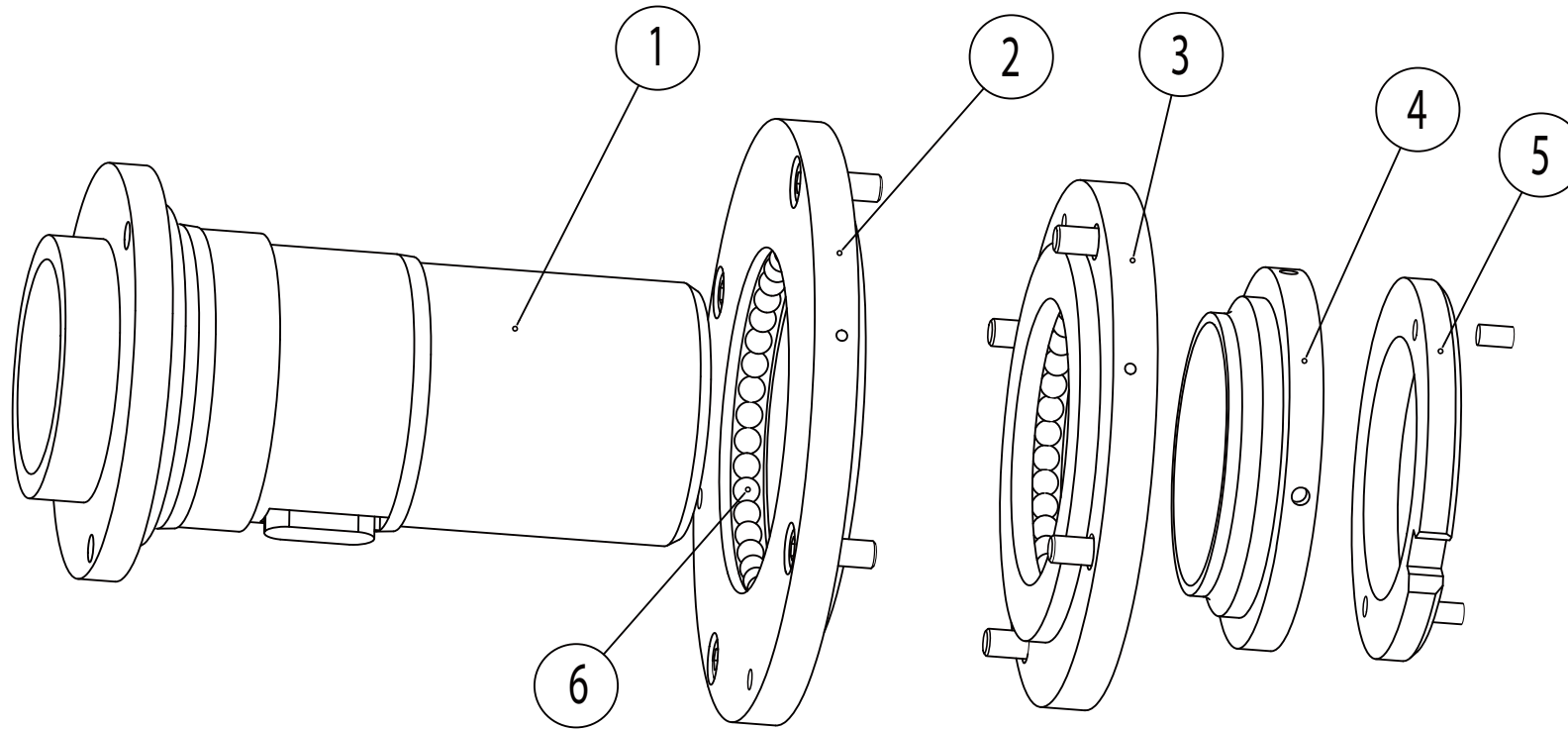


UNIT:mm

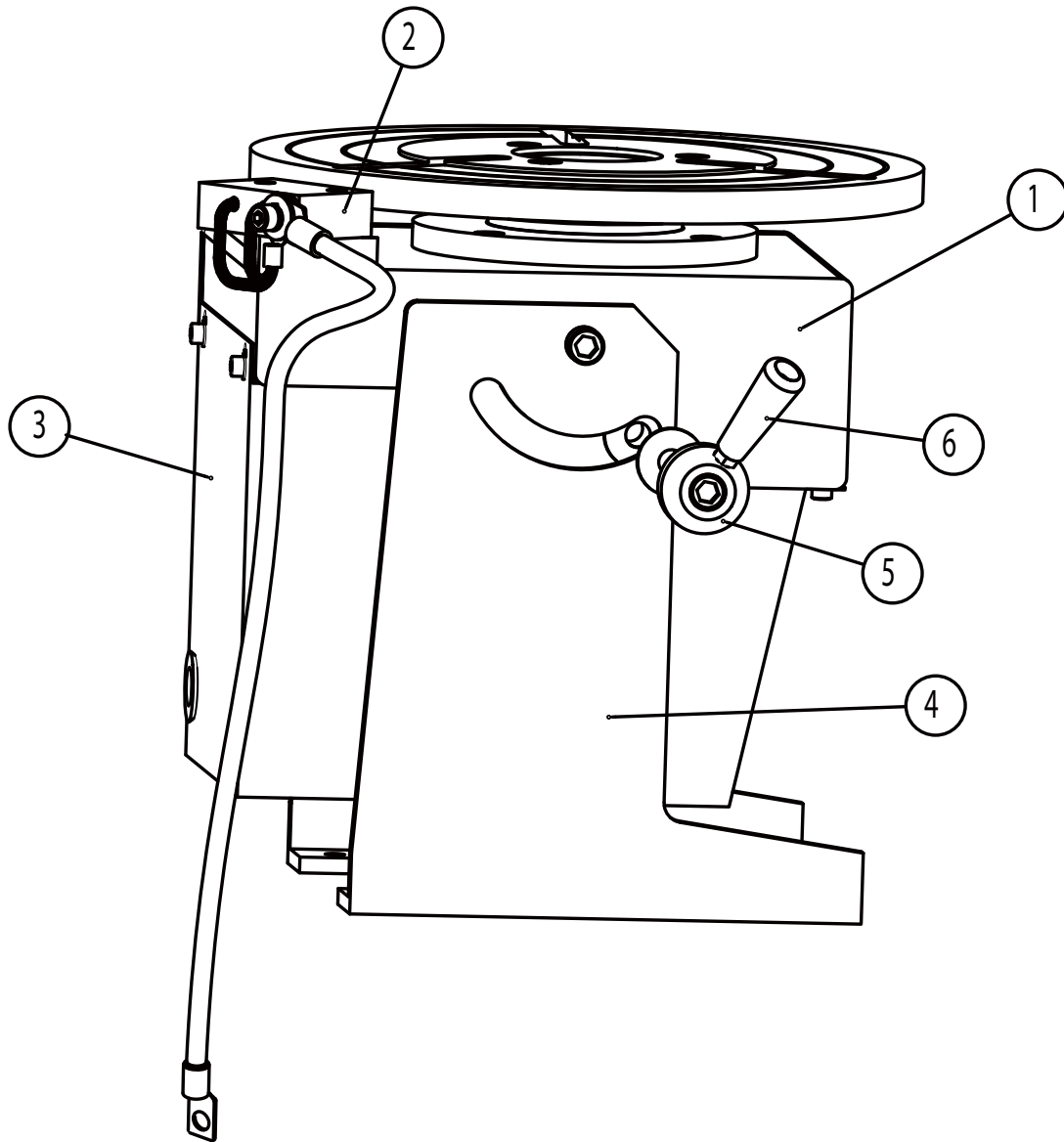


Item	Part Name	Part No.	Quantity
1	Table case	P1004	1
2	Table	P1003	1
3	Table axis group	P100A2-1	1
4	Axis gear	P1002	1
5	Switch seat	P1010	1
6	Fixed position switch	TM1308	1
7	Drive gear	P1M01	1
8	Motor flange	P1M02	1
9	Reducing gear box	5NG	1
10	DC motor	DC65W90V	1
11	Table case cover	P1004-1	1

•Table axis group(P100A2-1)



Item	Part Name	Part No.	Quantity
1	Table axis	P1001-1	1
2	Front bearing	P1001-2	1
3	End bearing	P1001-3	1
4	End bearing cover	P1001-4	1
5	Lock ring	P1001-5	1
6	Steel ball 3/8"	OD-3	80



Item	Part Name	Part No	Quantity
1	Table case group	P200A2	1
2	Welding ground	P100A3	1
3	Motor cover	P2002	1
4	Table shelf	P2001	1
5	Angle fixed screw	P1006	2
6	Handle	PH-W5/16	2