

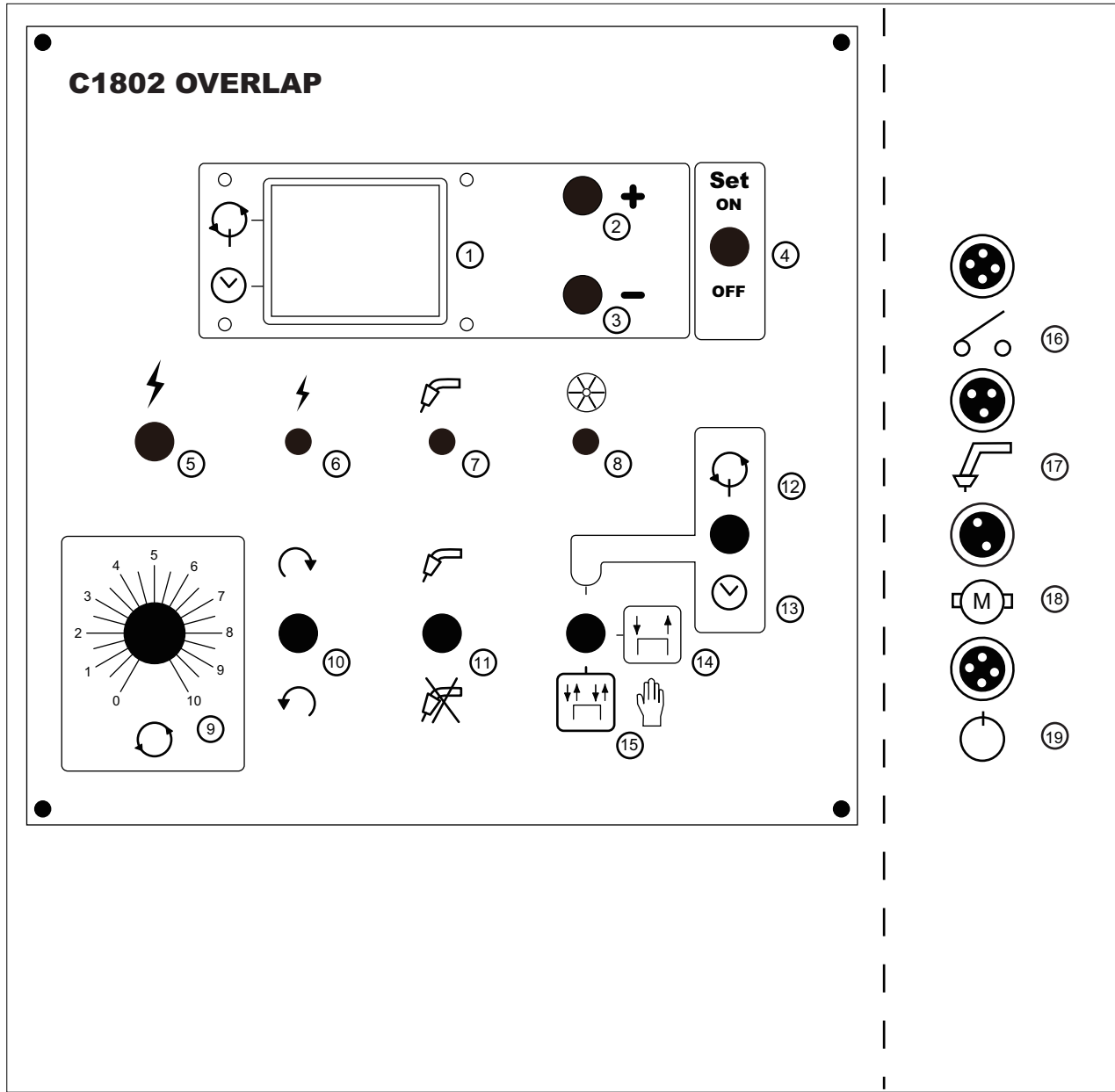


OWNERS MANUAL

PR02

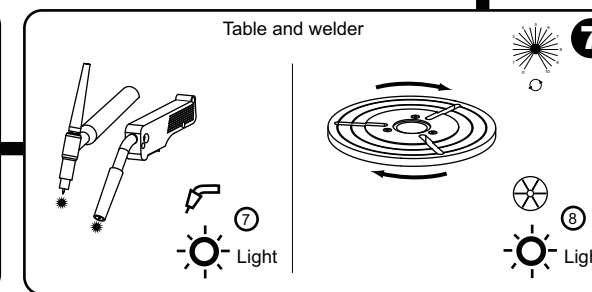
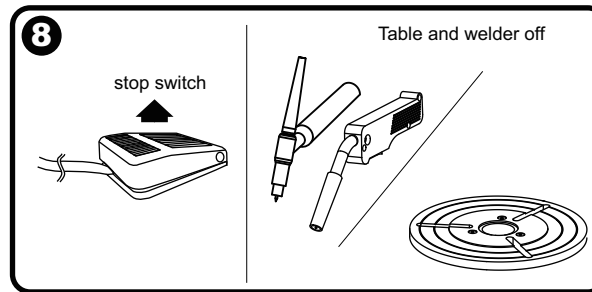
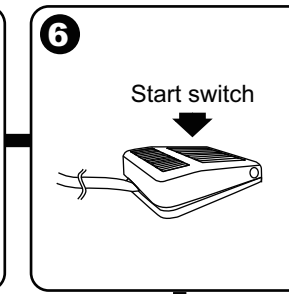
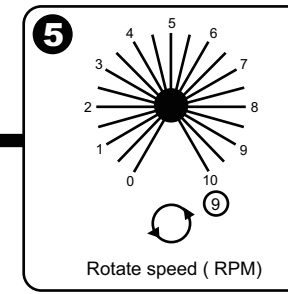
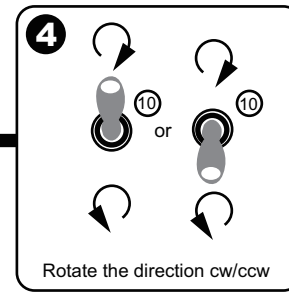
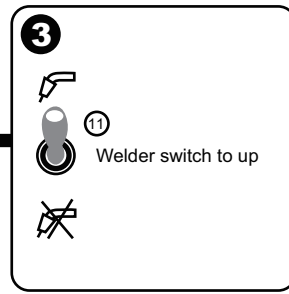
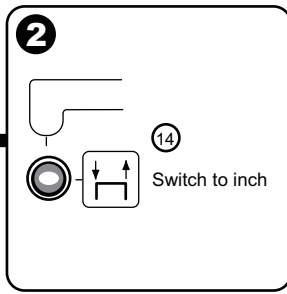
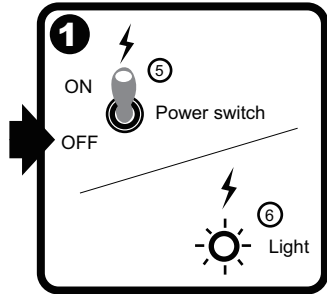
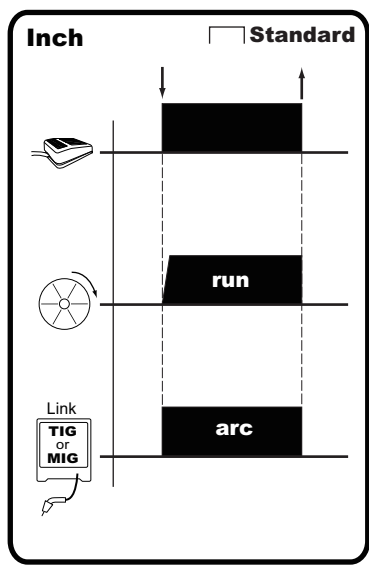


○Type C1802 overlap controller explanation of symbol & Specification

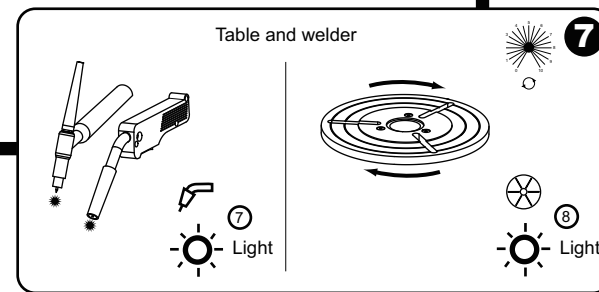
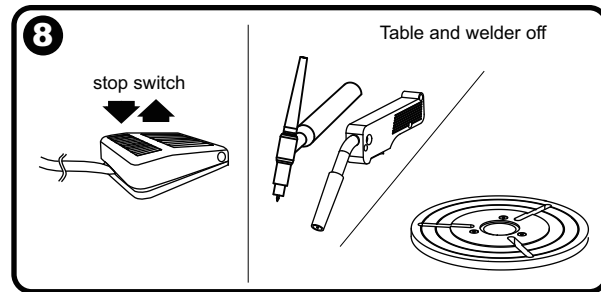
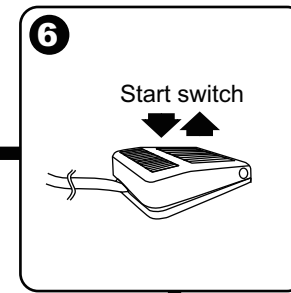
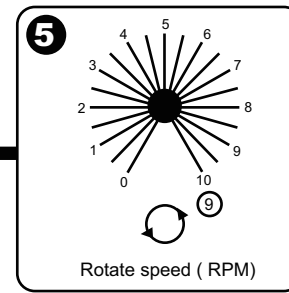
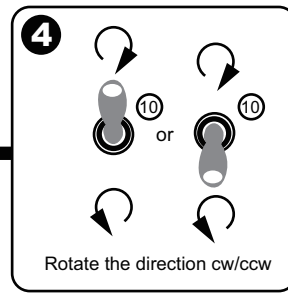
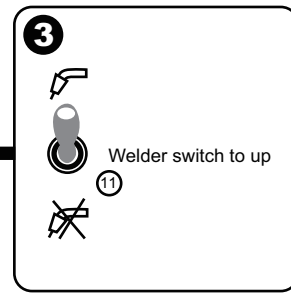
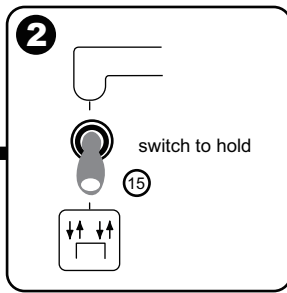
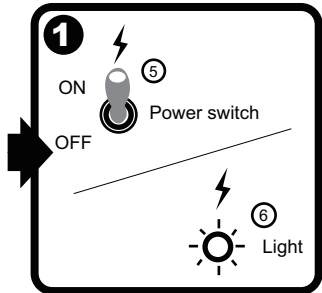
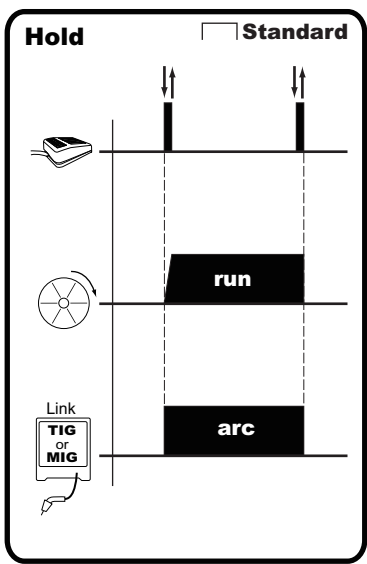


1. Time data (Unit : 0.1sec)
2. Set button (+)
3. Set button (-)
4. Time setting switch
5. Power switch
6. Power light
7. Welder light
8. Table light
9. Table speed (RPM)
10. Table cw/ccw switch
11. Welder switch
12. overlap
13. timer
14. Inch
15. Hold
16. Foot switch socket(4P)
17. Welder switch socket(3P)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

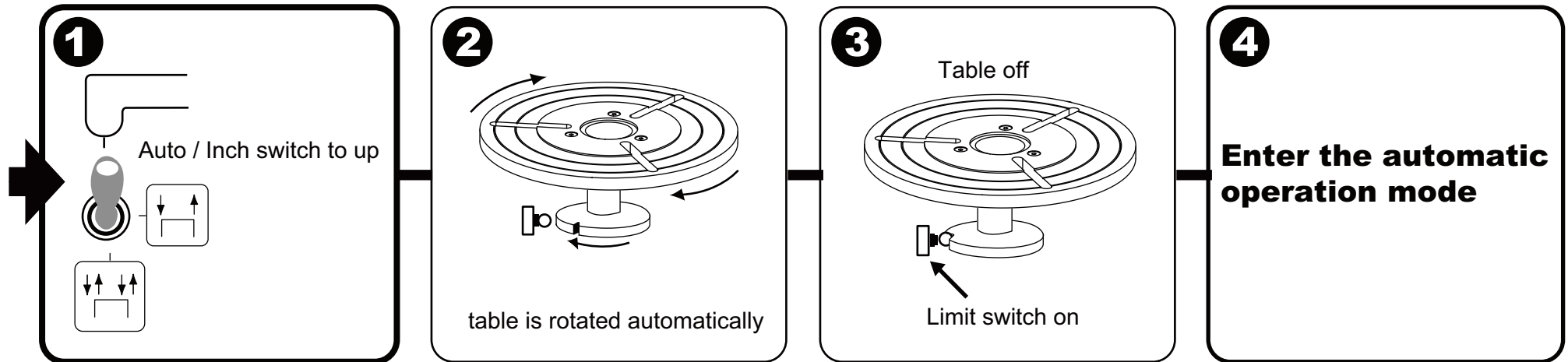
Specification / No.	C1802
Power	AC 230V/1Ø
Power of the motor	DC 90V/150W
Rotate the direction	cw/ccw
Lap well timer(Fixing point)	0-99.9sec (Digital display , unit:0.1sec)
Timer(Fixing point)	0-999sec (Digital display , unit:1sec)
Arc way of the welder	<input type="checkbox"/> Standard
Line welder	1st
Stop the brake	Magnetism brake
H.F. Protect	92%
Start the device	Foot switch (Line 2M)

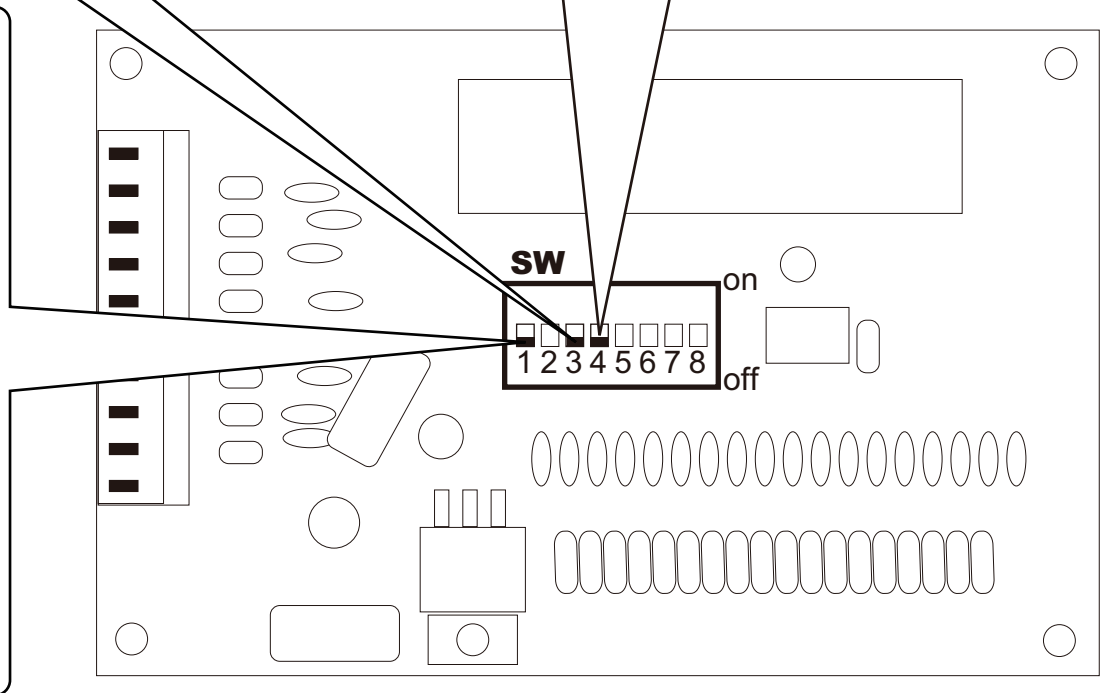
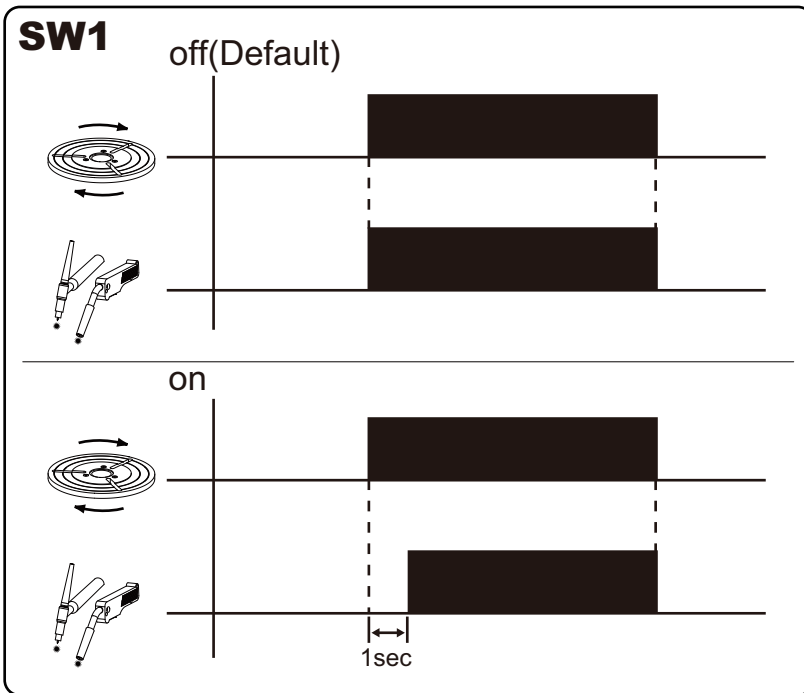
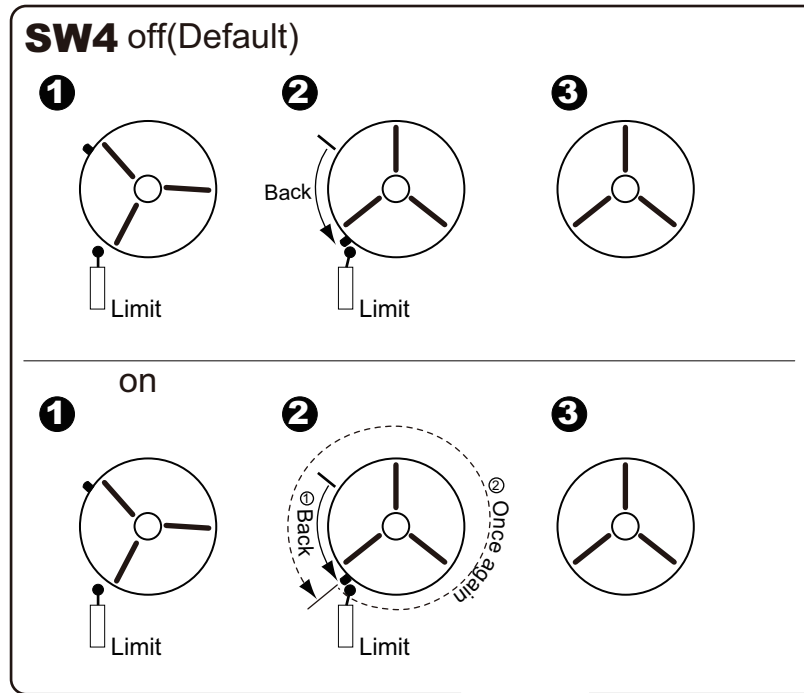
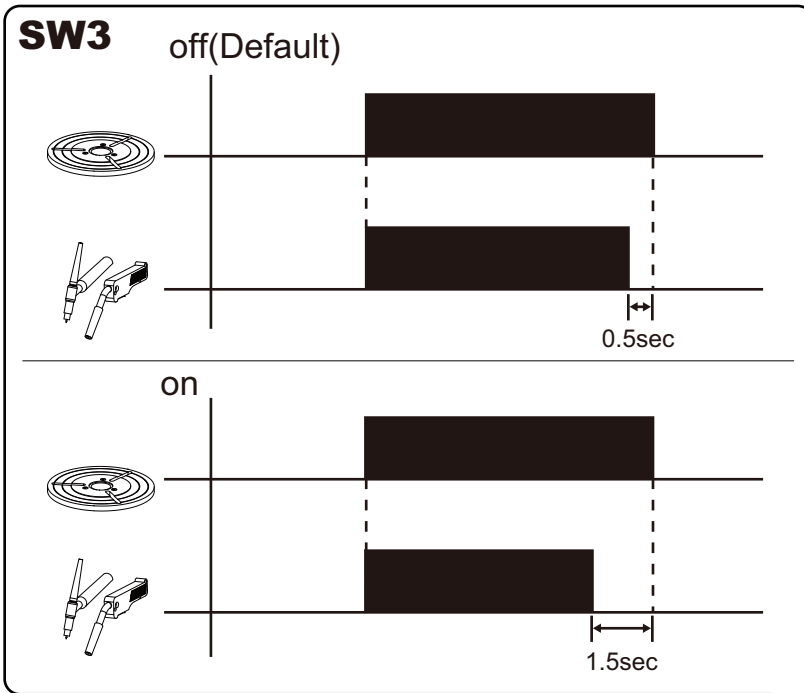


○ Start hold (□ Standard)

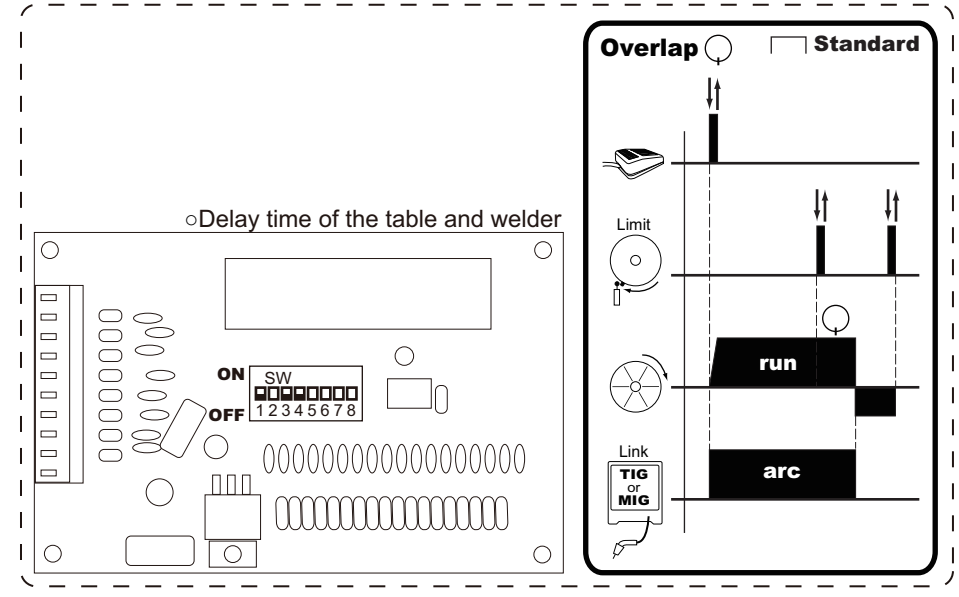
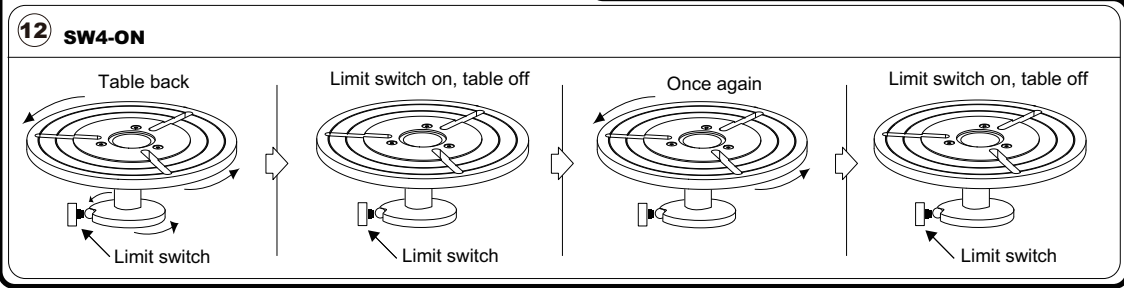
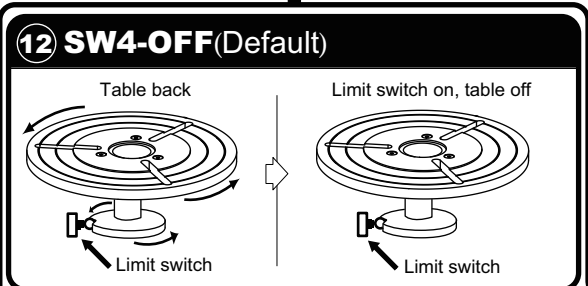
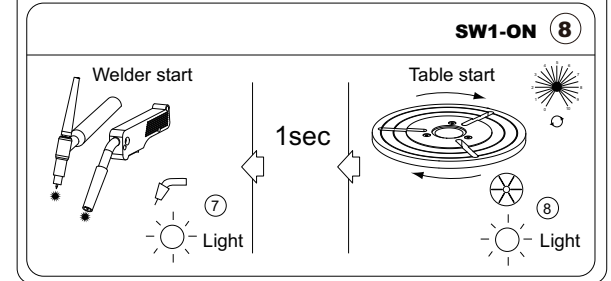
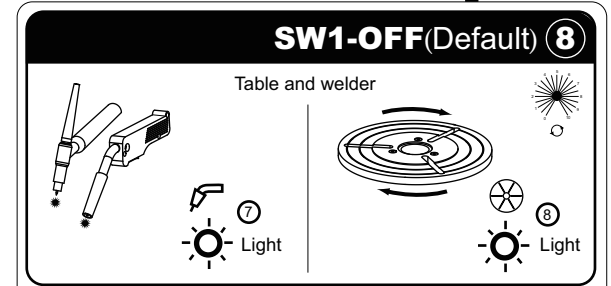
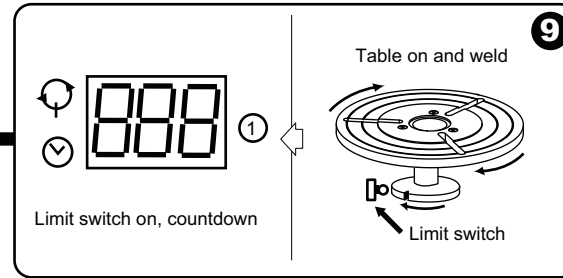
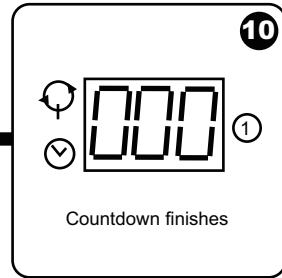
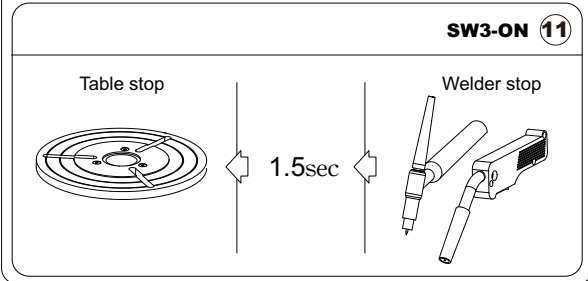
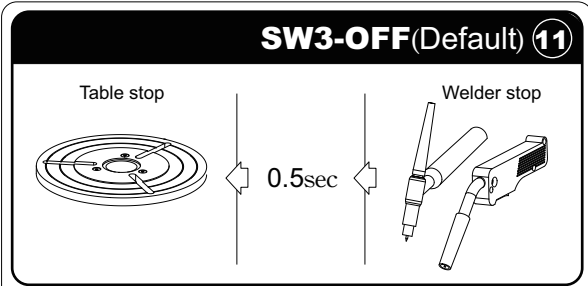
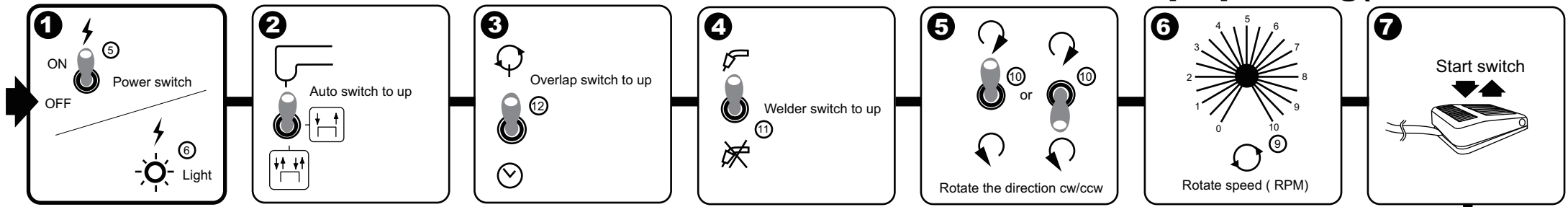


○ **The table is first by fixed position before entering automatic operation mode**





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

7
Light

8
Light

SW1-ON 8

Welder start

1sec

Table start

7
Light

8
Light

12

Table back

Limit switch on, table off

Limit switch

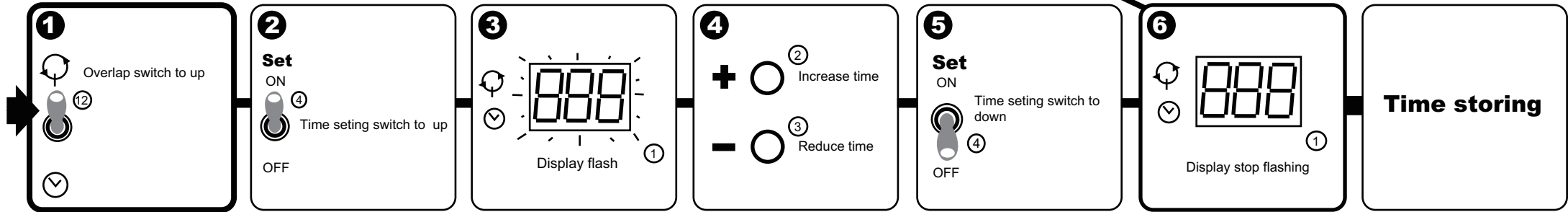
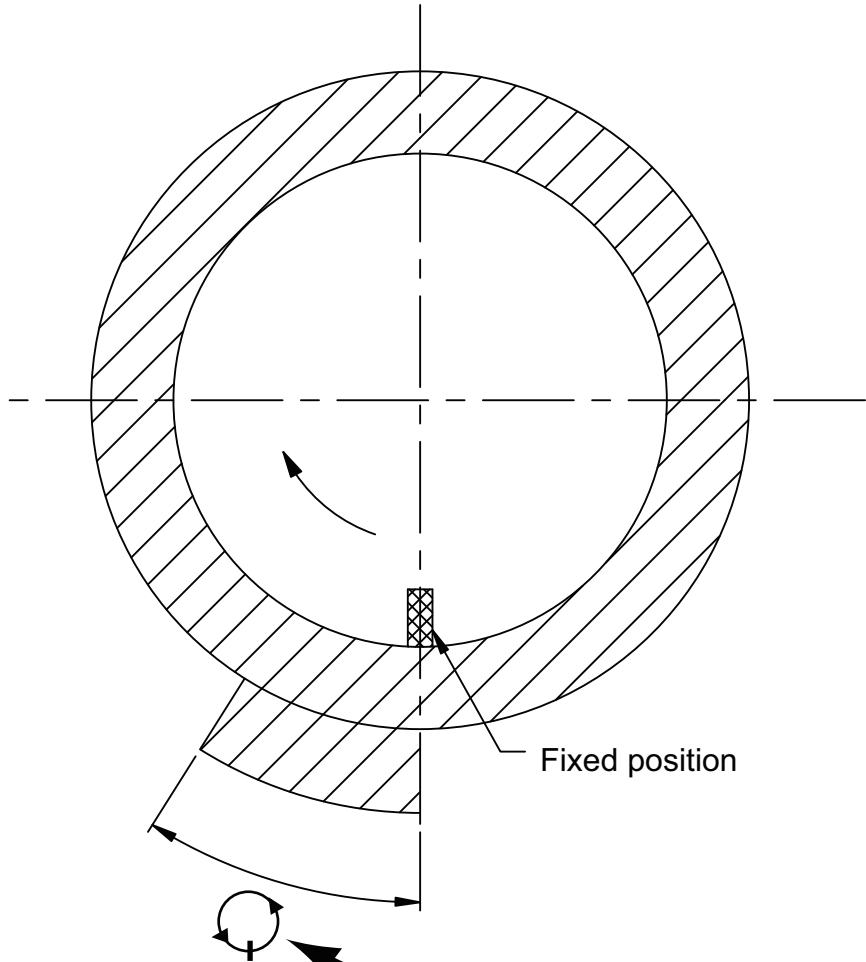
Limit switch

Timer Standard

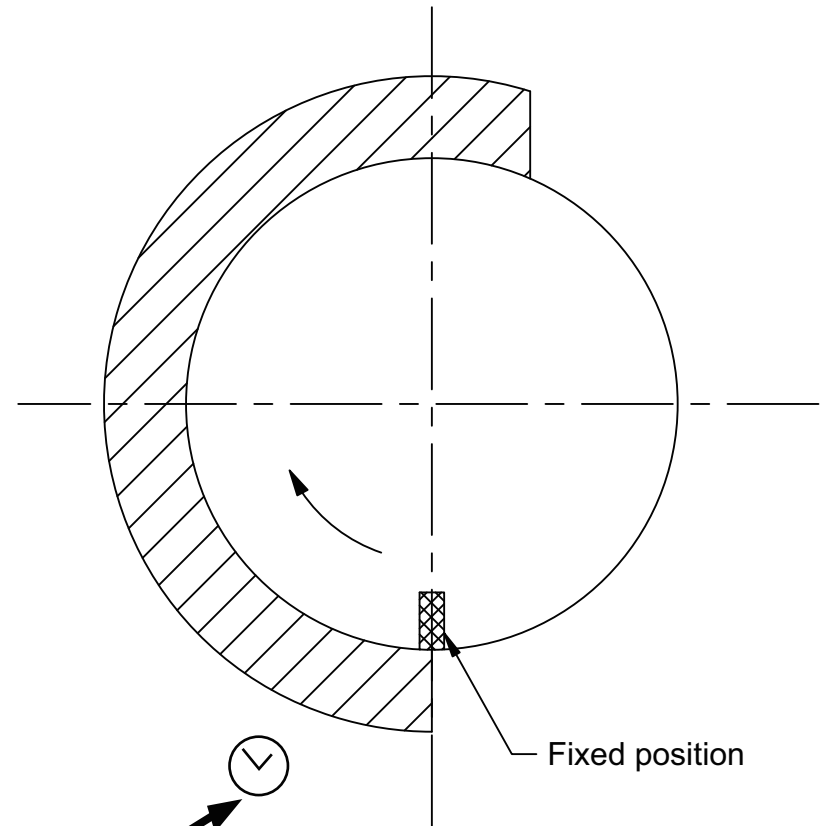
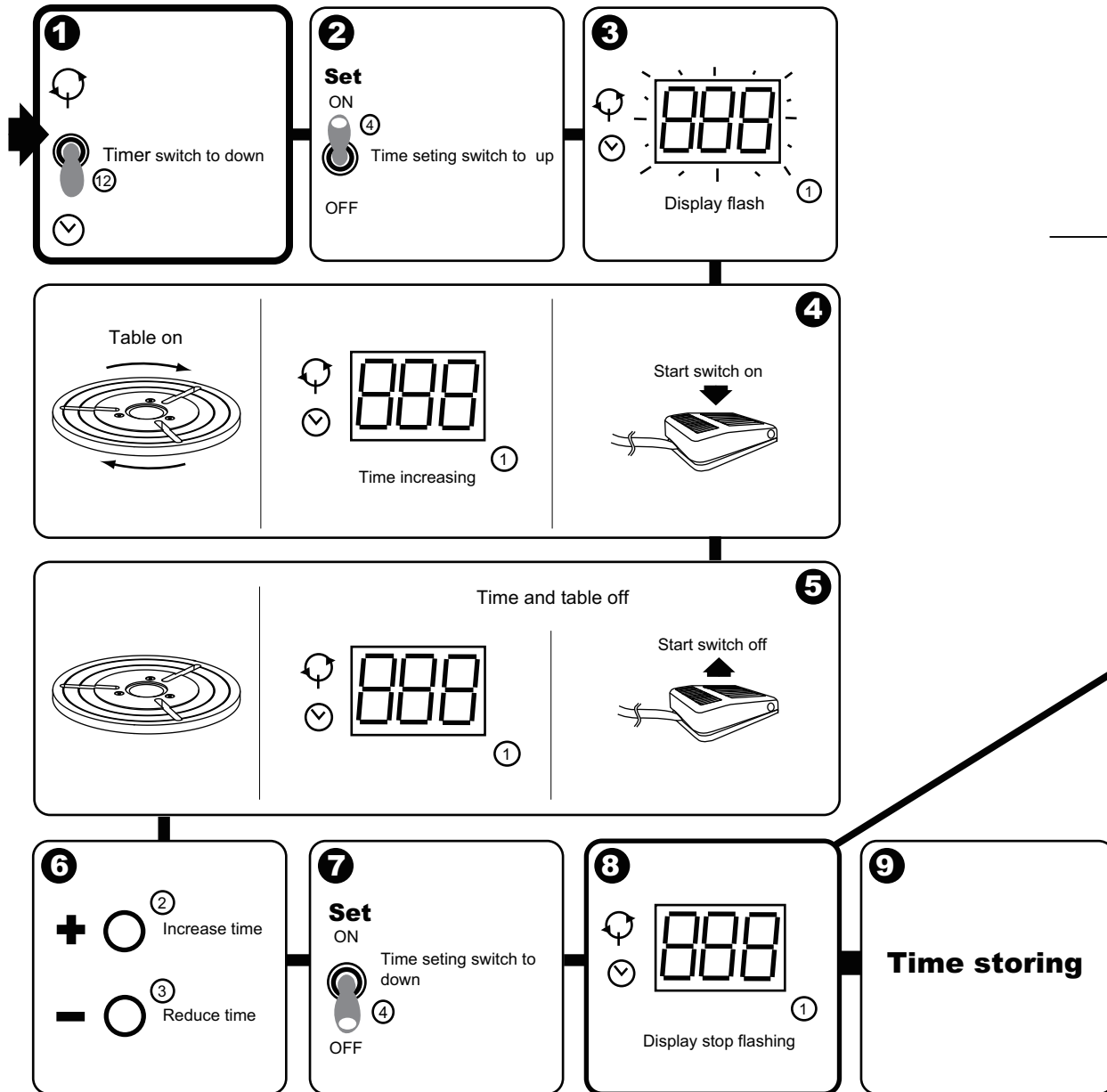
o Delay time of the table and welder

ON SW 12345678
OFF

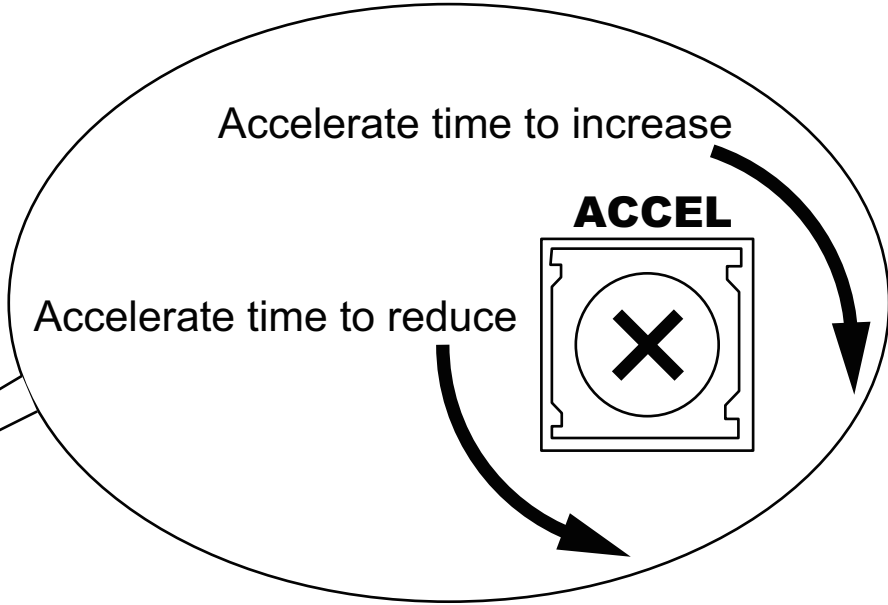
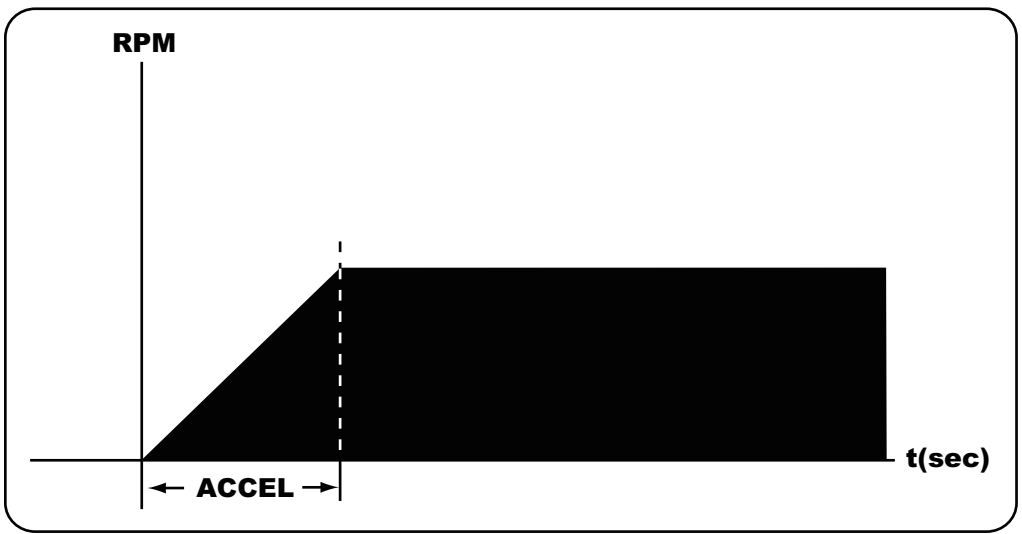
○ **Weld the overlap time establishing operating**



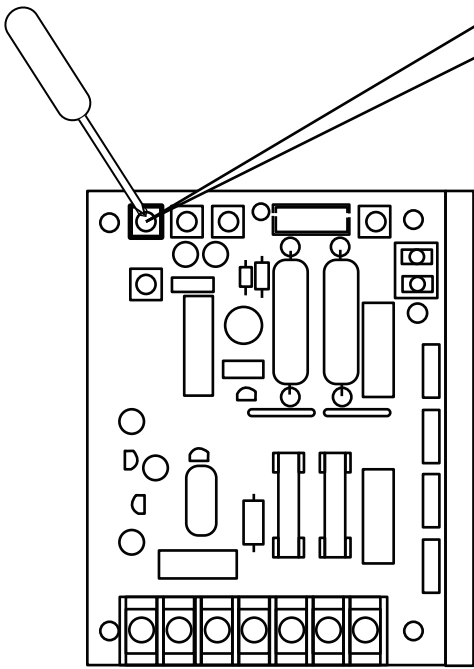
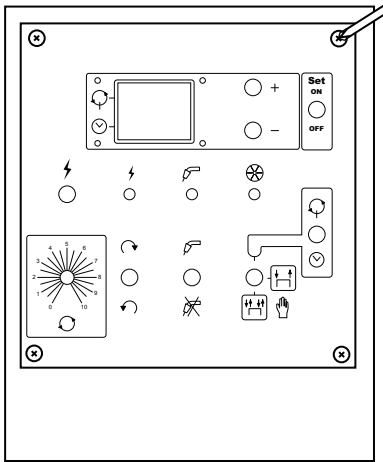
○Weld the timing establishing operating



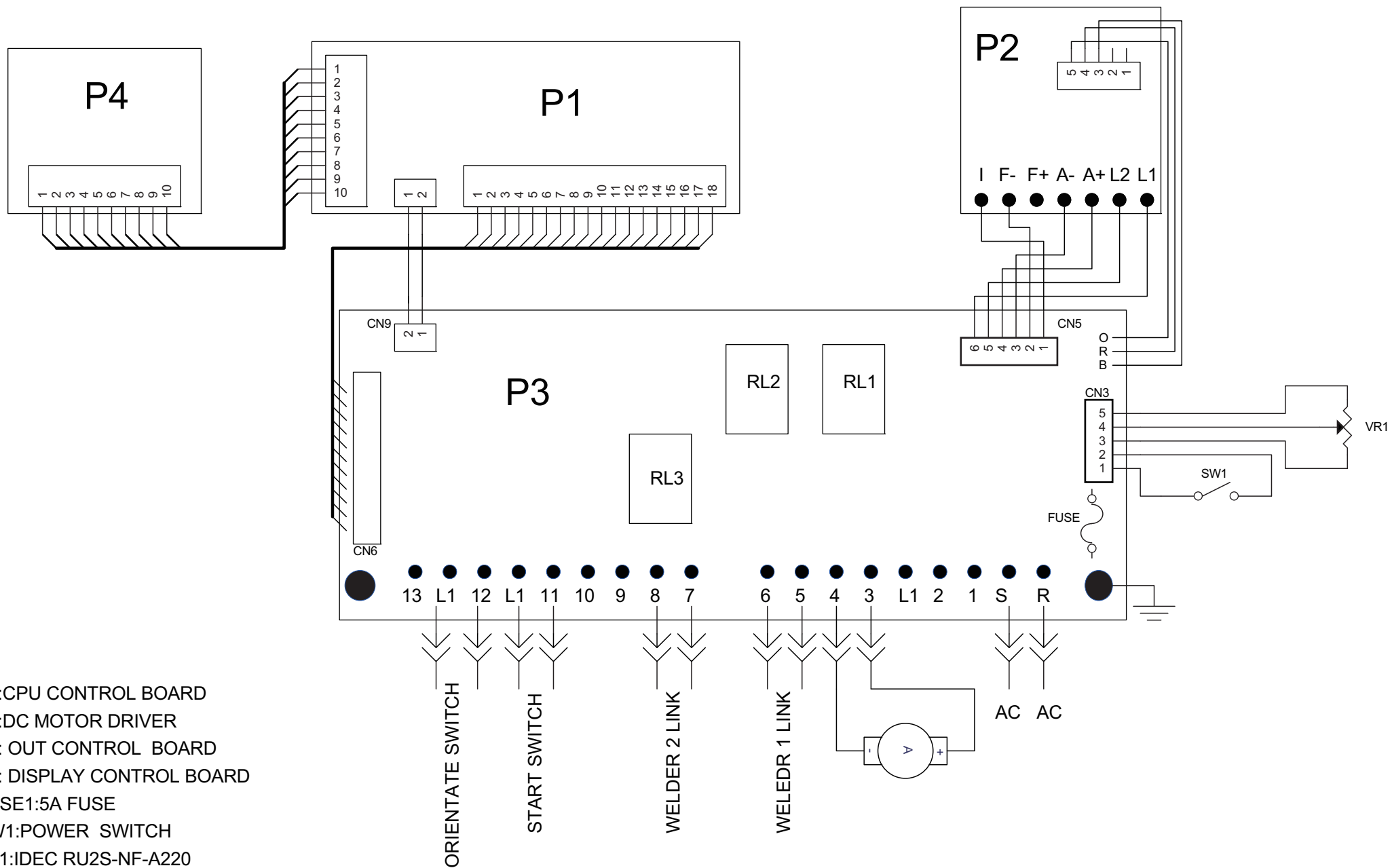
○ **Table start and accelerate time to adjust**



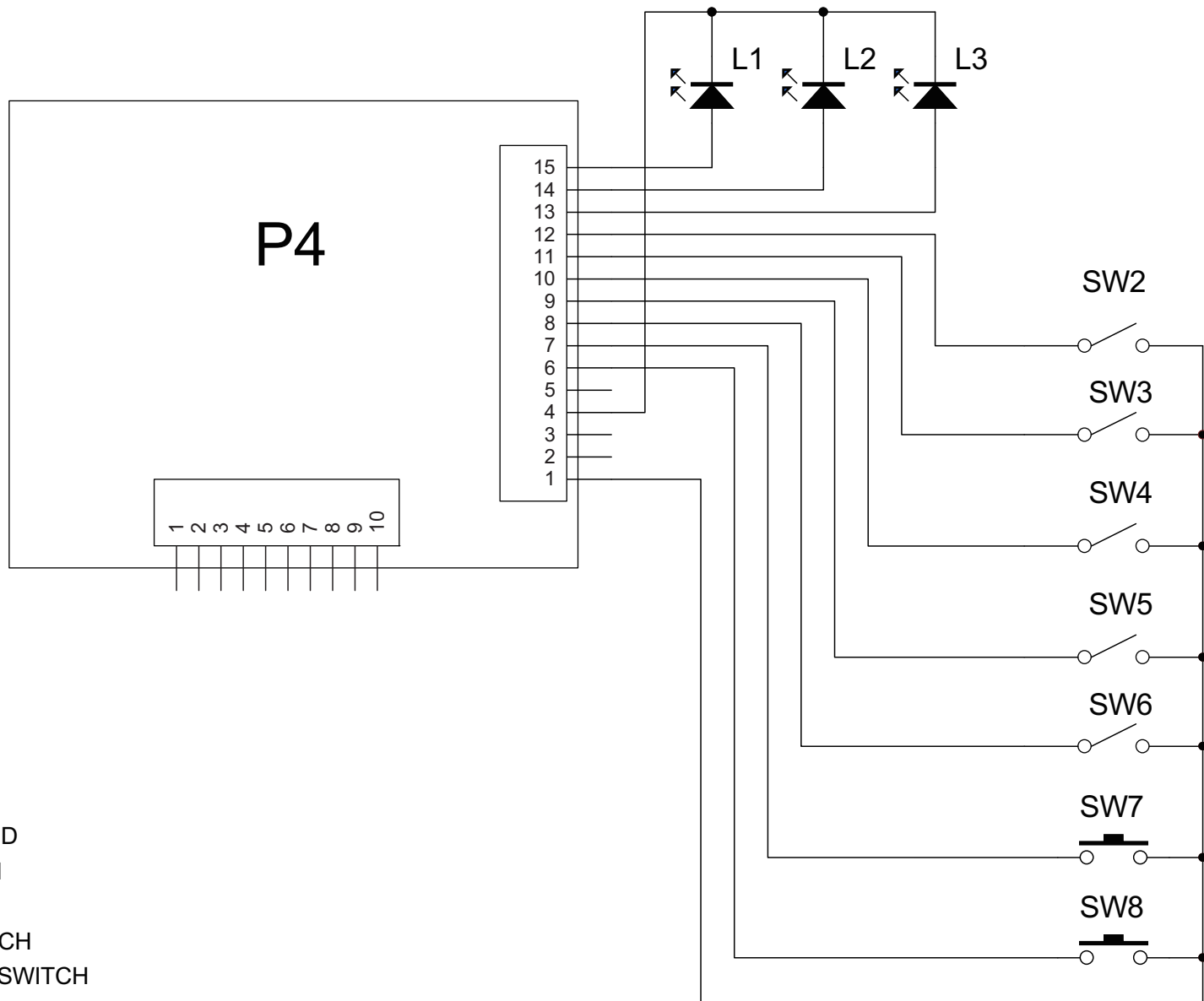
Open the control panel



DC motor driver

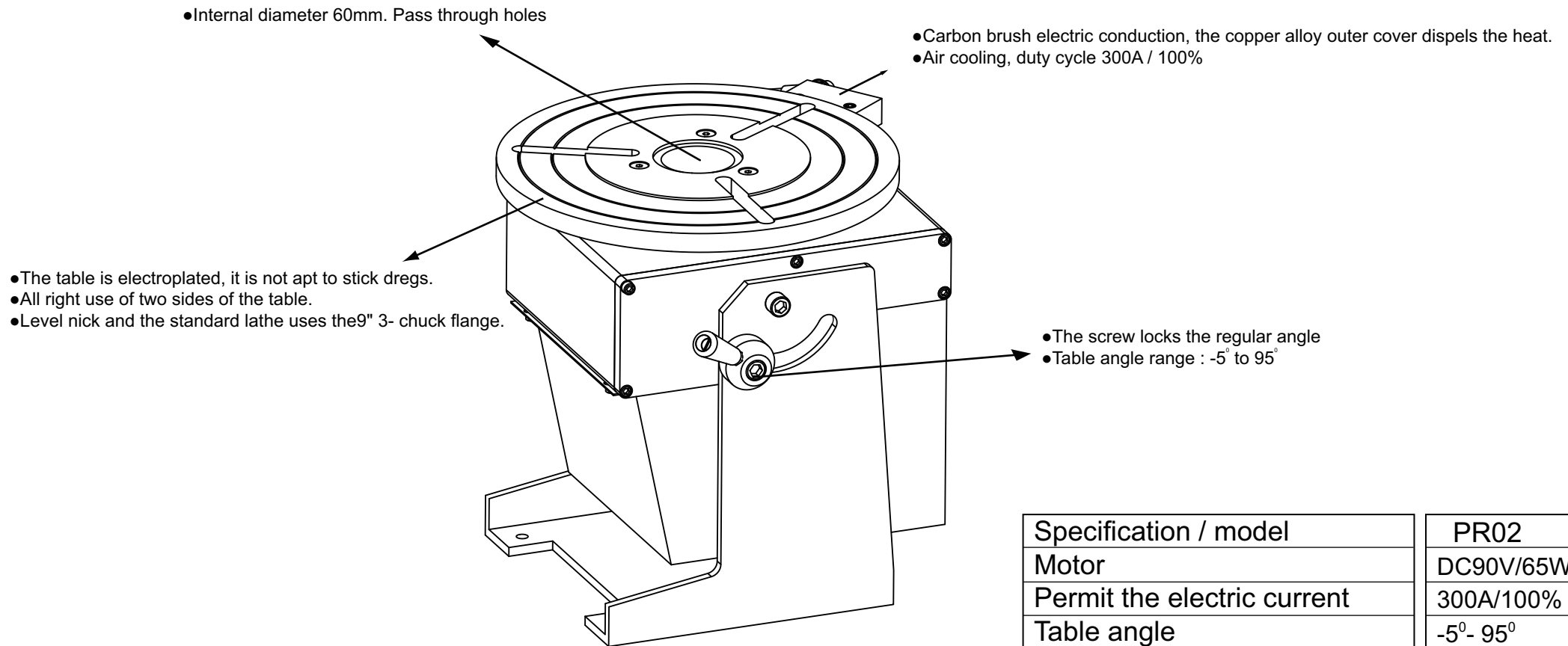


- P1:CPU CONTROL BOARD
- P2:DC MOTOR DRIVER
- P3: OUT CONTROL BOARD
- P4: DISPLAY CONTROL BOARD
- FUSE1:5A FUSE
- SW1:POWER SWITCH
- RL1:IDEC RU2S-NF-A220
- RL2:IDEC RU2S-NF-A220
- RL3:IDEC RU2S-NF-A220
- VR1:5Kohm RATATIONAL SPEED



- 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

○PRO2Structure characteristic and Specification



○Welding method that can be matched

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

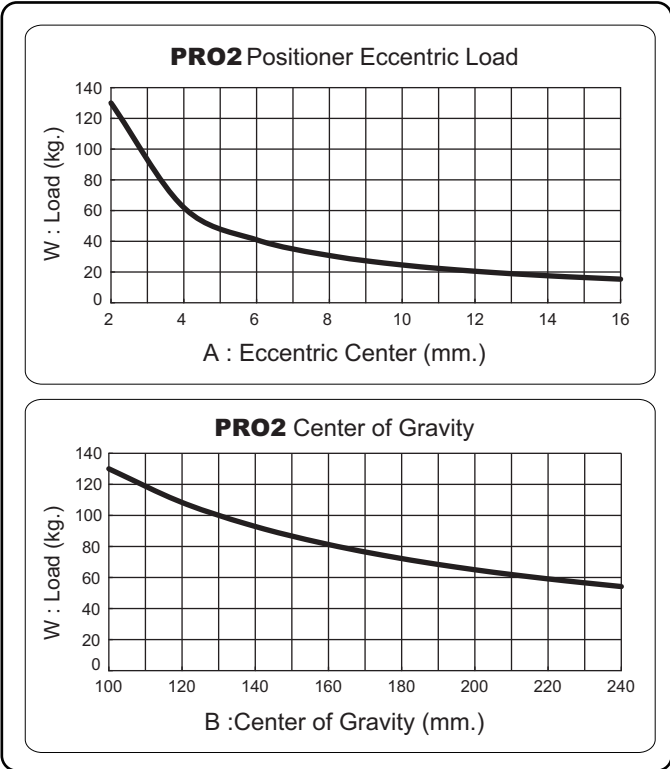
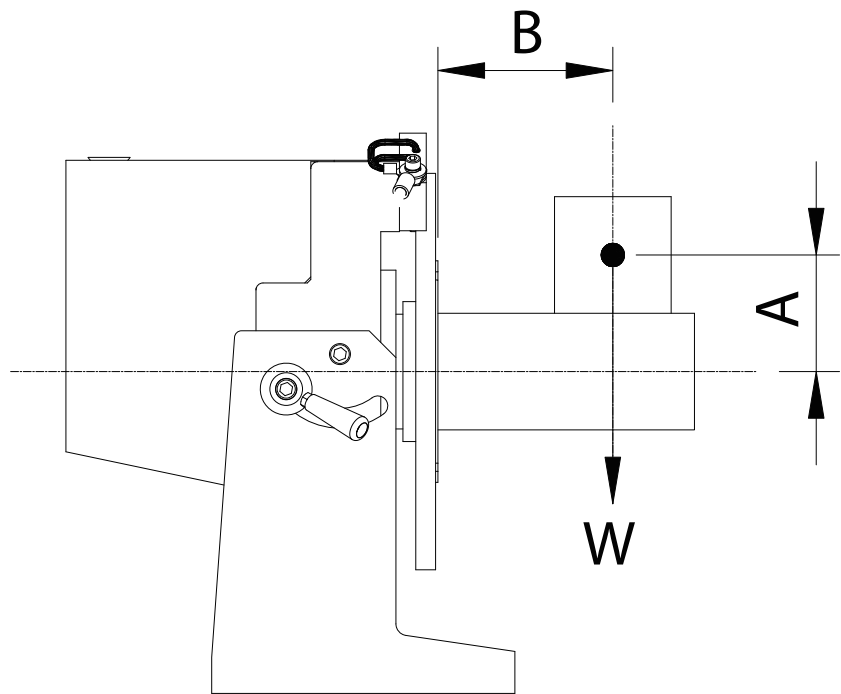
○Dispose the place

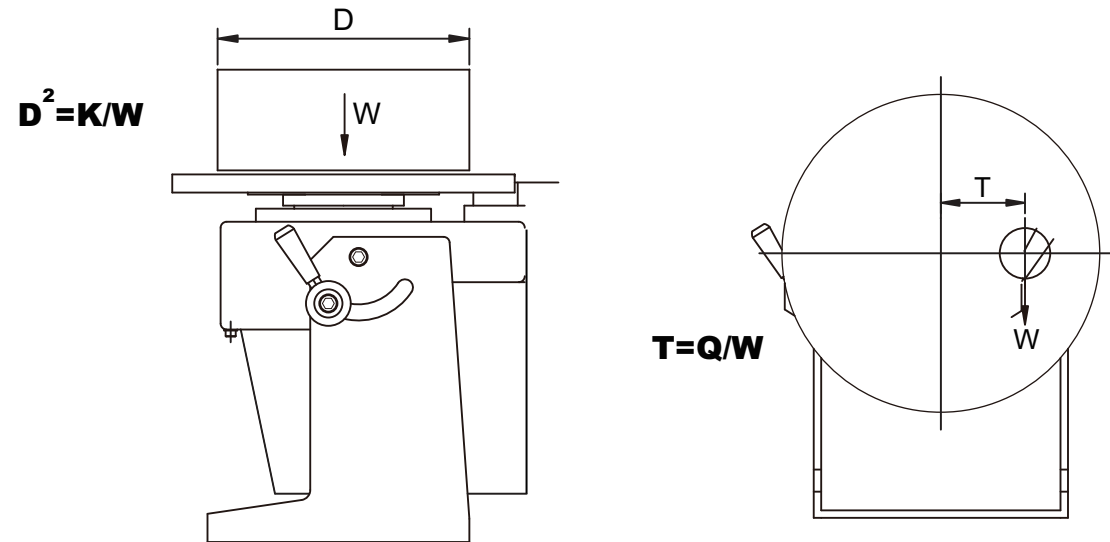
- In the factory

○Duty cycle

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

Specification / model	PR02
Motor	DC90V/65W
Permit the electric current	300A/100%
Table angle	-5°- 95°
Table Dia	Dia 340mm
Table speed	2.4 - 24 rpm
Loading (Table angle is 00)	120 Kg
Loading (Table angle is 900) (Have not supported)	80 Kg
Diameter / weight Data K	38200
Skew / weight Data Q	60
Size / net weight	L:340mm W:288mm H:340mm N.W:56Kg





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)

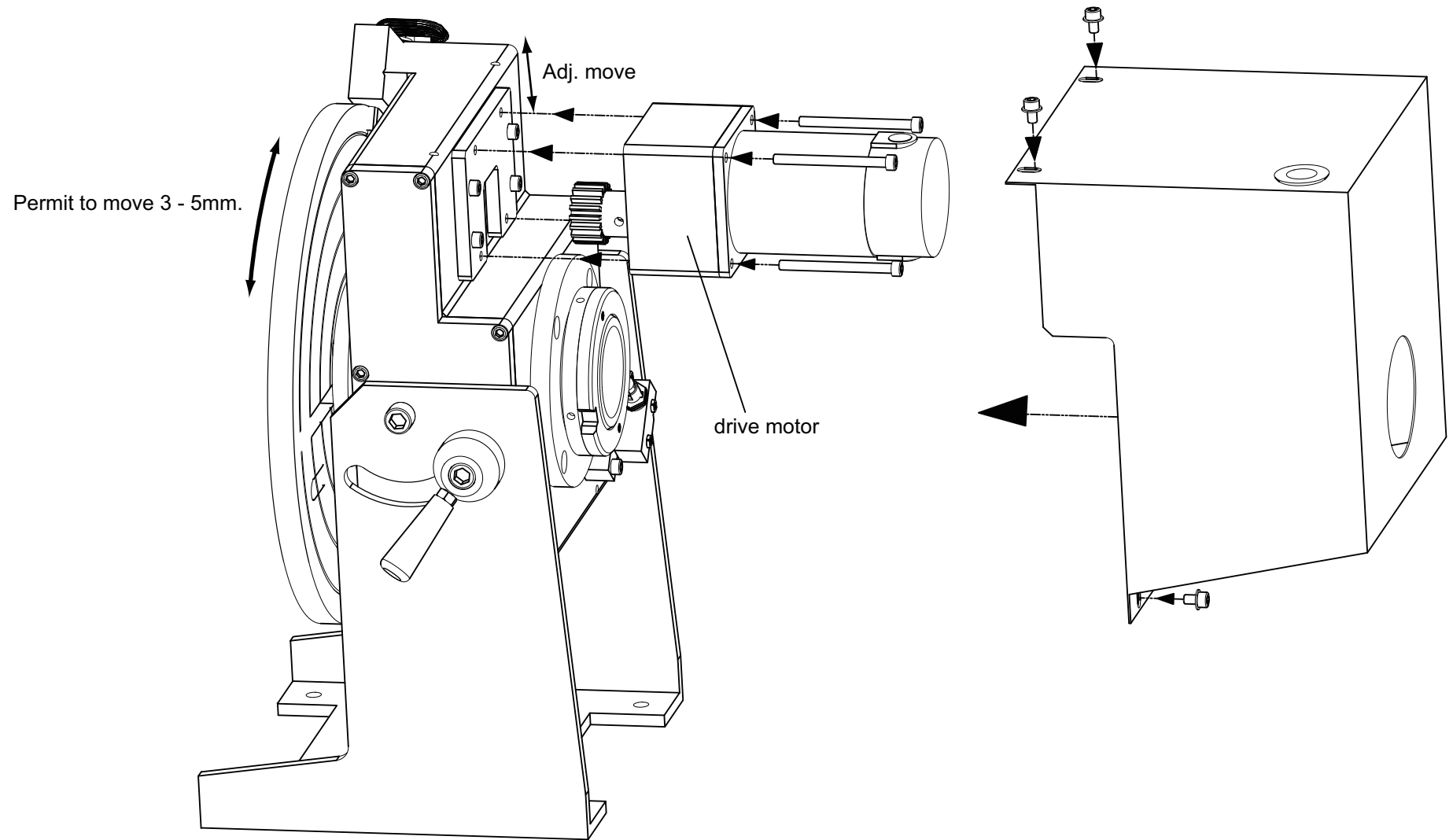
2. Before needing to know the Center skew of the work piece, Please according to the (Q) value shown of the model performance form of the rotary table [Skew / weight], Calculate according to the formula. Formula $T = Q/W$ Unit T=cm W=kg

Example:

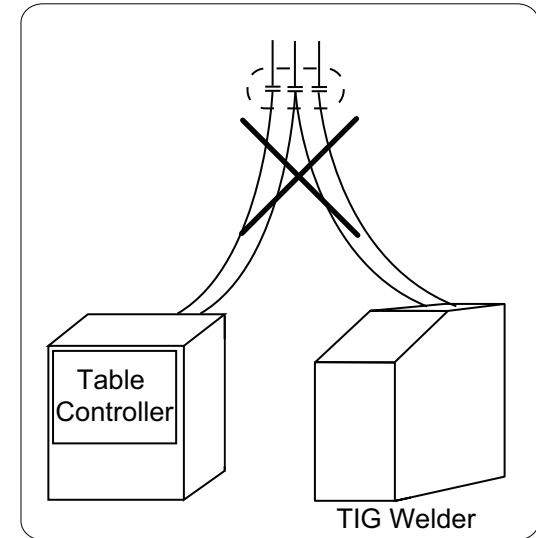
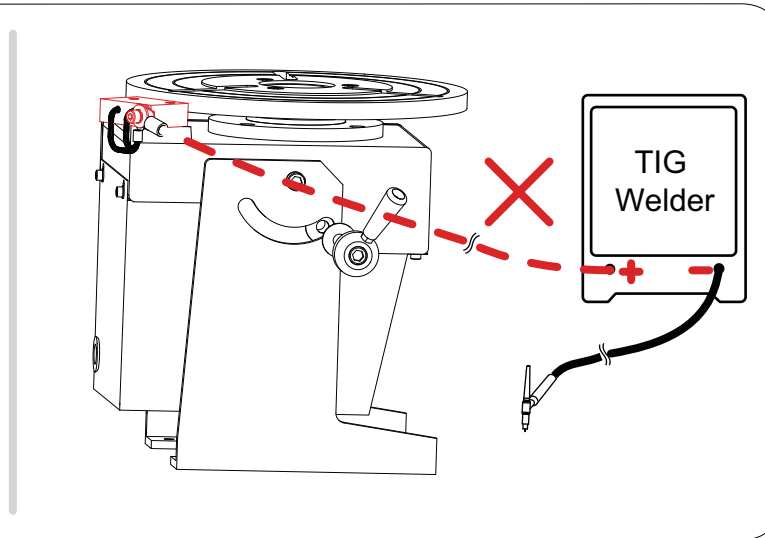
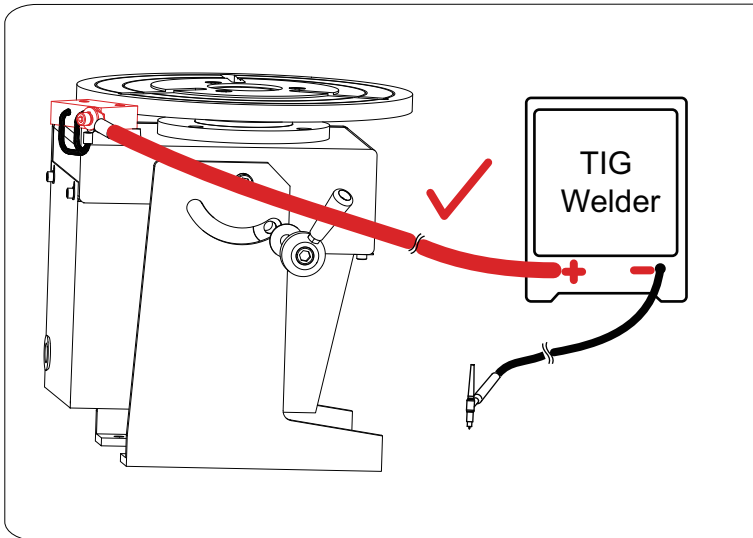
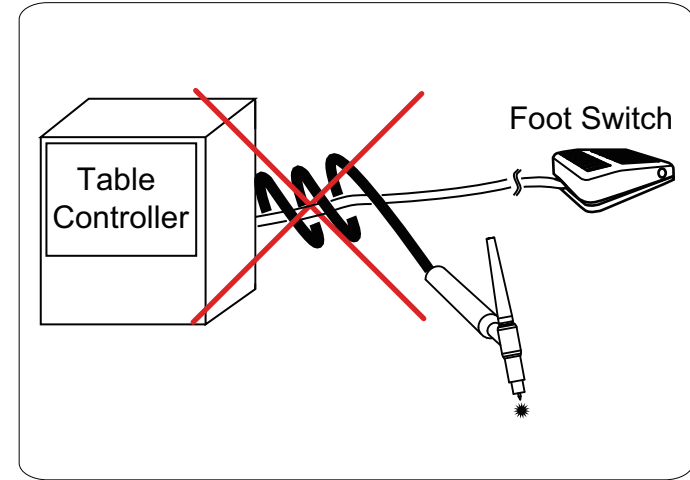
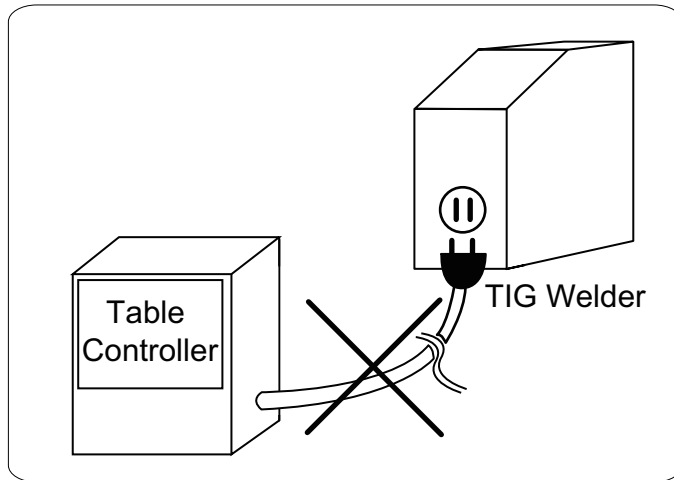
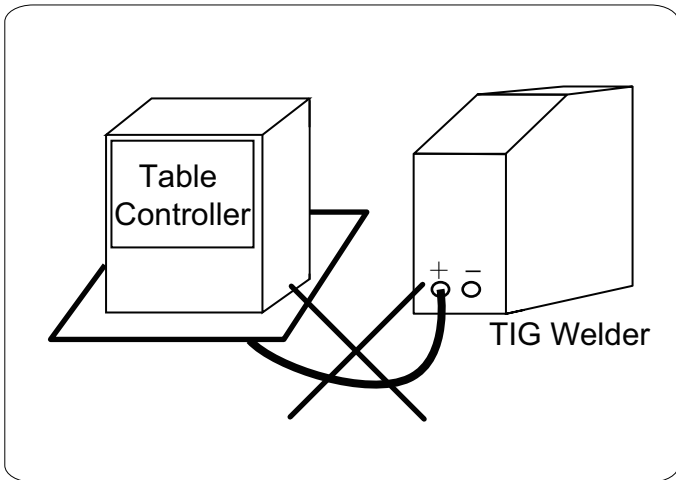
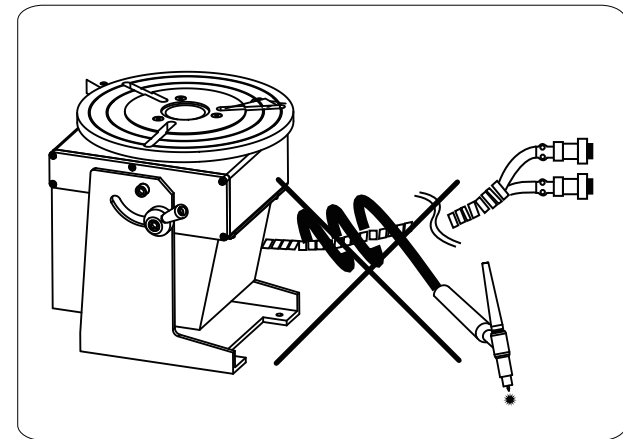
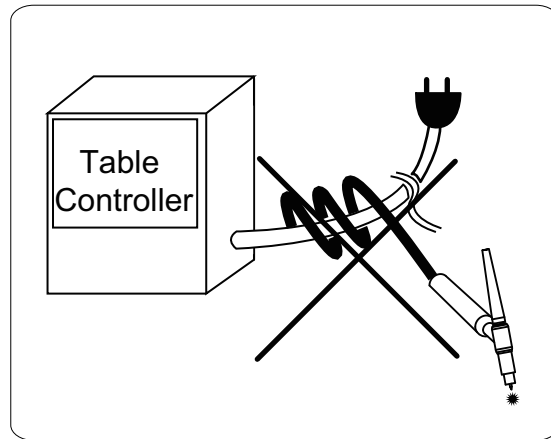
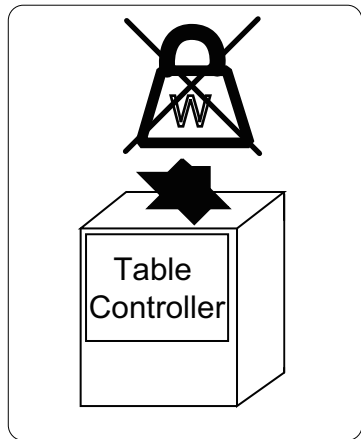
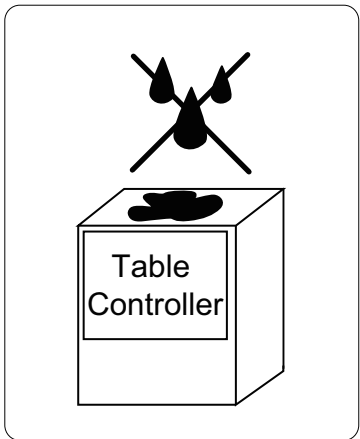
Take rotary table of POS2B as an example, The weight of the work piece is 120kg. The formula calculating:

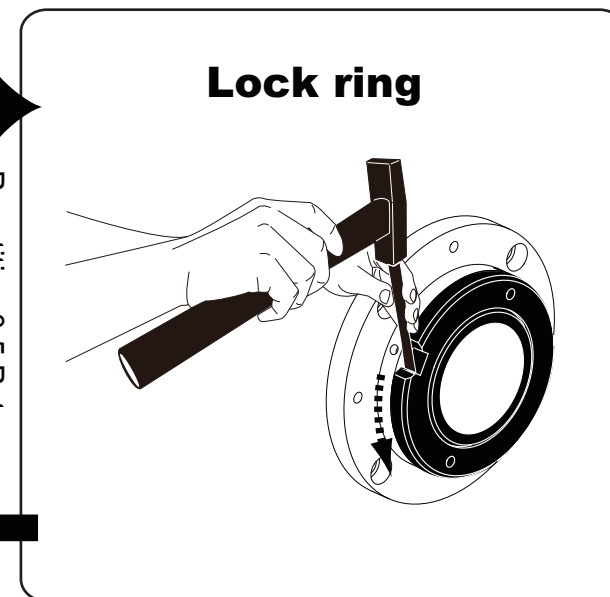
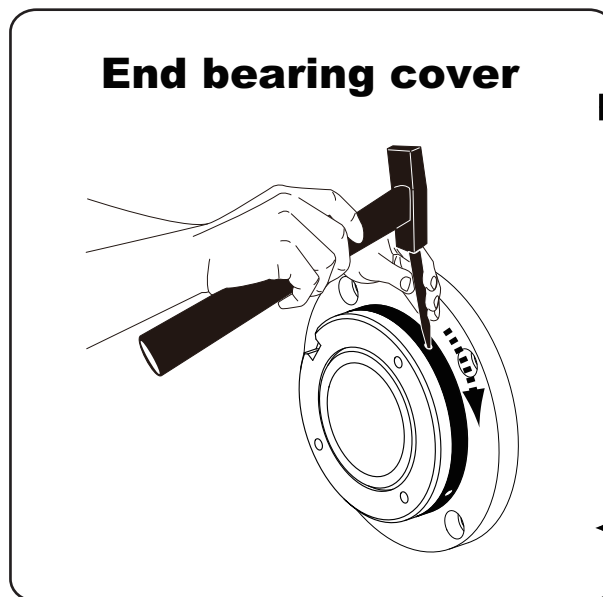
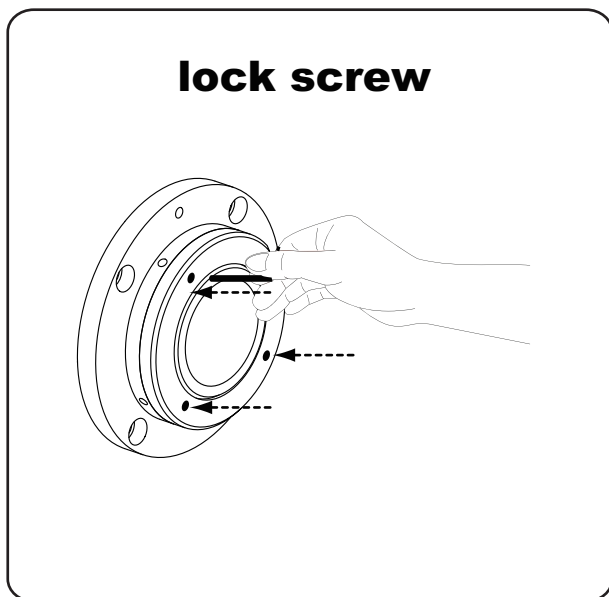
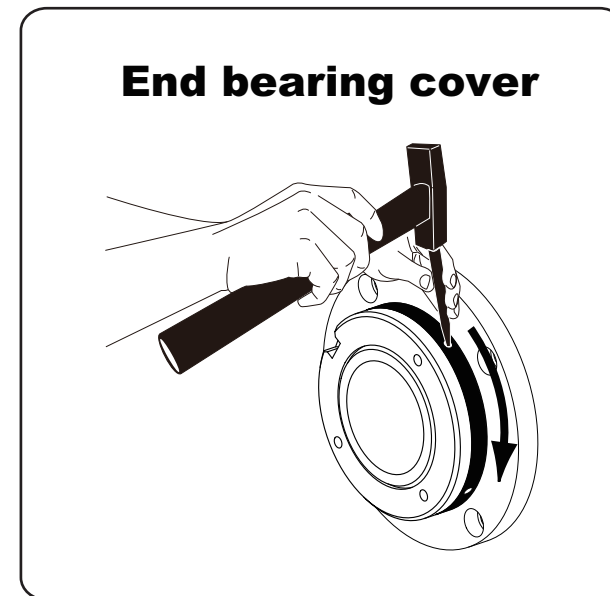
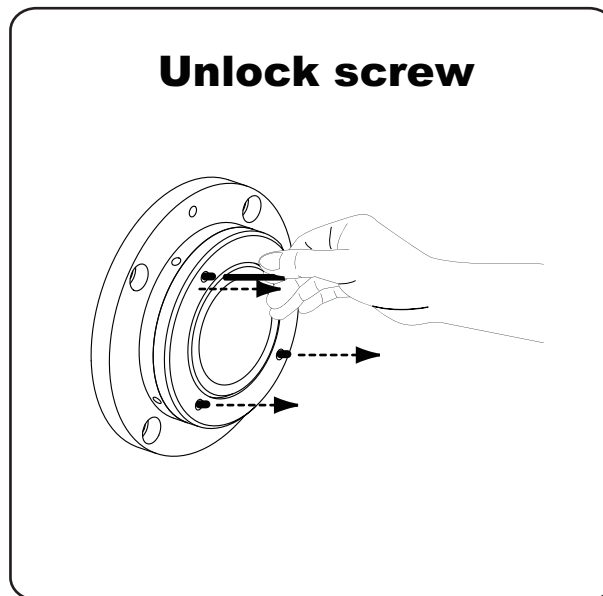
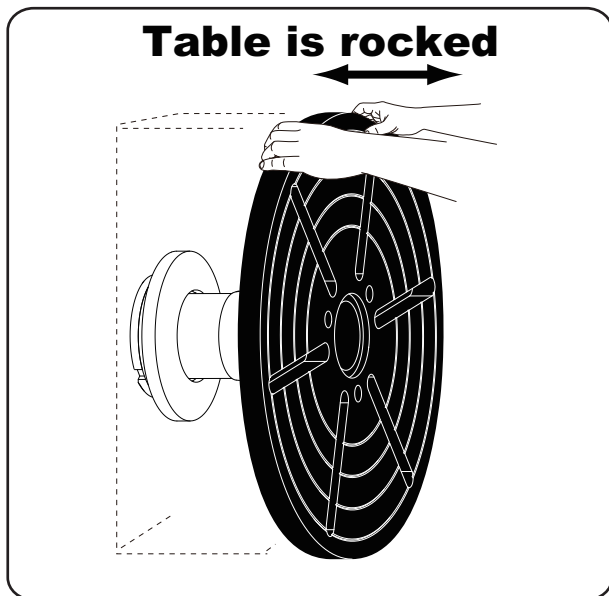
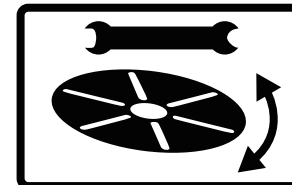
$T = 175/120$ Know after calculating T=1.45cm (Work piece center skew)

•Install the method of the drive motor



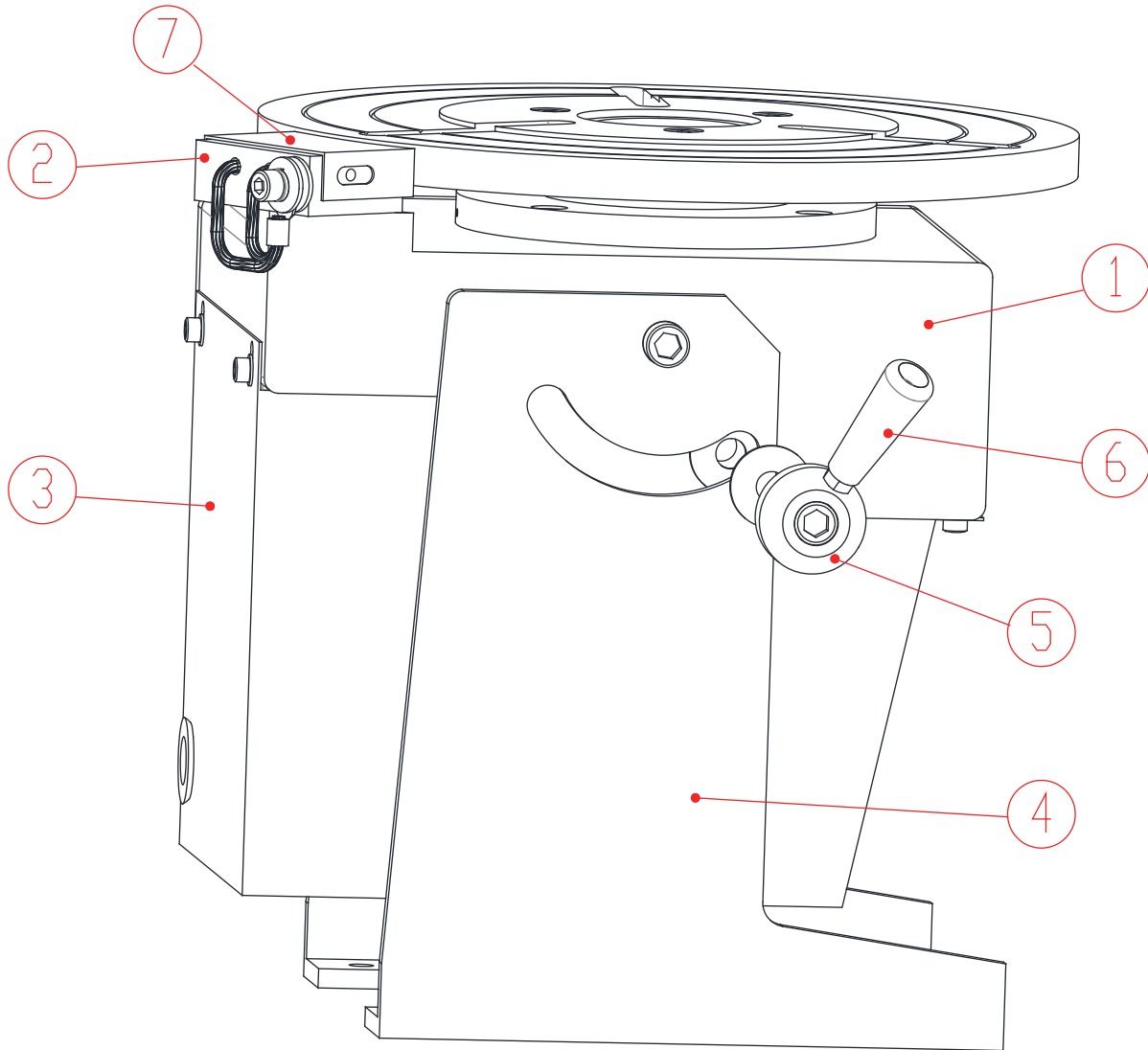
Rotate the table and confirm moving the distance(3 - 5 mm) with hands, lock the drive motor





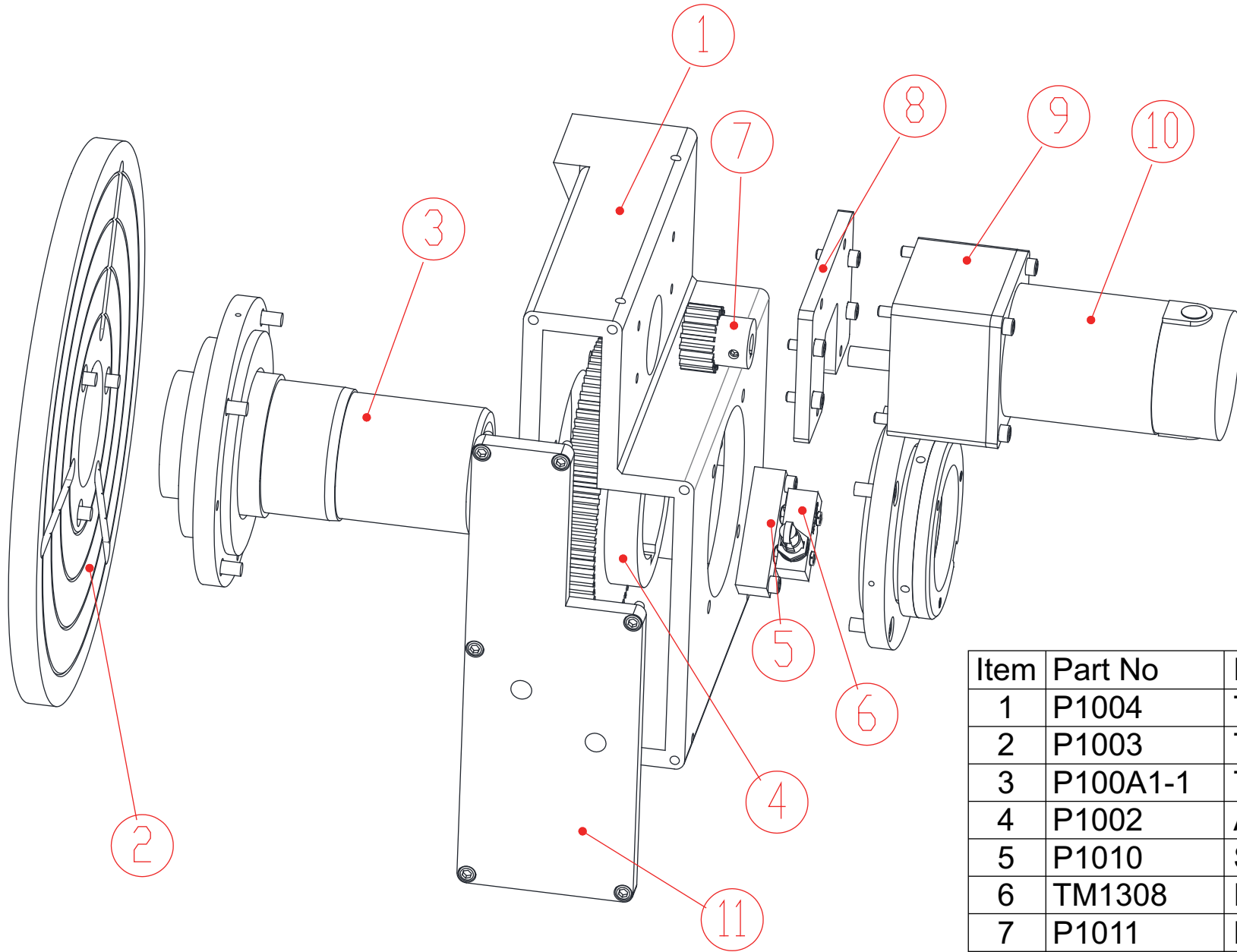
Repetition 3-5 Returns

POS1 Structure

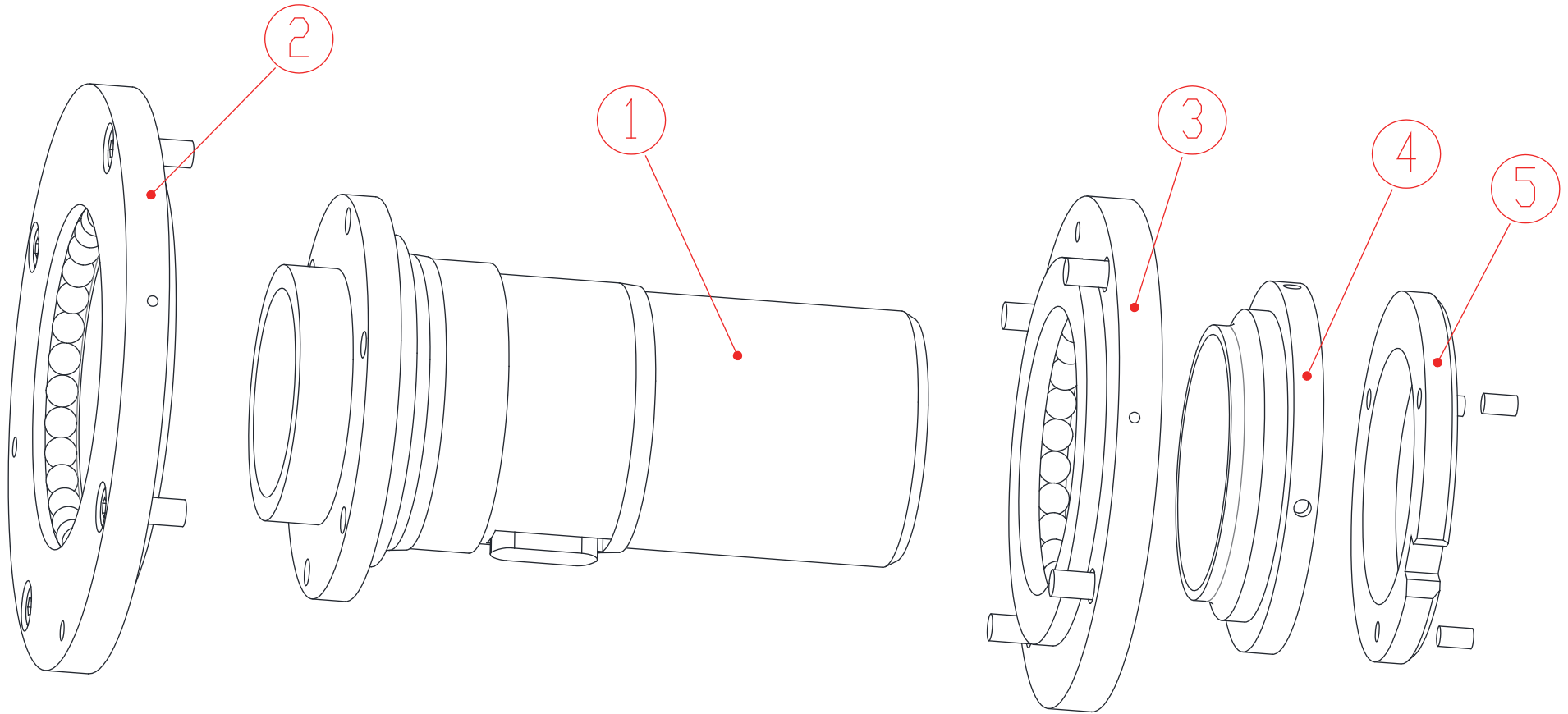


Item	Part No	Part Name	Q'TY
1	P100A1	Table case group	1
2	P100A2	Welding ground	1
3	P1005	Motor cover	1
4	P1007	Table shelf	1
5	P1006	Angle fixed screw	2
6		W5/16"handle	2
7	P1008-4	202Copper seat cover	1

POS1 Structure

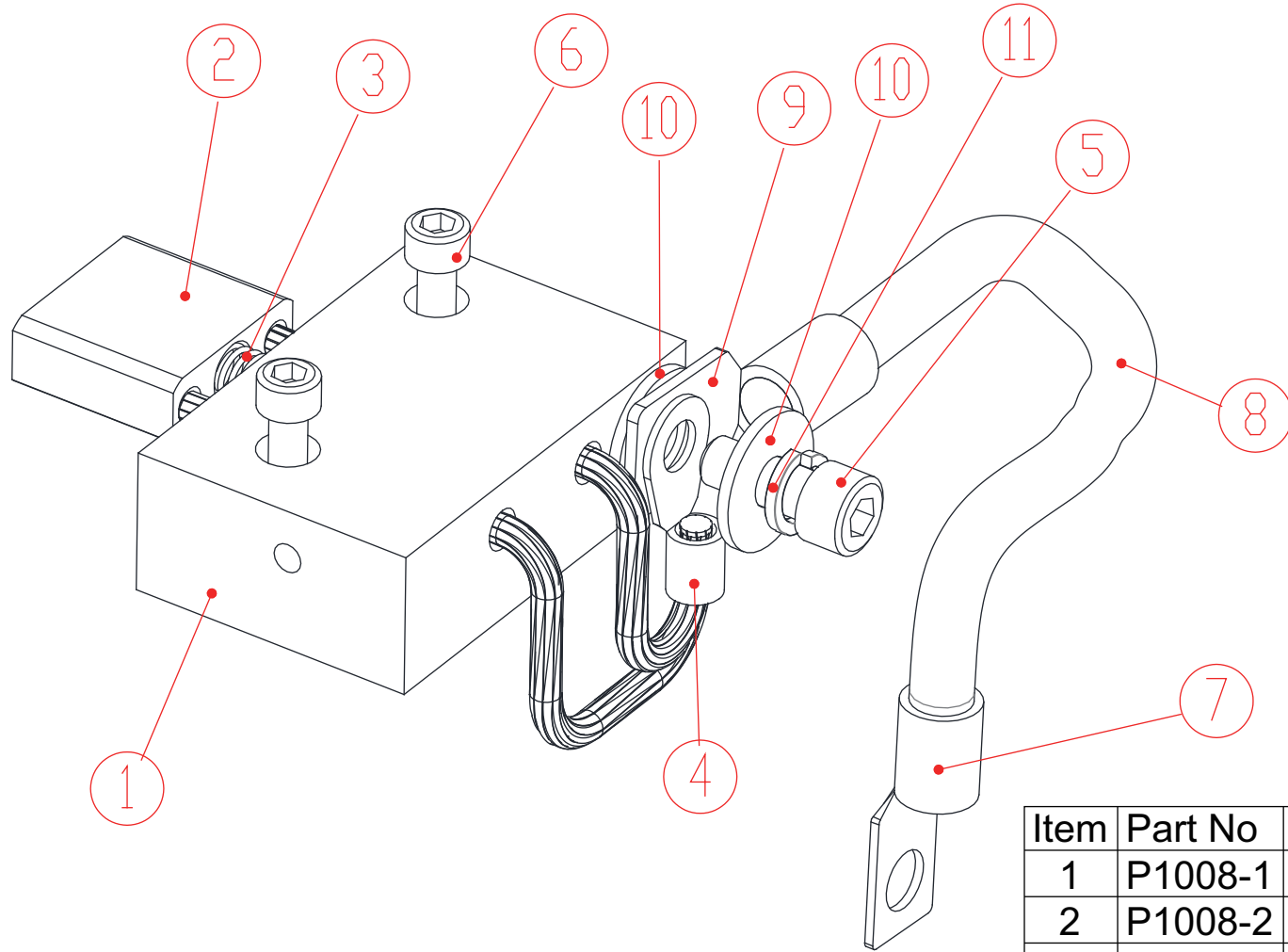


Item	Part No	Part Name	Q'TY
1	P1004	Table case	1
2	P1003	Table	1
3	P100A1-1	Table axis group	1
4	P1002	Axis gear	1
5	P1010	Switch seat	1
6	TM1308	Fixed position switch	1
7	P1011	Drive gear	1
8	P1012	Motor flange	1
9	5GN	Reducing gear box	1
10	DC65W90V	DC motor	1
11	P1004-1	Table case cover	1

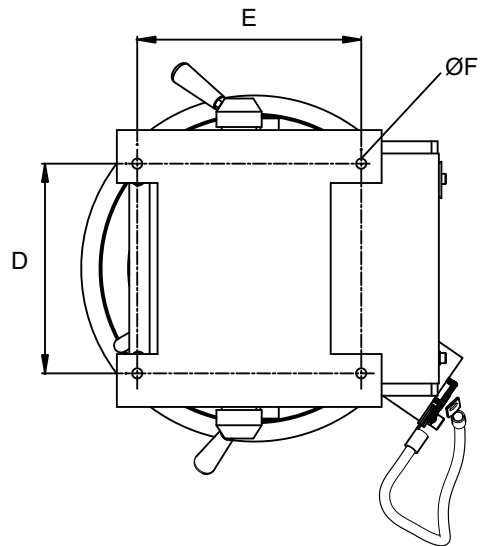
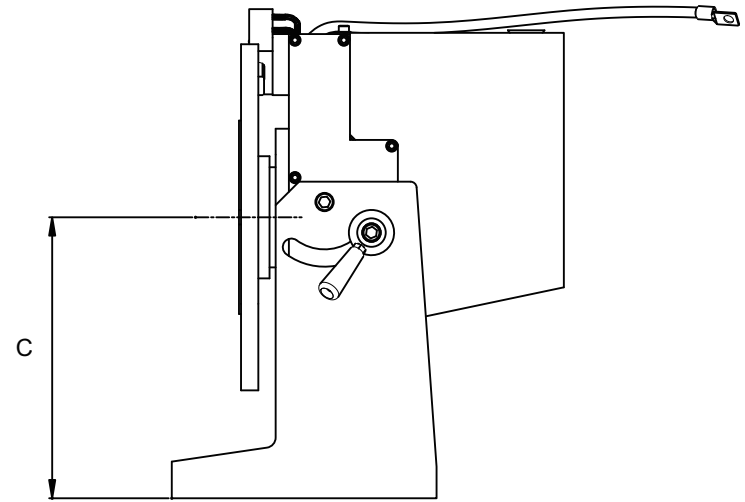
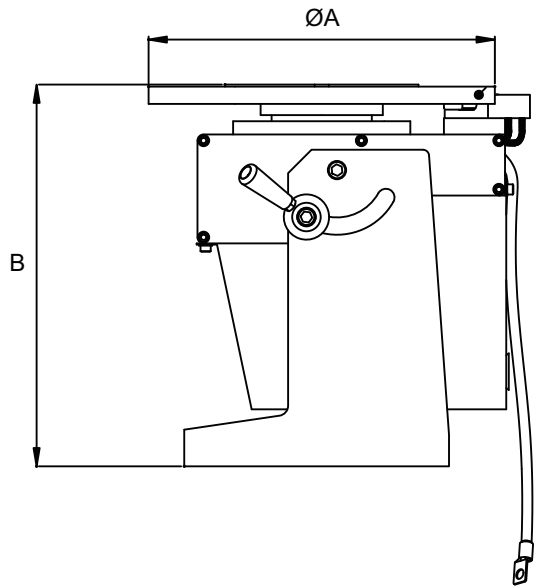


Item	Part No	Part Name	Q'TY
1	P1001-1	Main axial tube	1
2	P1001-2	Main axial seat	1
3	P1001-3	Axial seat	1
4	P1001-4	Axial piece	1
5	P1001-5	Lock ring	1

POS1 Structure



Item	Part No	Part Name	Q'TY
1	P1008-1	Welding ground	1
2	P1008-2	Grounded carbon brush	1
3	P1008-3	Grounding spring	1
4		8-8 Terminal	1
5		M8*30 Hexagon socket head screw	1
6		M6*25 Hexagon socket head screw	2
7		50-12 Terminal	1
8		50 square ground cable	1
9		50-10 Terminal	1
10		M8 Washer	2
11		M8 Spring washer	1



	PR02
A	340mm
B	375mm
C	276mm
D	206mm
E	220mm
F	10mm