



Owner's Operating Manual

AVC101 ARC LENGTH CONTROLLER



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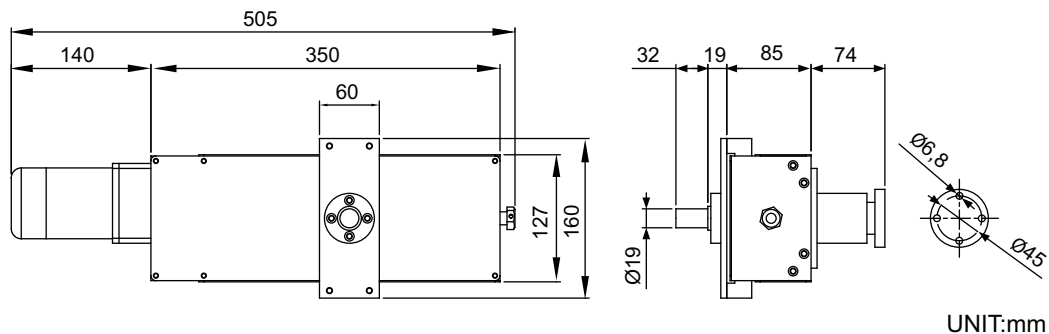
<http://www.batons.com.tw/> e-mail : batons@mail2000.com.tw

Chapter 1: Function

1.1 AVC-101 ARC LENGTH CONTROLLER

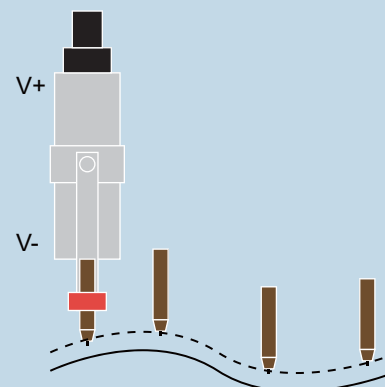


Model	AVC-101
Input Power	AC 220V / 4A / 1Ø
Torch Stroke	150mm.
Torch Speed	150 mm / min
Weight Capacity	6Kgs.
Sensitiv	0.1V - 0.5V
Arc way of the welder	Standard(2 cycle) / Cater(4 cycle)
Travel Start Delay	0 - 99.9 Sec
Travel Stop Delay	0 - 99.9 Sec
Volt Sensing	DC 5 - 50V
Line welder	1Set
Slide (Size / weight)	6.5Kgs
Controller (Size / weight)	19(D)*30(W)*33(H) / 8Kgs

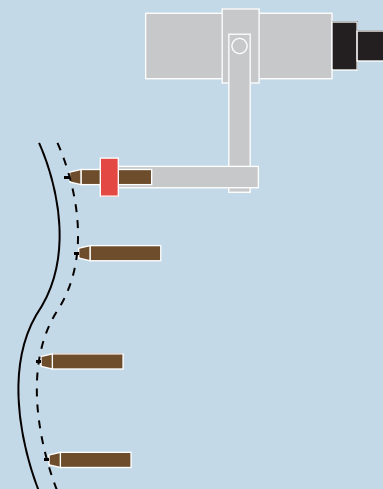


Installer

Horizontal

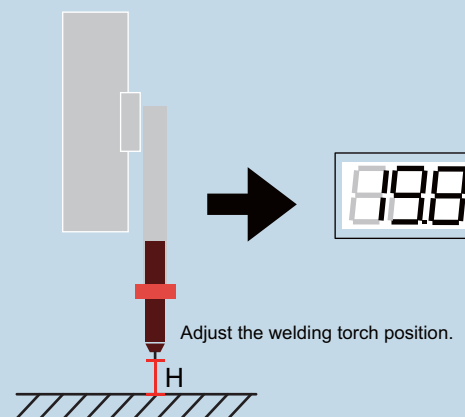


Vertical

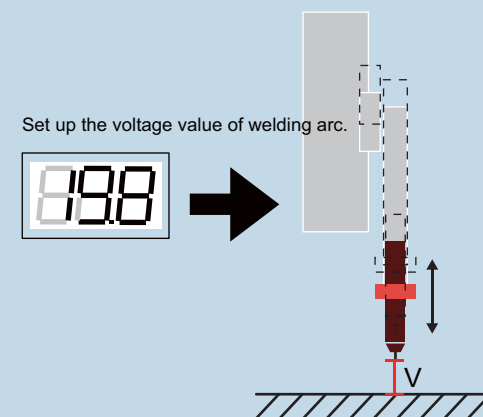


Operation mode

The operator adjusts the position (with the distance of the work piece) of the welding torch at first, the AVC-101 arc length controller will automatically detect the voltage value of the welding arc.



The operator sets up the voltage value of welding arc directly, AVC-101 arc length controller will to adjust the position of the welding torch automatically.

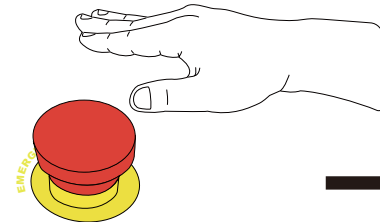
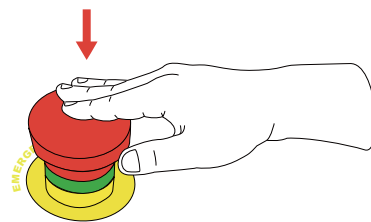


Chapter 2: Safe and explaining

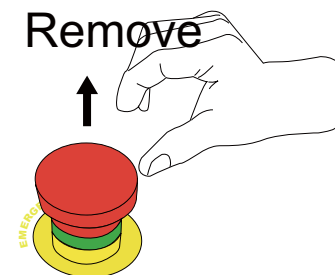
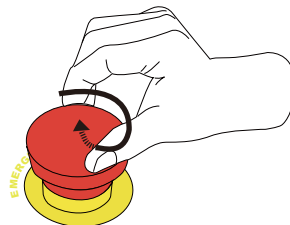
The power stops promptly



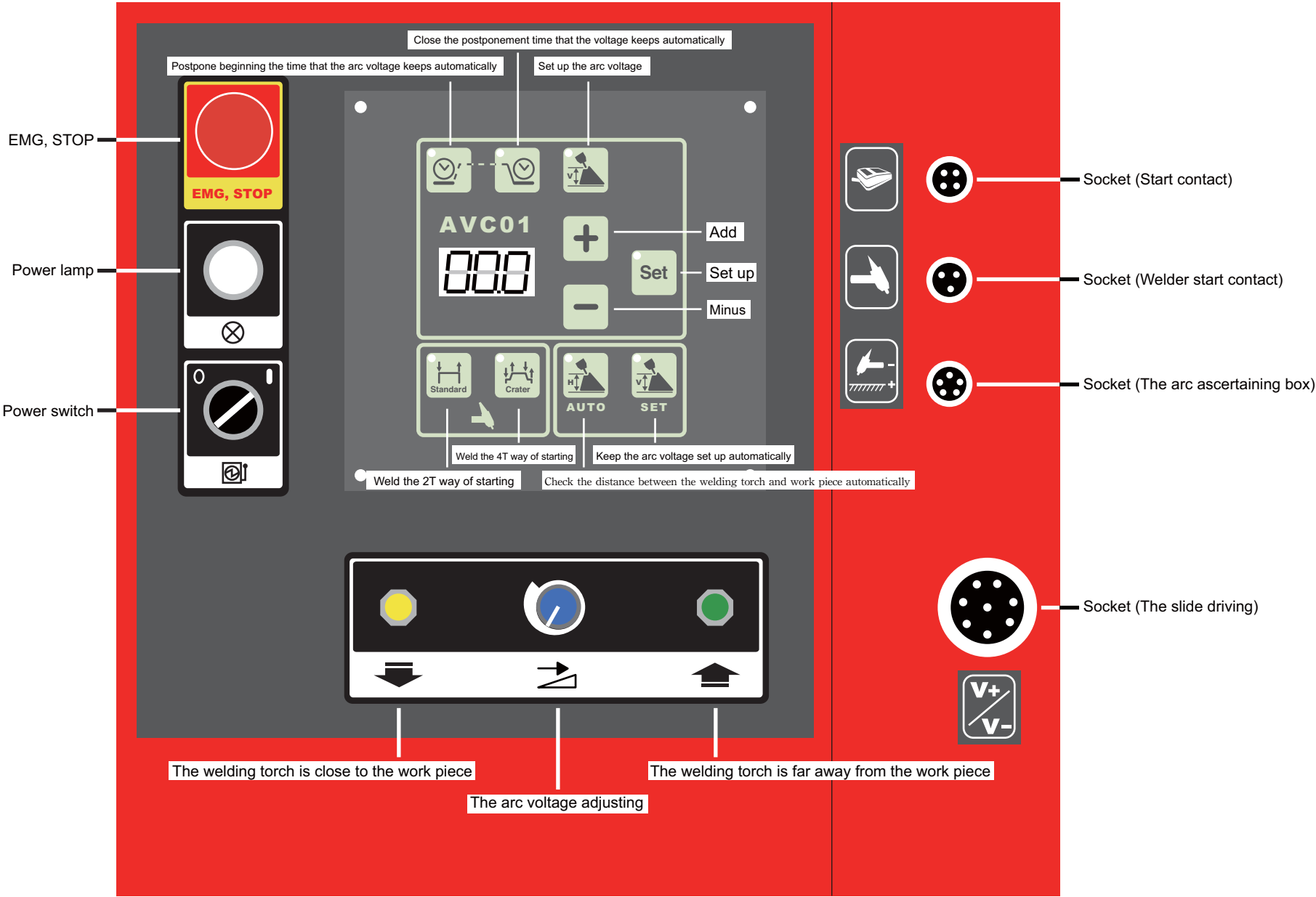
EMG, STOP



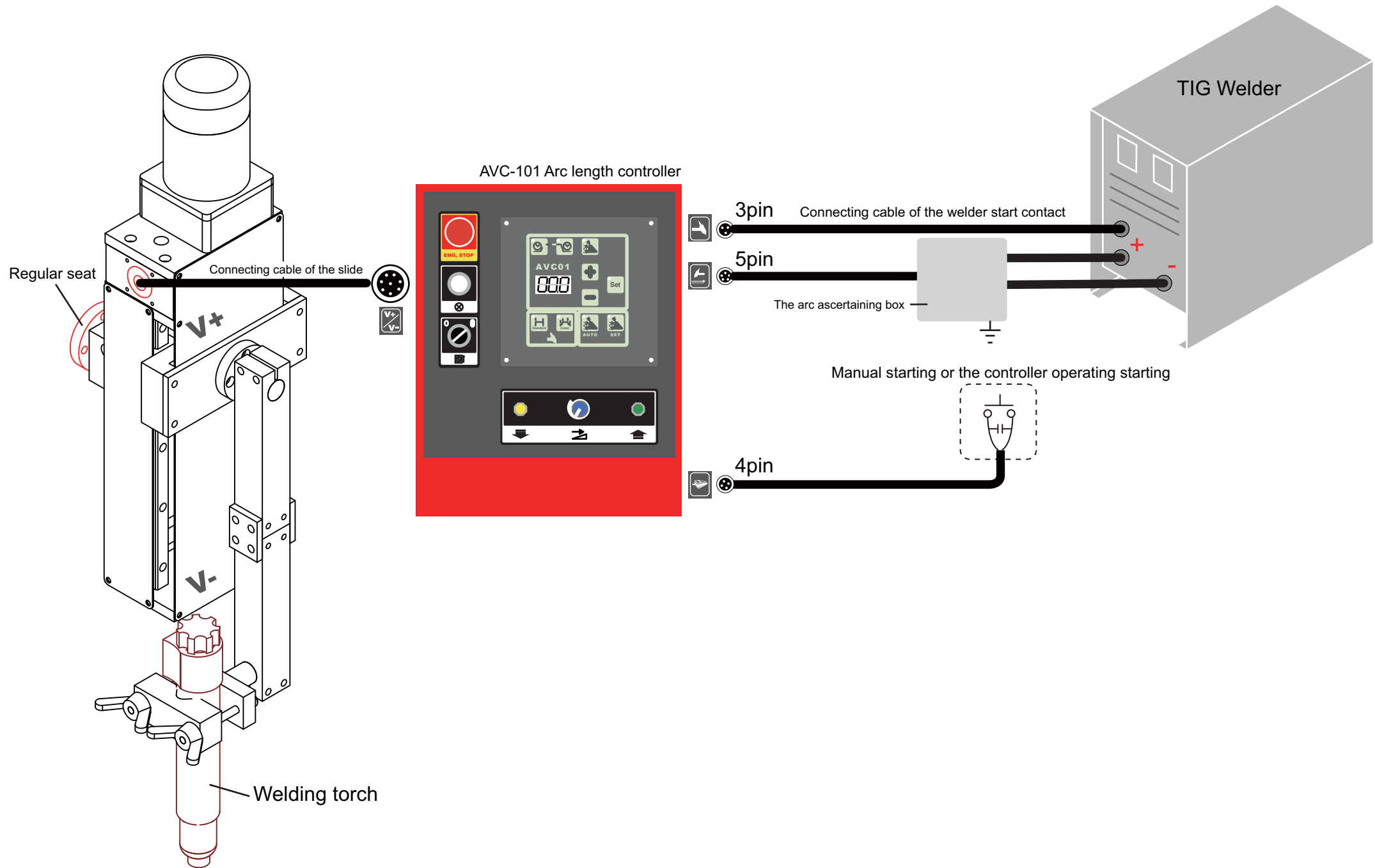
All functions stop being over



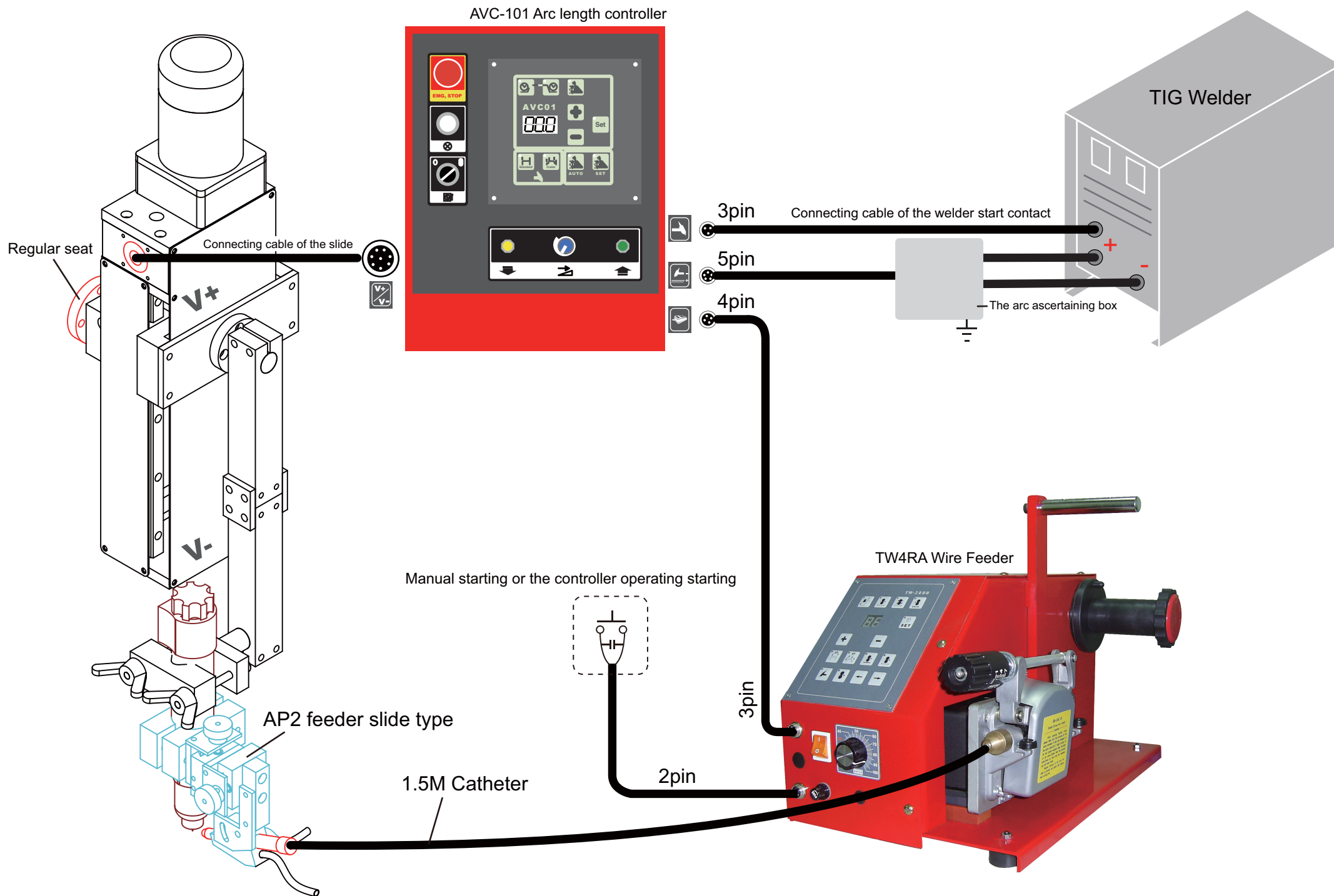
Resume operating



Chapter 3: Installation



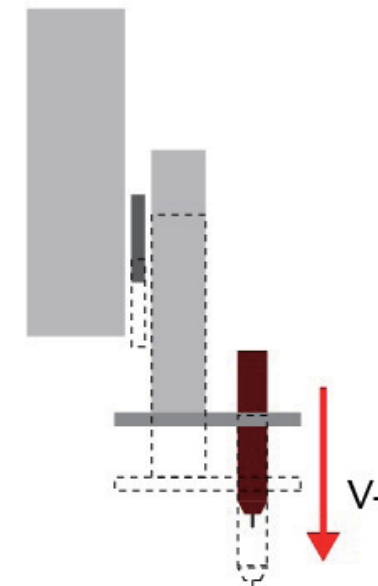
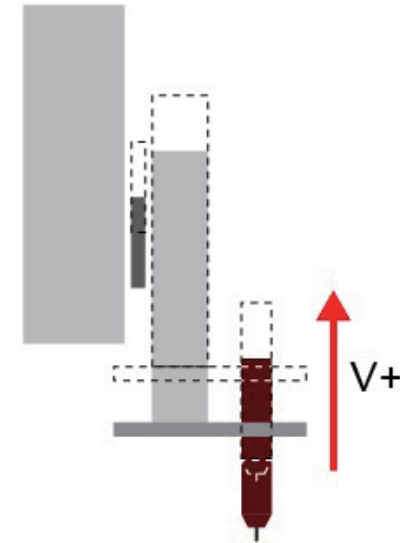
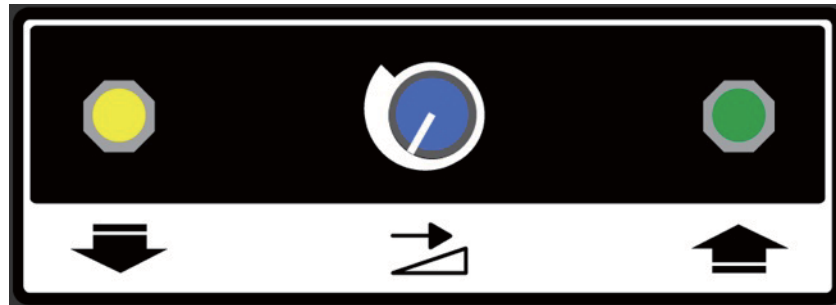
3.2 AVC101 Installation(TIG + wire or Plasma welding + wire)

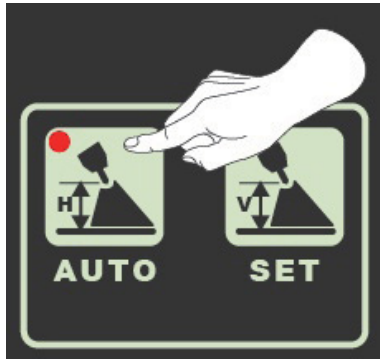


Chapter 4: Operation

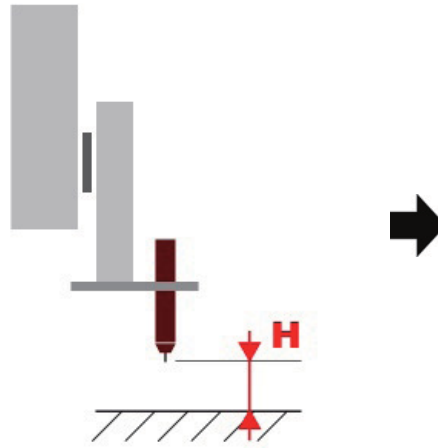
4.1 Adjust the position of the welding torch

(Have not carried out keeping the function of arc length)

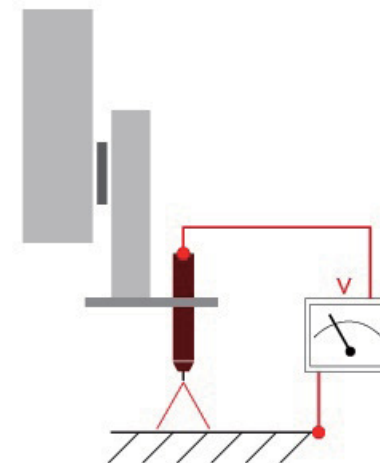




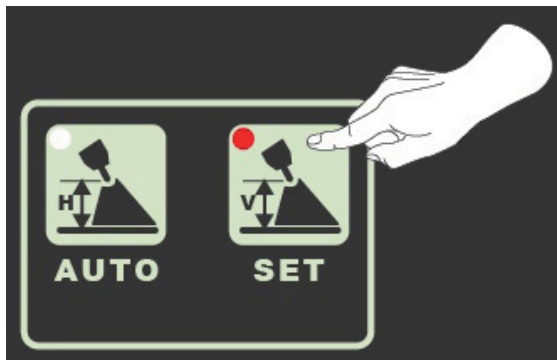
Check the distance between the welding torch and work piece automatically



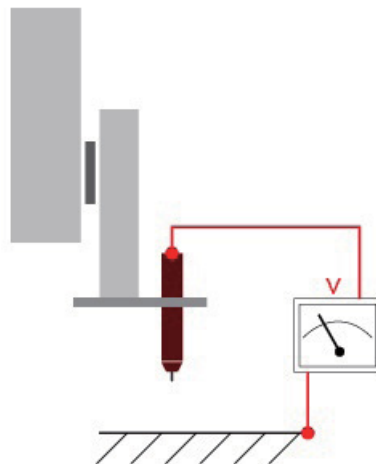
Adjust the position of the welding torch
(The operator operates by oneself)



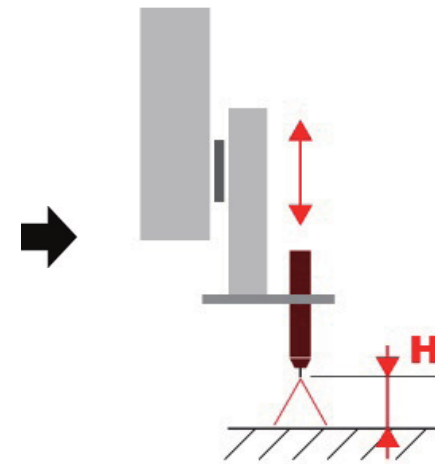
After beginning to weld, check the arc voltage automatically



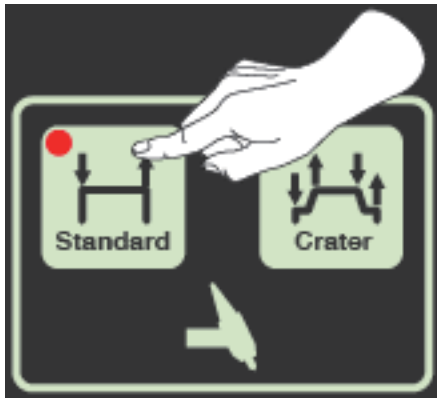
Keep the arc voltage set up automatically



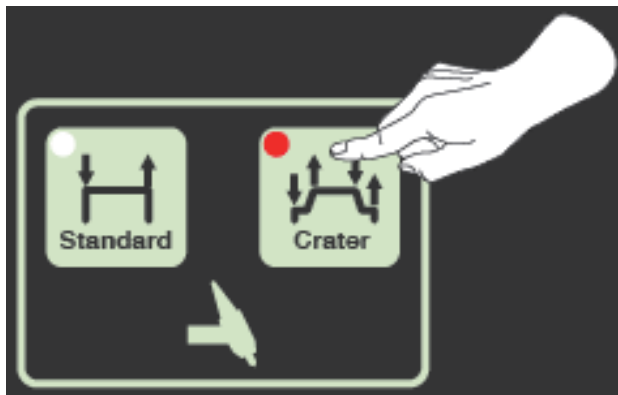
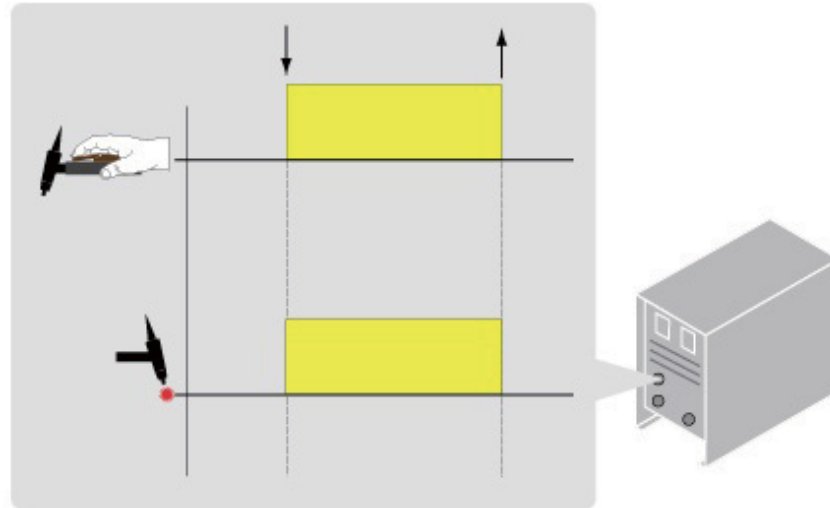
Set up the value of the arc voltage
(The operator operates by oneself)



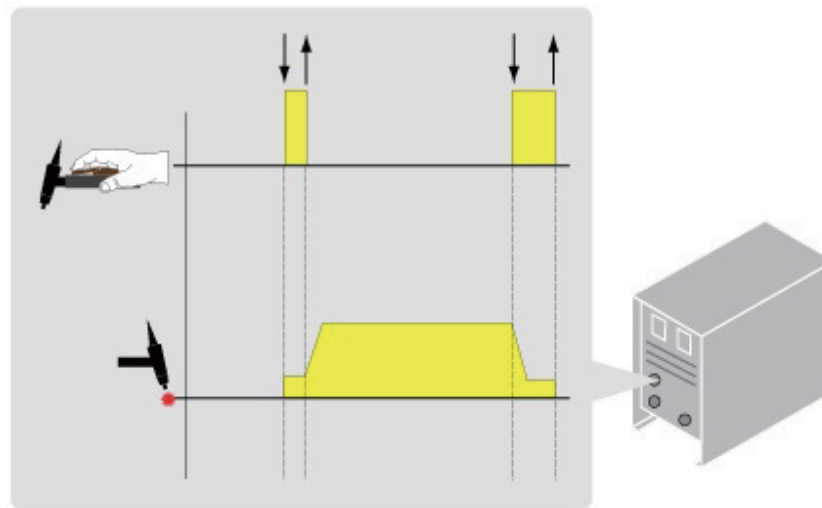
After beginning to weld, adjust the welding torch position automatically according to the arc voltage of setting up



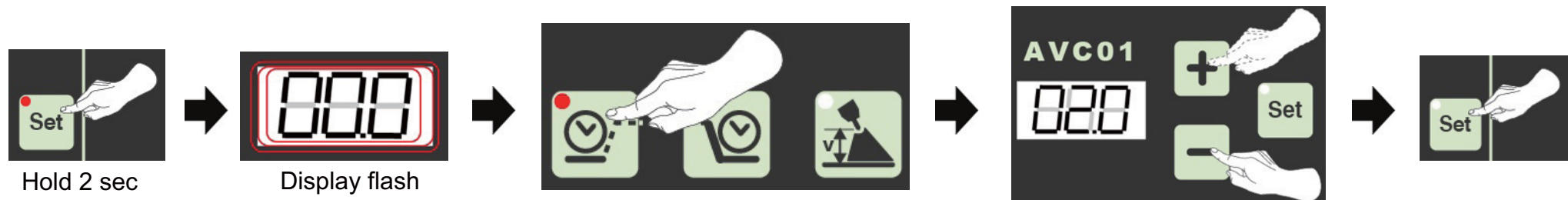
Weld the 2T way of starting



Weld the 4T way of starting



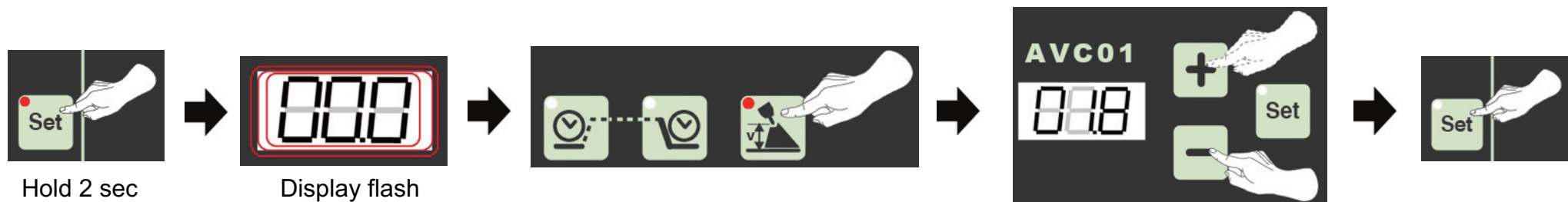
4.4 Postpone beginning the time that the arc voltage keeps automatically



4.5 Close the postponement time that the voltage keeps automatically

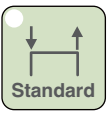


4.6 Set up the arc voltage



Weld the 2T way of starting

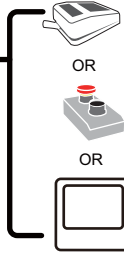
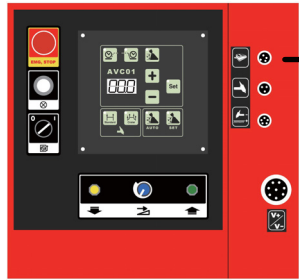
4.7



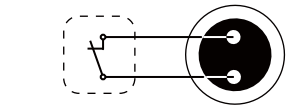
Standard



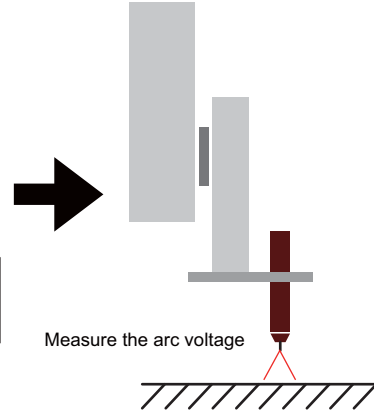
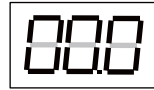
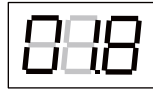
AUTO



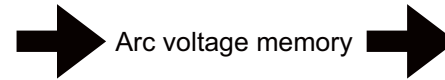
Auto start controller



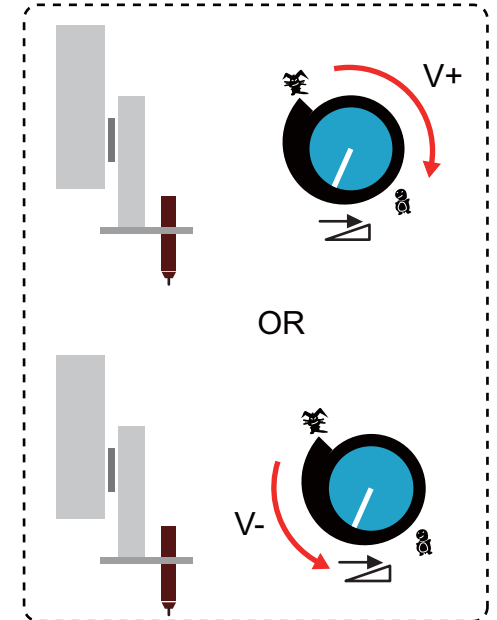
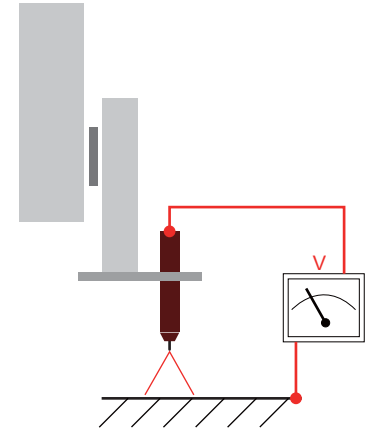
Start contact ON



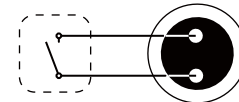
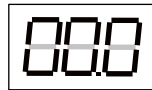
Measure the arc voltage



Arc voltage memory



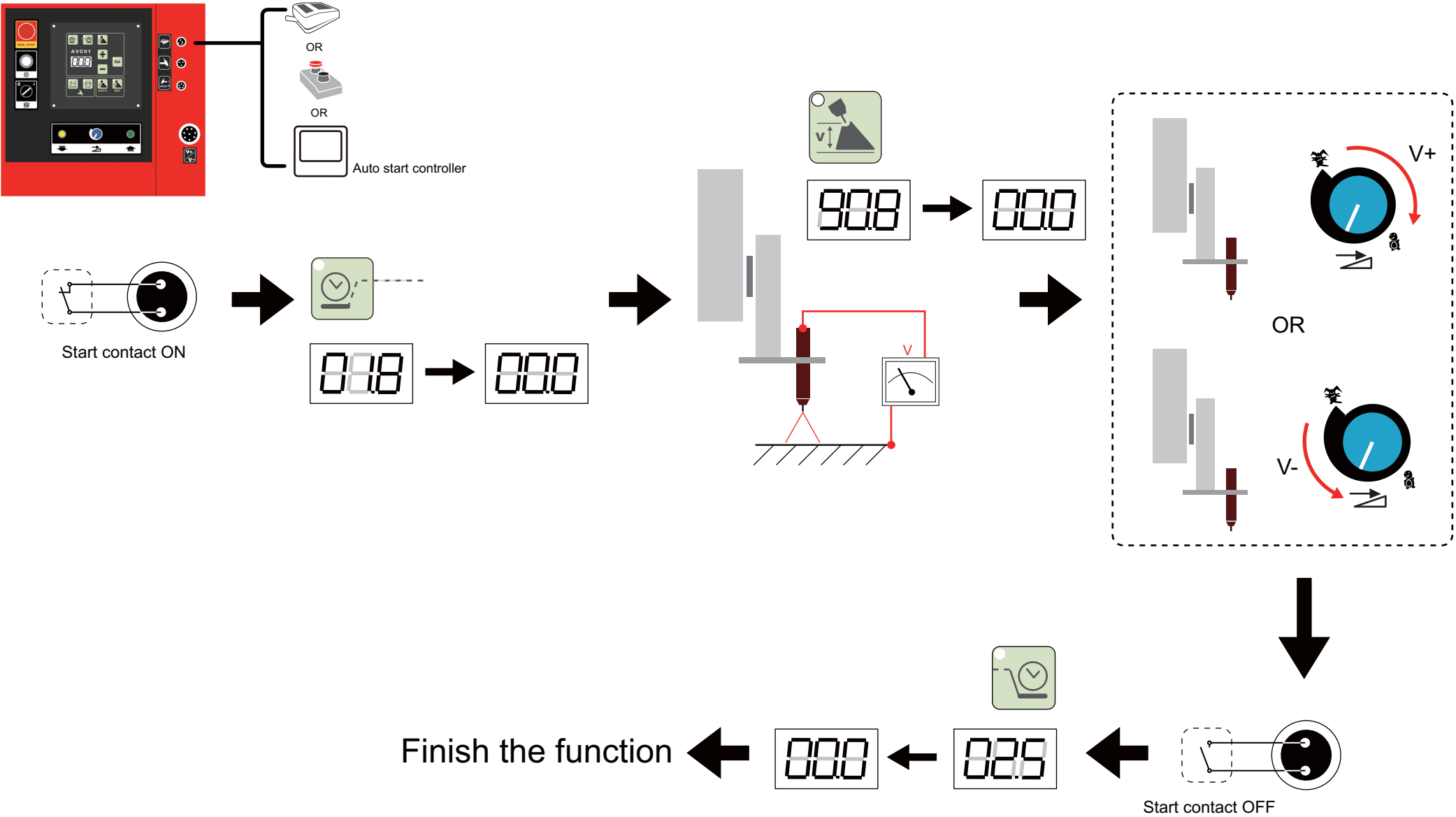
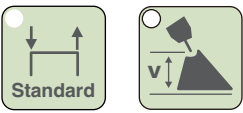
OR



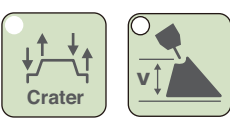
Start contact OFF

Finish the function

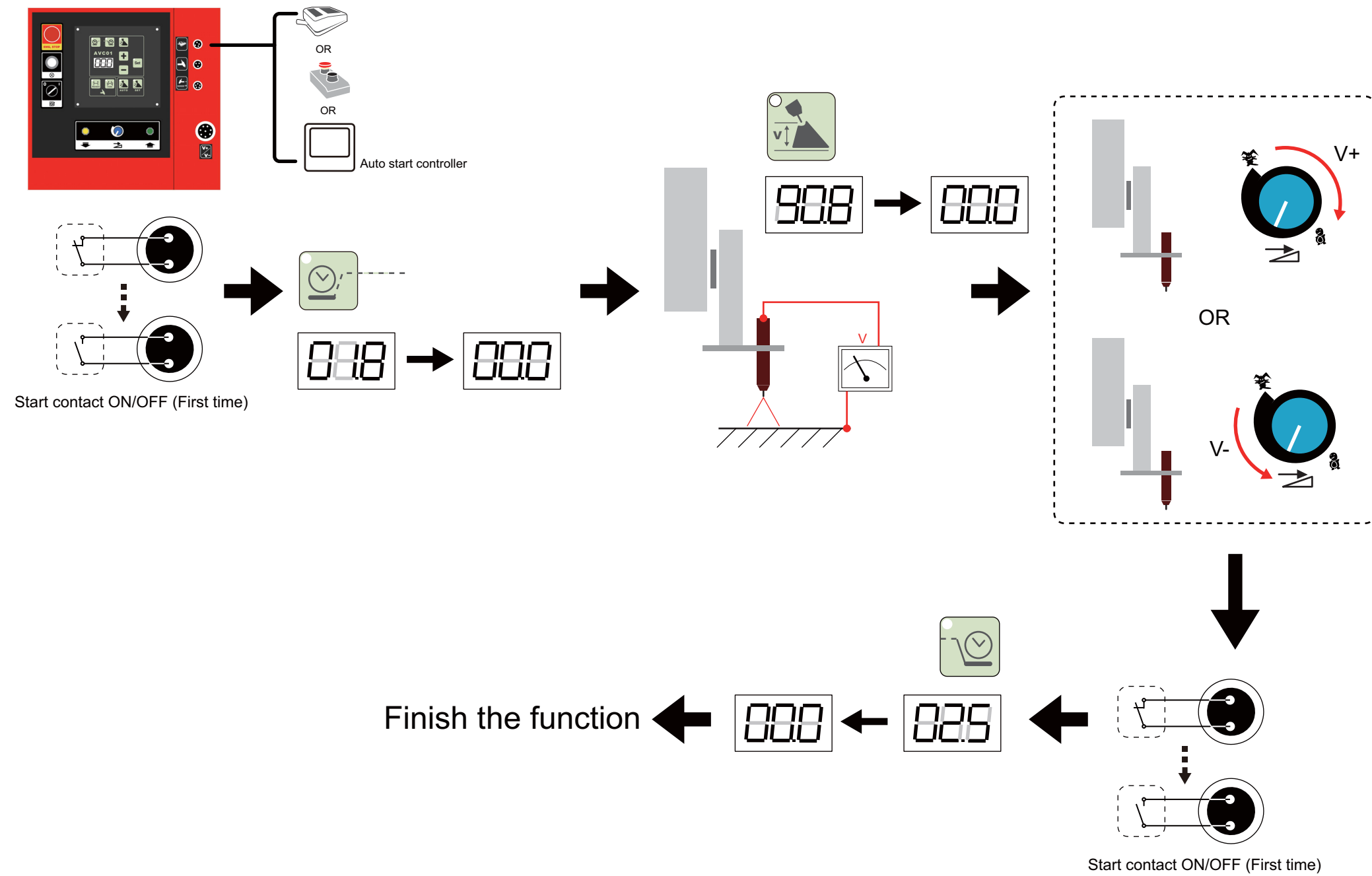
4.8 Weld the 2T way of starting



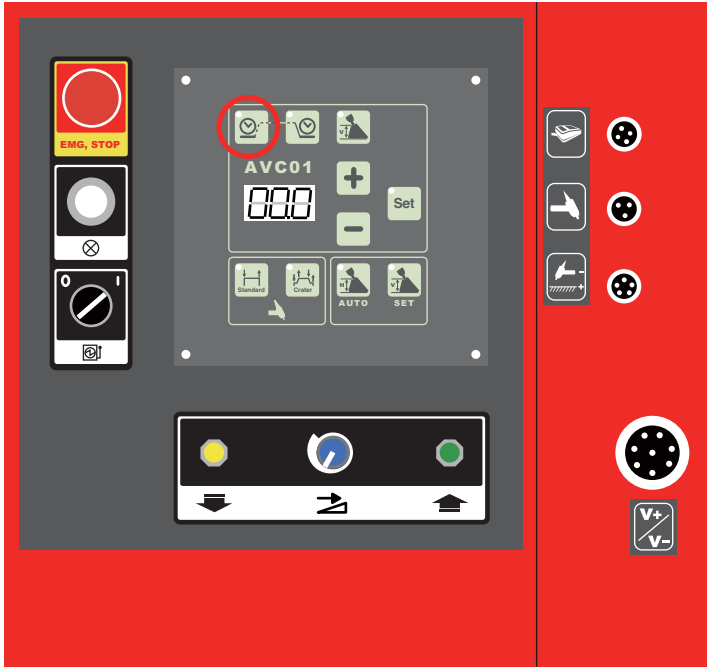
4.10



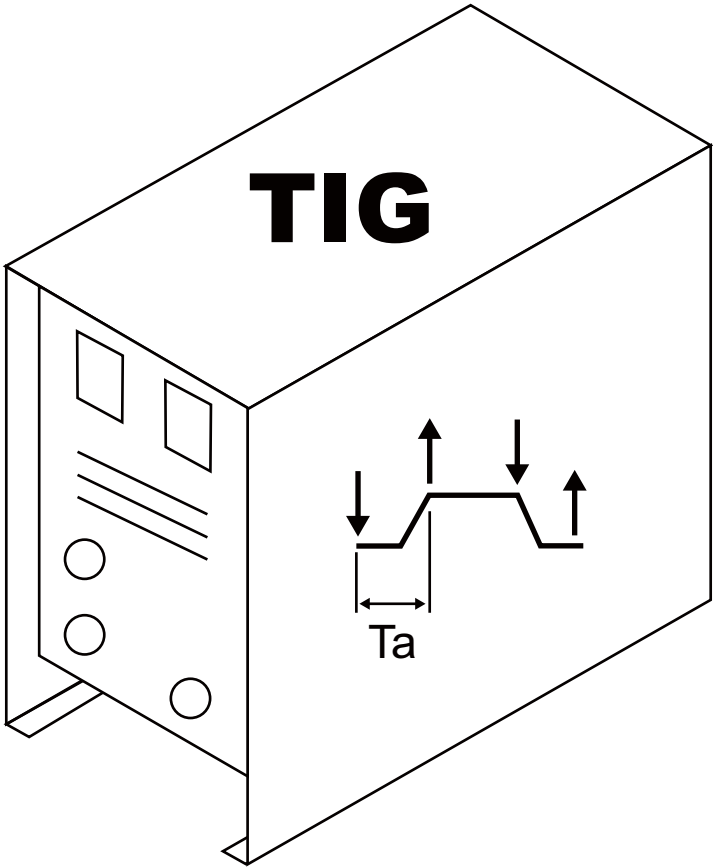
Weld the 4T way of starting

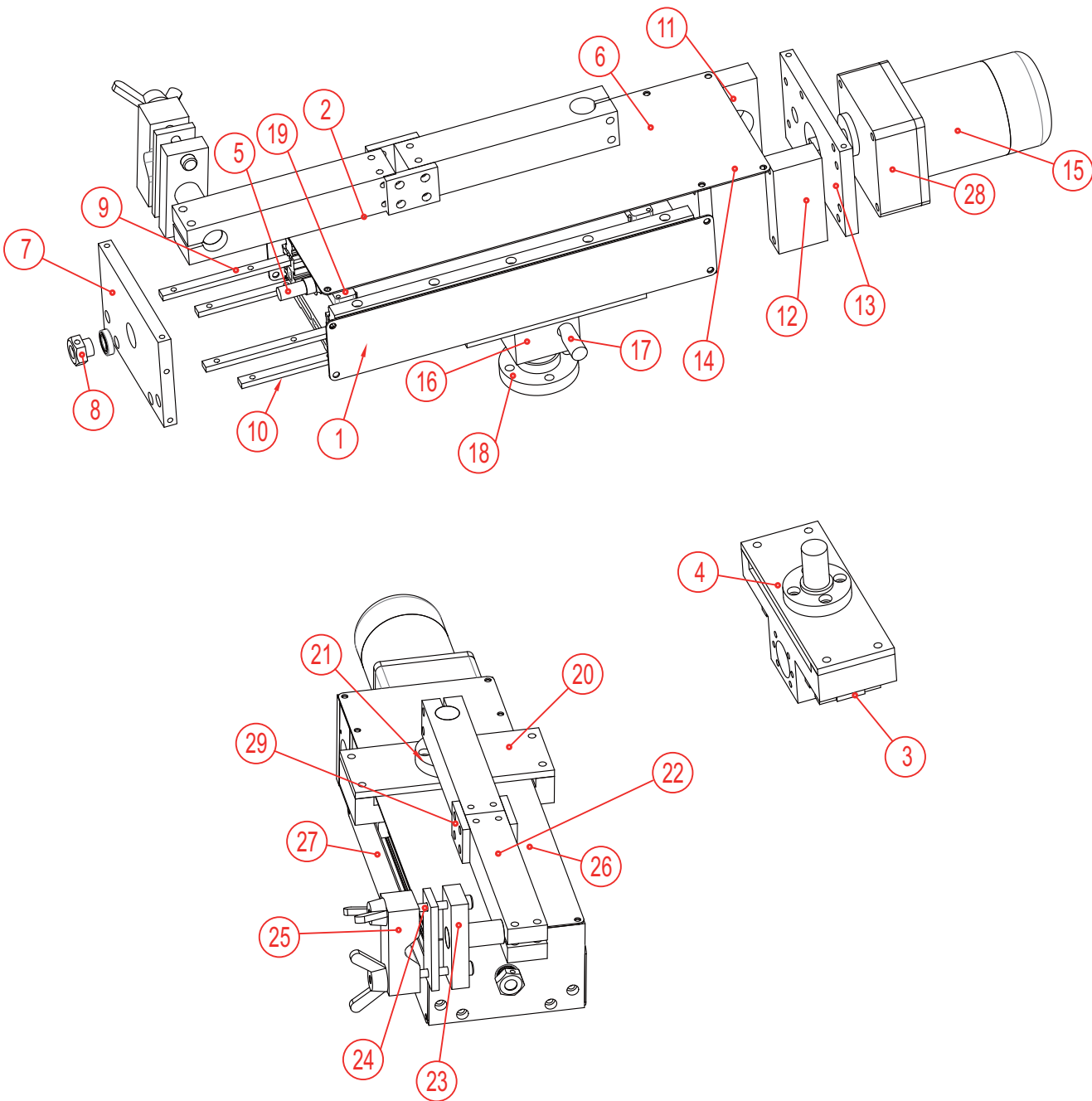


Appendix

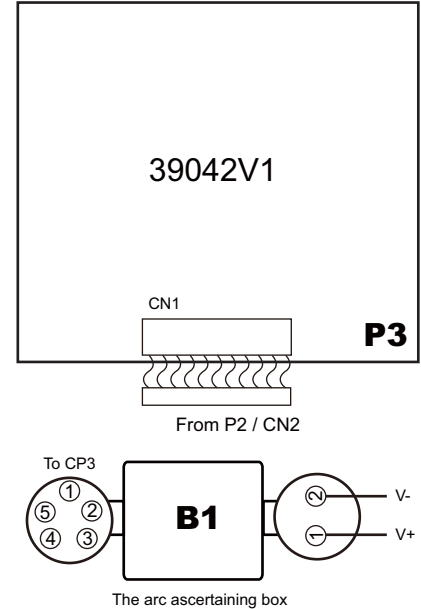
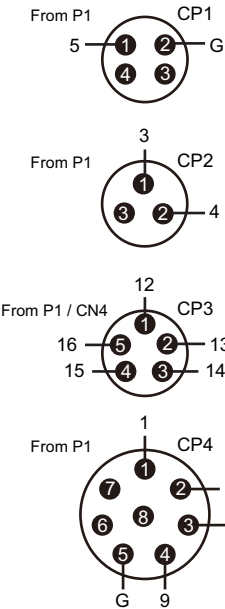
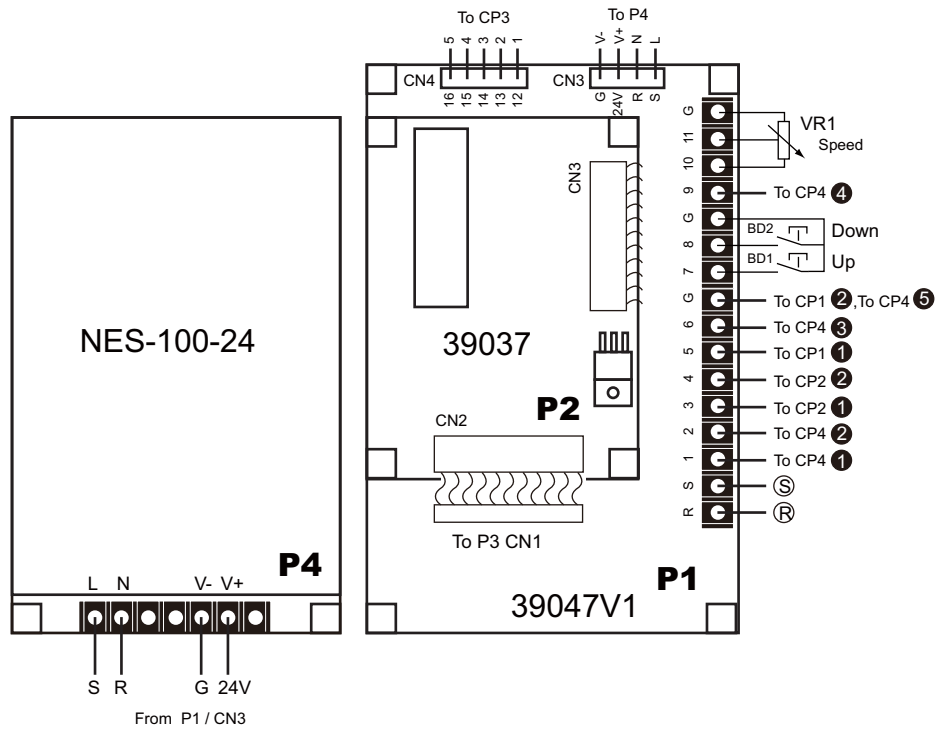
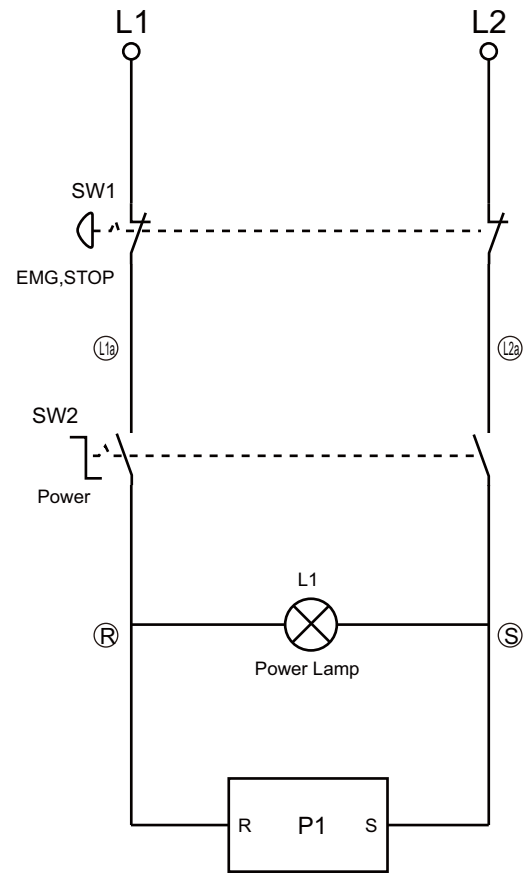


$\geq T_a$





Item	Part No.	Part No.	Q'TY
1	AVC101-04	移行座	1
2	BRS15B(280mm)	滑軌	2
3	BRS15BS	滑塊	2
4	AVC101-03	螺桿固定座	1
5	AVC101-05	滾珠螺桿	1
6	AVC101-02	後固定板	1
7	AVC101-01	前固定板	1
8	LW2A-09	固定螺帽	1
9	OL10K-229	滑軌定位板(5孔)	2
10	OL10K-227	滑軌定位板(3孔)	2
11	TEXY1-07	開孔支撐塊	1
12	TEXY1-06	支撐塊	1
13	TEXY1-05	馬達固定板	1
14	TEXY1-08	聯結套筒	1
15	DC30W/924V	直流馬達	1
16	LW2A-10	移型座固定板	1
17	LW2A-11	固定螺栓	1
18	LW2A-12	固定轉軸	1
19	TWV102-C	微動開關	2
20	LW2A-13	槍架固定板	1
21	TE106M-31	加長塊底座	1
22	AVC101-08	焊槍加長塊	2
23	TEO02	焊槍座	1
24	TEO04	墊塊	1
25	TEO03	固定塊	1
26	AVC101-06	遮板	1
27	AVC101-07	側遮板	2
28	4GN60B	減速機	1
29	AVC101-09	固定板	2



Item	Part NO.	Part Name	Q`TY
P1	39047V1	Controller	1
P2	39037 / BIOS	BIOS	1
P3	39042V1 / LED Displayer	LED Displayer	1
P4	NES-100-24 / Output 24V	Output 24V	1
SW1	TN2BK-2B	EMG,STOP	1
SW2	TN-2SS2-2A	Power switch	1
L1	TN2PN-220V	Power lamp	1
BD1	PUSH-12Ø	Up	1
BD2	PUSH-12Ø	Down	1
VR1	RV24YN205	Speed	1
B1	39040	The arc ascertaining box	1
CP1	16Ø4P	Pedal switch	1
CP2	16Ø3P	Weld	1
CP3	16Ø5P	Connected to the B1	1
CP4	25Ø6P	Connected to the machine(AVC)	1

AVC-101
AC 220V