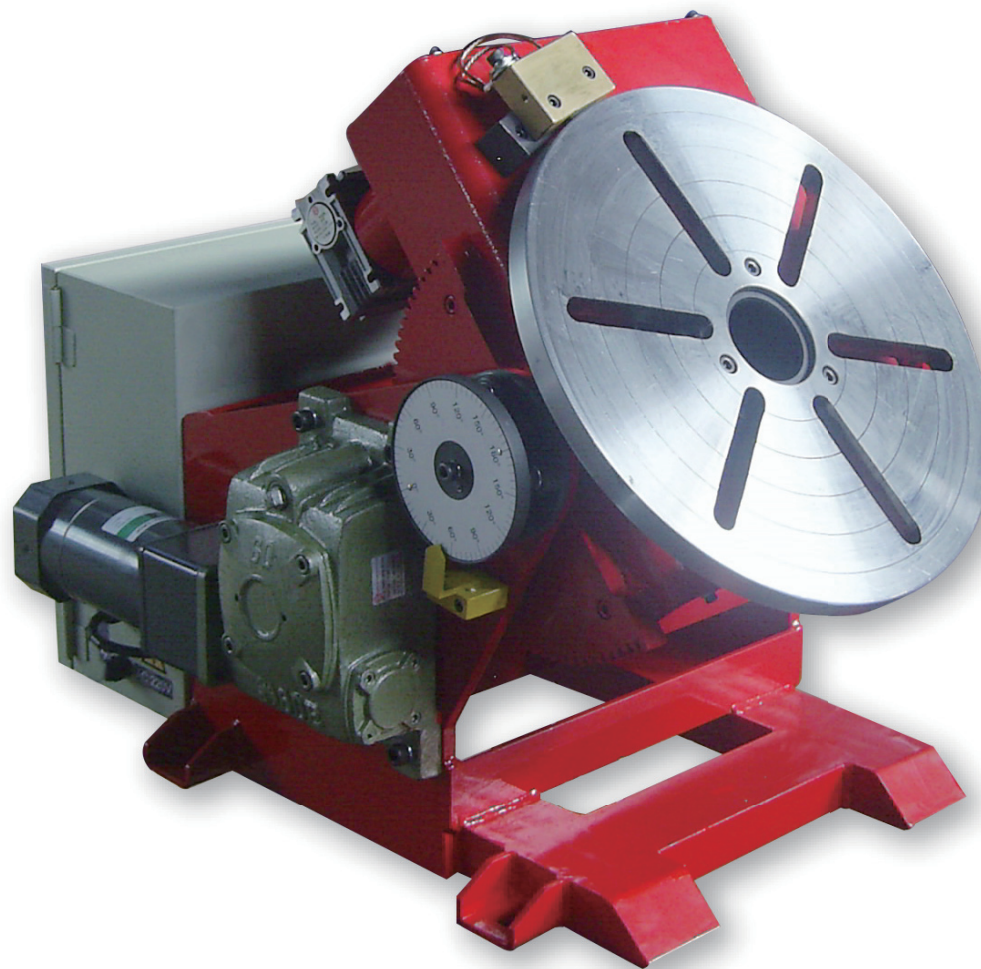




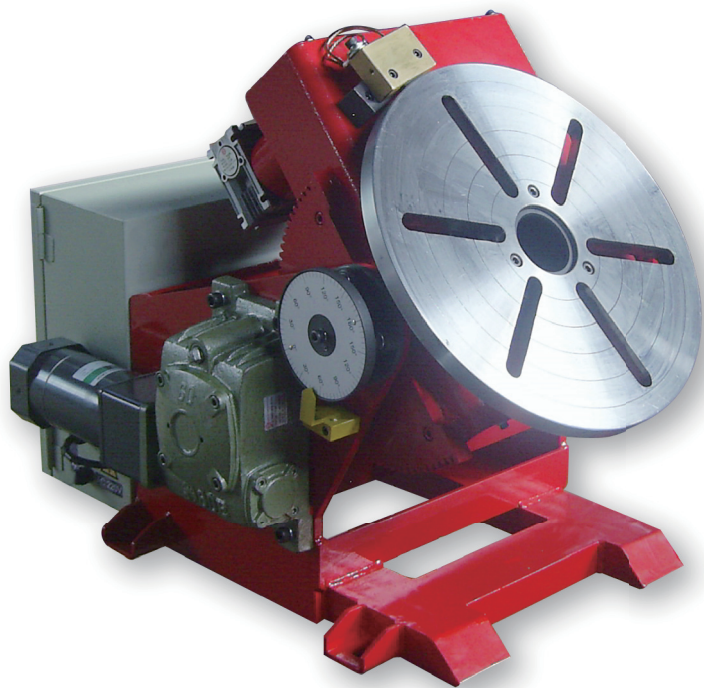
操作手冊

EVPOS-300ACA 銲接定位器

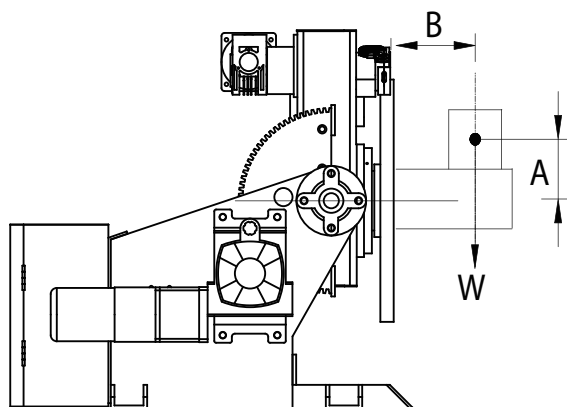


Chapter 1: 諸元

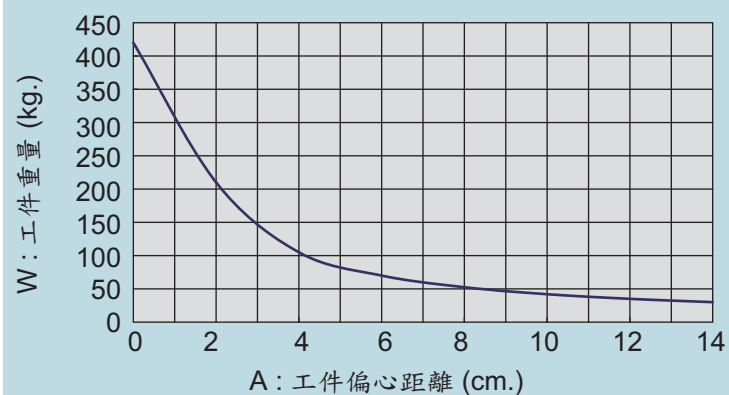
1.1 諸元



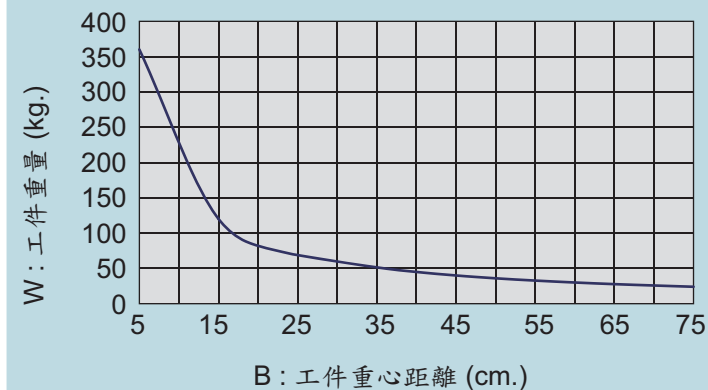
型號	EVPOS-300ACA
入力電源	AC 200 ~ 240V / 8A / 50;60Hz / 1Ø
轉盤馬達	DC 90V / 65W
偏心承載荷重(W)	300Kg.
旋轉荷重偏心距(A)	12mm.
盤面傾斜重心高(B)	55mm.
盤面直徑	400mm.
軸心孔徑	60mm.
盤面轉數	0.34 - 3.4 RPM
盤面傾斜角度	0° - 90°
盤面傾斜速度	12.5 sec / 90°
盤面傾斜馬達	AC90W
盤面傾斜安全鎖	強制煞車
接地效率	300A / 100%
盤面啟動	腳踏開關(3M長)
操作模式	寸動 / 自保持
遙控操作	有線遙控(3M長)
銲接啟動模式	標準 (二周期)
操作模式	寸動 / 自保持 / 原點覆歸 / 原點定時
原點覆歸功能	0-99.9秒-數字顯示(單位0.1秒)
原點定時功能	0-999秒-數字顯示(單位1秒)
原點搭接計時	0-99.9秒-數字顯示(單位0.1秒)
起弧/收弧時間	0-99.9秒-數字顯示(單位0.1秒)



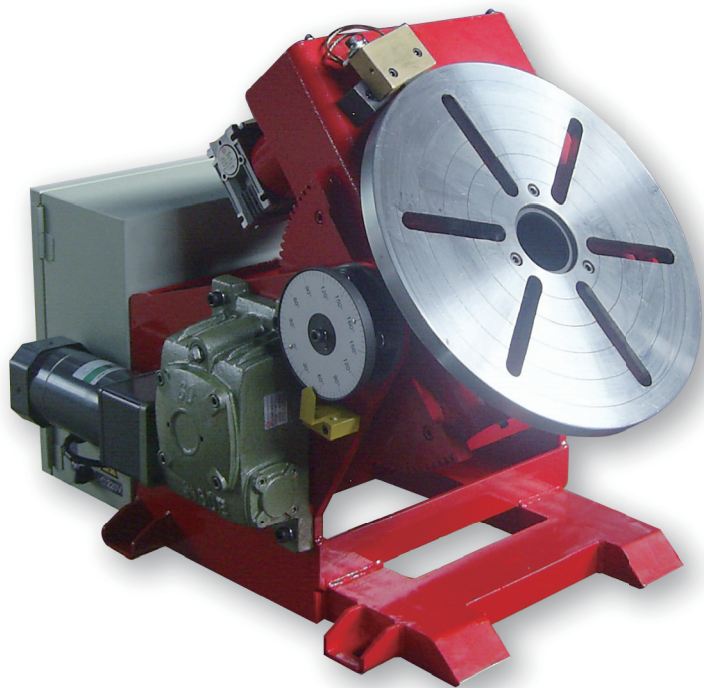
EVPOS-300ACA 旋轉荷重偏心距離表



EVPOS-300ACA 盤面傾斜重心高度表



1.1 諸元

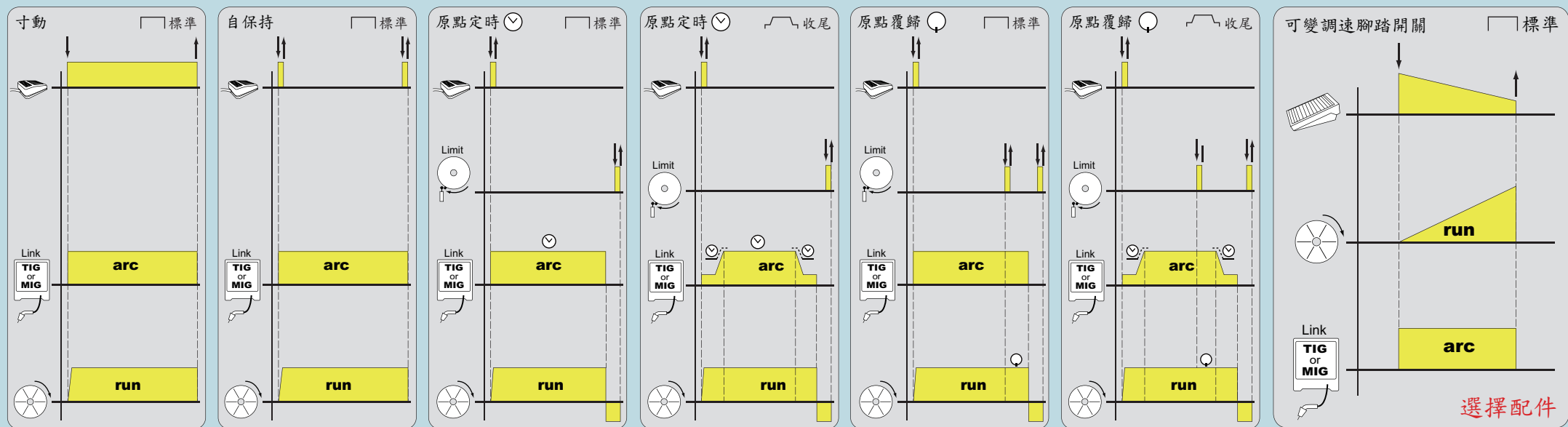


選擇性配件



VSPS-101Z 可變調速腳踏開關(線長3公尺)

●規格修正時以新版規格為主,本公司有修改權利。 ●客戶若需修改部分規格時,請詳細說明修改需求。



Chapter 2: 安全説明

2.1 安全說明

2.1.1 本文檔提供了安全規則。有些信息需要進行安全或程序上的原因，特別注意。用適當的標題警示標籤和小心將用於在本手冊。例如：

WARNING

2.1.1.1 如果不遵守警告指示，可能會導致嚴重傷害。

CAUTION

2.1.1.2 不遵守注意事項，將可能導致操作人員受傷，或者機器損壞的部件和/或控制。

DANGER

2.1.1.3 不按照危險的指令，可能會導致嚴重傷害。

ATTENTION

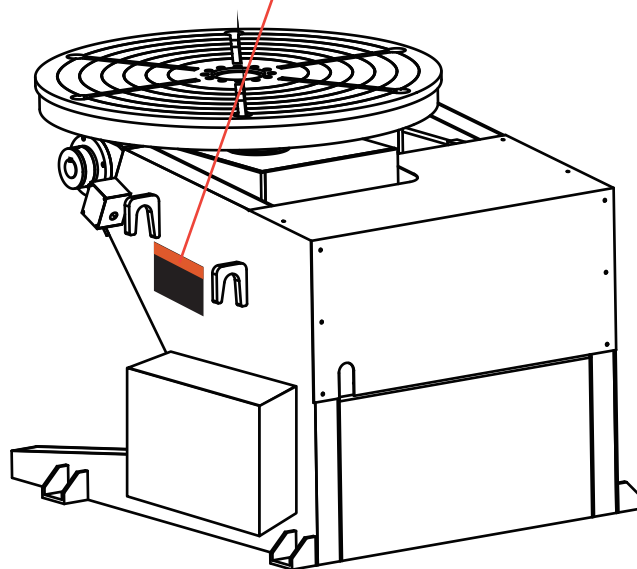
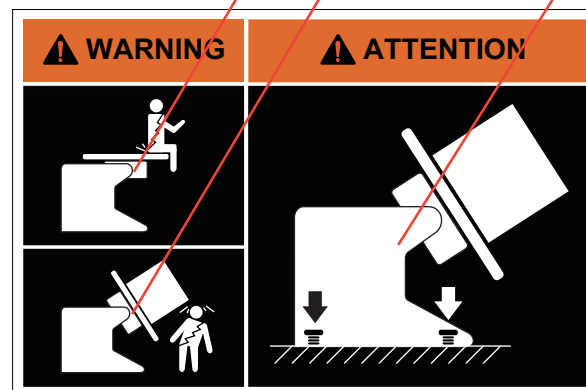
2.1.1.4 不遵守注意事項，將可能導致操作人員受傷，或者機器損壞的部件和/或控制。

2.2 安全標籤

禁止坐在盤面上方

當機械表角度被移動或靜止的，禁止站在機器前方。

機械固定在地面。



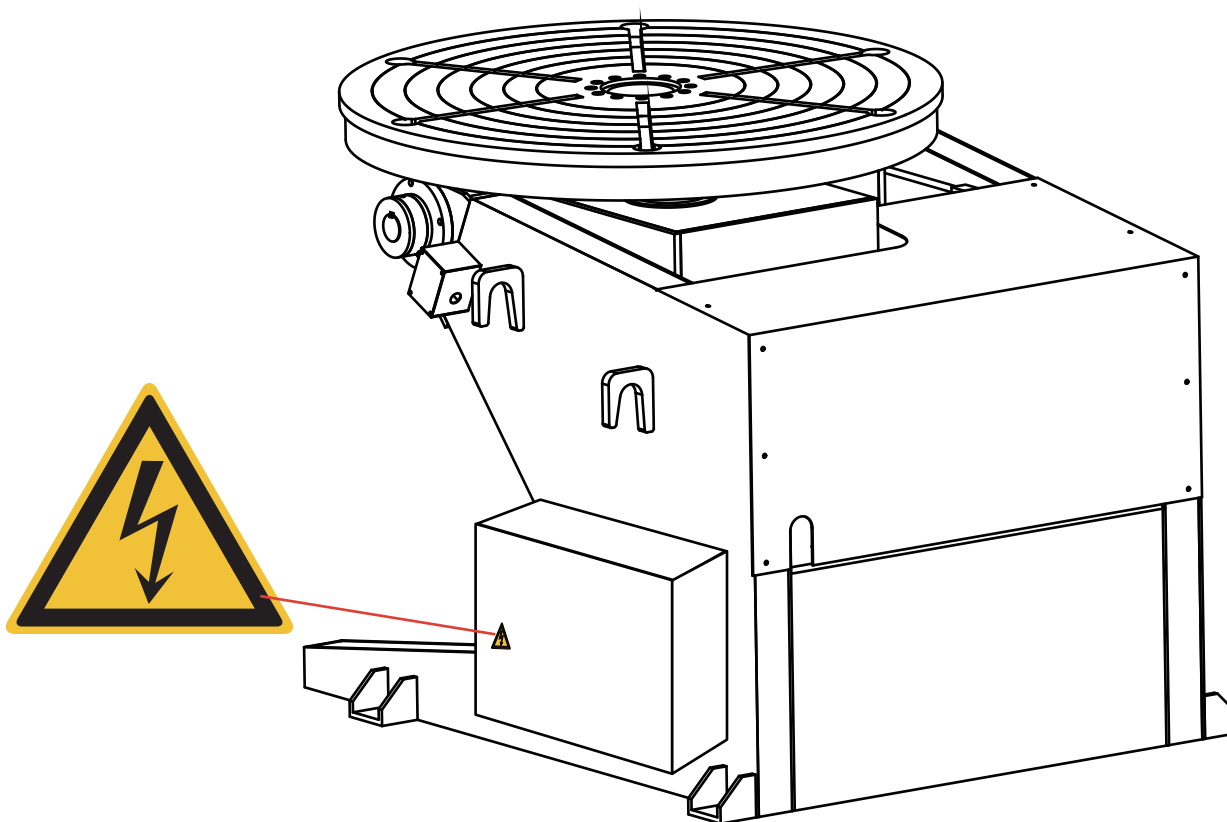
2.3 電氣危險和高溫



電氣危險



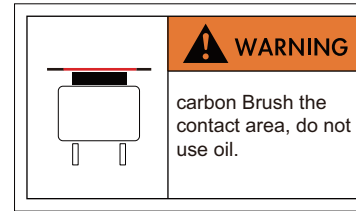
高溫請勿觸摸



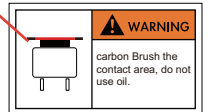
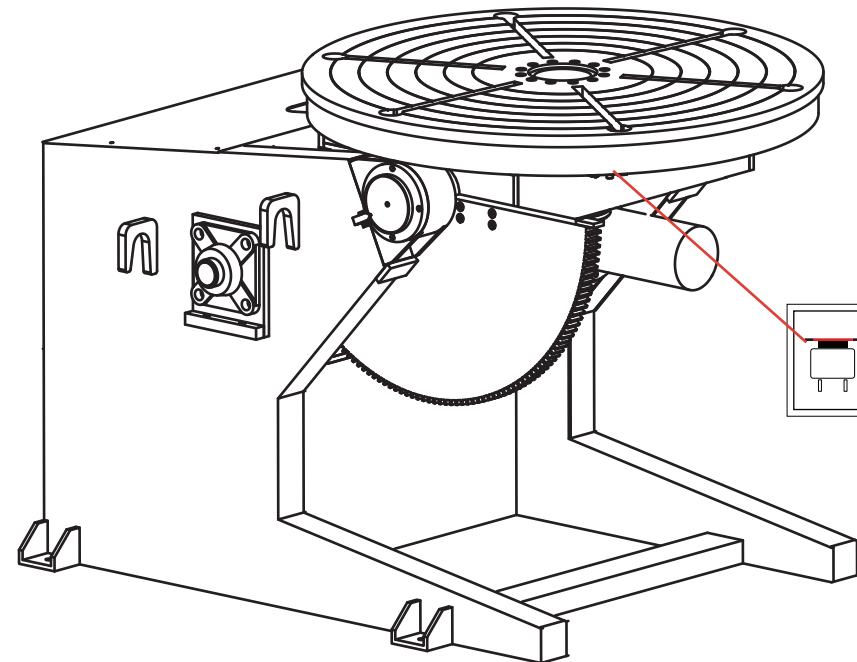
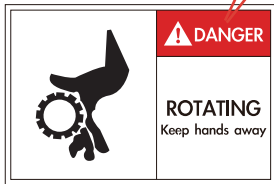
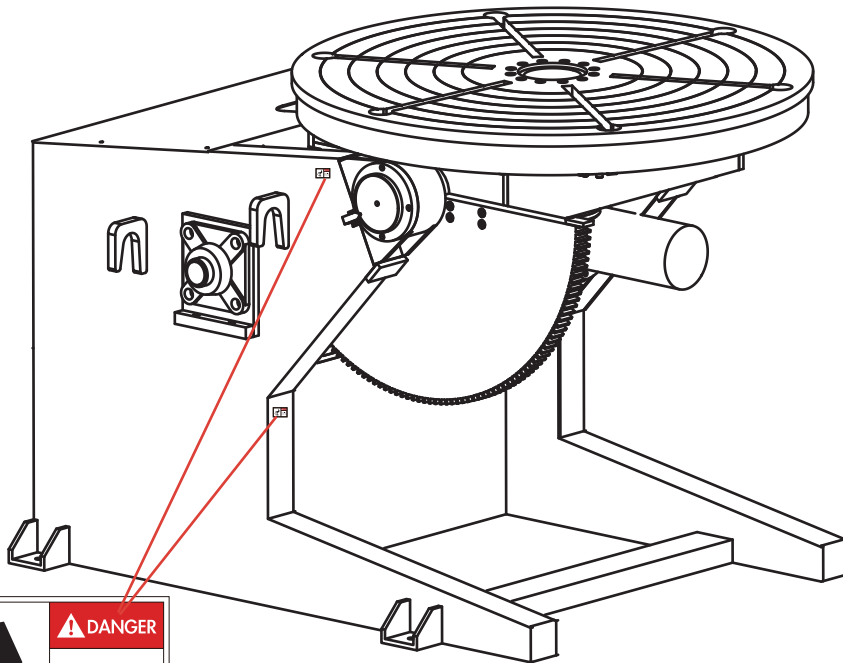
2.4 旋轉及其它



旋轉運作時讓手遠離

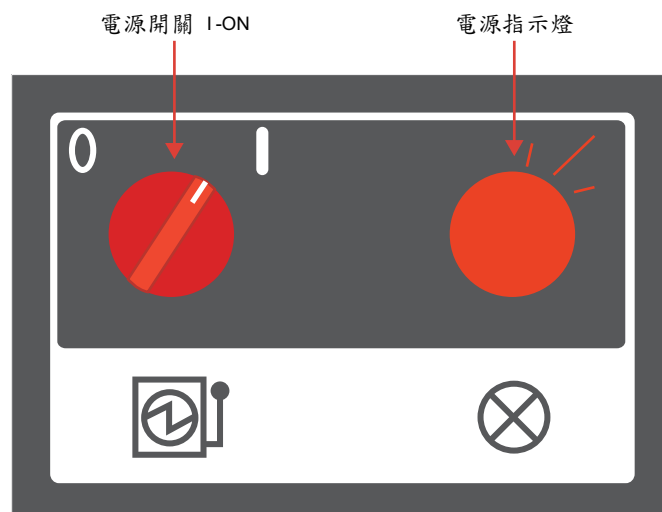
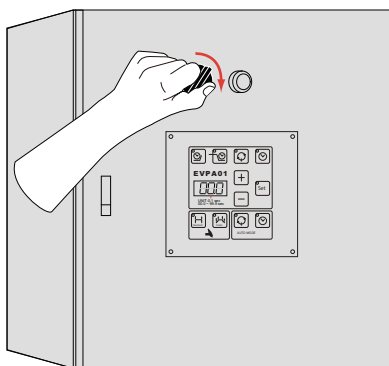


—碳刷接觸面積，不使用油。

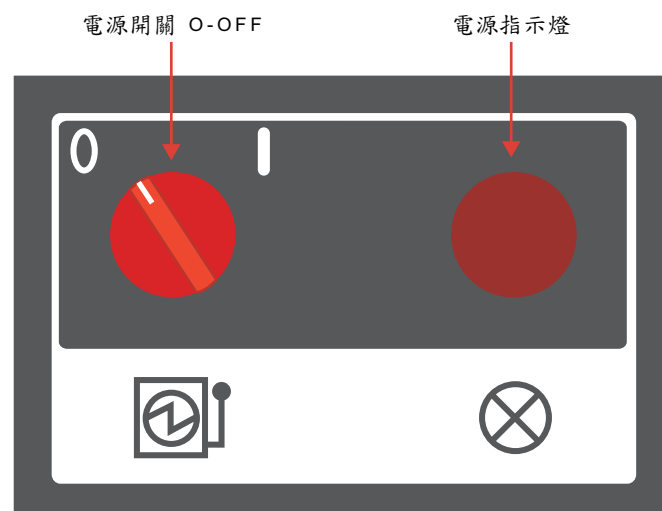
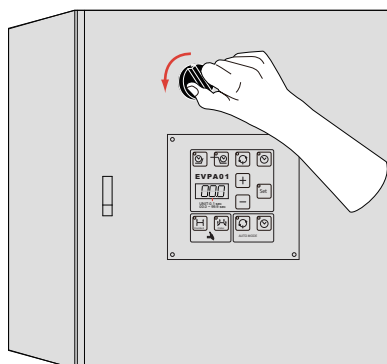


2.5 電源

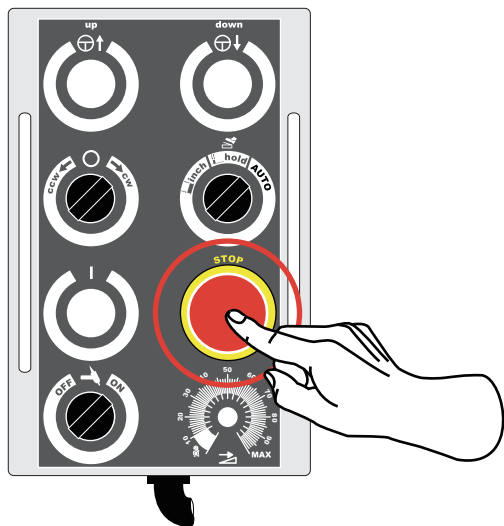
2.5.1 電源 ON



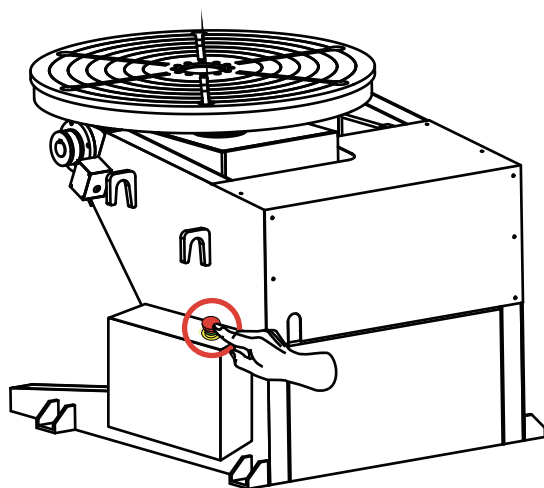
2.5.2 電源 OFF



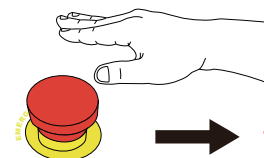
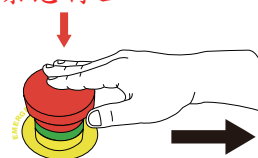
2.6 停止



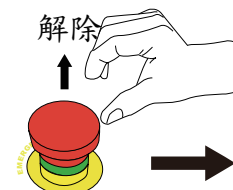
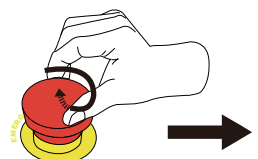
2.6.1 緊急停止



緊急停止



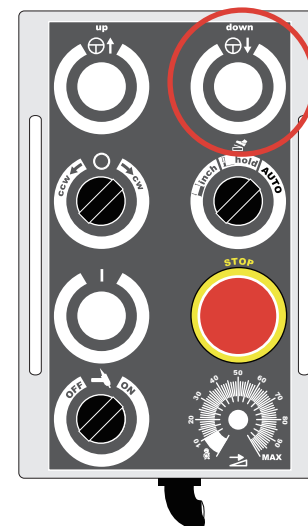
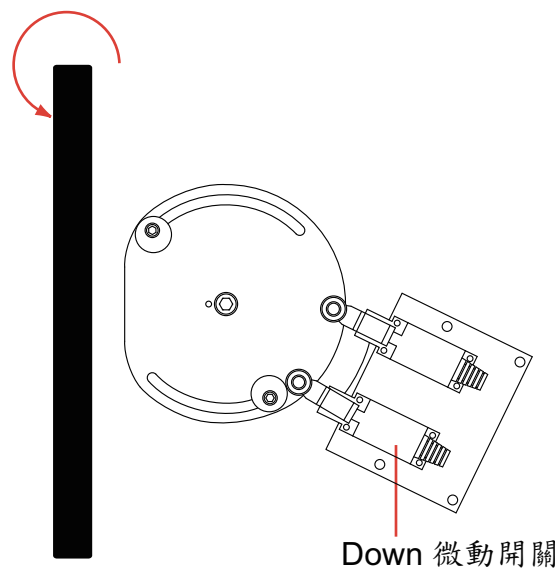
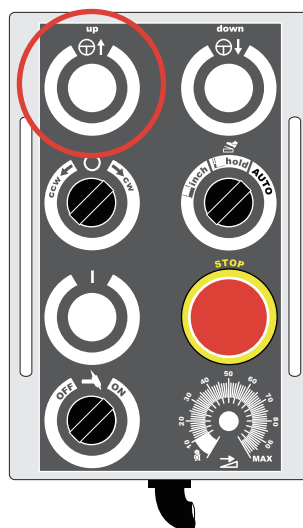
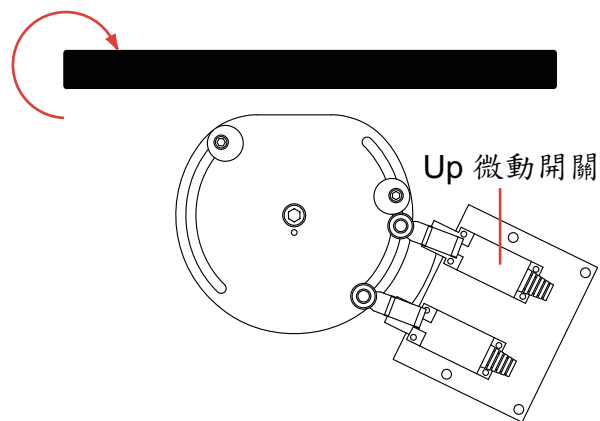
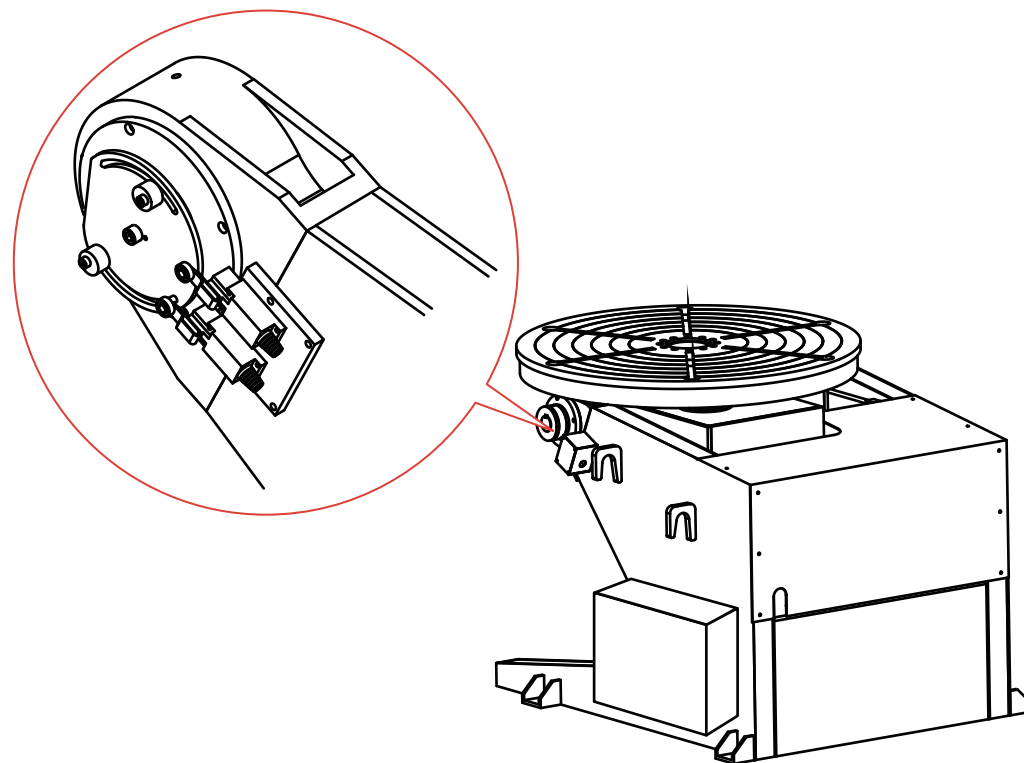
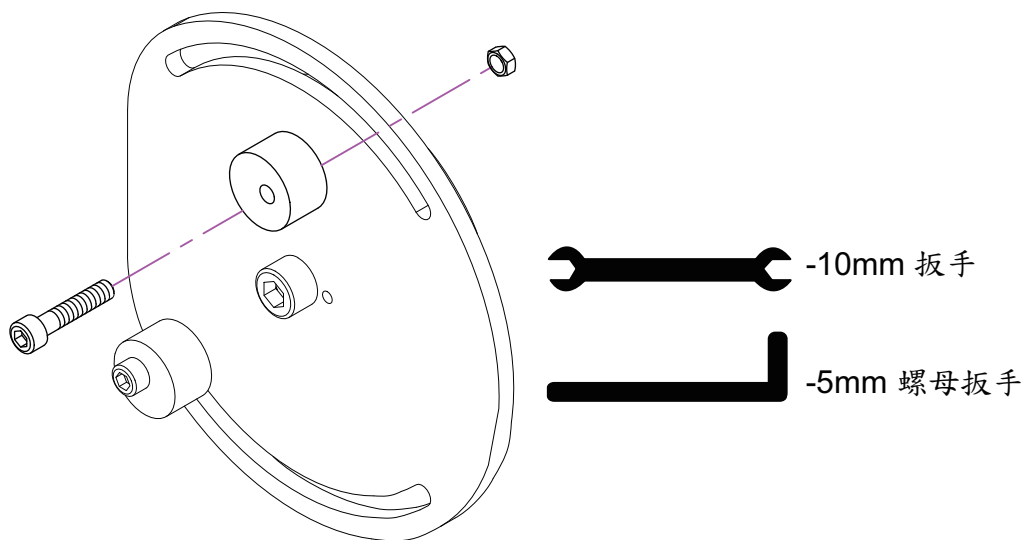
電源跟所有動作強制關閉



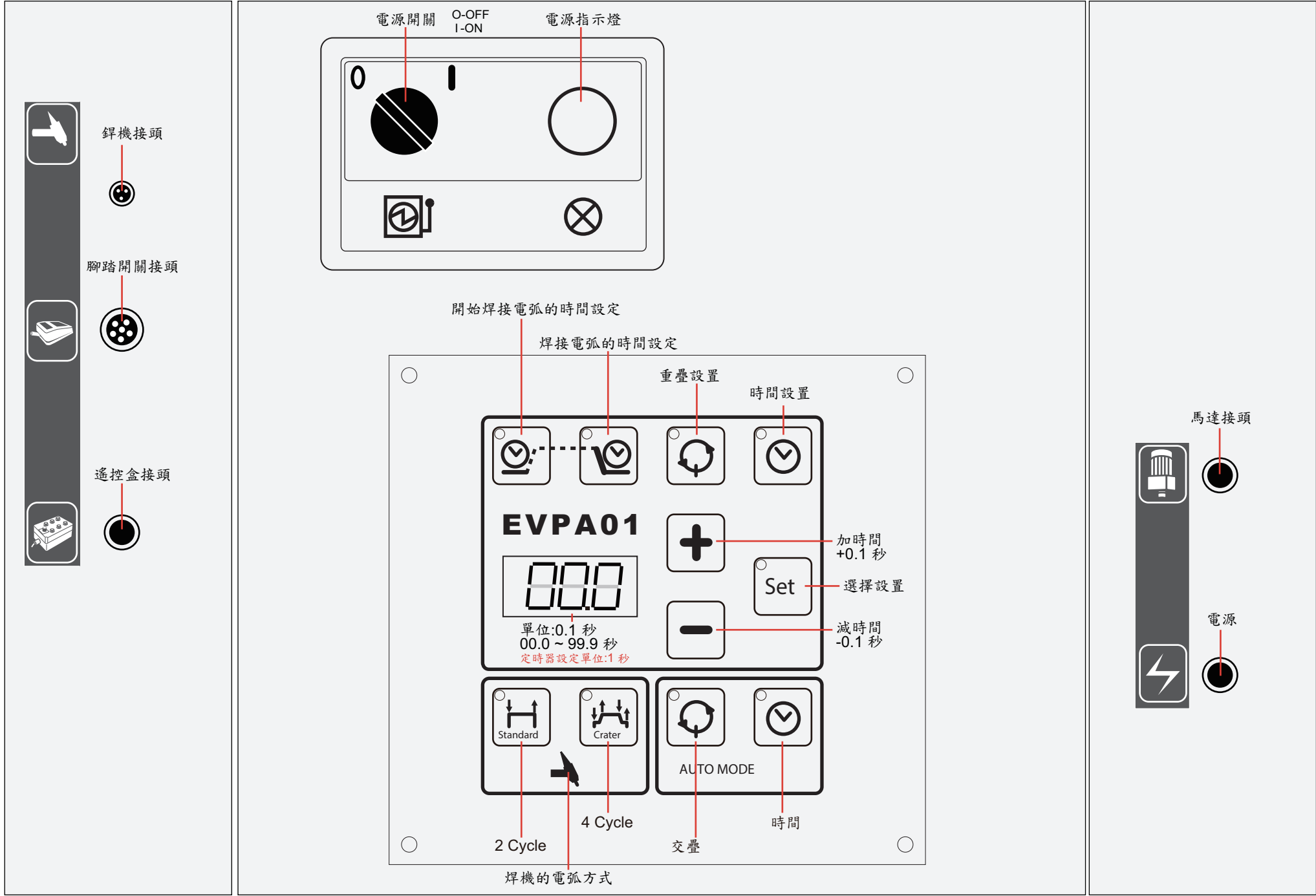
解除

電源以及動作重新啟動

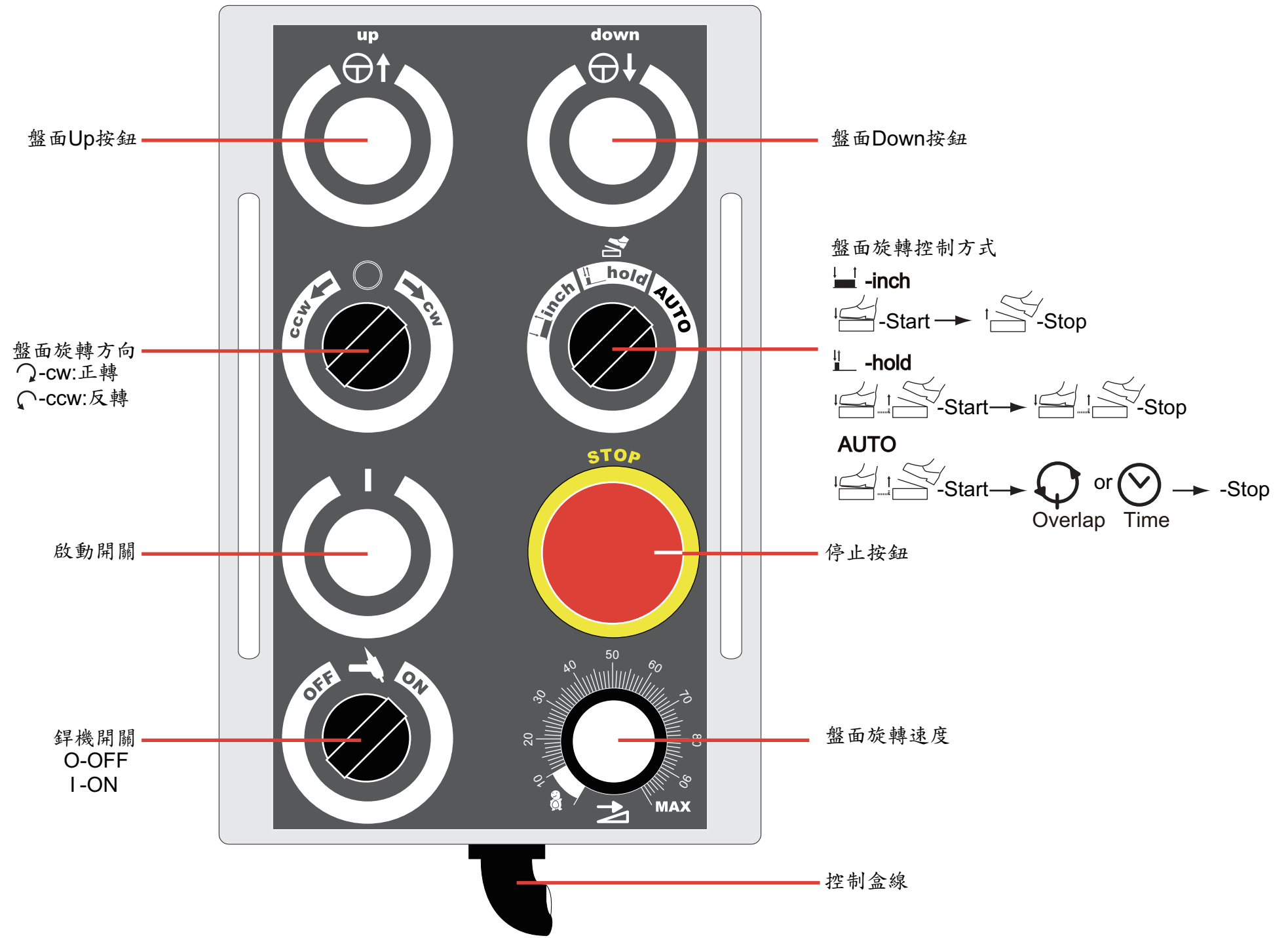
2.7 角度傳感器



2.8 控制箱



2.9 控制盒

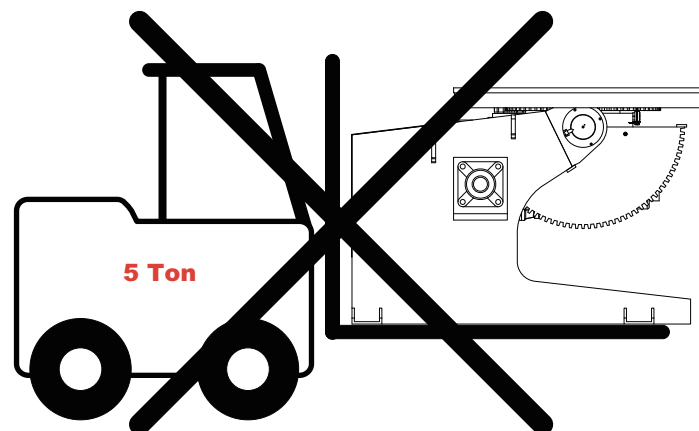
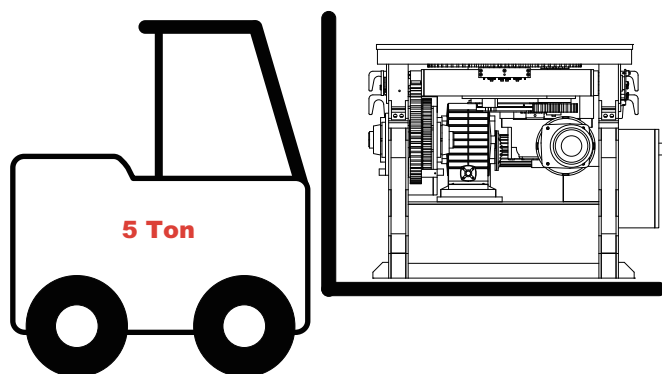
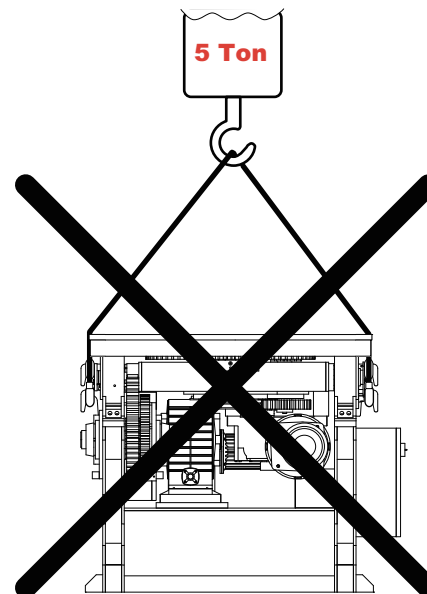
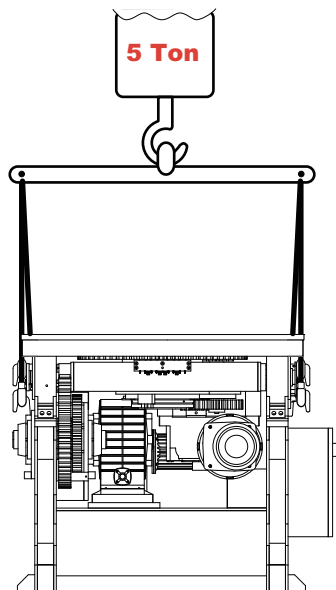


Chapter 3: 安裝說明

3.1 一般

3.1.1 為了保證工件的動作，所以需要真正的安裝POS機的ACA系列定位器的安全性，確認安裝結束後即可操作，請審議這一章的解釋，這樣做。

3.2 運輸



3.2 電源連接

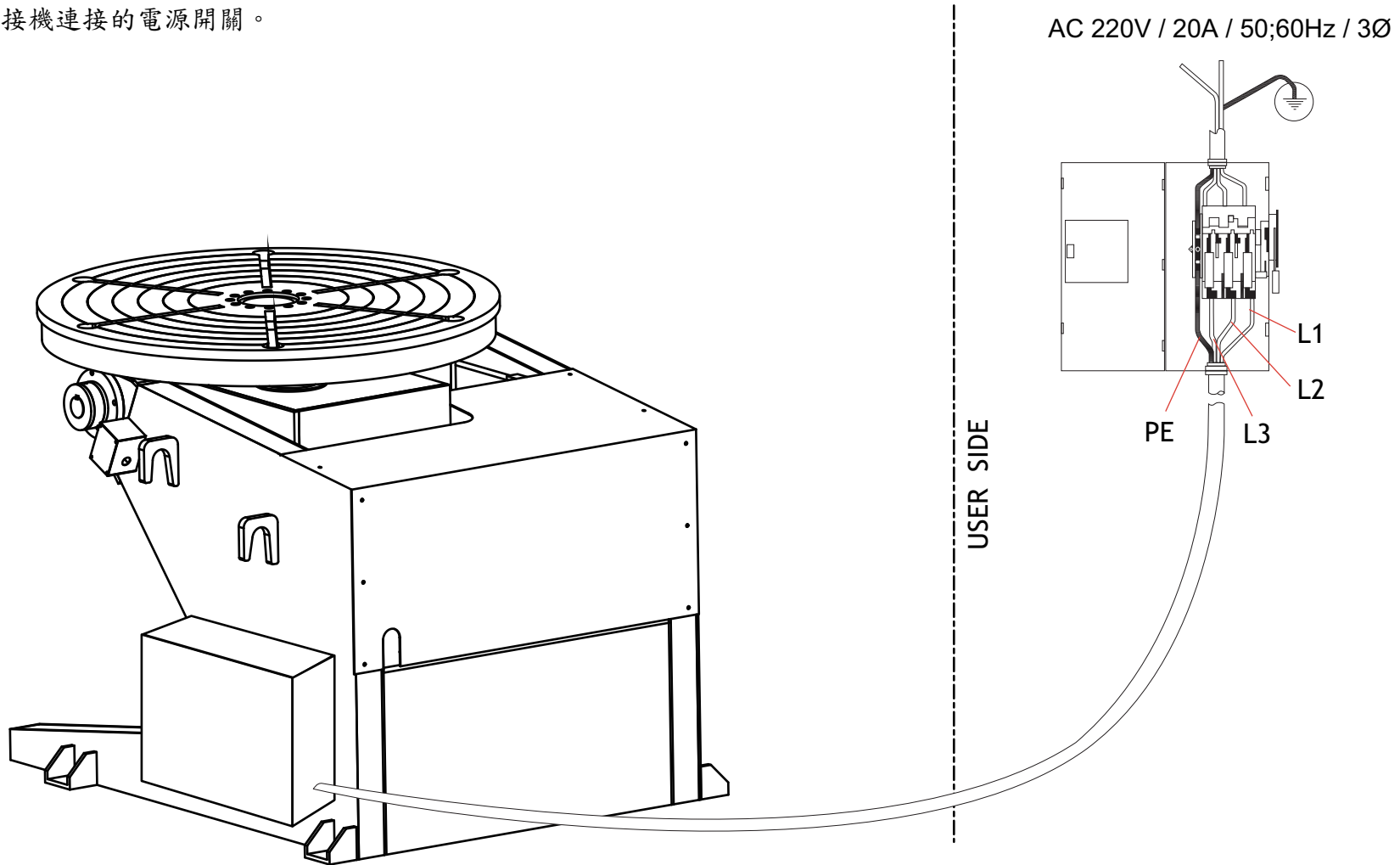
3.2.1 電源為AC 220V/20A/50;60Hz/3Ø與具有接地線路上。

3.2.2 使用電源斷路開關（電流5A）。

3.2.3 使用合適的工具，真正鎖定電源線和電源斷路開關。

3.2.4 不能有電源電纜表面損傷或電線斷裂後加入。

3.2.5 不建議用焊接機連接的電源開關。

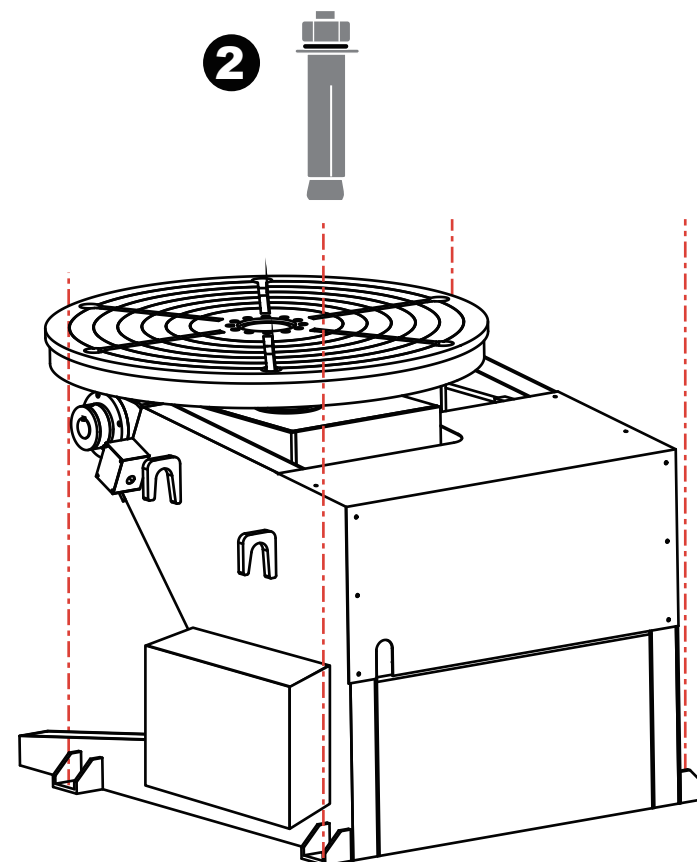
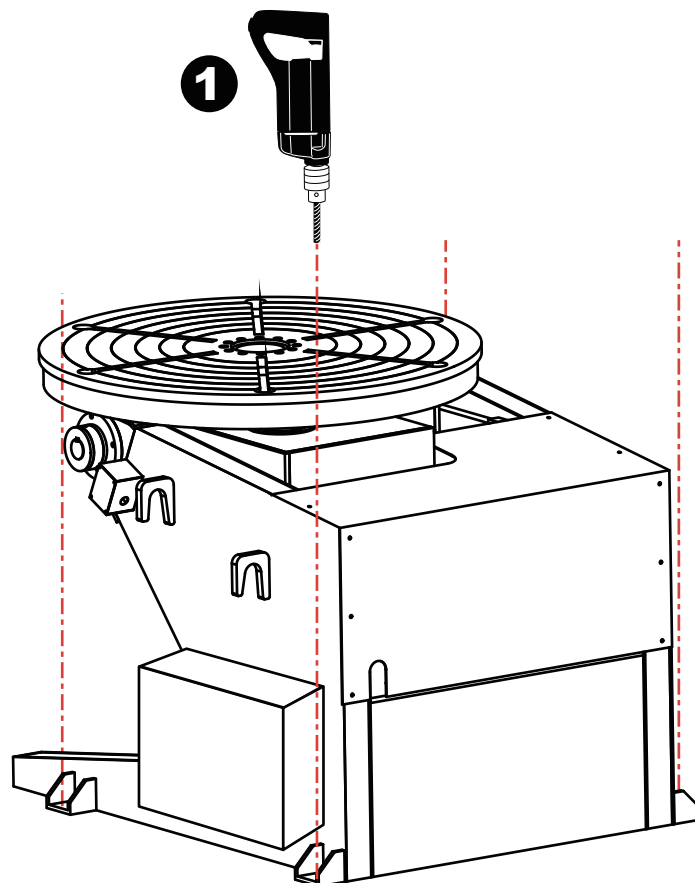


3.3 機械固定安裝

3.3.1 如果機器是固定的，安裝在地面，利用地面的螺栓鎖定機械在地面上。

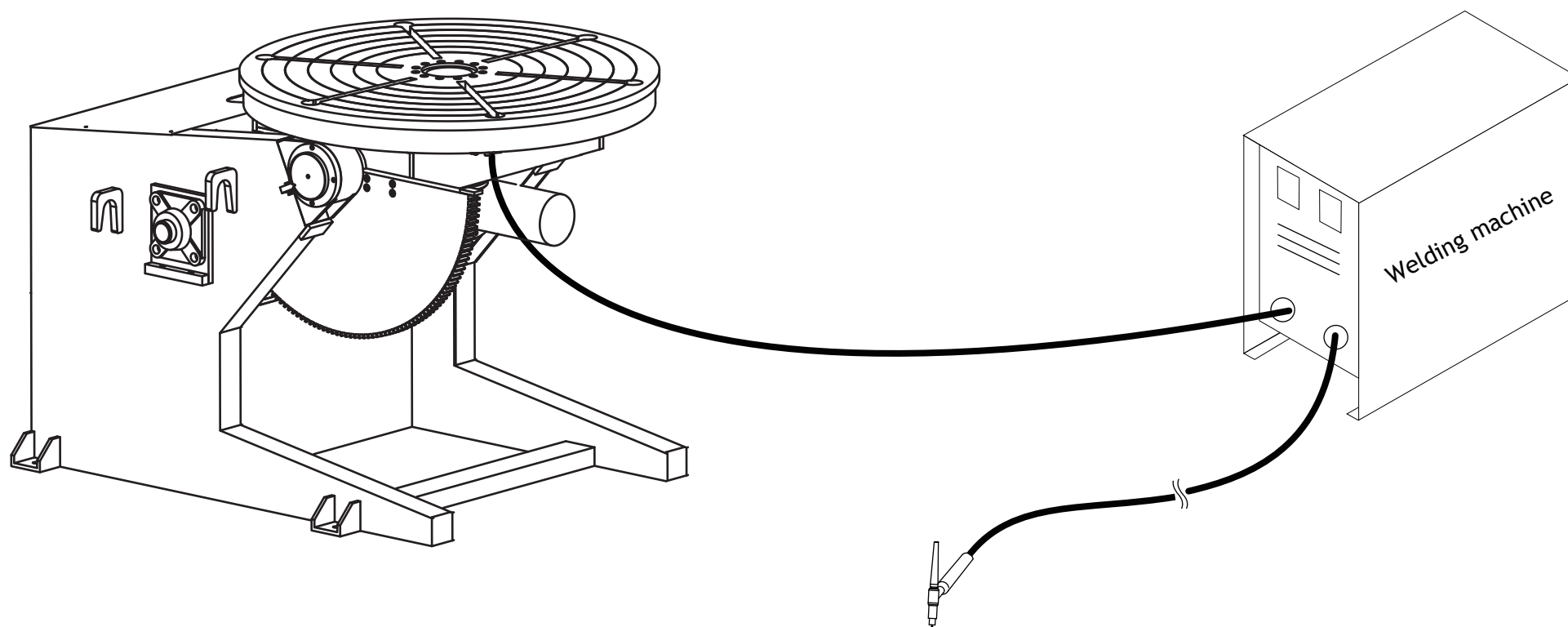
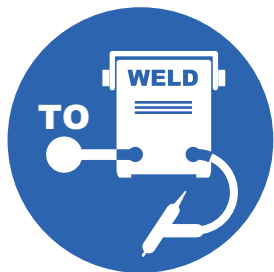


		
300MCA	M12x40mm	M14
500MCA	M12x40mm	M14
750MCA	M12x40mm	M14



3.4 銑機接地

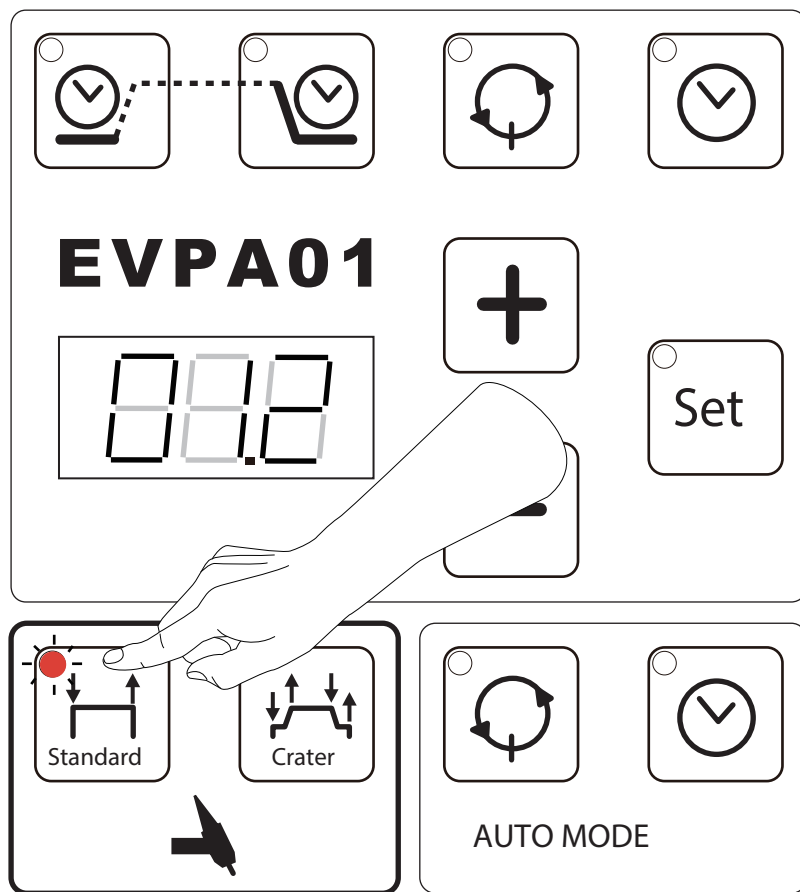
3.4.1 請鎖定電纜，電焊機接觸，破刷牢固。



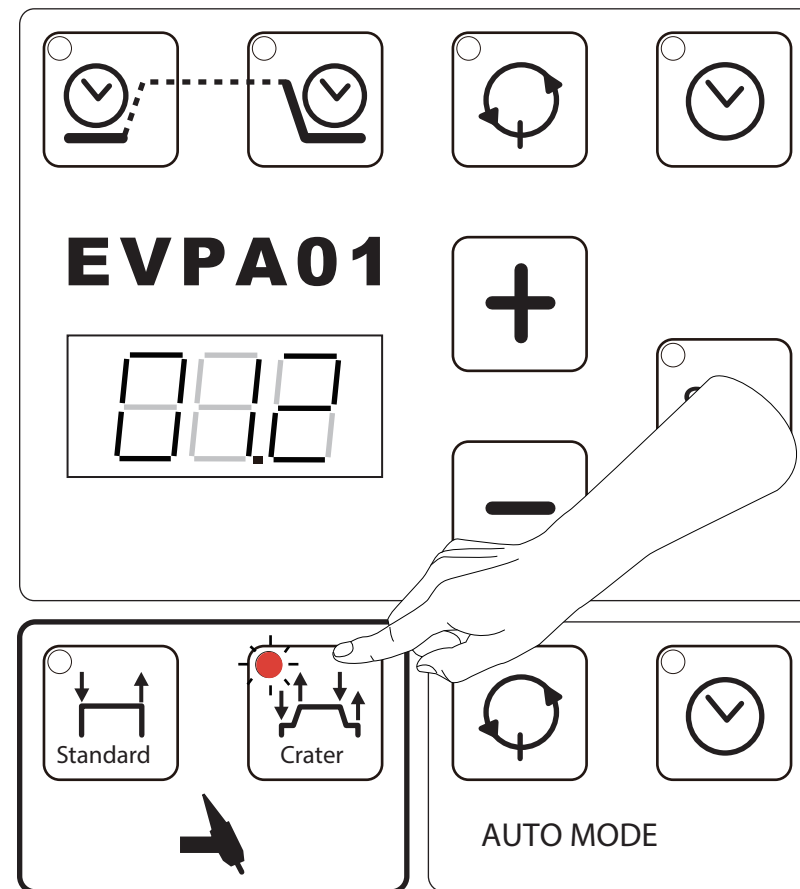
Chapter 4: 手動操作

4.1 電弧方式的鐸機

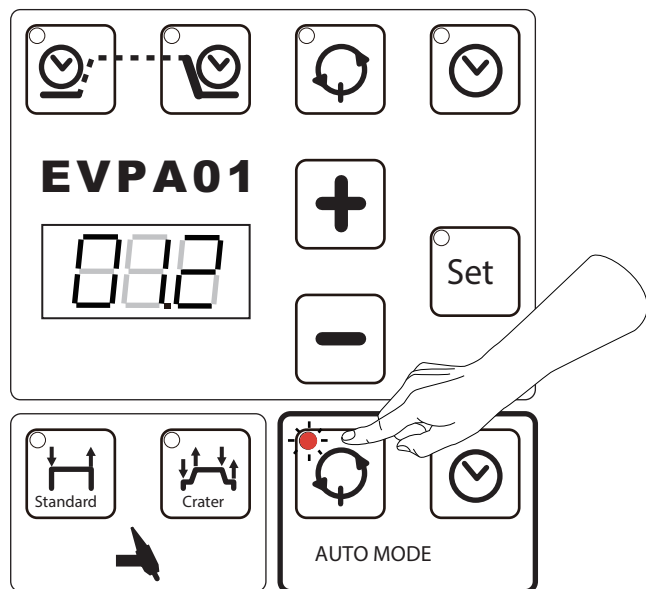
2T(2 CYCLE)



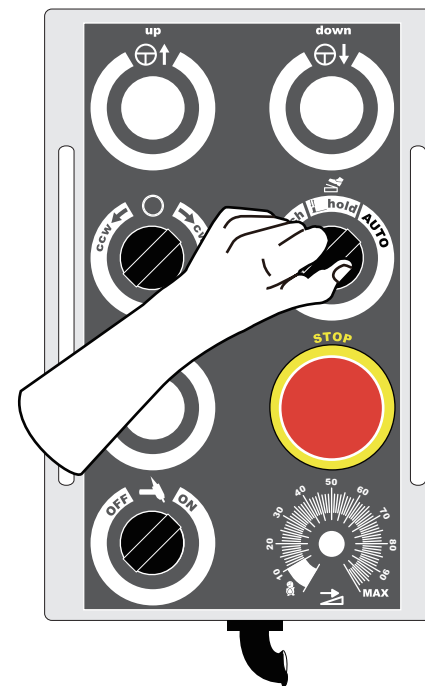
4T(4 CYCLE)



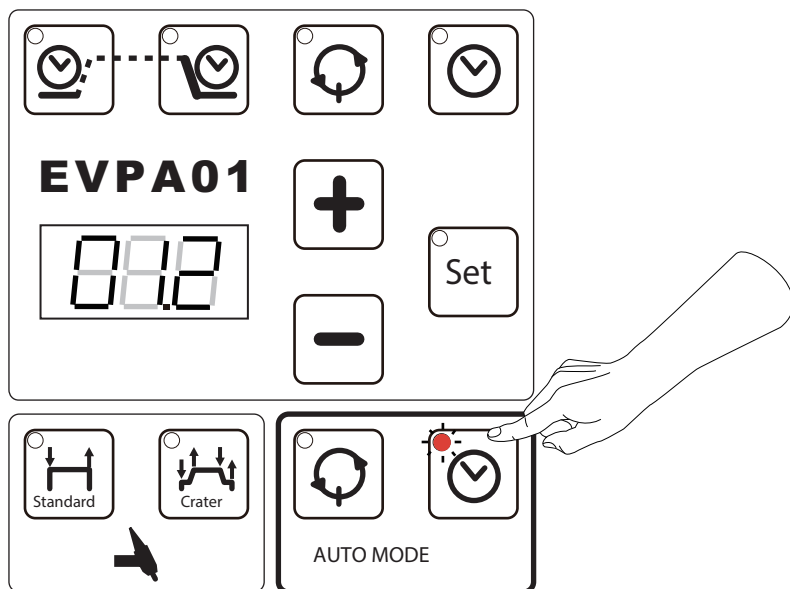
4.2 重疊自動模式



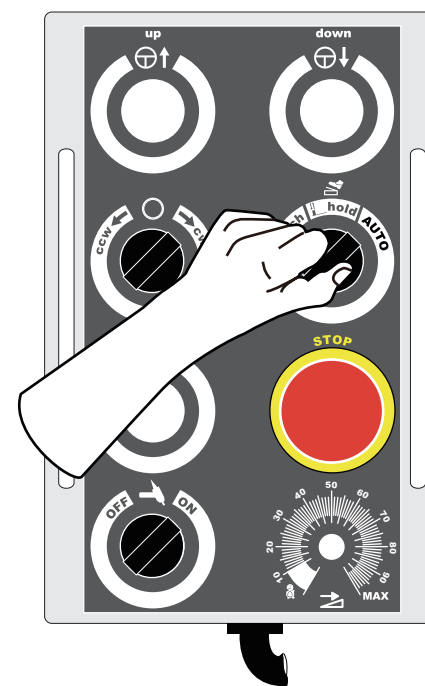
AND



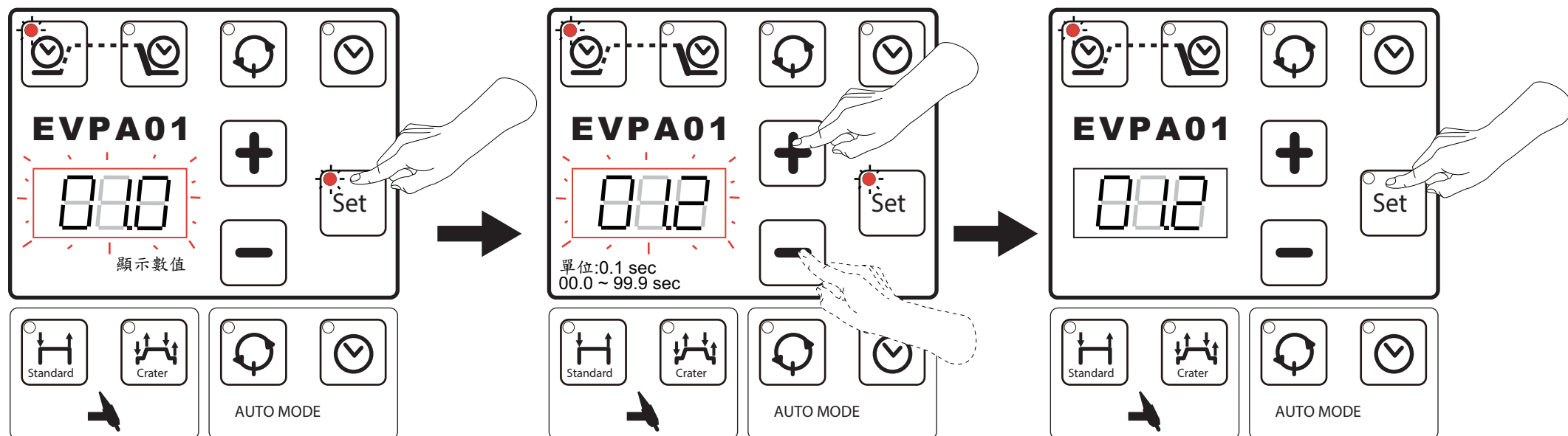
4.3 定時器自動模式



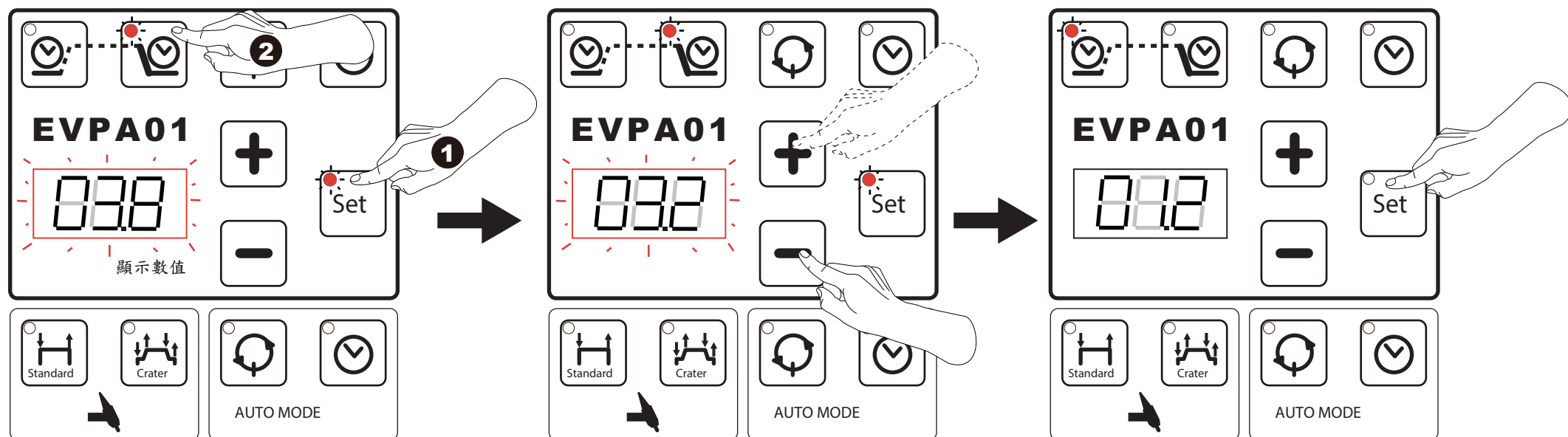
AND



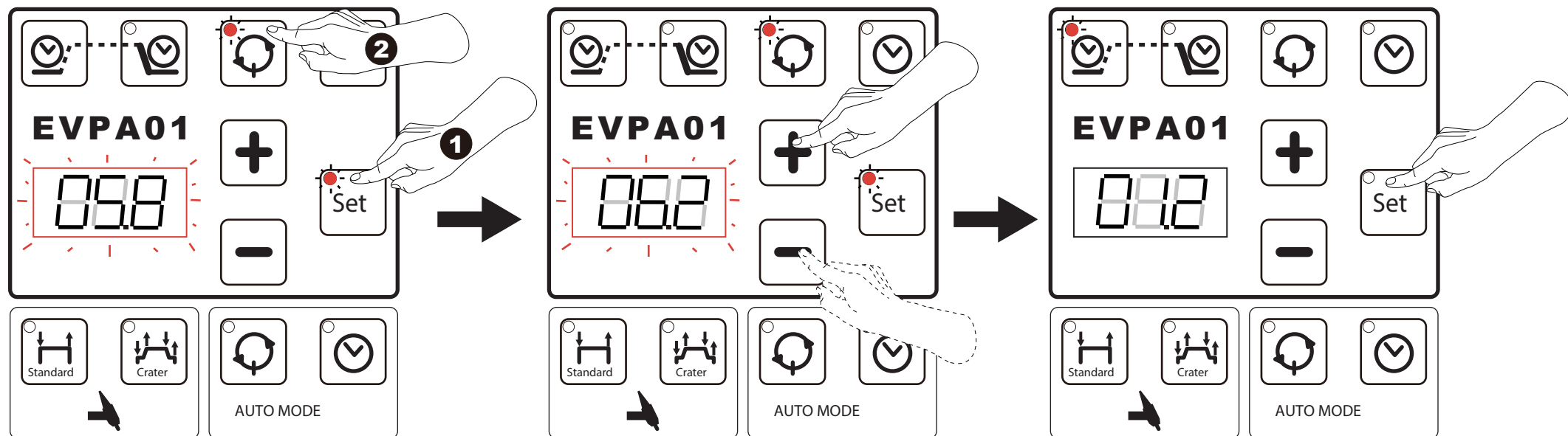
4.4 電弧路的開始時間設置



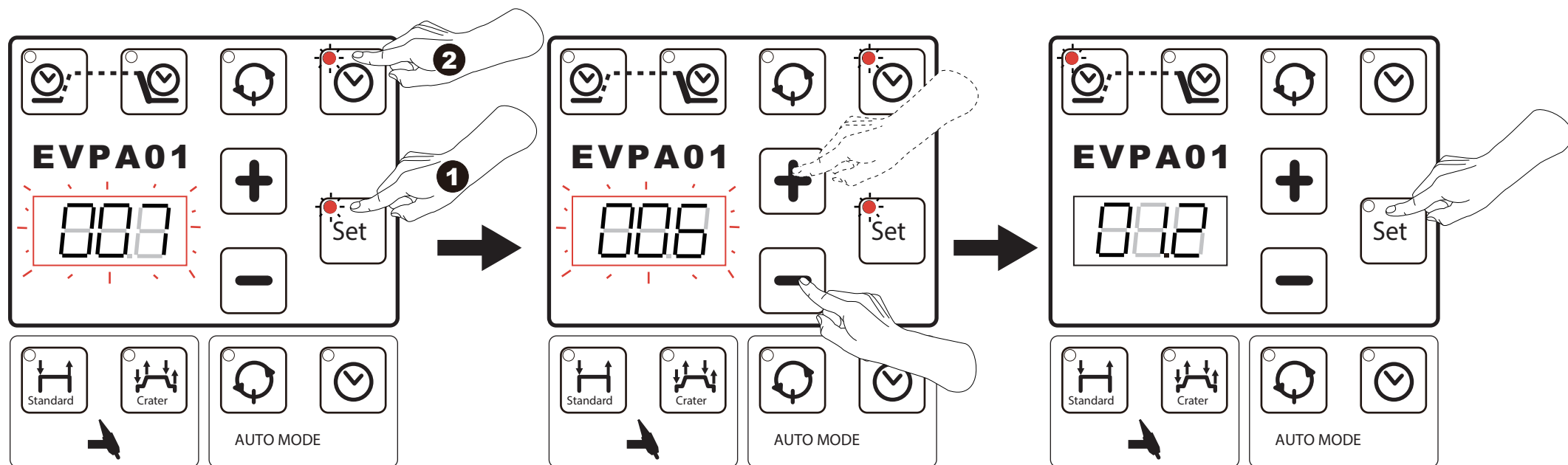
4.5 起弧時間設定方式



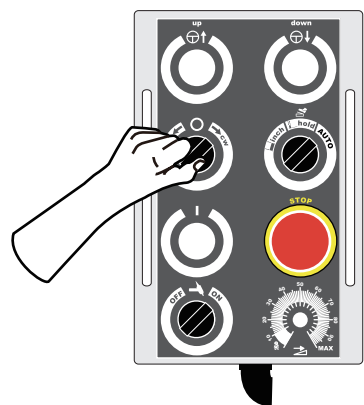
4.6 原點覆歸時間設置



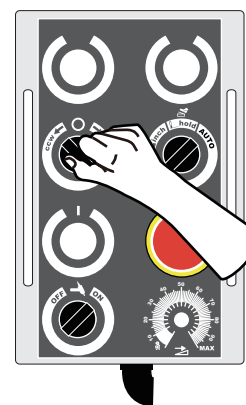
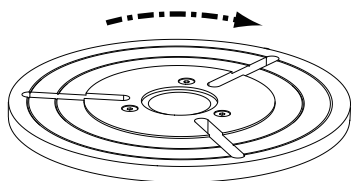
4.7 定時時間設置



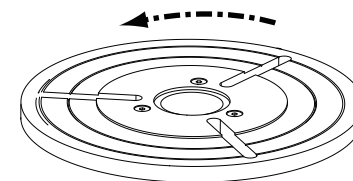
4.8 盤面旋轉方向



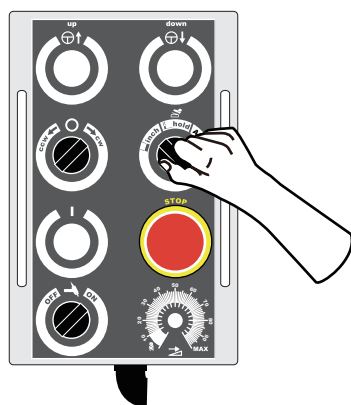
切換 CW 模式



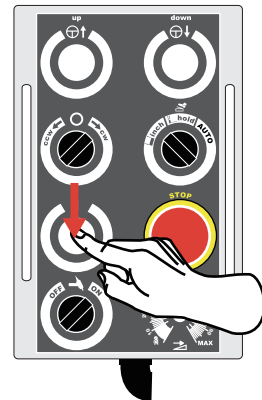
切換 CCW 模式



4.9 轉盤寸動旋轉



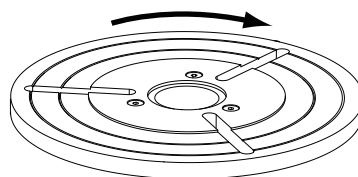
切換 Inch 模式



OR



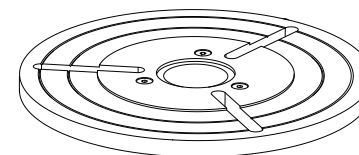
啟動



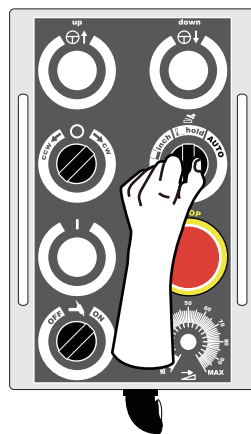
OR



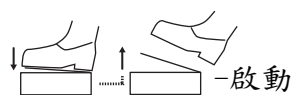
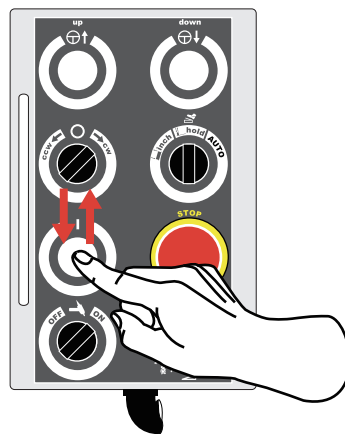
停止



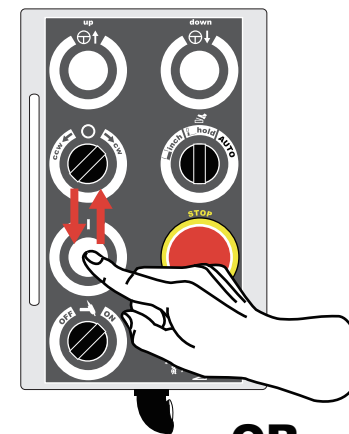
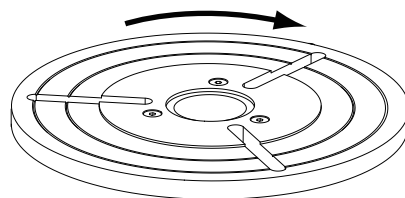
4.10 轉盤自保持旋轉



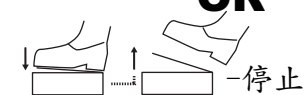
切換hold模式



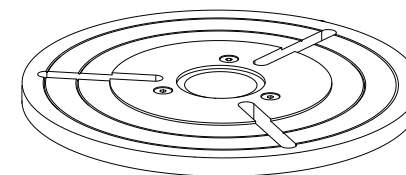
-啟動



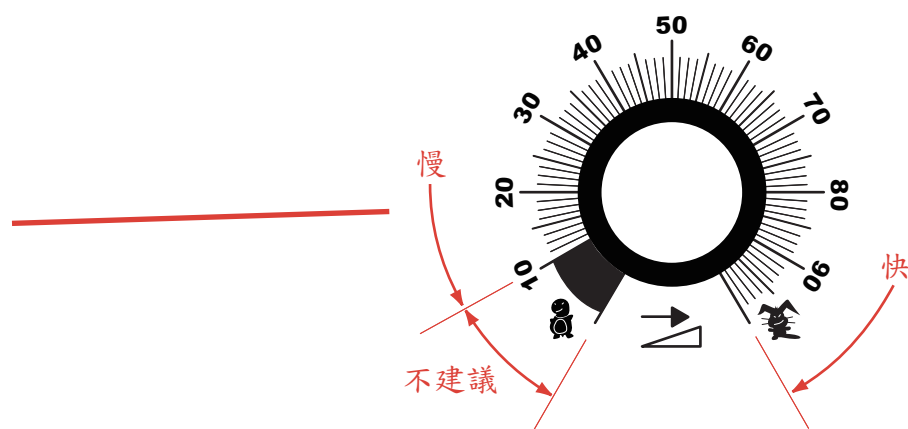
OR



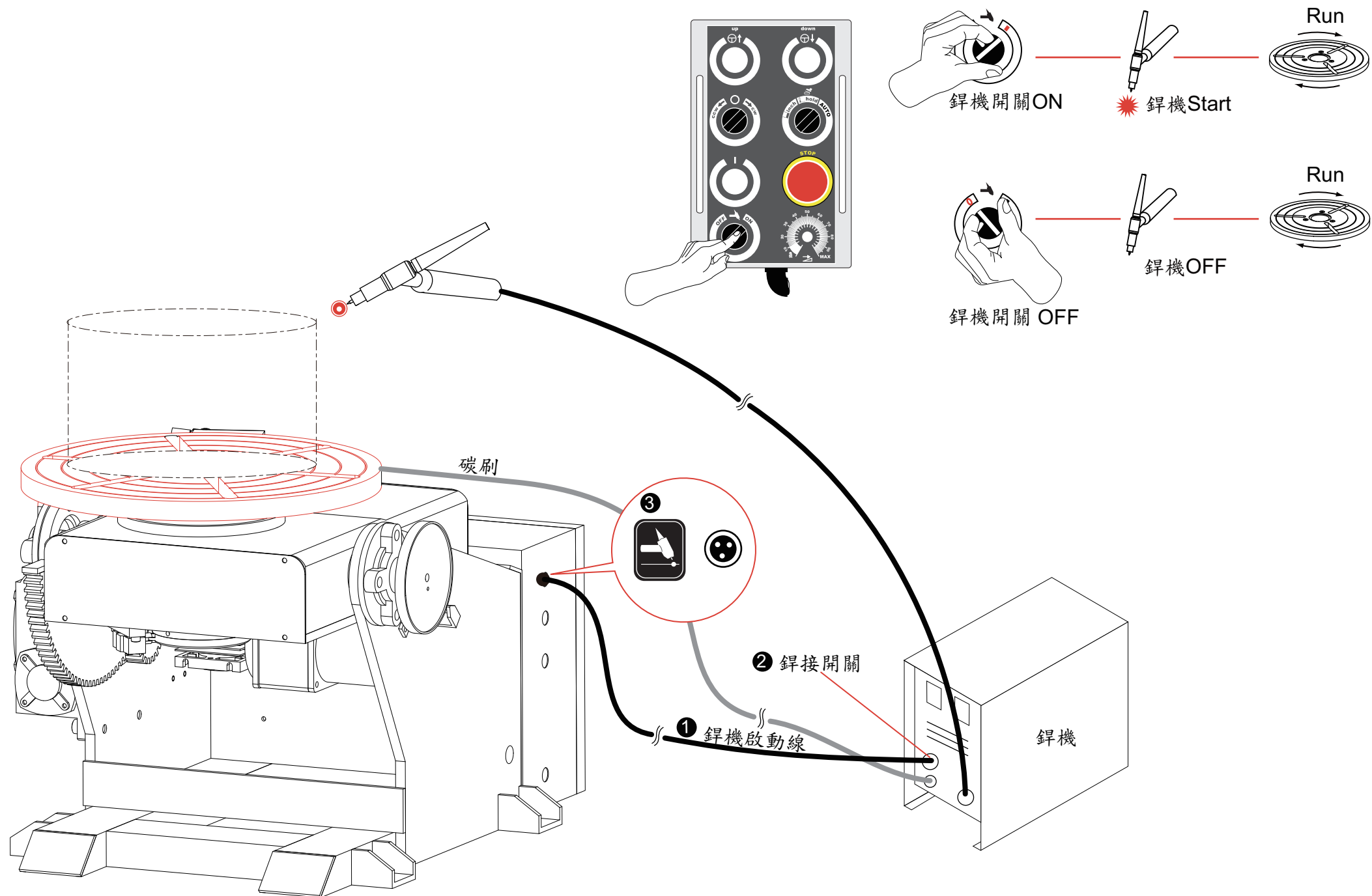
-停止



4.11 轉盤旋轉速度



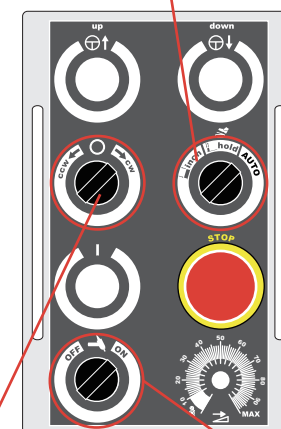
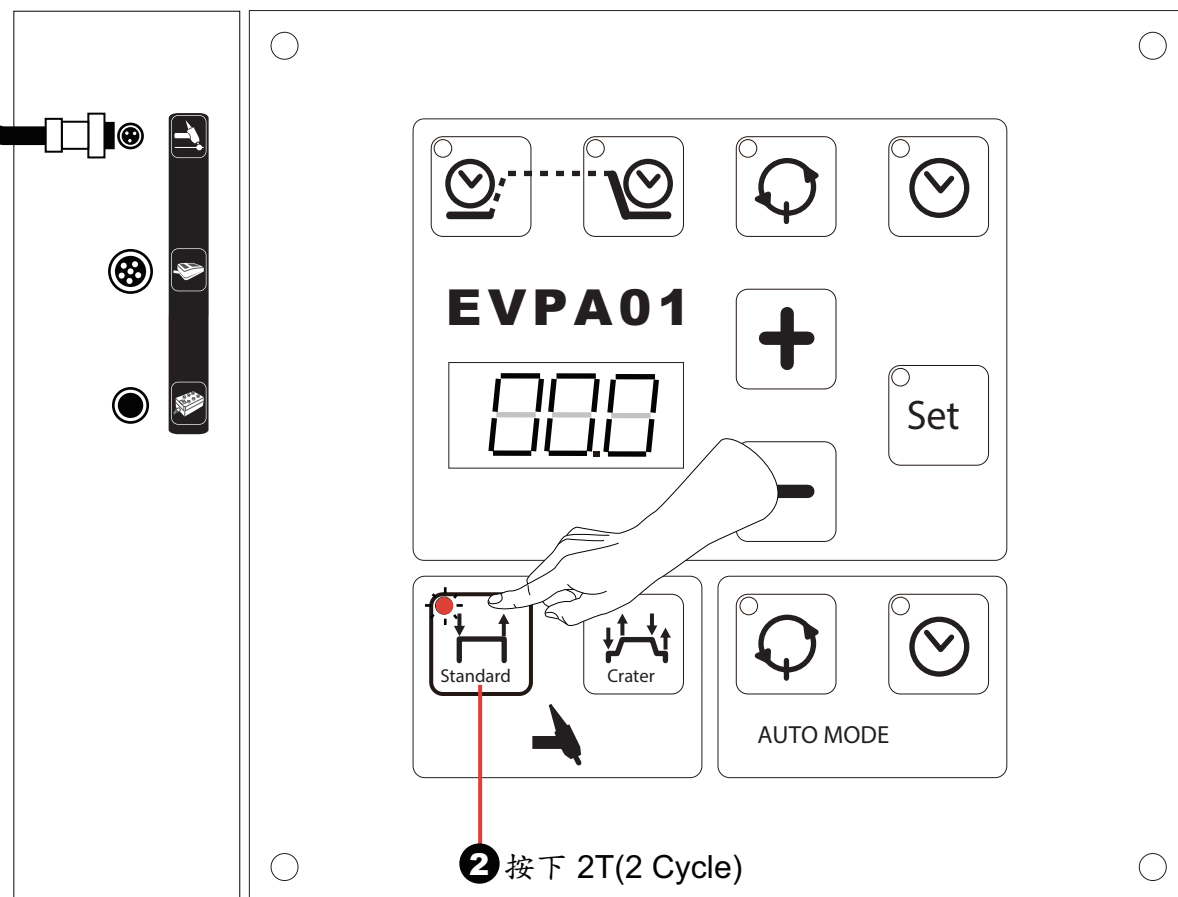
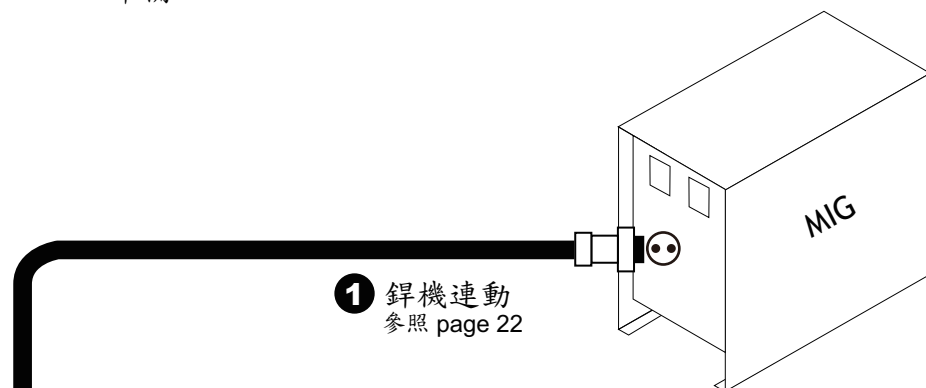
4.12 鐸機啟動步驟



2T(2 cycle) 機器操作

4.13 2T(2 Cycle) / 自保持(HOLD)/ MIG

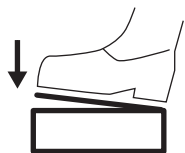
4.13.1 準備



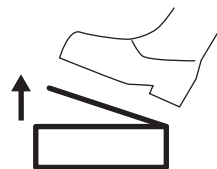
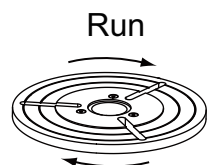
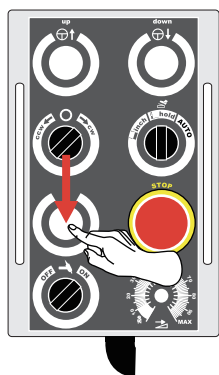
4.13 2T(2 Cycle) / 自保持(HOLD) / MIG

4.13.2 銲接啟動

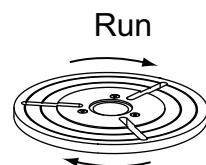
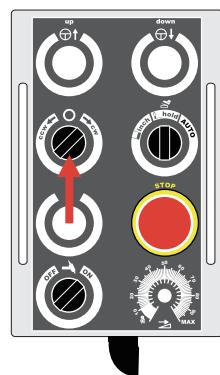
❶ 啟動



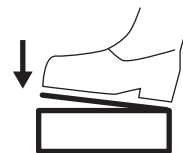
or



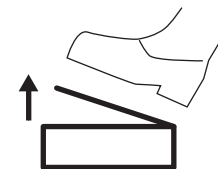
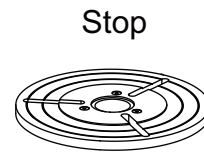
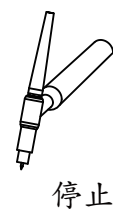
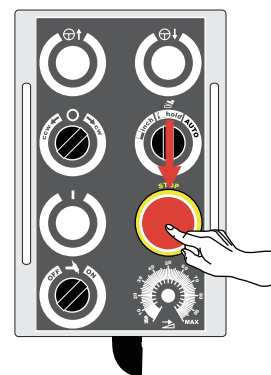
or



❷ 停止



or

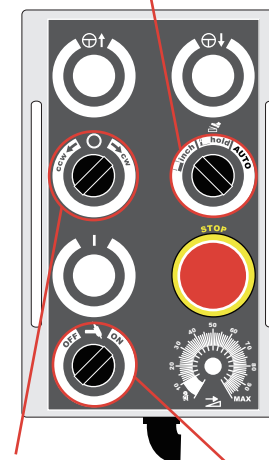
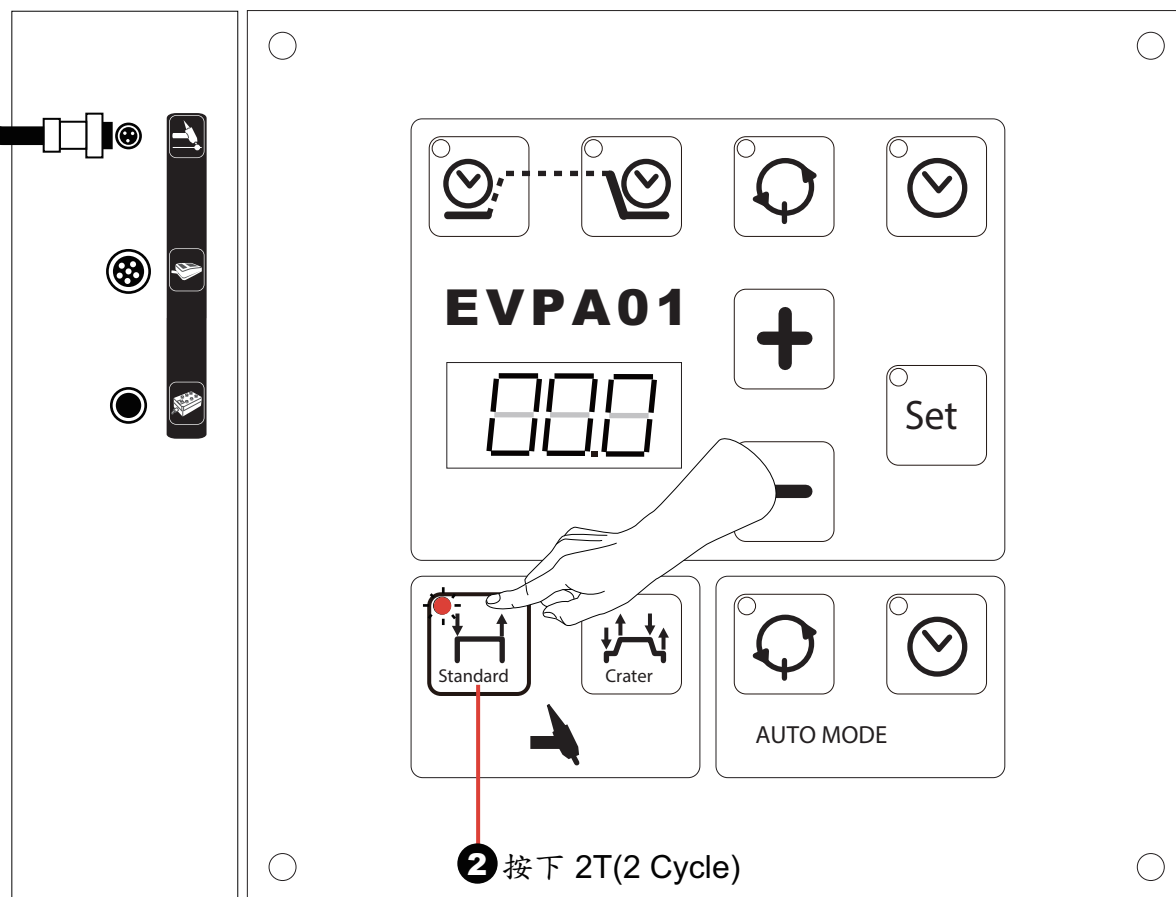
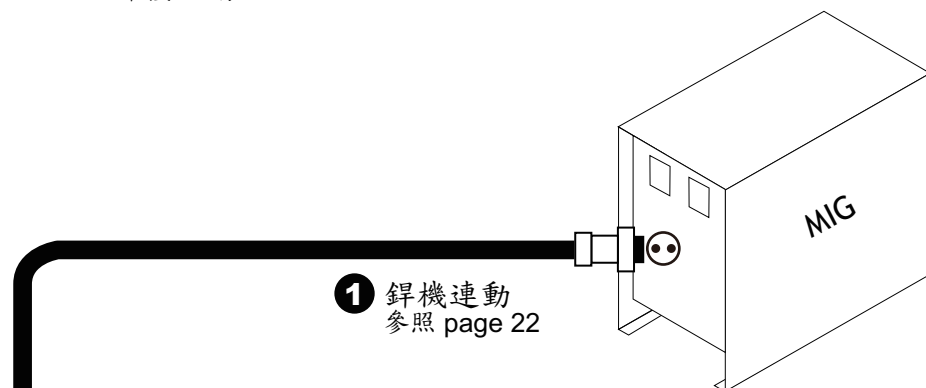


or



4.14 2T(2 Cycle) / 寸動(INCH) / MIG

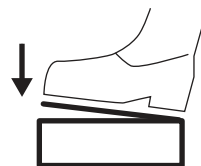
4.14.1 銲接啟動



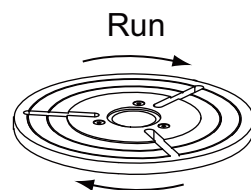
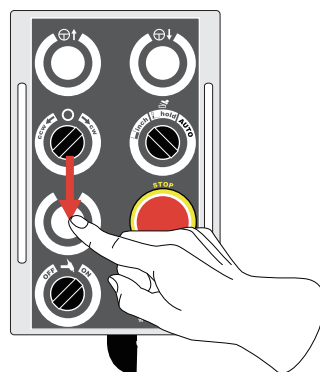
4.14 2T(2 Cycle) / 寸動(INCH) / MIG

4.14.2 銲接啟動

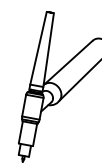
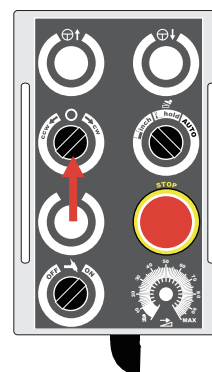
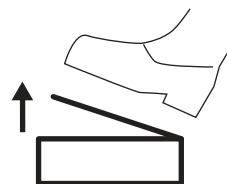
① 啟動



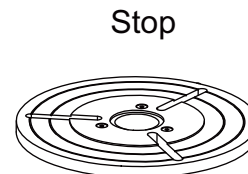
or



② 停止

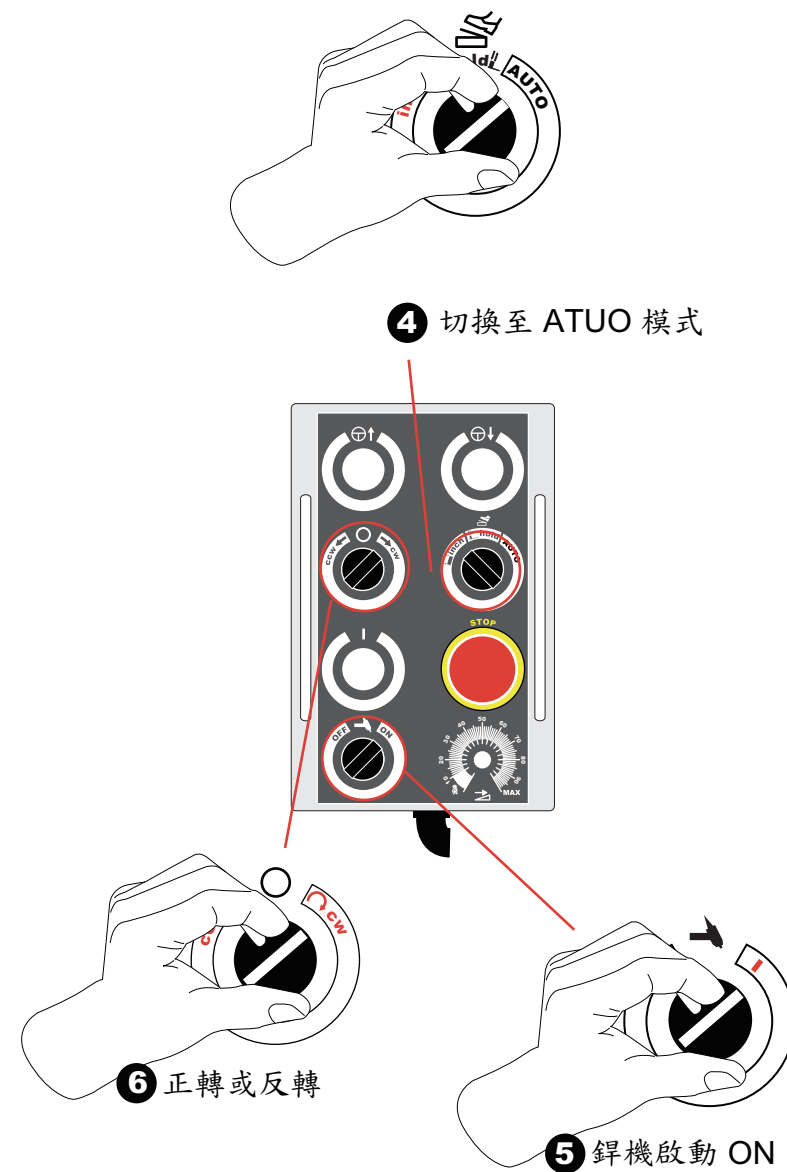
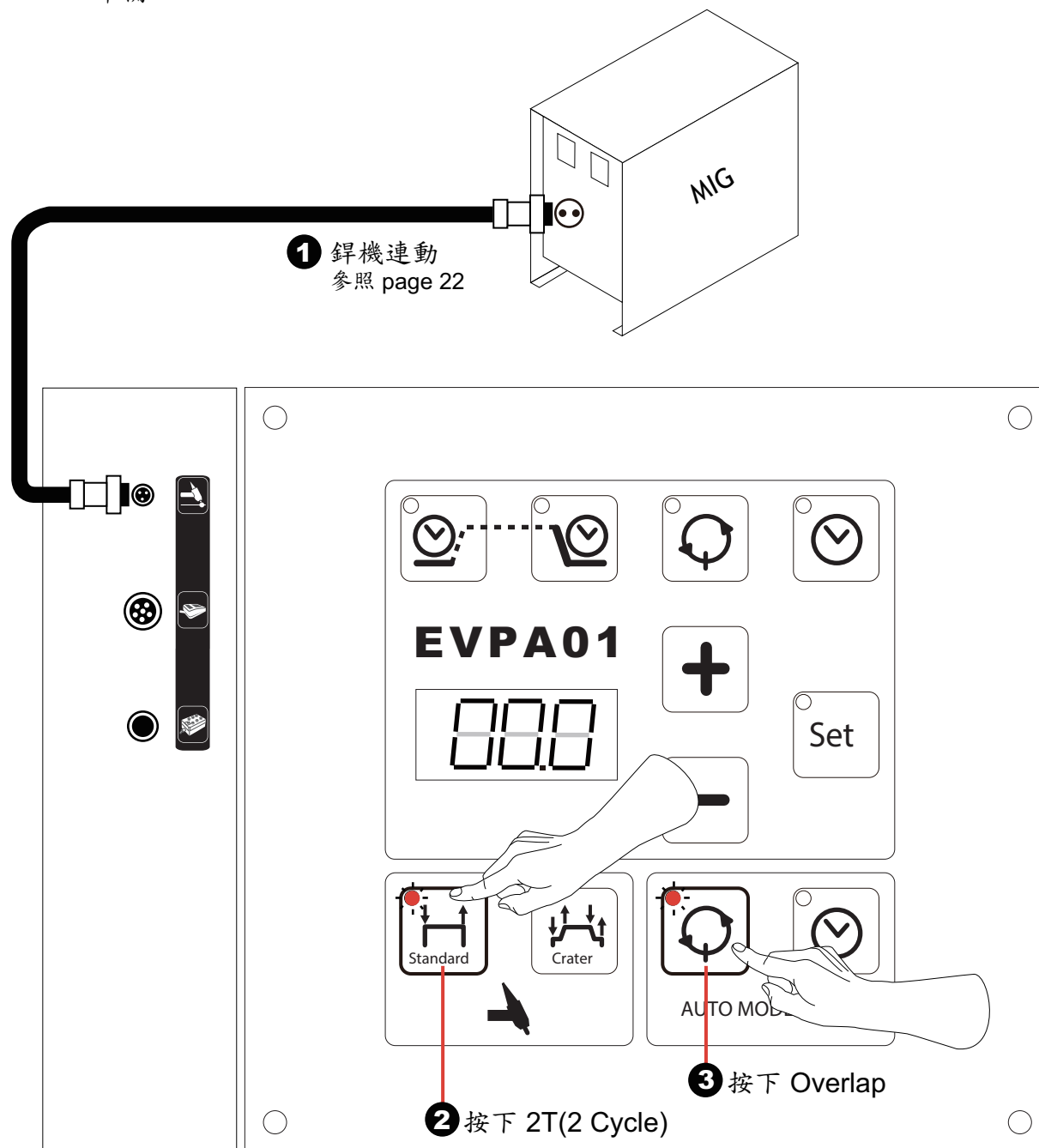


停止



4.15 2T(2 Cycle) / 交疊(OVERLAP) / MIG

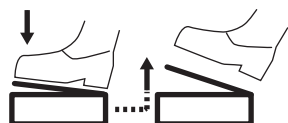
4.15.1 準備



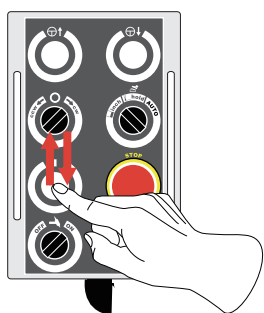
4.15 2T(2 Cycle) / 交疊(OVERLAP) / MIG

4.15.2 銲接啟動

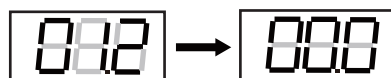
❶ 啟動



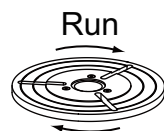
or



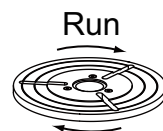
❷ 開始時間



銲接電弧

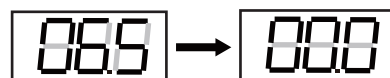


Run

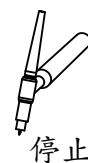


Run

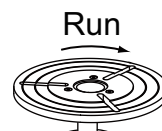
❸ 交疊(Overlap)



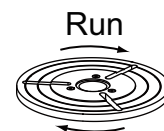
銲接電弧



停止

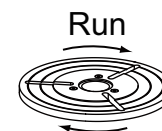
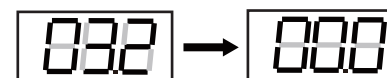


Run

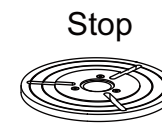


Run

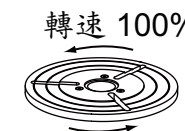
❹ 起弧時間



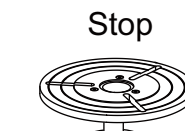
Run



Stop



轉速 100%



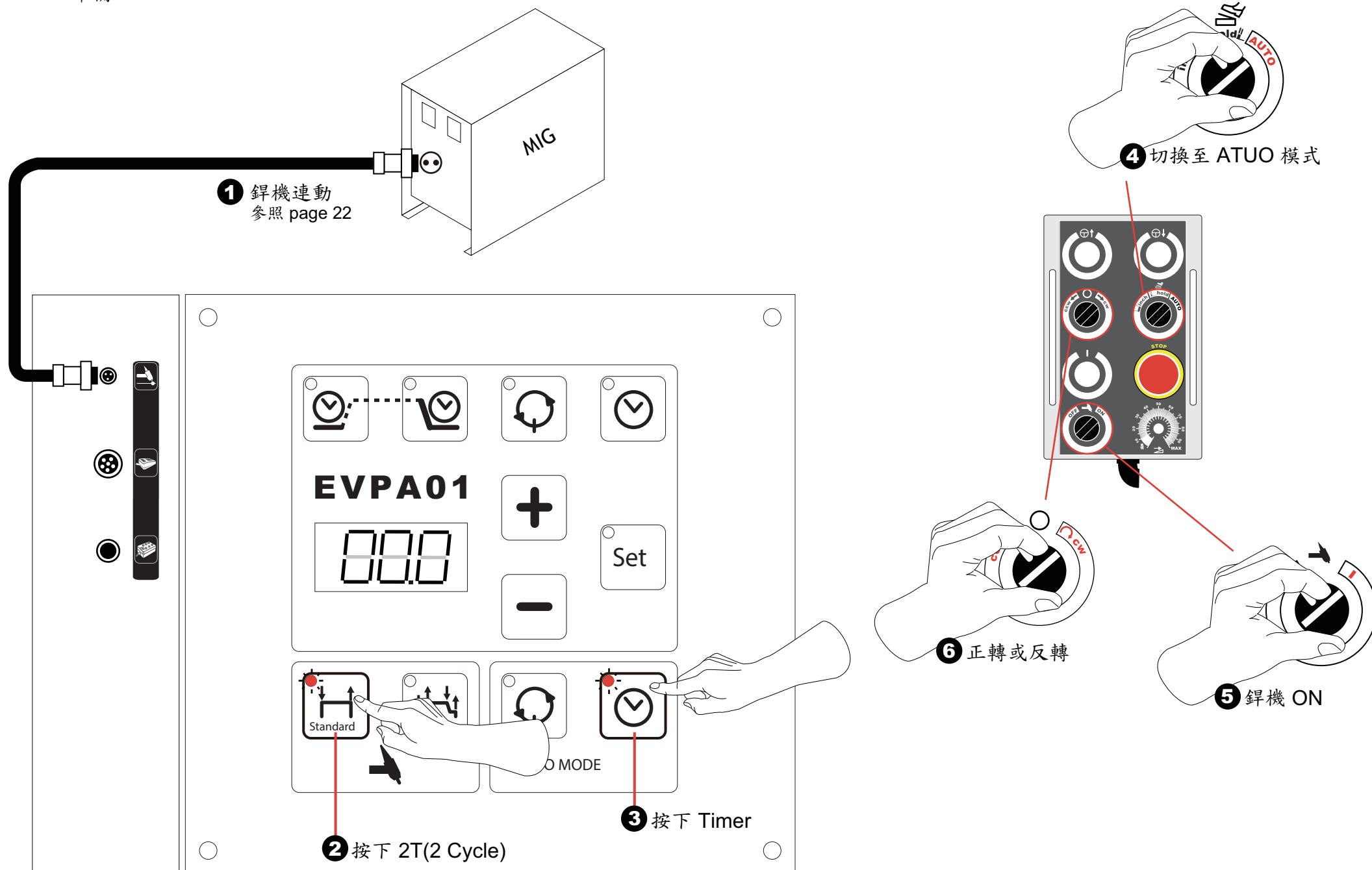
Stop

微動開關 ON

微動開關 ON

4.16 2T(2 Cycle) / 計時器(TIMER) / MIG

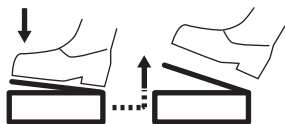
4.16.1 準備



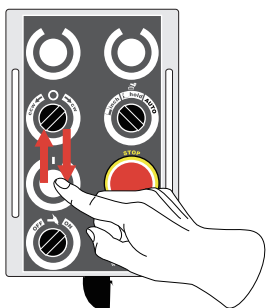
4.16 2T(2 Cycle) / 計時器(TIMER) / MIG

4.16.2 銲機啟動

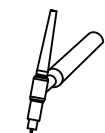
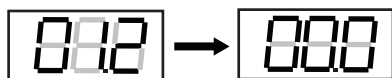
① 啟動



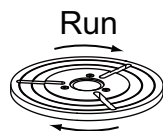
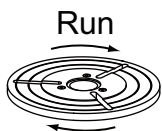
or



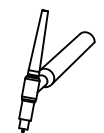
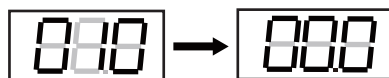
② 啟動時間



銲接電弧



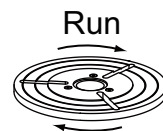
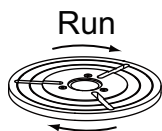
③ 計時器時間



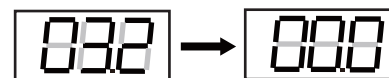
銲接電弧



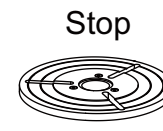
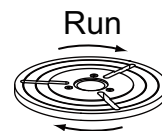
停止



④ 起弧時間



銲接電弧



轉速 100%



Stop

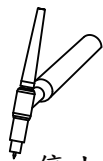
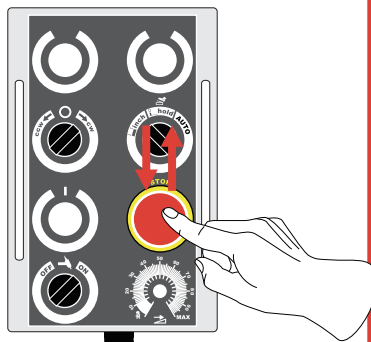


微動開關 ON

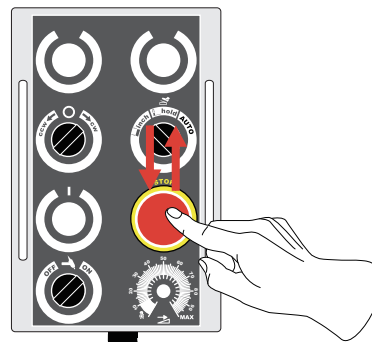
4.17 (2 Cycle)

重疊而停止工作

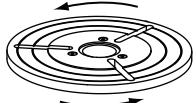
4.17.1 禁止運行



停止

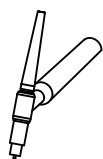
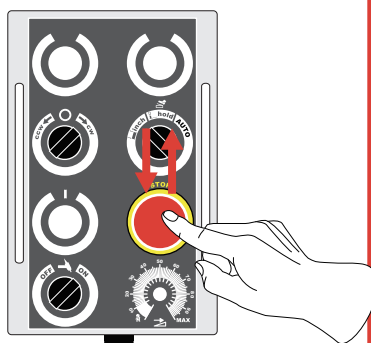


轉速100%

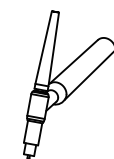
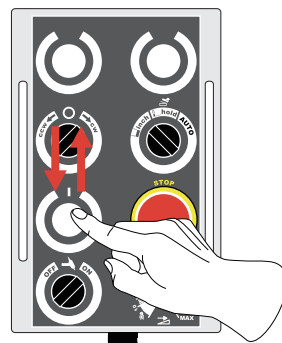


停止

4.17.2 重新啟動

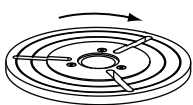


停止



銲接電弧

Run

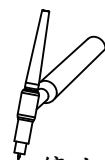
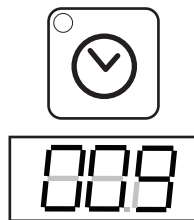
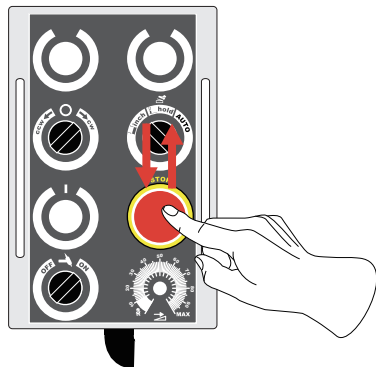


銲接 page 28 動作



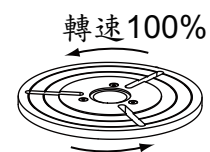
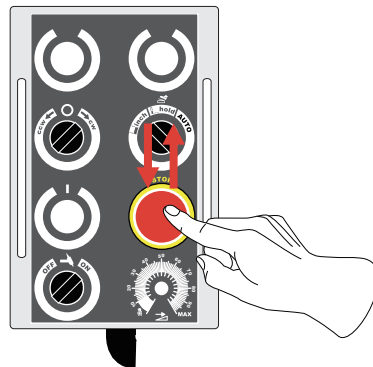


4.18.1 禁止運行

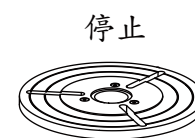


停止

停止

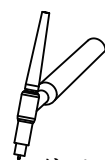
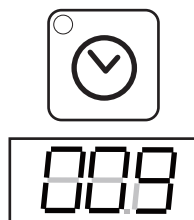
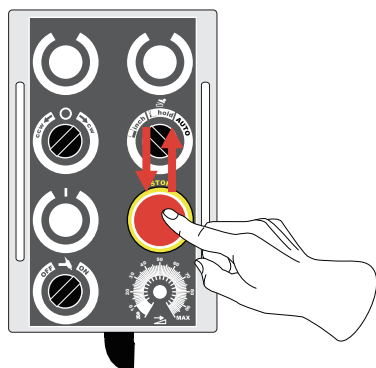


轉速100%



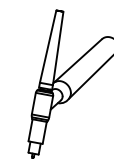
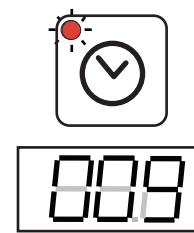
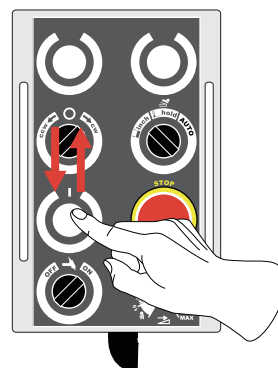
停止

4.18.2 重新啟動

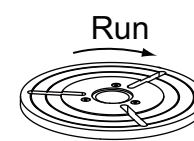


停止

停止



銲接電弧



Run

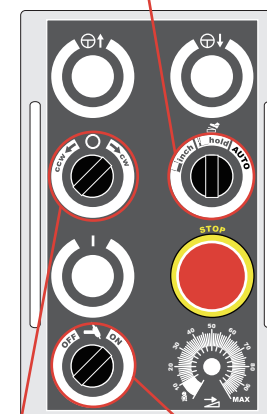
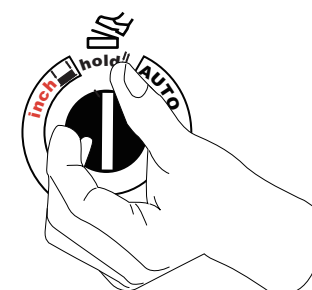
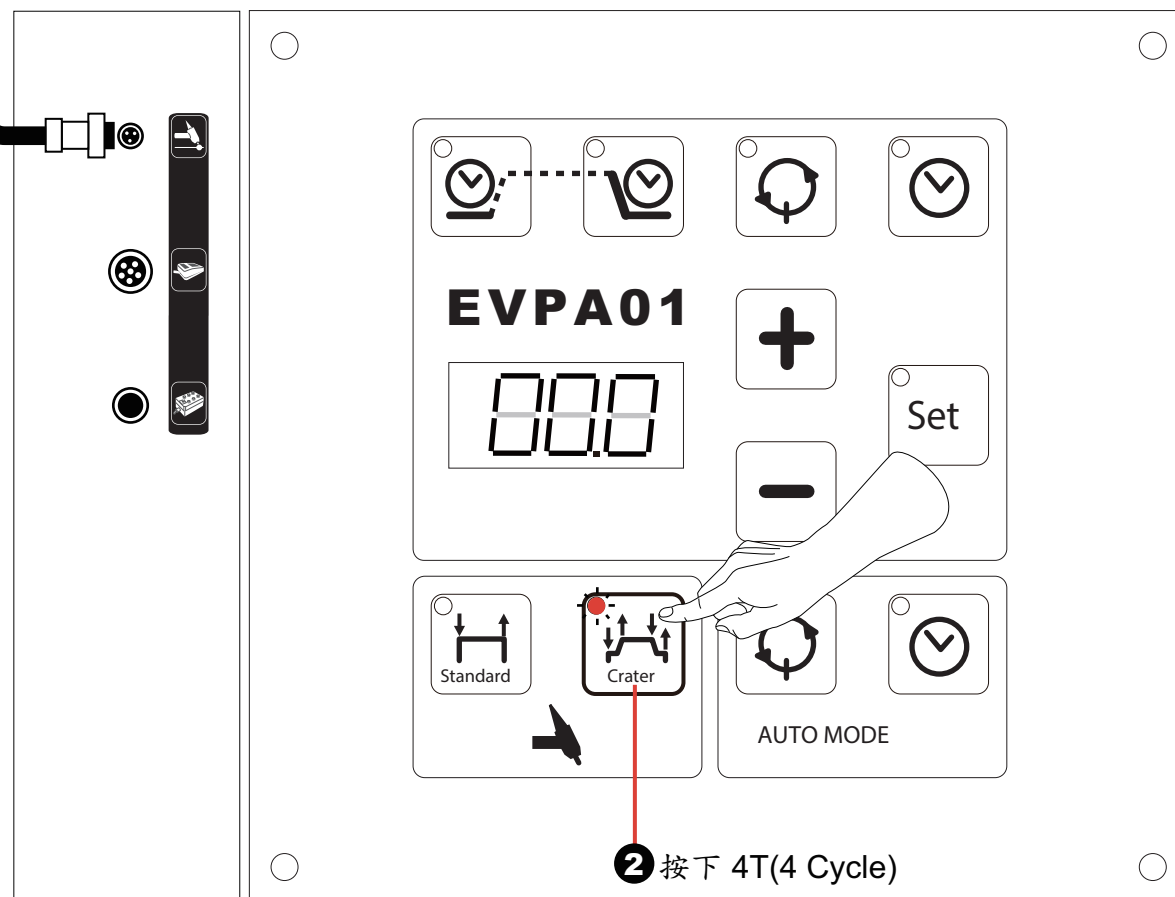
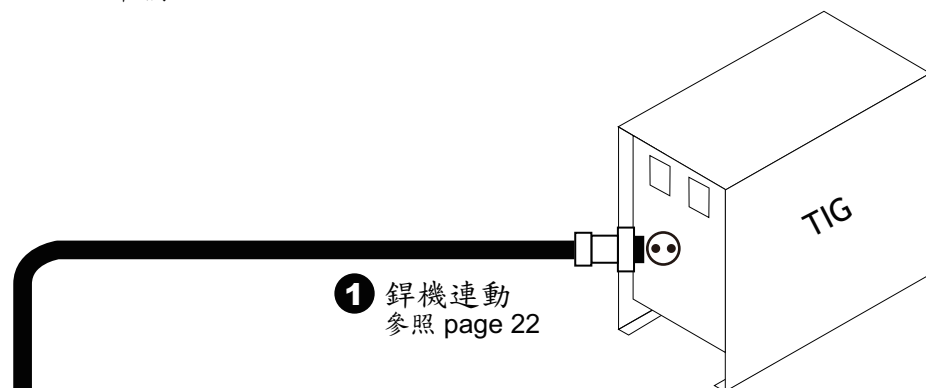
銜接 page 30 動作



4T(4 cycle) 機器操作

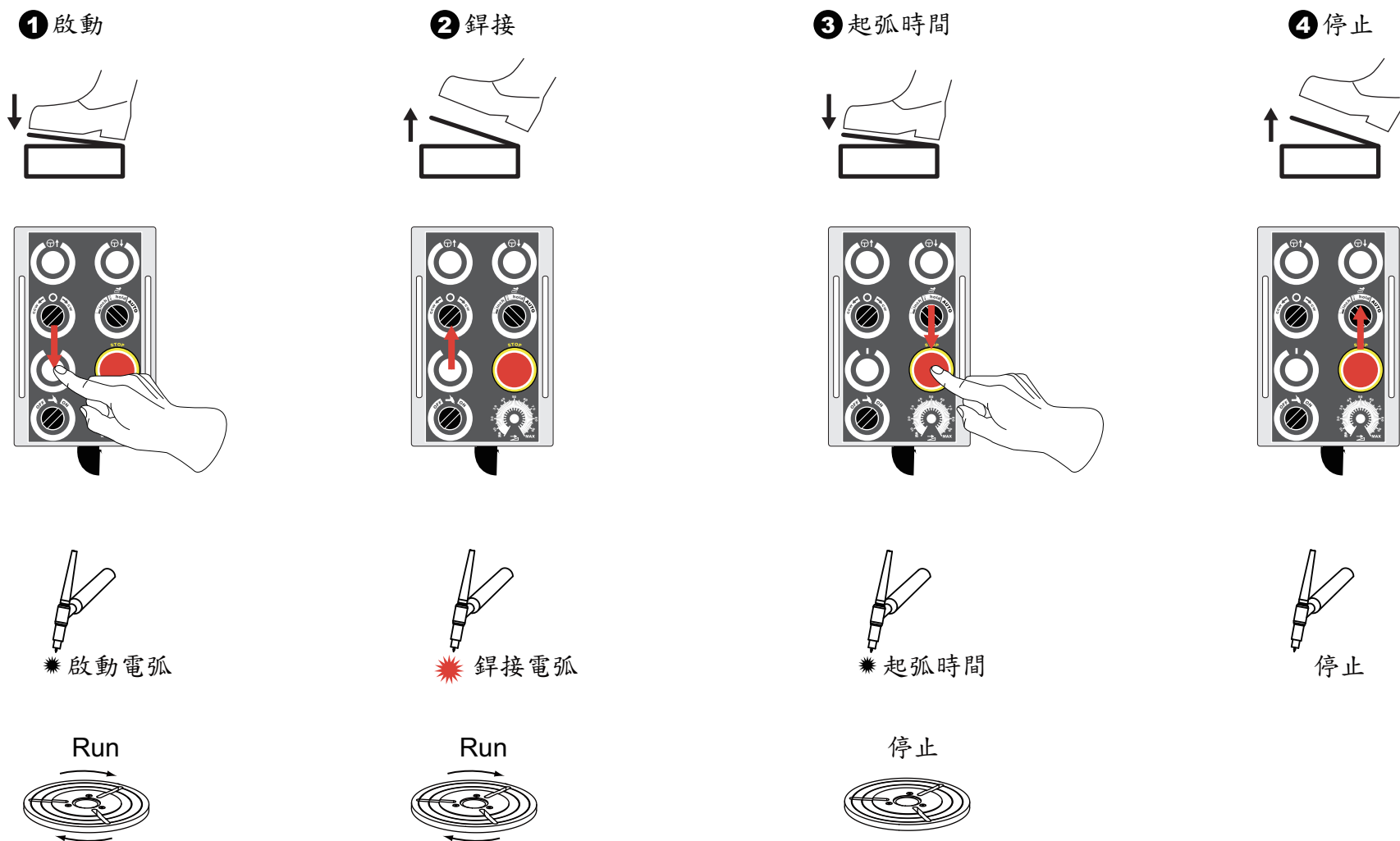
4.19 4T(4 Cycle) / (自保持)HOLD / TIG

4.19.1 準備



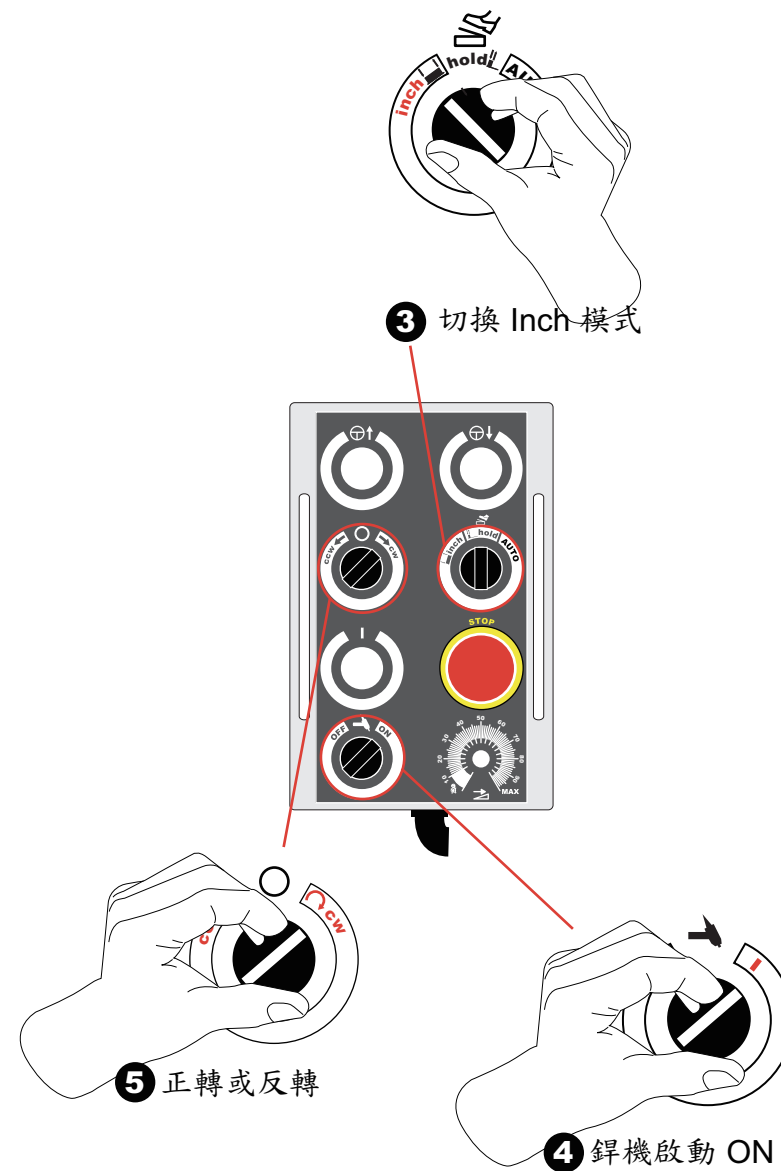
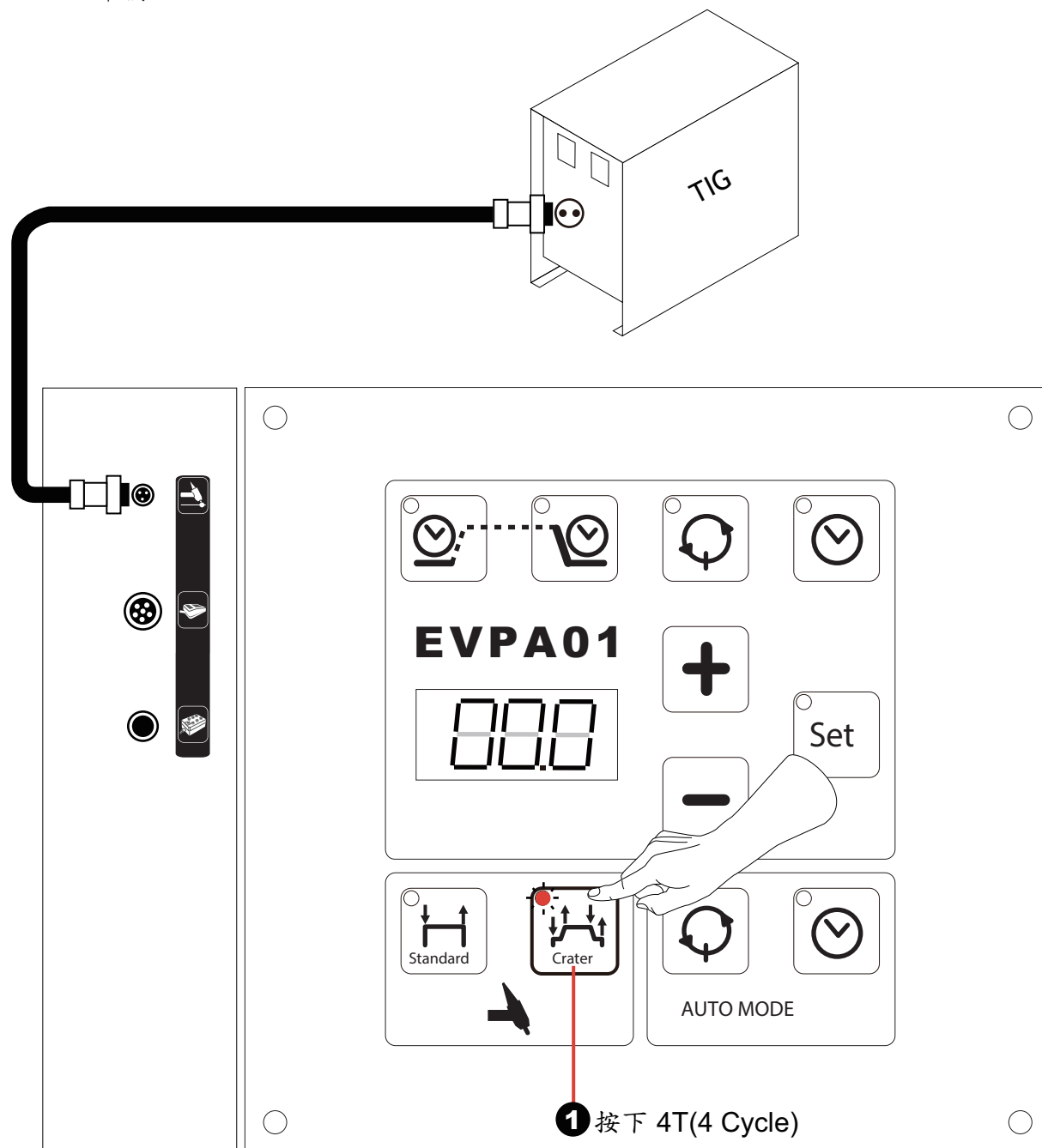
4.19 4T(4 Cycle) / 自保持(HOLD) / TIG

4.19.2 銲接啟動



4.20 4T(4 Cycle) / 寸動(INCH)

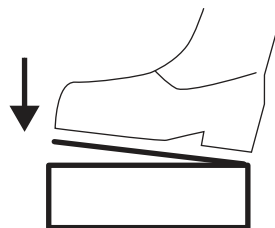
4.20.1 準備



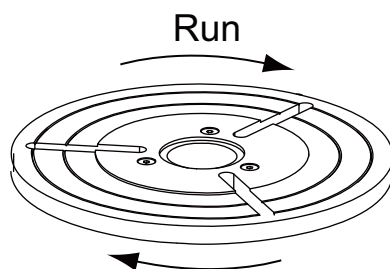
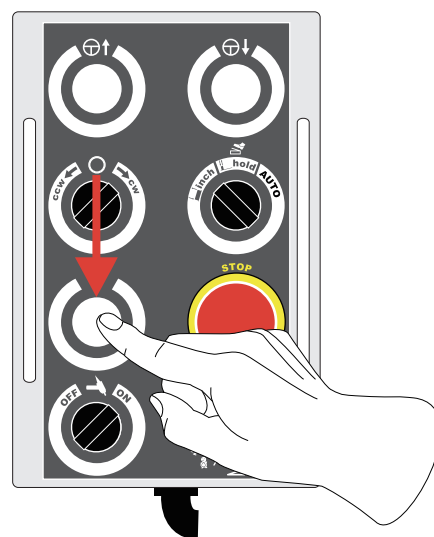
4.20 4T(4 Cycle) / 寸動(INCH)

4.20.2 啟動

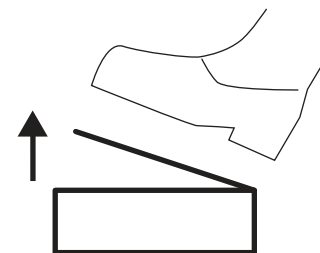
1 啟動



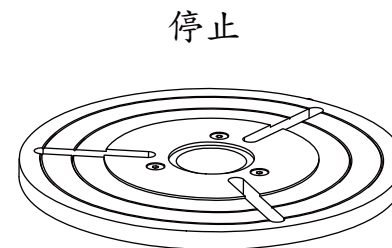
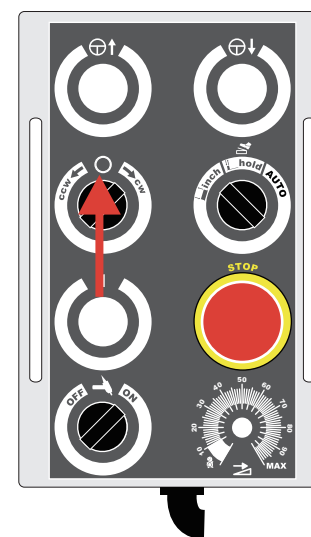
or



2 停止

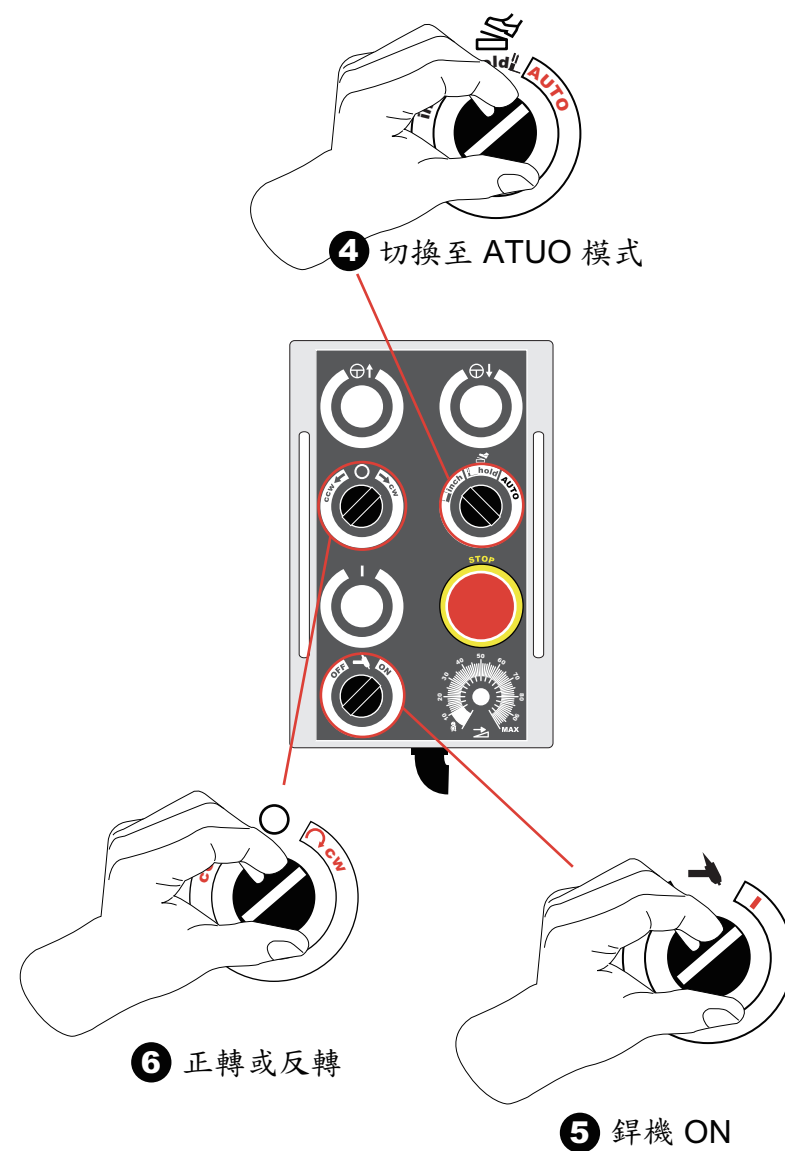
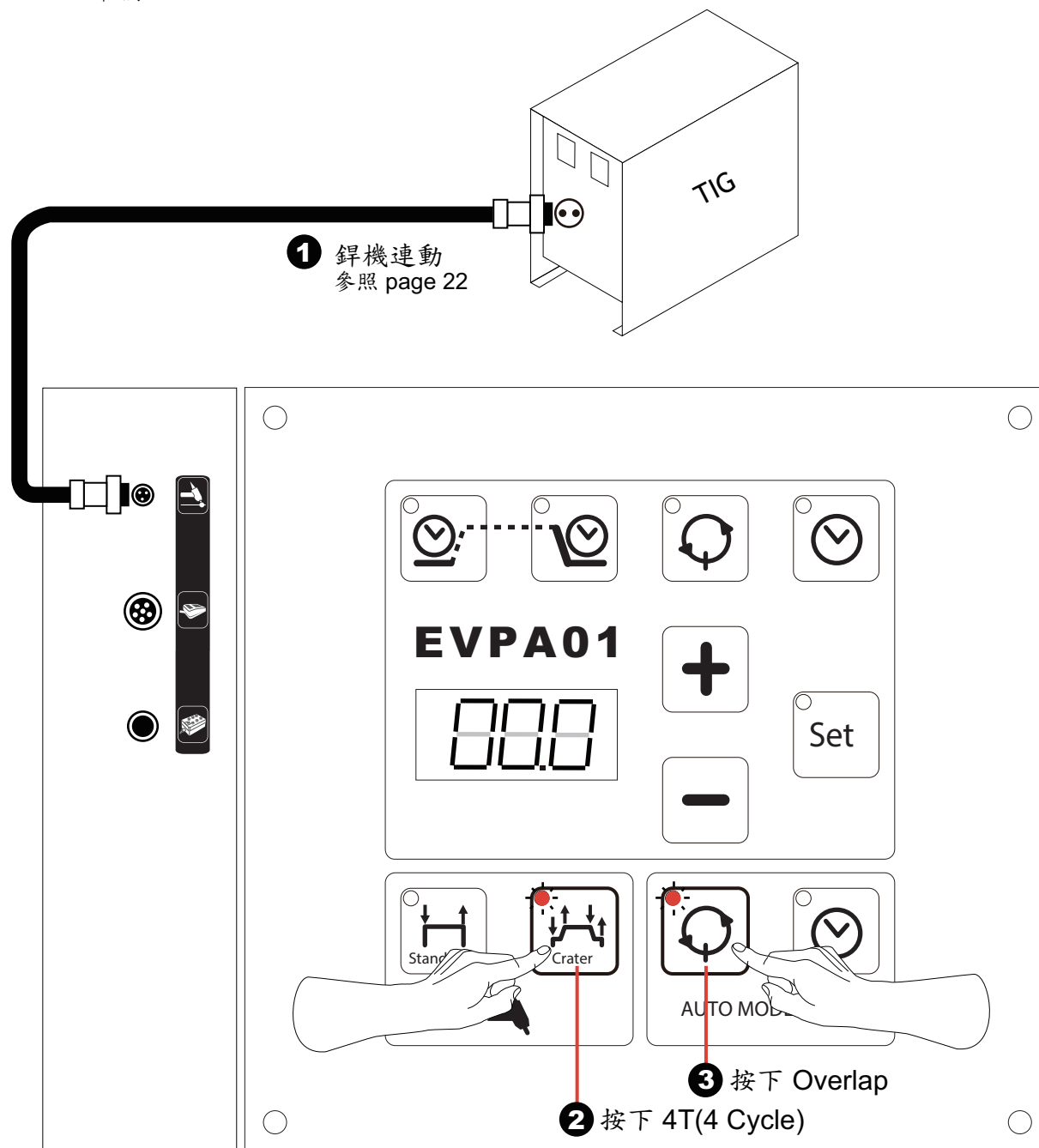


or



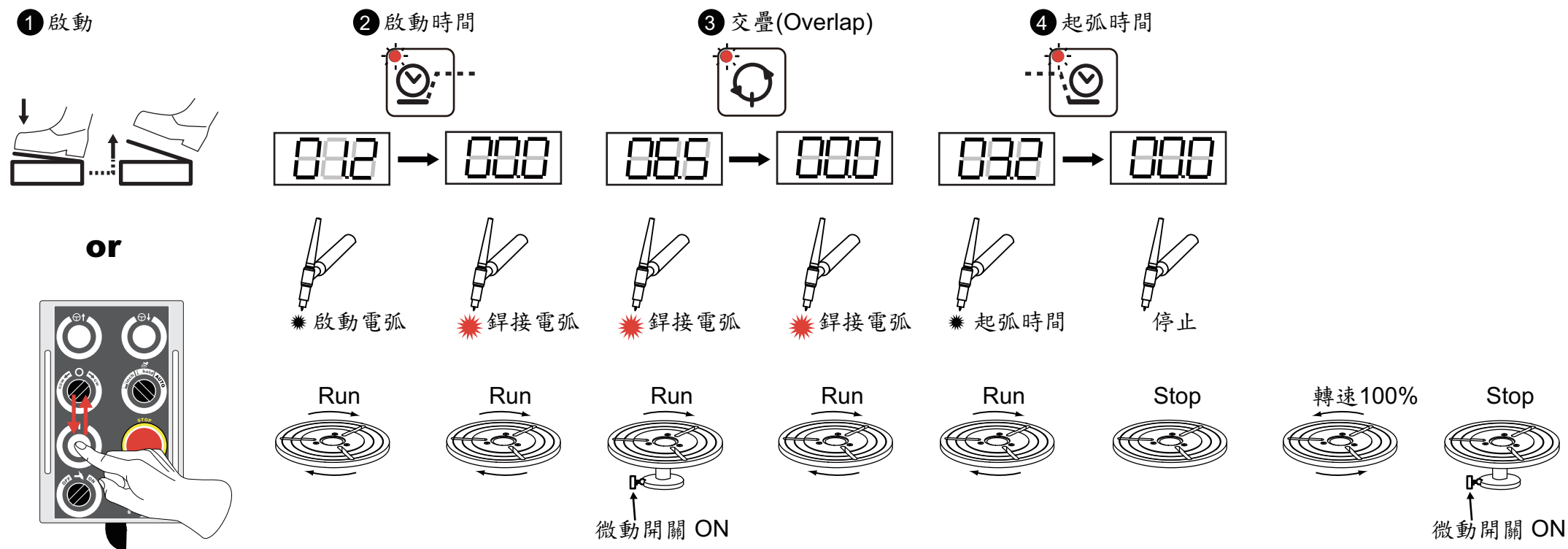
4.21 4T(4 Cycle) / 交疊OVERLAP / TIG

4.21.1 準備



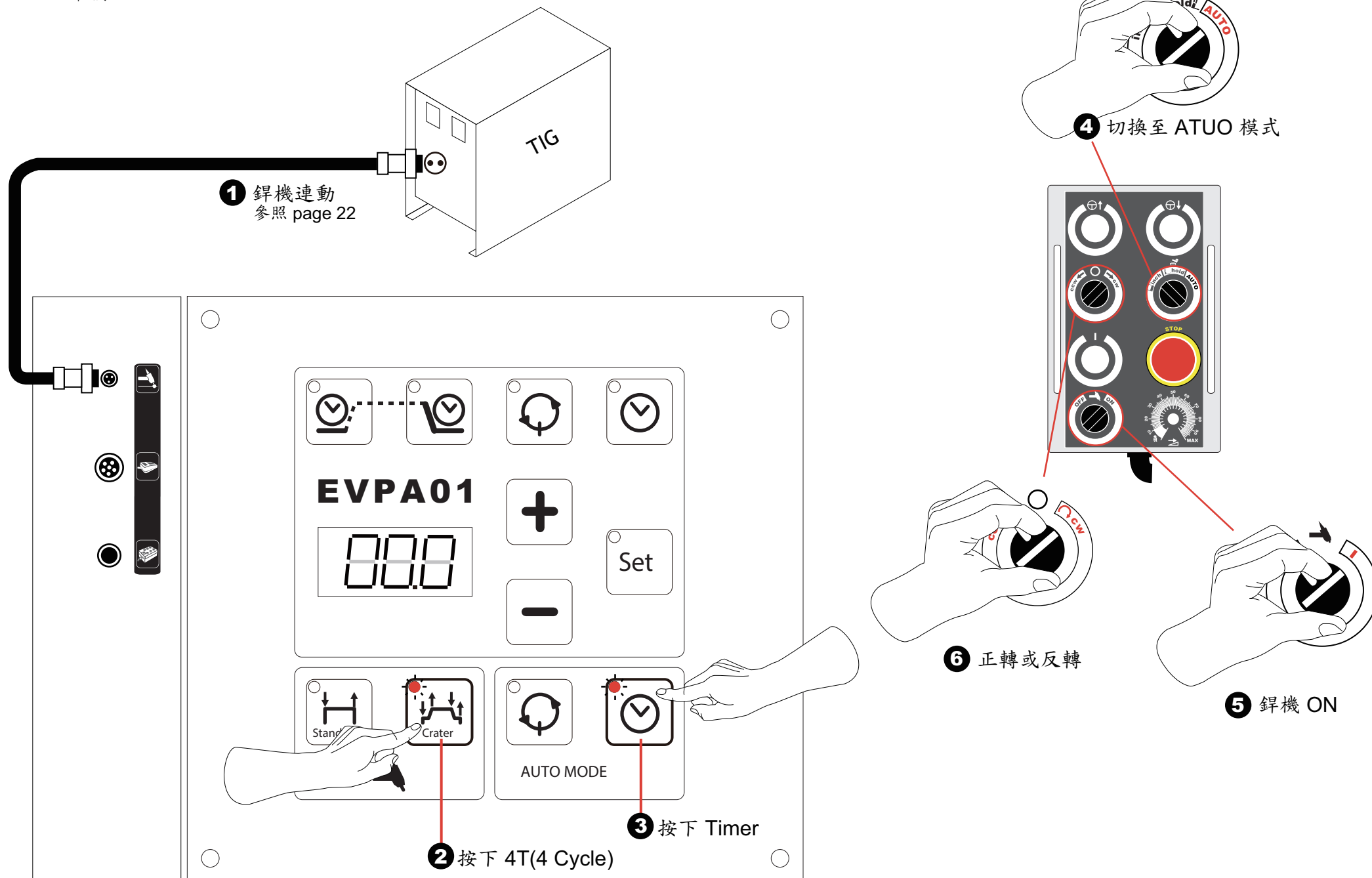
4.21 4T(4 Cycle) / 交疊(OVERLAP) / TIG

4.21.2 銲接啟動



4.22 4T(4 Cycle) / 計時器(TIMER) / TIG

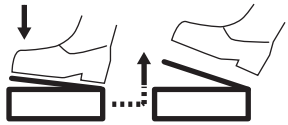
4.22.1 準備



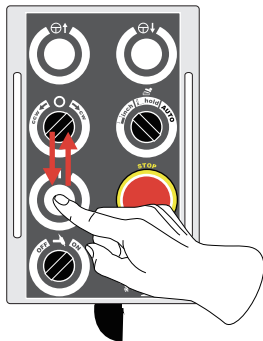
4.22 4T(4 Cycle) / 計時器(TIMER) / TIG

4.22.2 銲機啟動

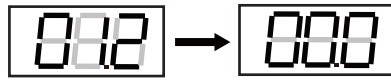
① 啟動



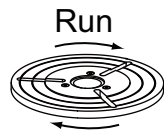
or



② 啟動時間



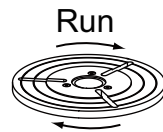
✱ 啟動電弧



Run

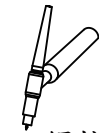
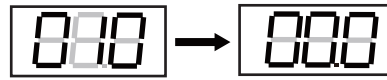


✱ 銲接電弧

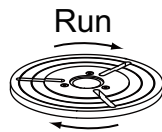


Run

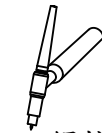
③ 計時器時間



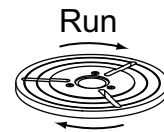
✱ 銲接電弧



Run

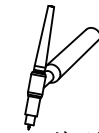
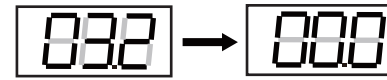


✱ 銲接電弧

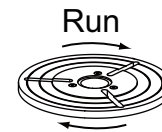


Run

④ 起弧時間



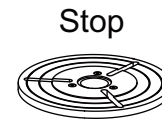
✱ 收弧



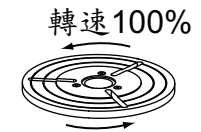
Run



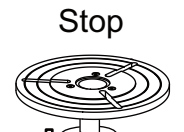
Stop



Stop



轉速 100%



Stop

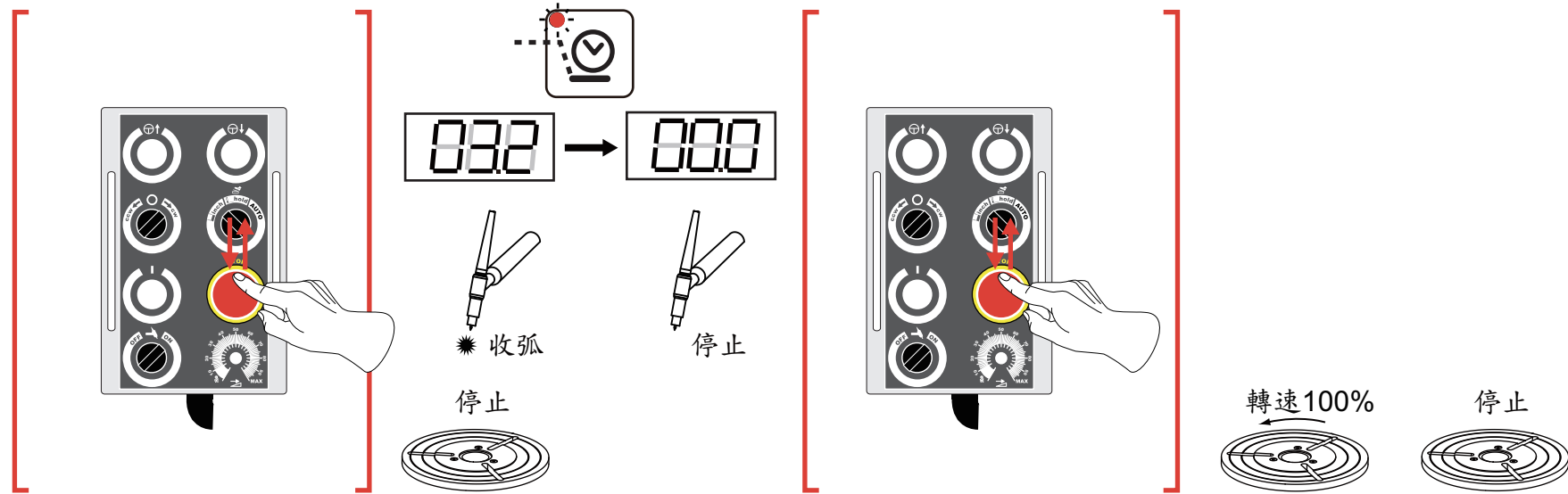
微動開關 ON

4.23 (4 Cycle)

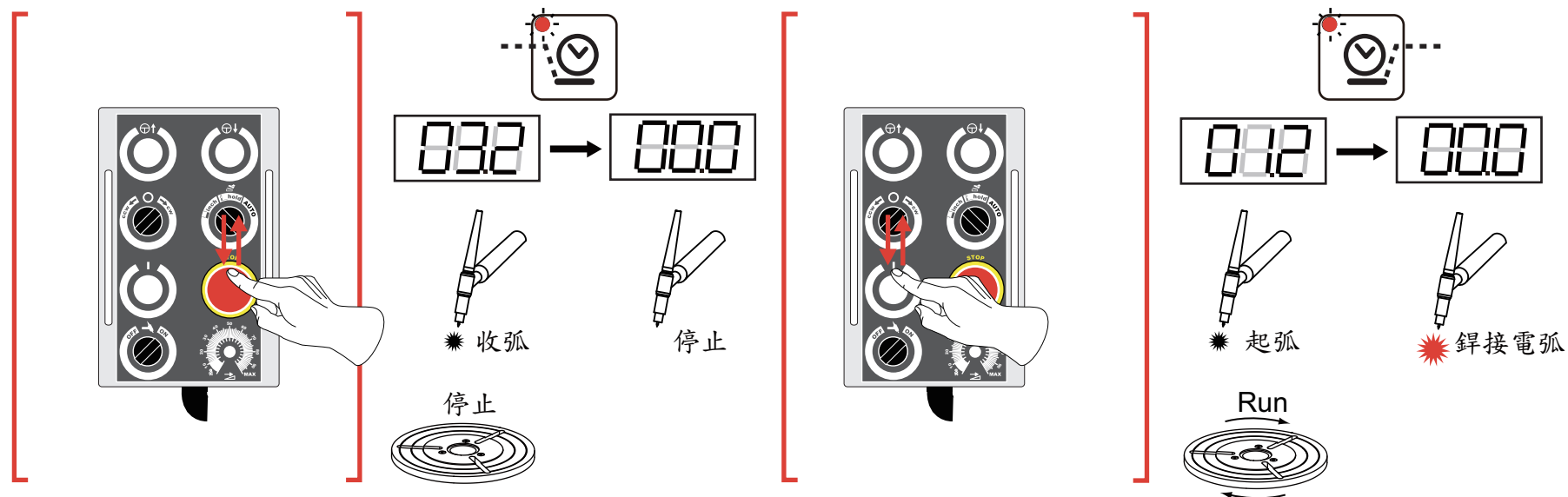


重疊而停止工作

4.23.1 禁止運行



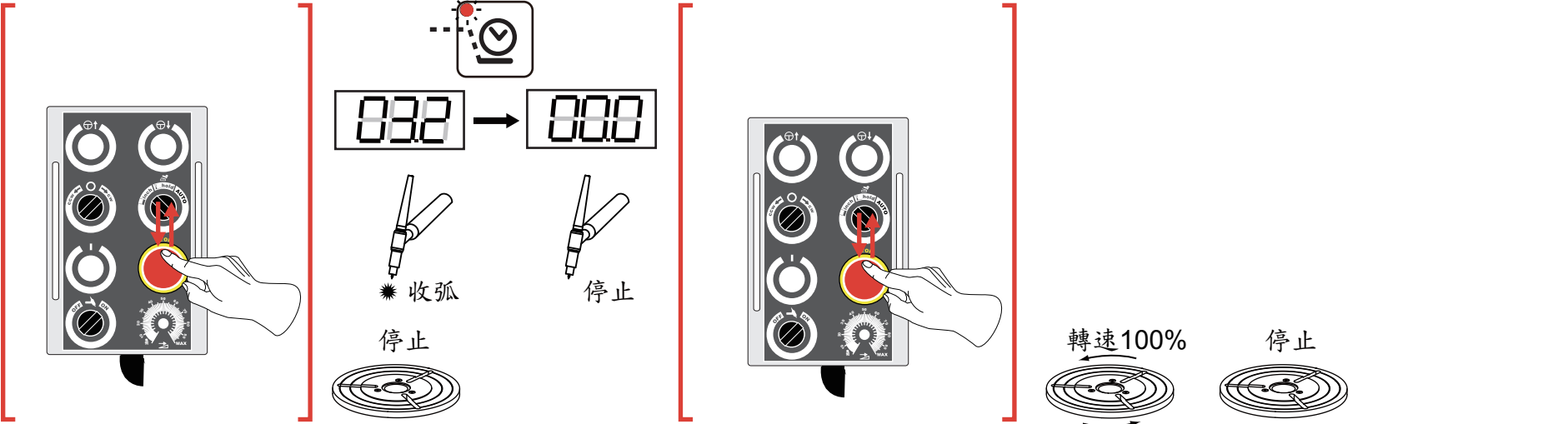
4.23.2 重新啟動



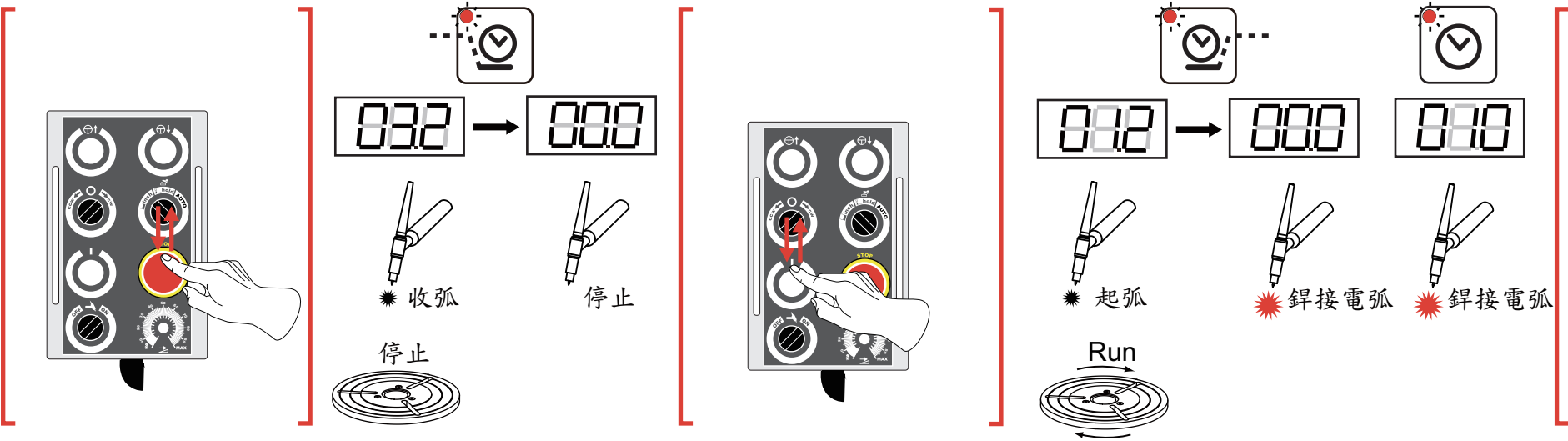
銜接 page 38 動作



4.24.1 禁止運行



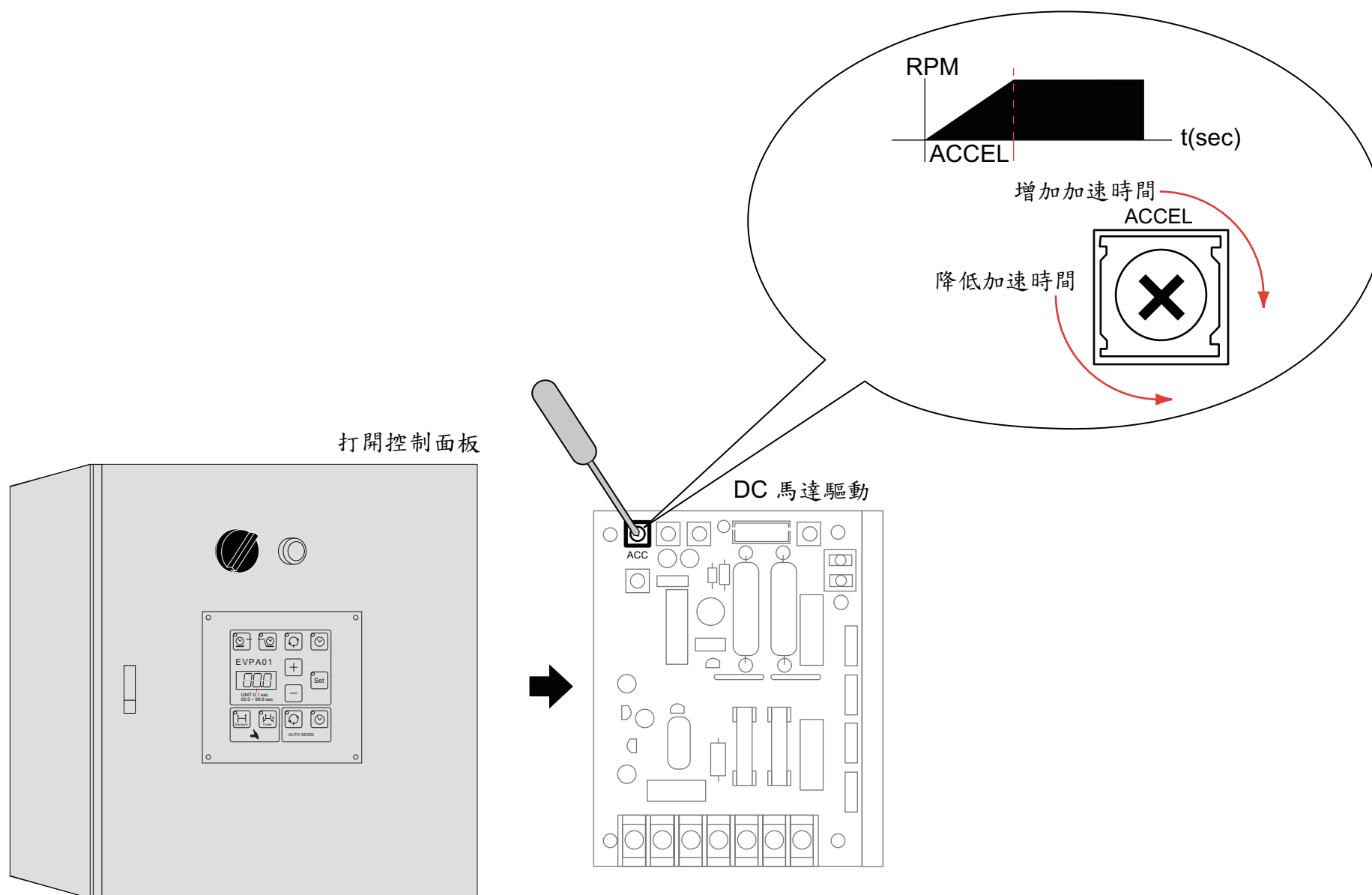
4.24.2 重新啟動



銜接 page 40 動作
I

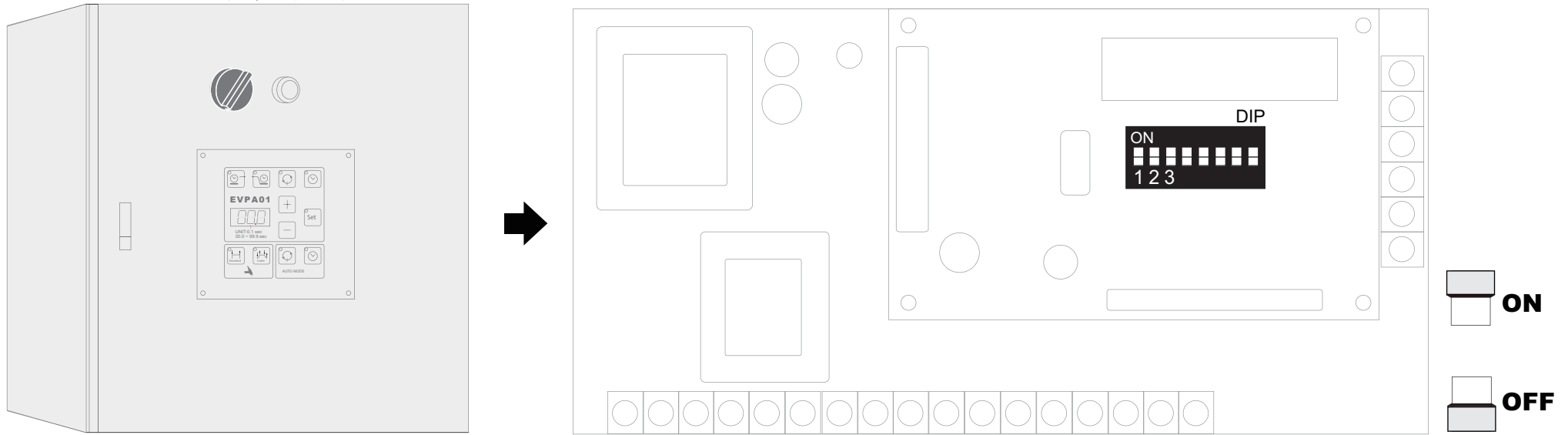
Chapter 5: 設置步驟

5.1 轉盤加速時間



5.2 控制電路板的開關說明

打開控制面板



5.2.1 DIP1 (4 Cycle) Mode



DIP1
ON

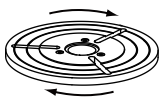
啟動時間



00.2 → 00.0



Run

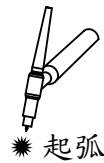


DIP1
OFF

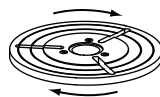
啟動時間



00.2 → 00.0



Run



5.2.2 DIP2 (4 Cycle) Mode

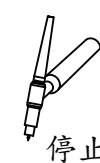


DIP2
ON

起弧時間



03.2 → 00.0



停止

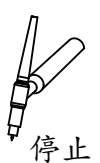


DIP2
OFF

起弧時間



03.2 → 00.0

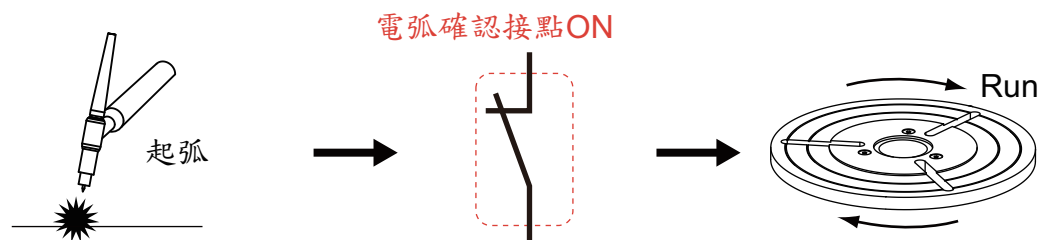
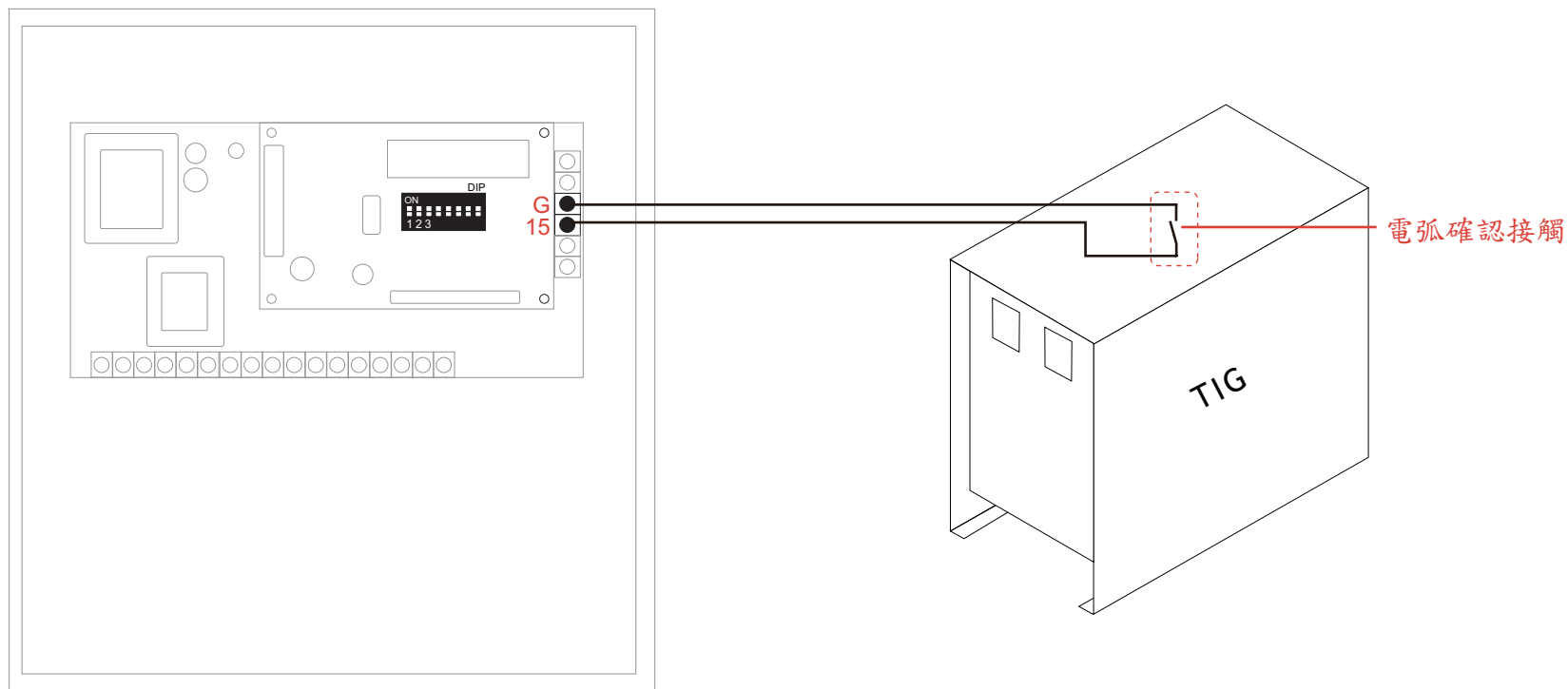


停止



5.2 控制電路板的開關說明

5.2.3 DIP3 ☒ ON (僅使用電力TIG電弧確認接觸)

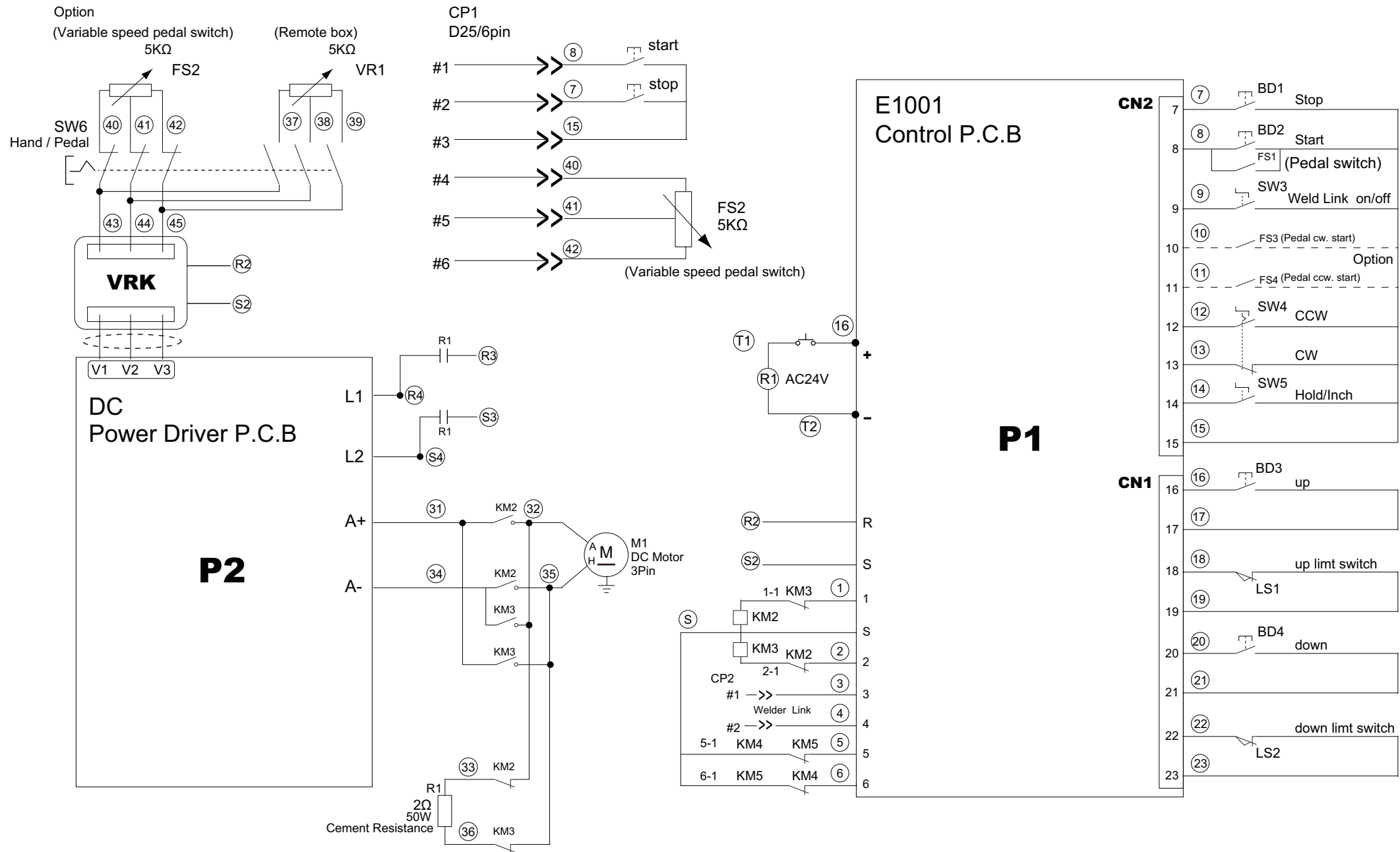


DIP3 ☐ OFF (不接觸)



附錄

線路圖

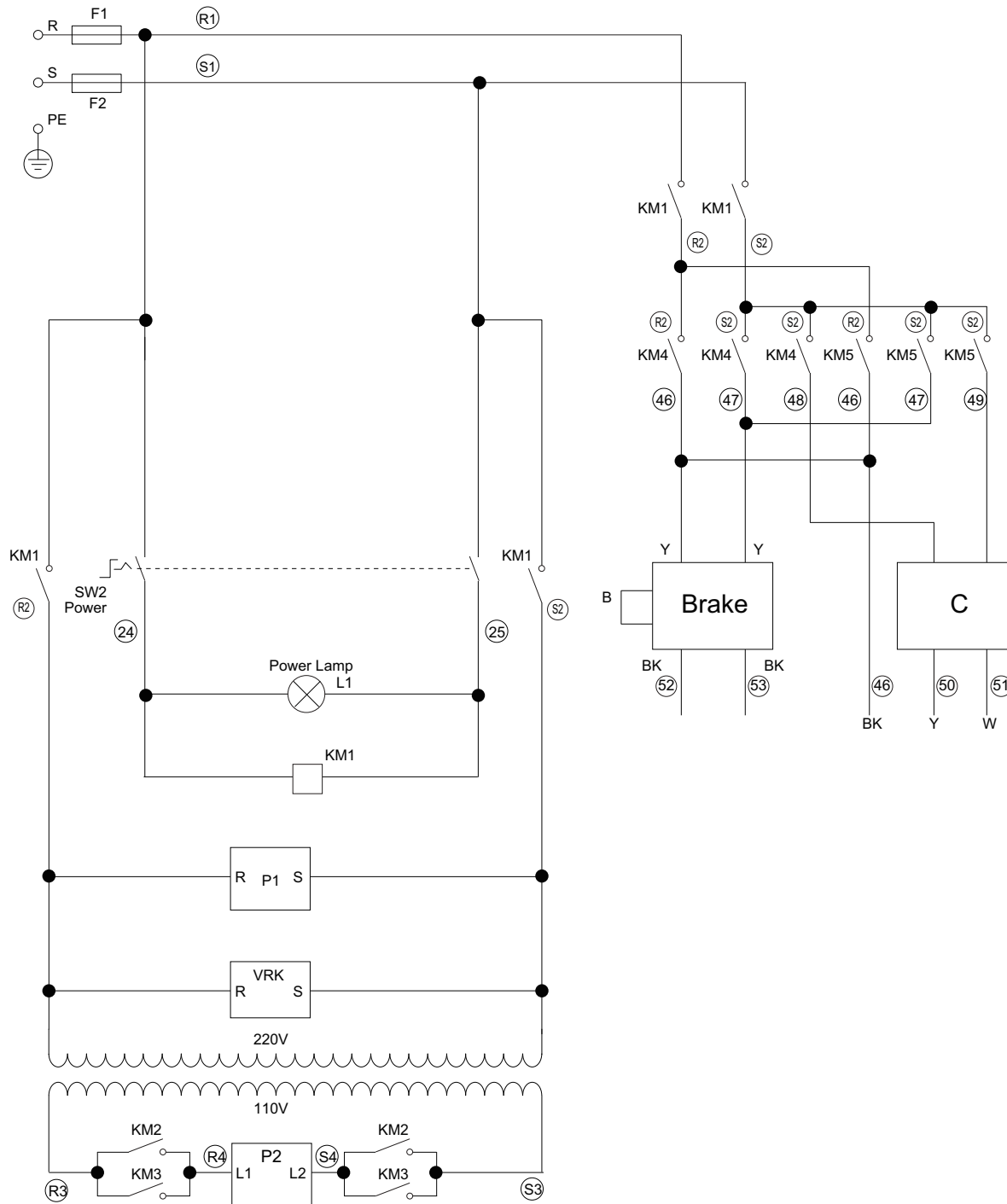


R、S、3、4、7、8、12、13、14、15、16、17、18、19、20、21、22、23、32、35、37、38、39、40、41、42、46、50、51、52、53

EVPOS-300A

AC 220V/1Ø

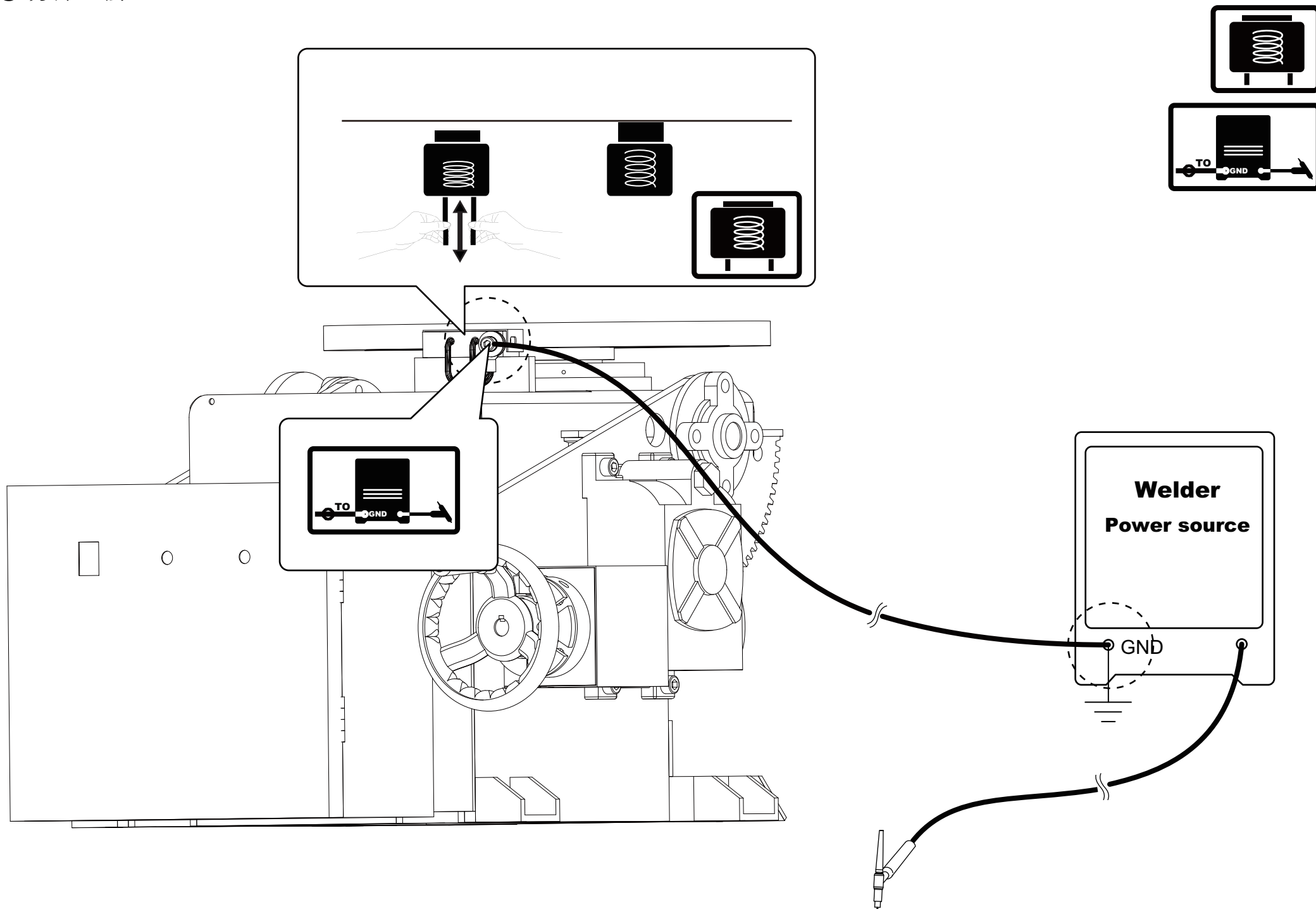
線路圖



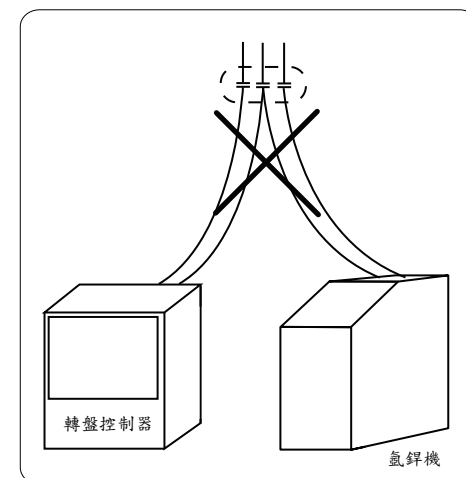
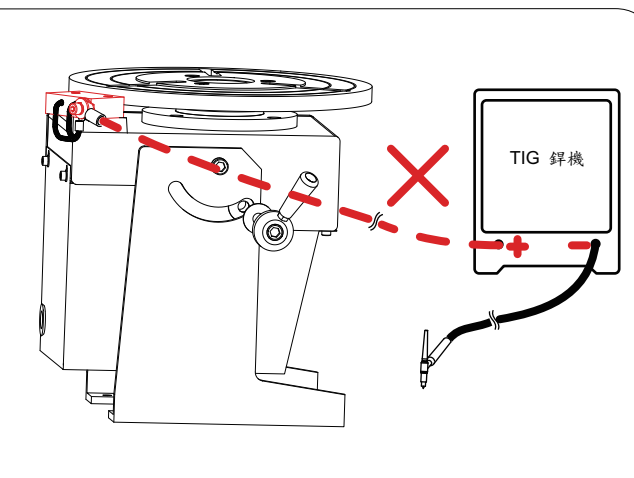
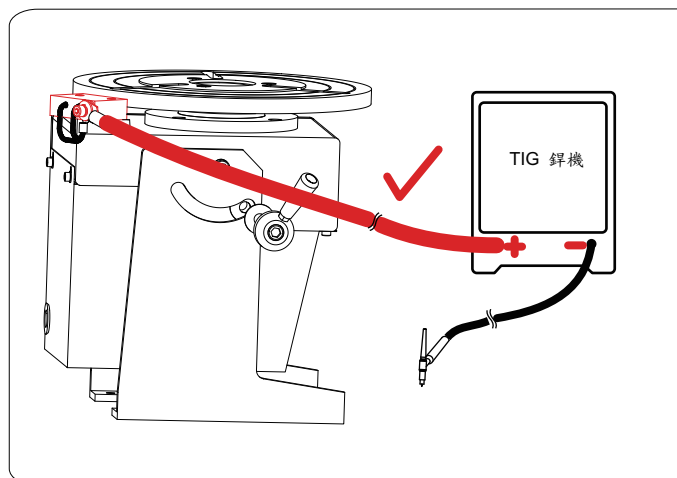
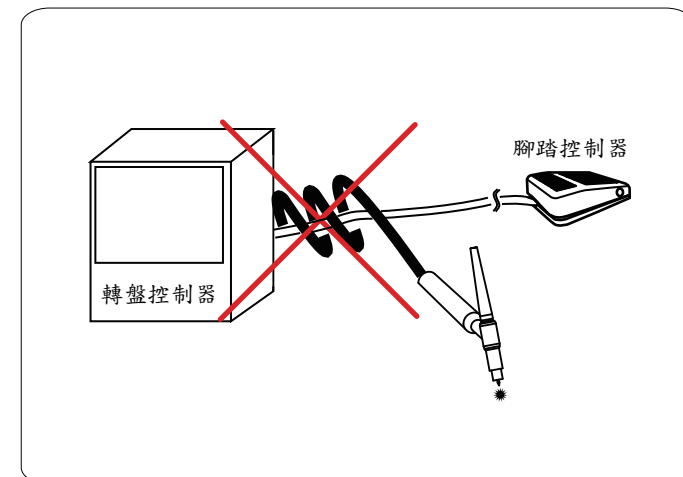
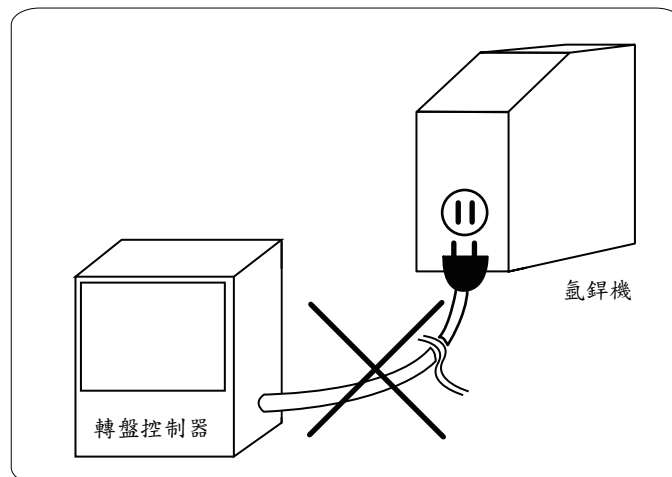
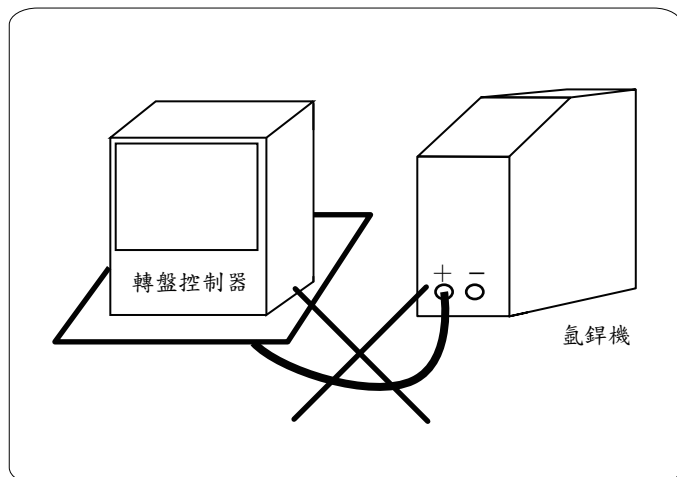
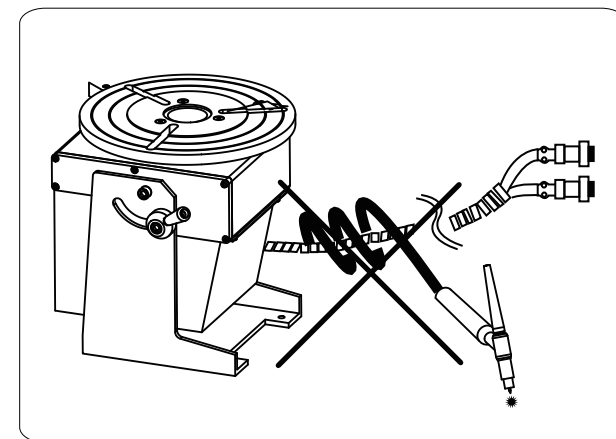
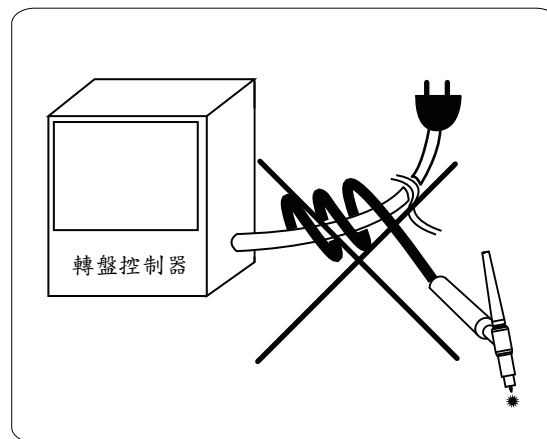
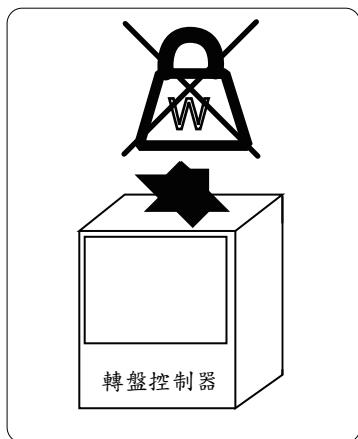
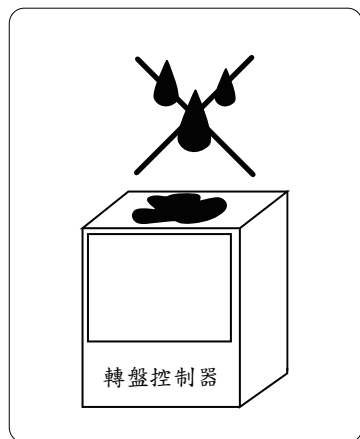
Item	Part No.	Part Name	Q`TY
P1	E1001	Control P.C.B	1
P2	DC220/90V	DC Power driver P.C.B	1
KM1	CU11/220 / 4A	Power Relay	1
KM2	CU11/220 / 4A	Table Power Relay	1
KM2+2B	CUA202 / 2B	Table Power Relay(Additional point)	1
KM3	CU11/220 / 4A	Table Power Relay	1
KM3+2B	CUA202 / 2B	Table Power Relay(Additional point)	1
KM4	CU11/220 / 3A1b	Angle Power Relay	1
KM5	CU11/220 / 3A1b	Angle Power Relay	1
SW2	SW22(2A)	Power	1
SW3	SW22	Welder Link	1
SW4	SW22	CW / CCW	1
SW5	SW22	Inch / Hold	1
SW6	SNAP142	Hand / Pedal Mode	1
DB1	RB22	Stop	1
DB2	RB22	Start	1
DB3	RB22	Up	1
DB4	RB22	Down	1
VR1	PC-VR1	Resistance 5kΩ	1
R	2Ω / 50W	Cement Resistance	1
VRK	VRK01-V2	VR Link P.C.B (AC 230)	1
LS1	TZ-8104	Limit Switch	1
LS2	TZ-8104	Limit Switch	1
M1	DCM-65W9V5GN	DC 65W/90V/5GN Motor	1
M2	5RK90GU	AC 90W;220V/1Ø/Brake Motor	1
FS1	CT-MD2	Pedal Switch	1
FS2	VSPS-101Z(Optional)	Variable speed pedal switch	1

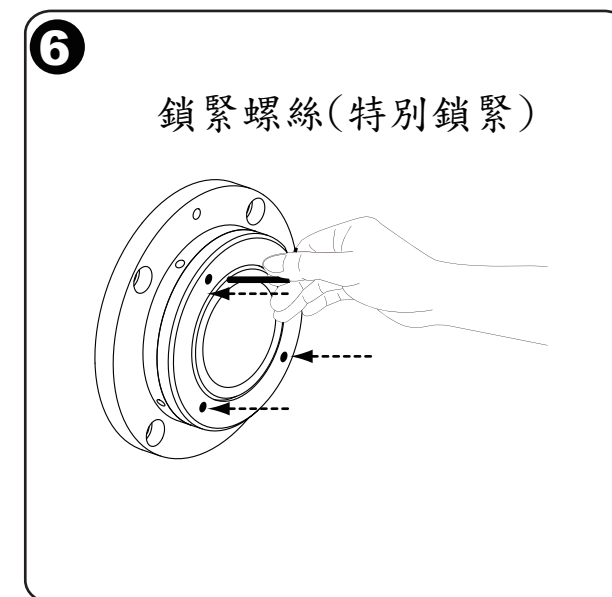
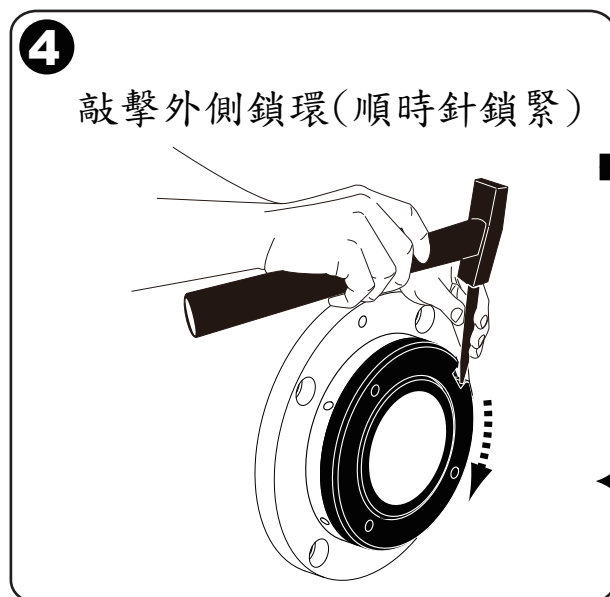
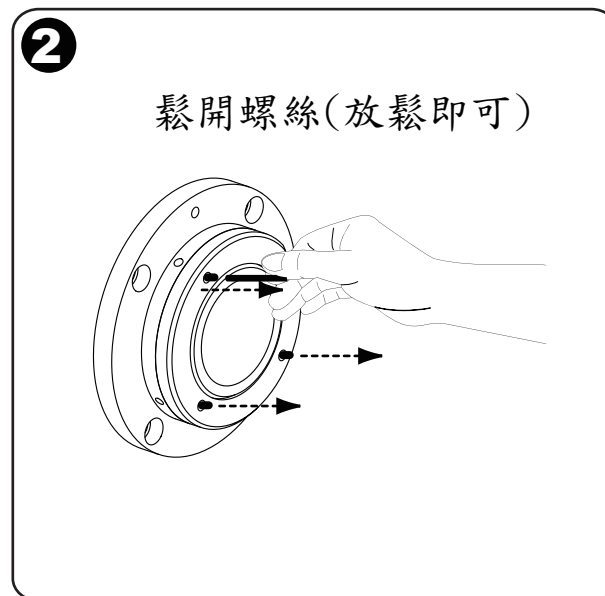
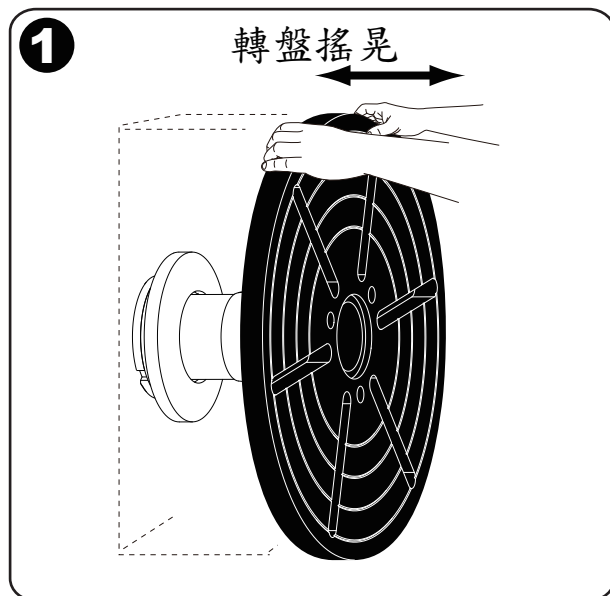
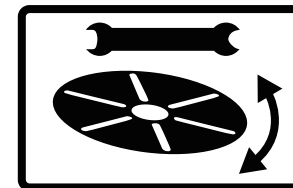
EVPOS-300A
AC 220V/1Ø

注意碳刷及接地



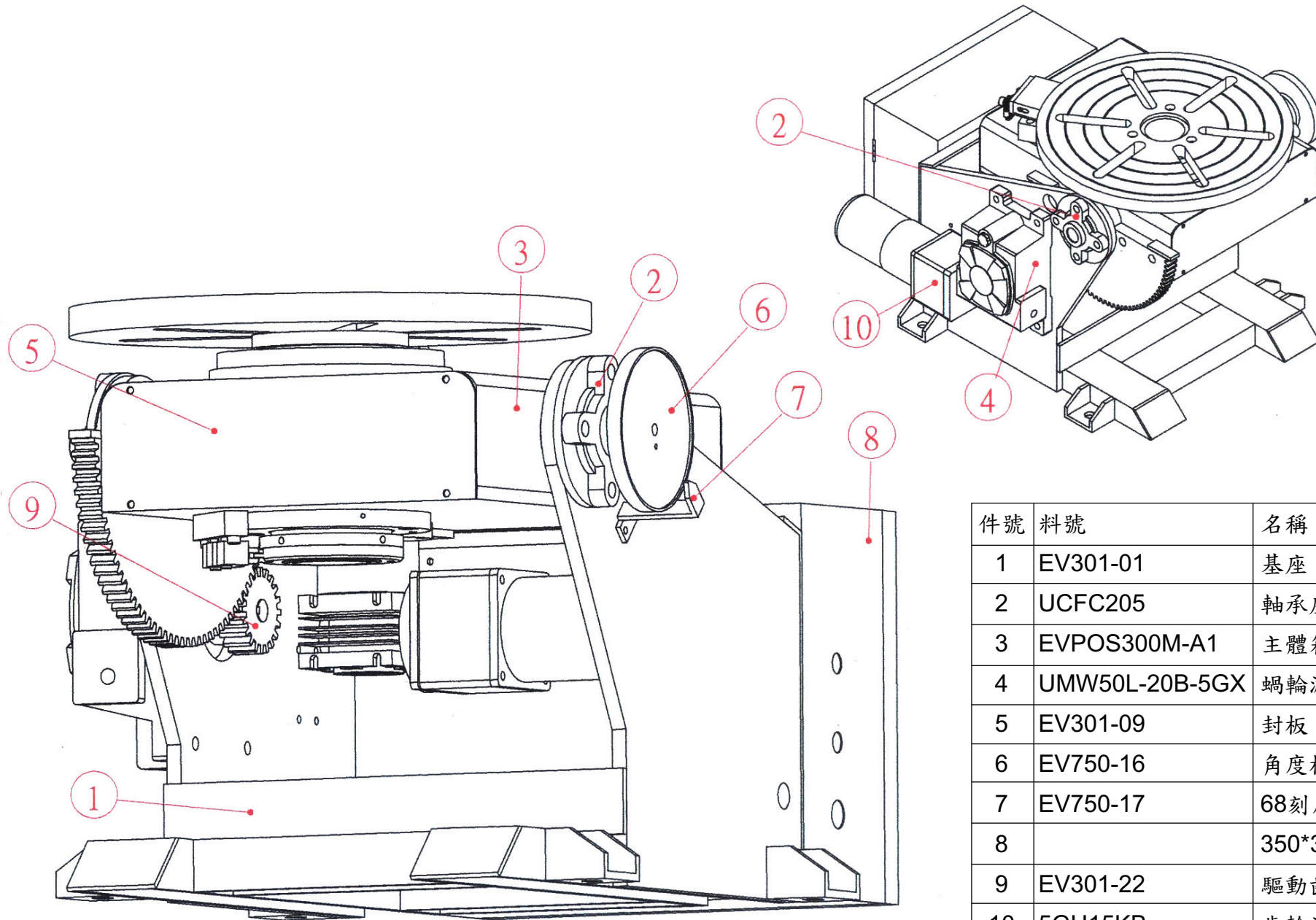
注意事項





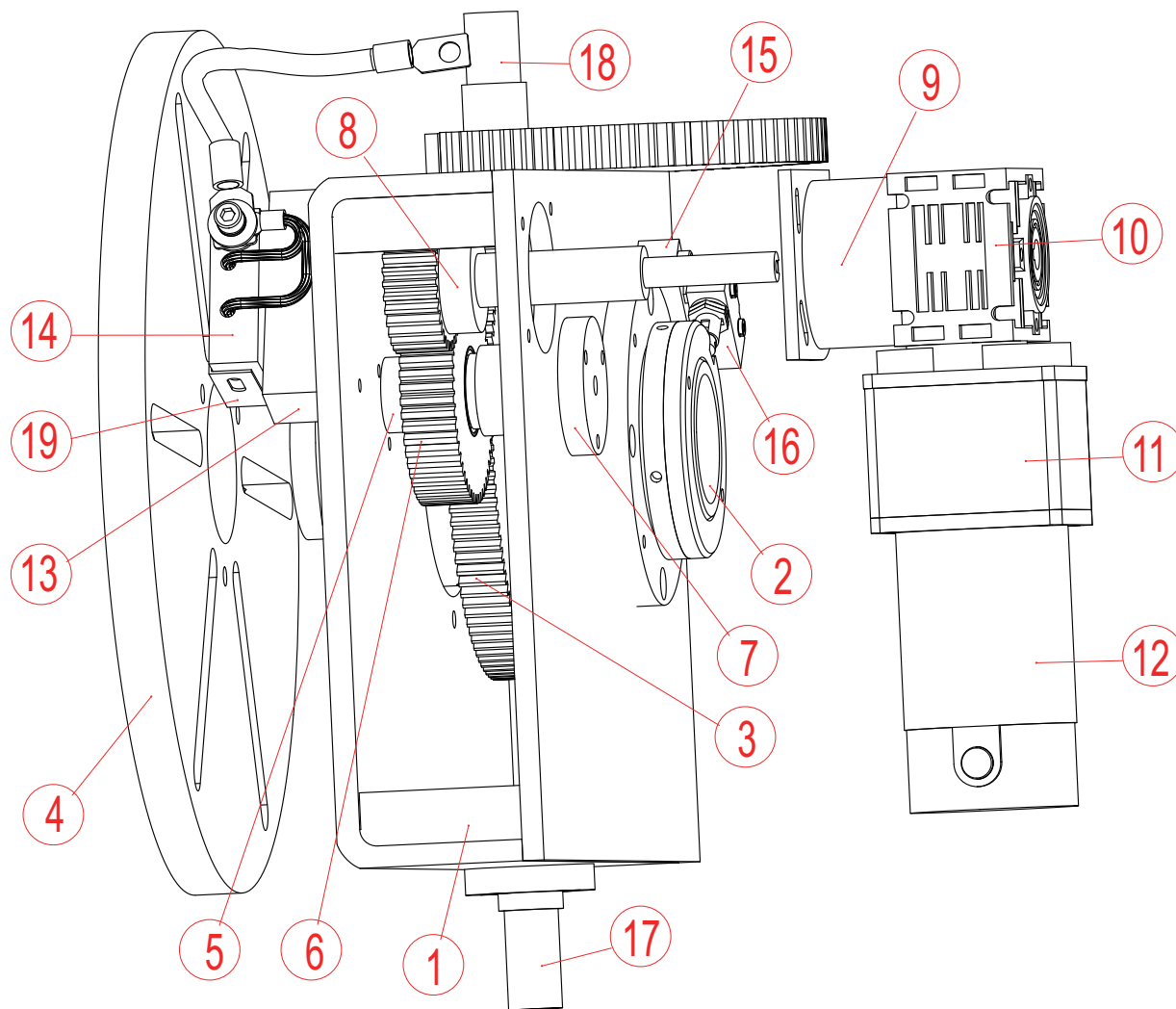
反覆 3-5 次

組合圖



件號	料號	名稱	數量
1	EV301-01	基座	1
2	UCFC205	軸承座	2
3	EVPOS300M-A1	主體箱組合	1
4	UMW50L-20B-5GX	蝸輪減速機	1
5	EV301-09	封板	2
6	EV750-16	角度板	1
7	EV750-17	68刻度指針	1
8		350*300控制箱	1
9	EV301-22	驅動齒輪	1
10	5GU15KB	齒輪減速機	1

組合圖



件號	料號	名稱	數量
1	EV301-02	主體齒輪組	1
2	P100A1-1	主軸總成	1
3	EV301-04	主齒輪	1
4	EV301-03	平盤	1
5	EV301-05	惰輪軸	1
6	EV301-06	惰齒輪	1
7	EV301-07	惰輪襯套	1
8	EV301-08	傳動齒輪	1
9	P120D-14	減速機固定座	1
10	FO32	蝸輪減速機	1
11		5GN減速機	1
12	DC65W	直流馬達	1
13	EV301-11	加高塊	1
14	P100A2	接地銅座組	1
15	P1010	微動塊	1
16	TM1308	微動開關	1
17	EV301-13	轉位軸心	1
18	EV301-12	加長轉位軸心	1
19	P1008-4	202銅座護蓋	1