



操作手冊

EVPOS-3TACA 銲接定位器

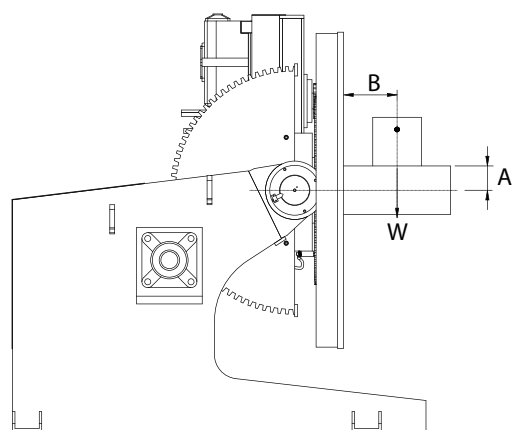


Chapter 1: 諸元

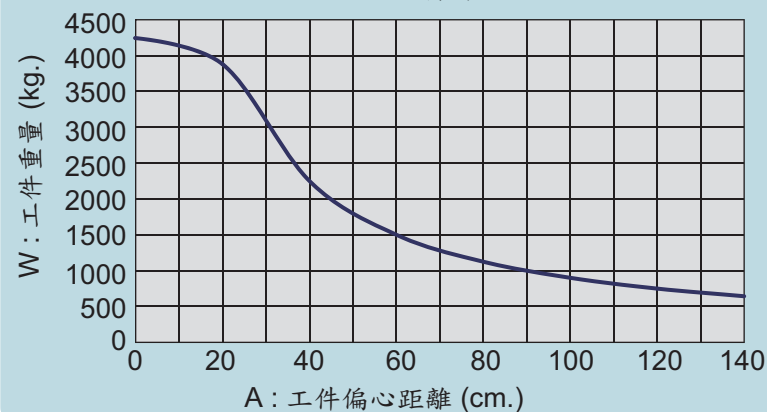
1.1 諸元



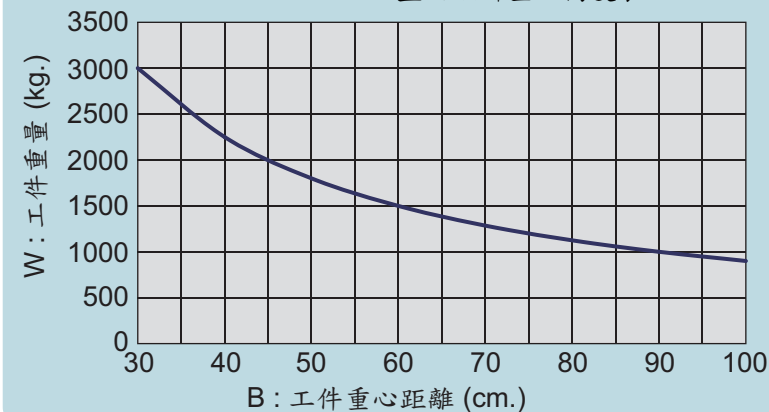
型號	EVPOS-3TACA
入力電源	V1:AC 220V / 30A / 50;60Hz / 3Ø V2:AC 380V / 25A / 50Hz / 3Ø
轉盤馬達	AC 2HP
偏心承載荷重(W)	3000Kg.
旋轉荷重偏心距(A)	300mm.
盤面傾斜重心高(B)	300mm.
盤面直徑	1300mm.
軸心孔徑	120mm.
盤面轉數	0.03~0.3 RPM
盤面傾斜角度	0° - 135°
盤面傾斜速度	58 秒 / 135°
盤面傾斜馬達	AC 2HP
盤面傾斜安全鎖	強制煞車
接地效率	1000A / 100%
盤面啟動	腳踏開關(4M長)
操作模式	寸動 / 自保持
控制操作	有線控制器(4M長)
銲機啟動模式	☐ 標準(二週期)
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)
接地效率	1000A / 100%
盤面啟動	腳踏開關(4M長)
控制操作	有線控制器(4M長)



EVPOS-3TACA 旋轉荷重偏心距離表



EVPOS-3TACA 盤面傾斜重心高度表



1.1 諸元

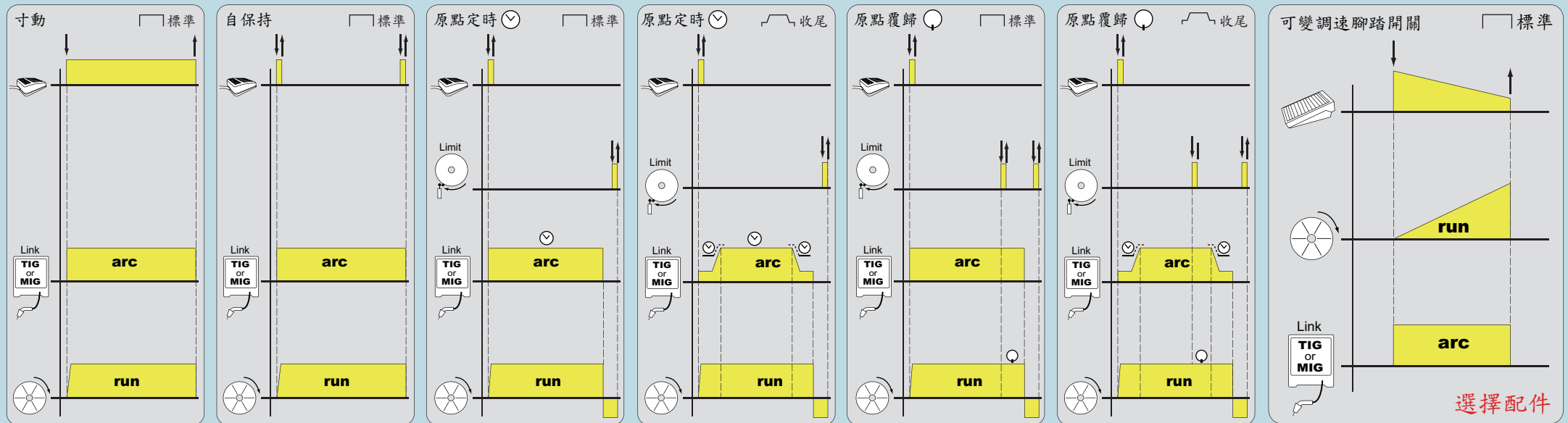


選擇性配件



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

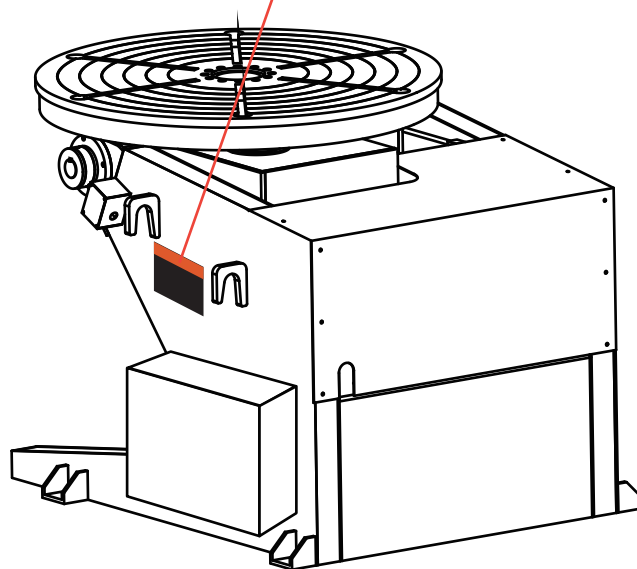
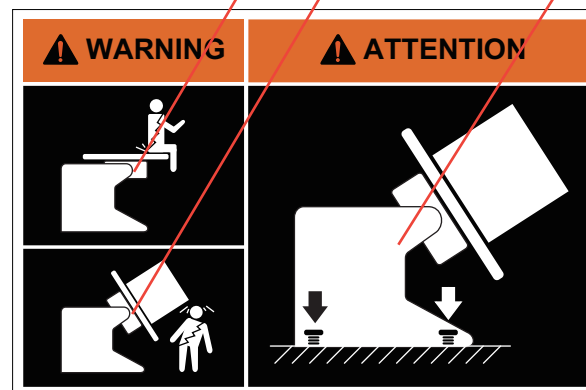
2.1.1.4 不遵守注意事項，將可能導致操作人員受傷，或者機器損壞的部件和/或控制。

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。



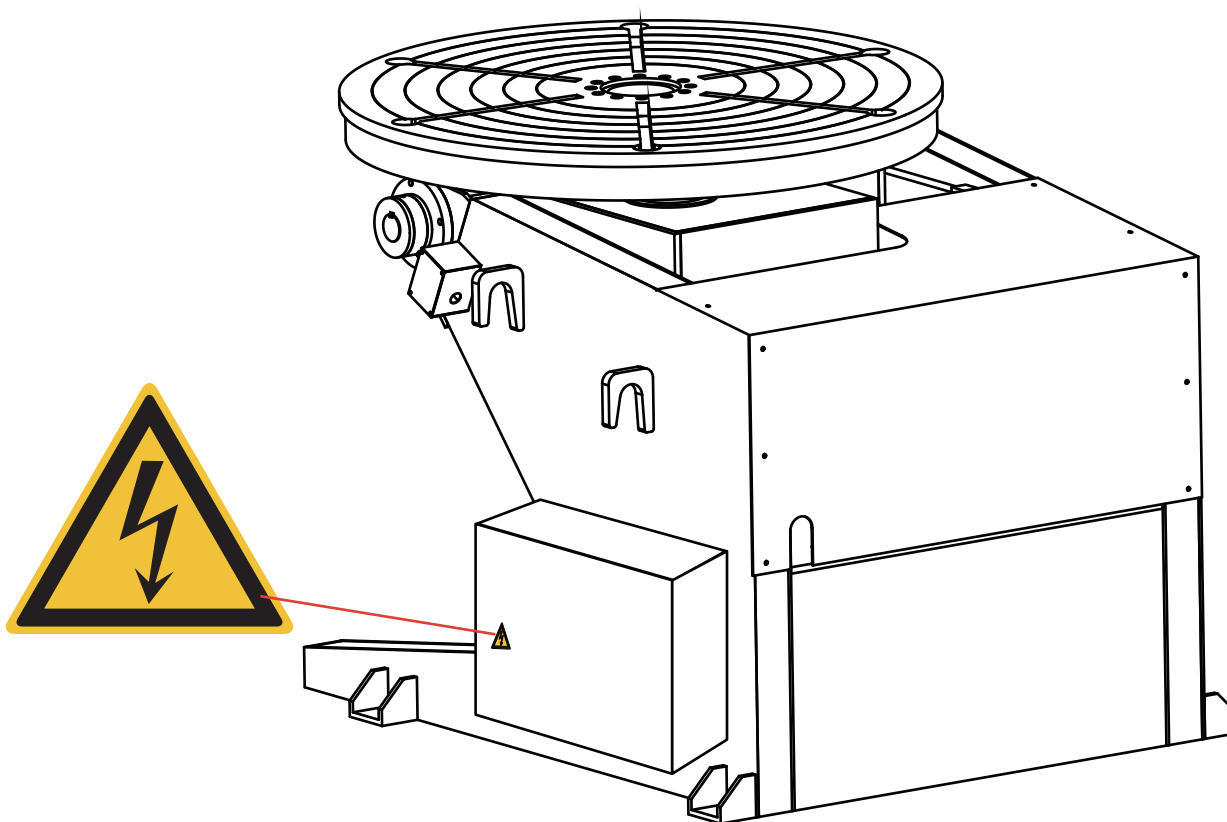
2.3 電氣危險和高溫



電氣危險



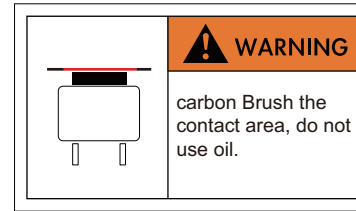
高溫請勿觸摸



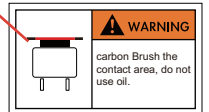
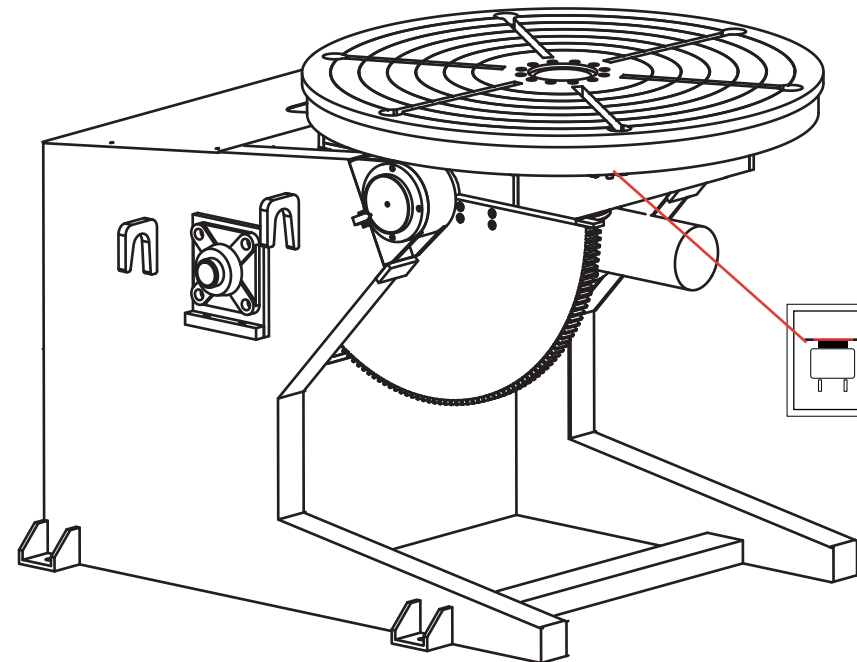
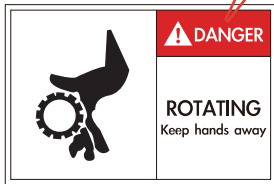
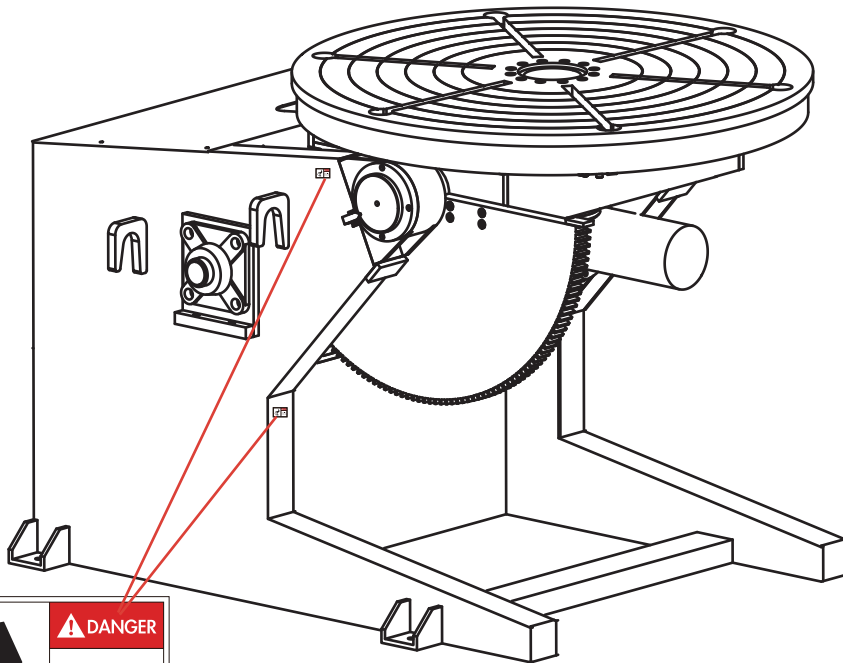
2.4 旋轉及其它



旋轉運作時讓手遠離

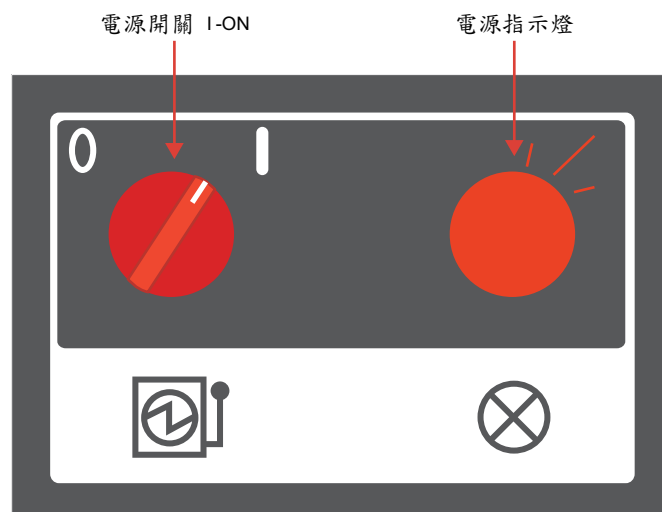
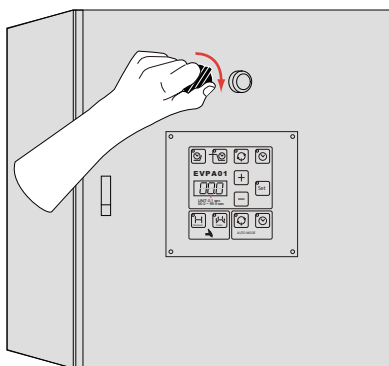


—碳刷接觸面積，不使用油。

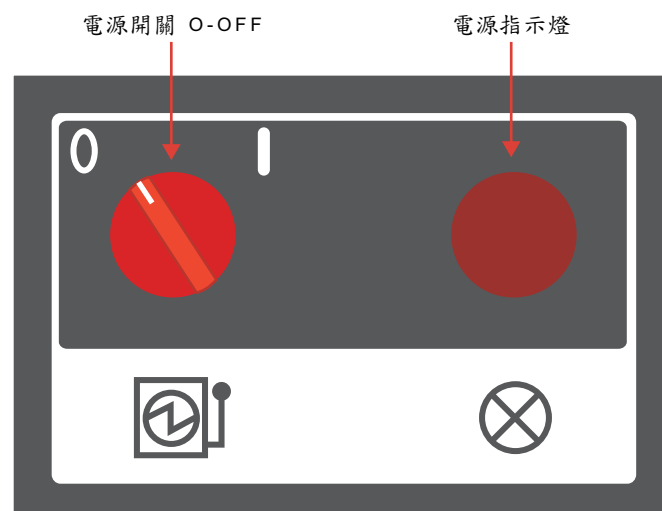
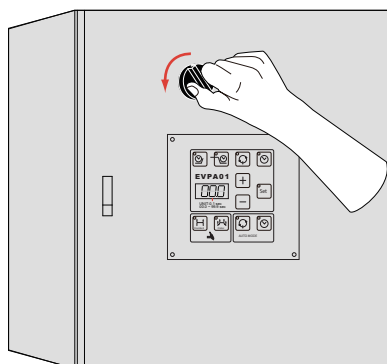


2.5 電源

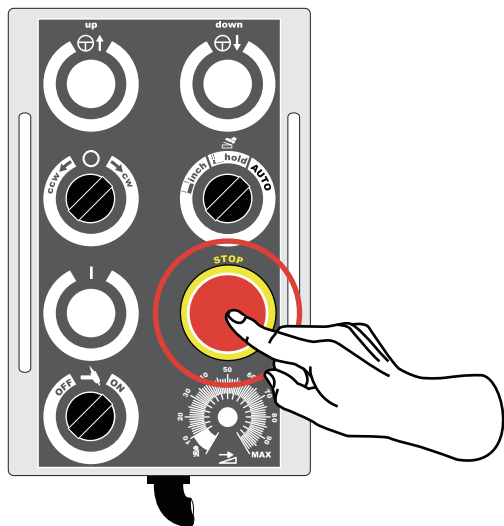
2.5.1 電源 ON



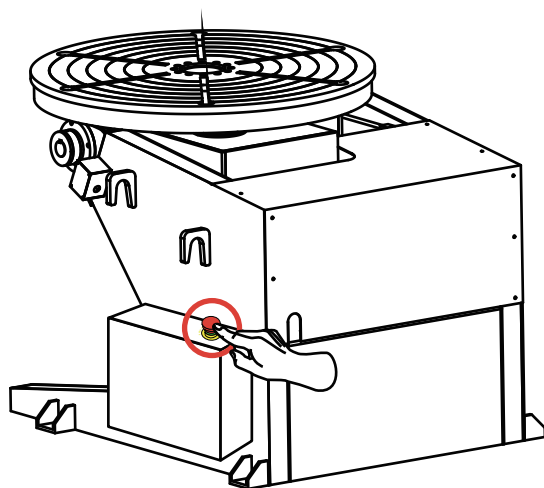
2.5.2 電源 OFF



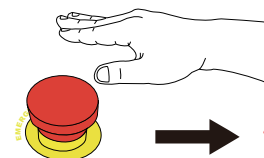
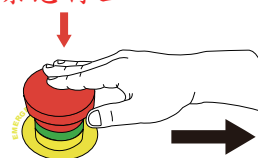
2.6 停止



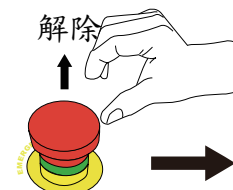
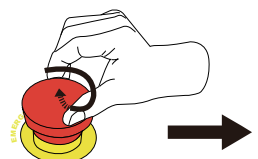
2.6.1 緊急停止



緊急停止

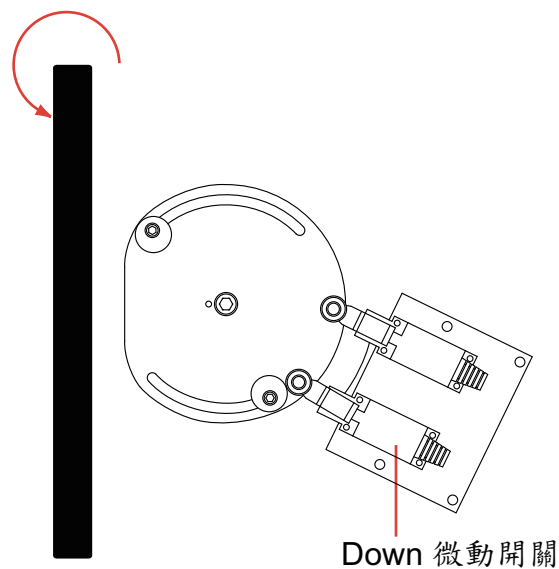
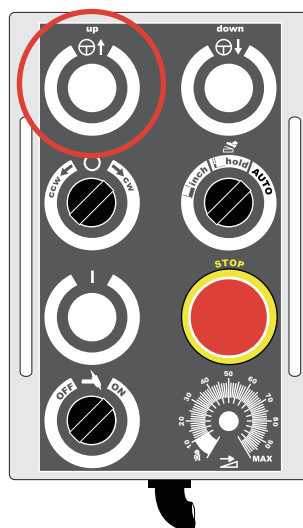
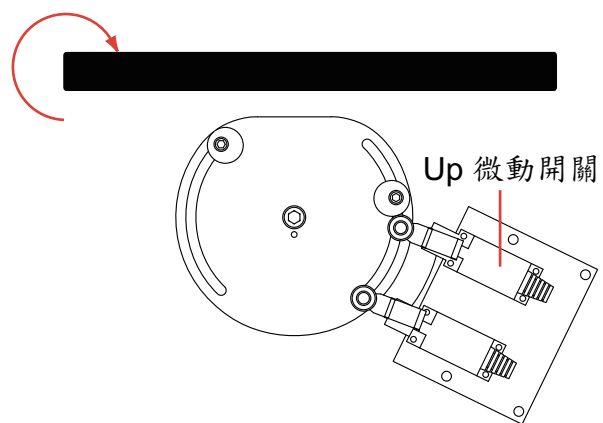
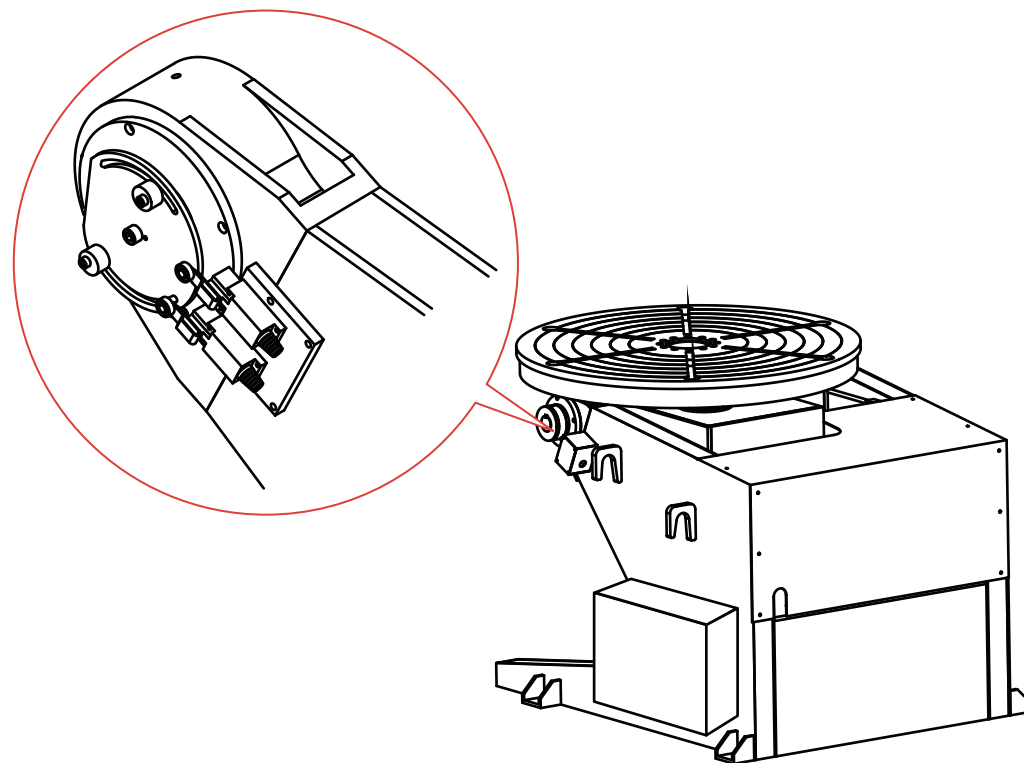
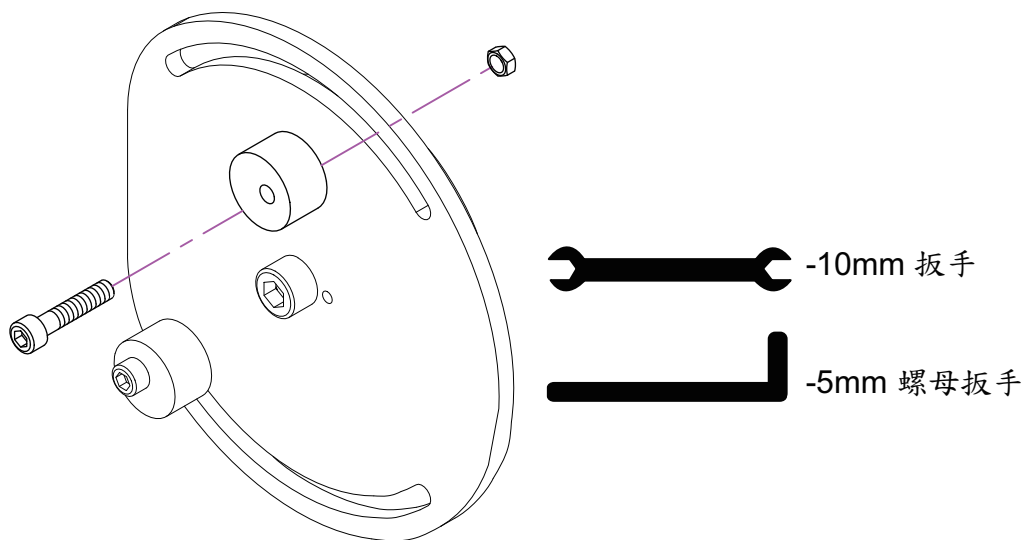


電源跟所有動作強制關閉

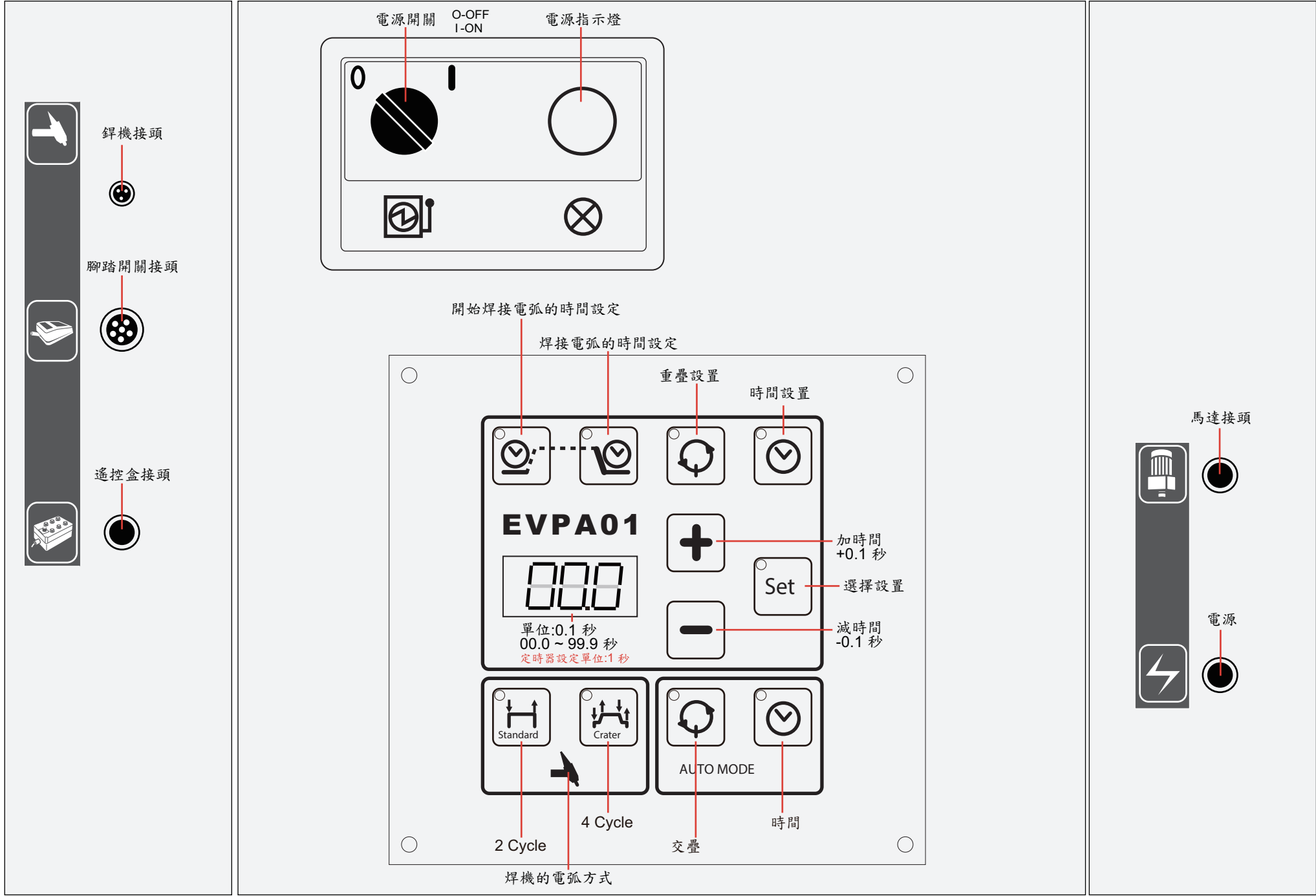


解除
電源以及動作重新啟動

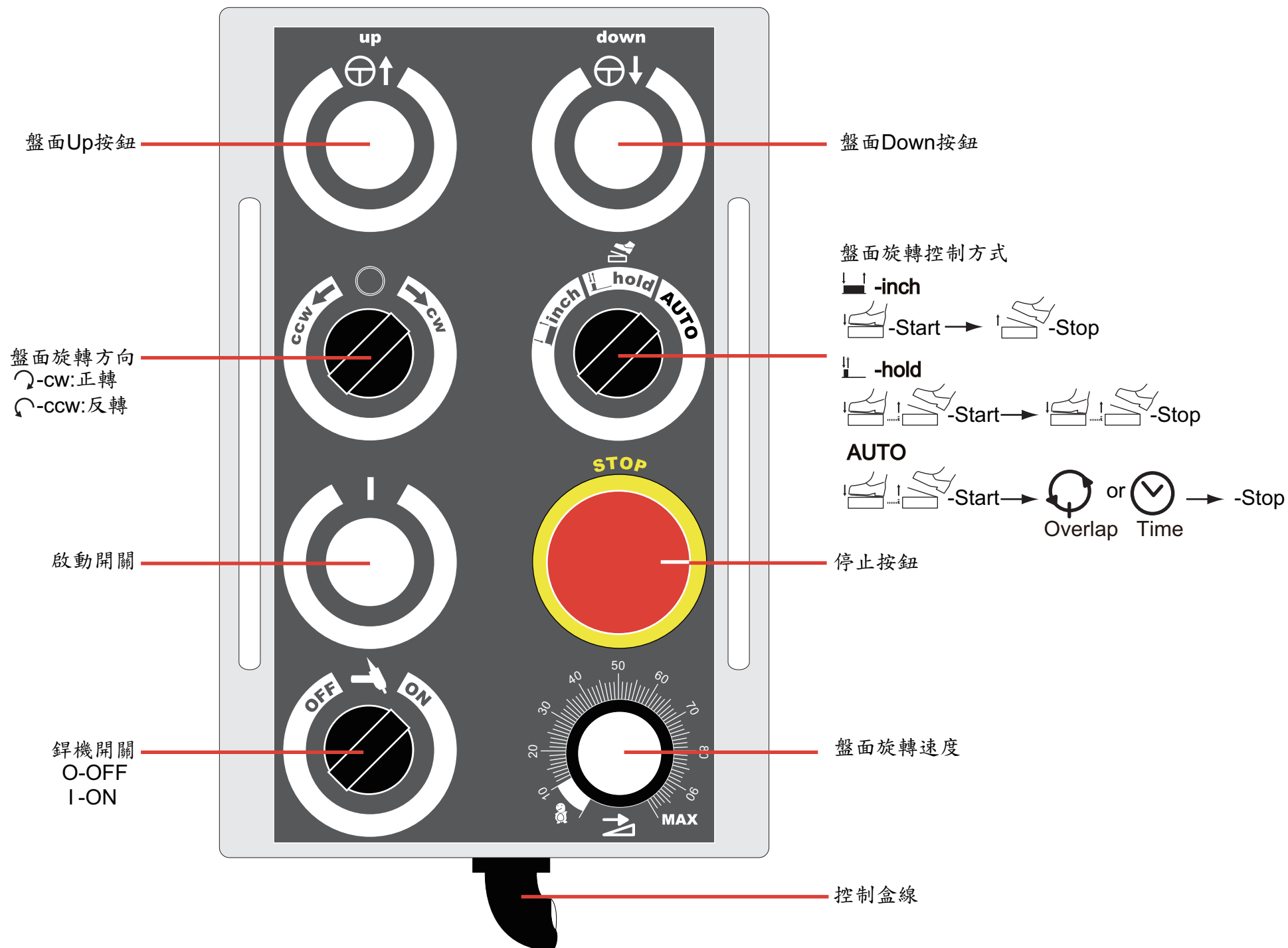
2.7 角度傳感器



2.8 控制箱



2.9 控制盒

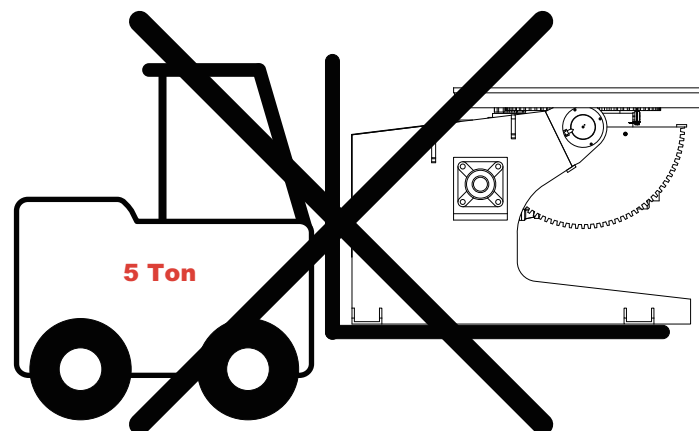
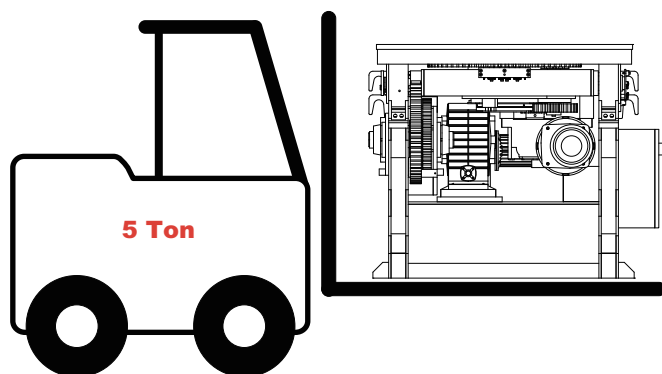
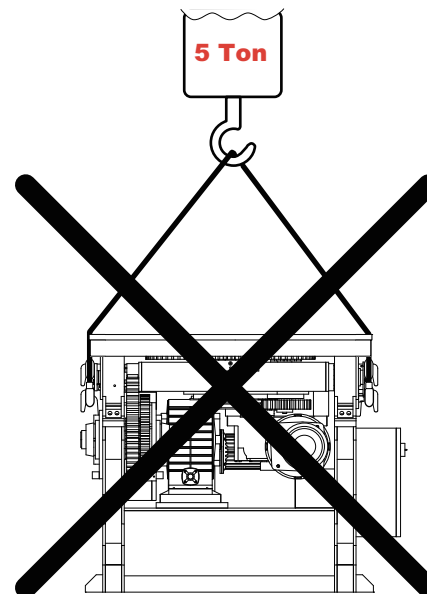
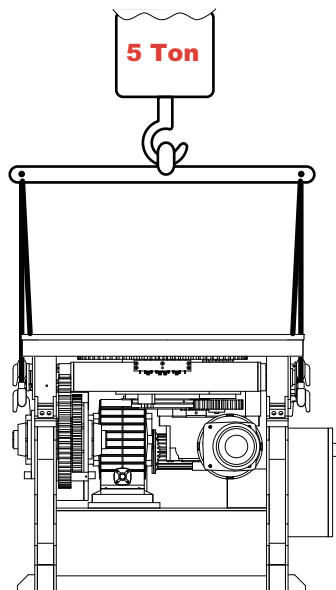


Chapter 3: 安裝說明

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

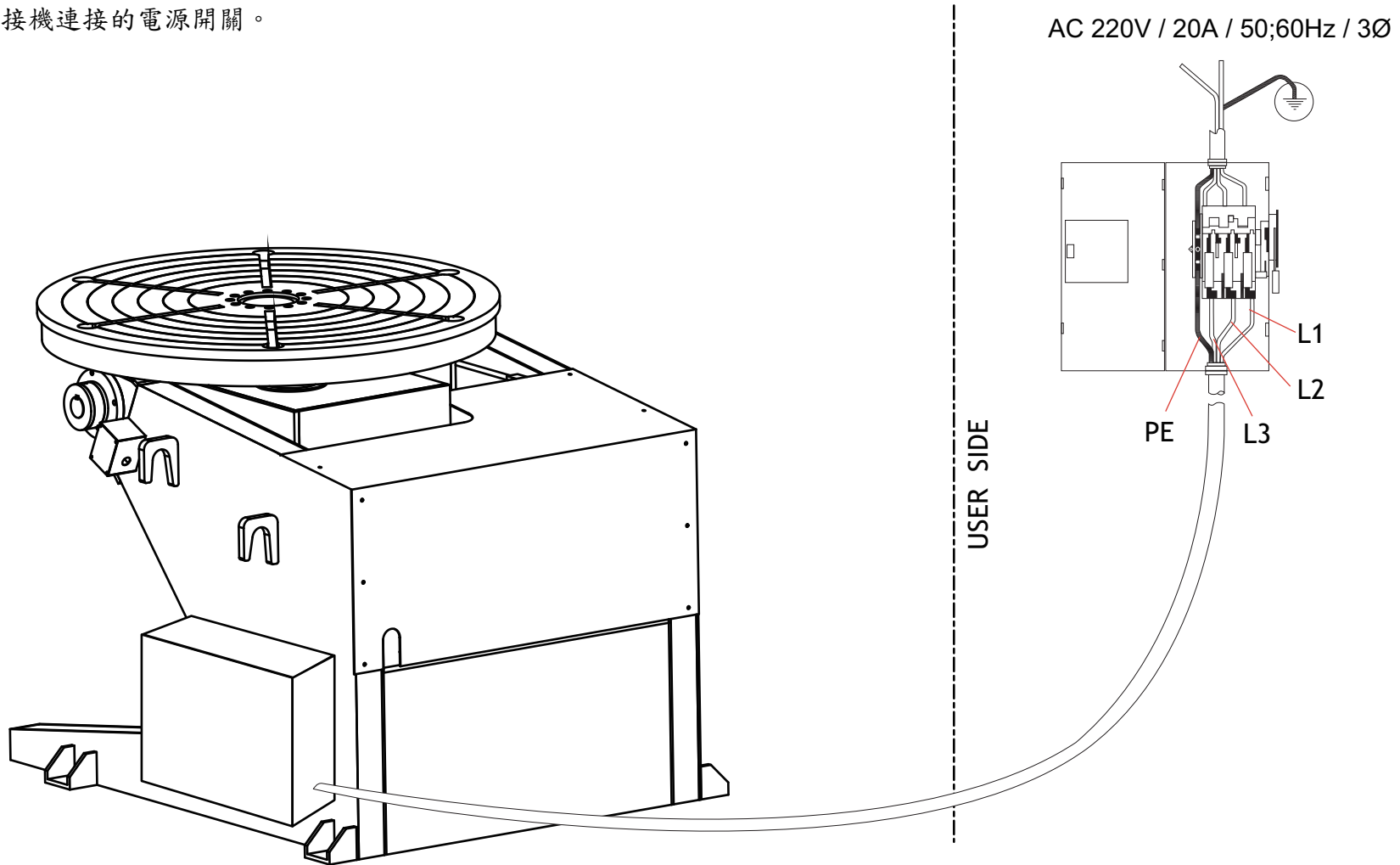
3.2.1 電源為AC 220V/20A/50;60Hz/3Ø與具有接地線路上。

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。

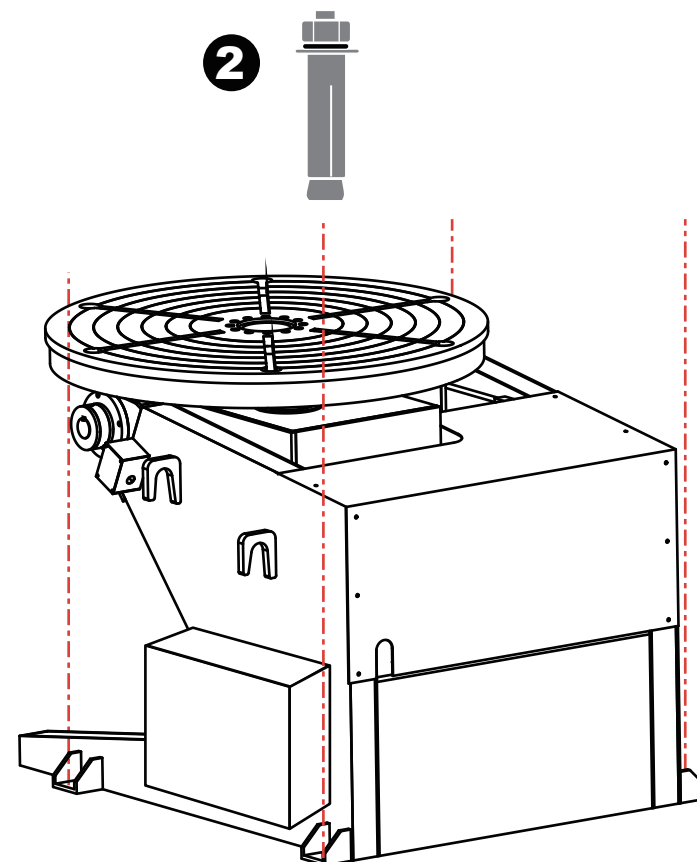
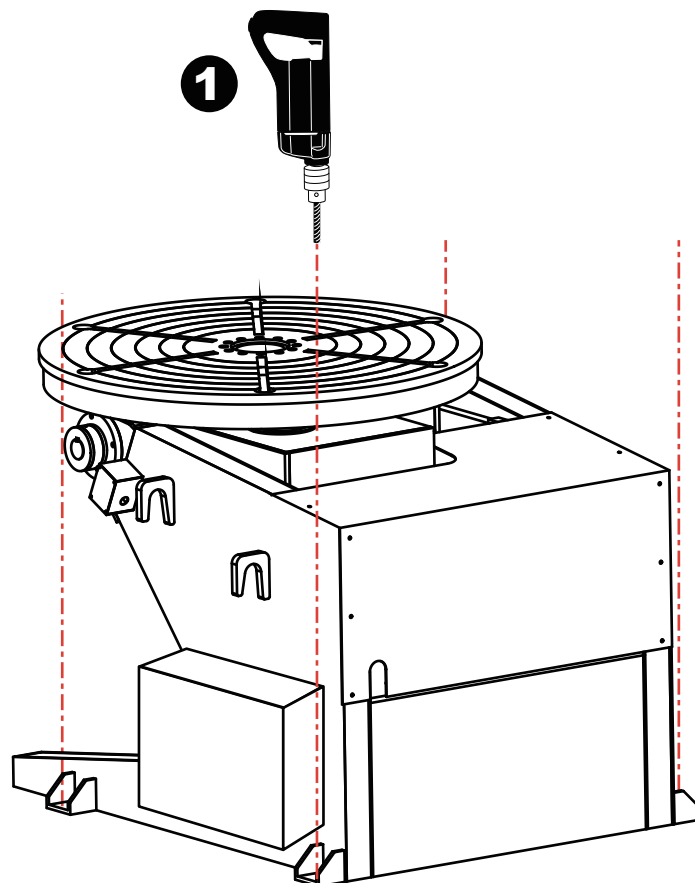


3.3 機械固定安裝

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。

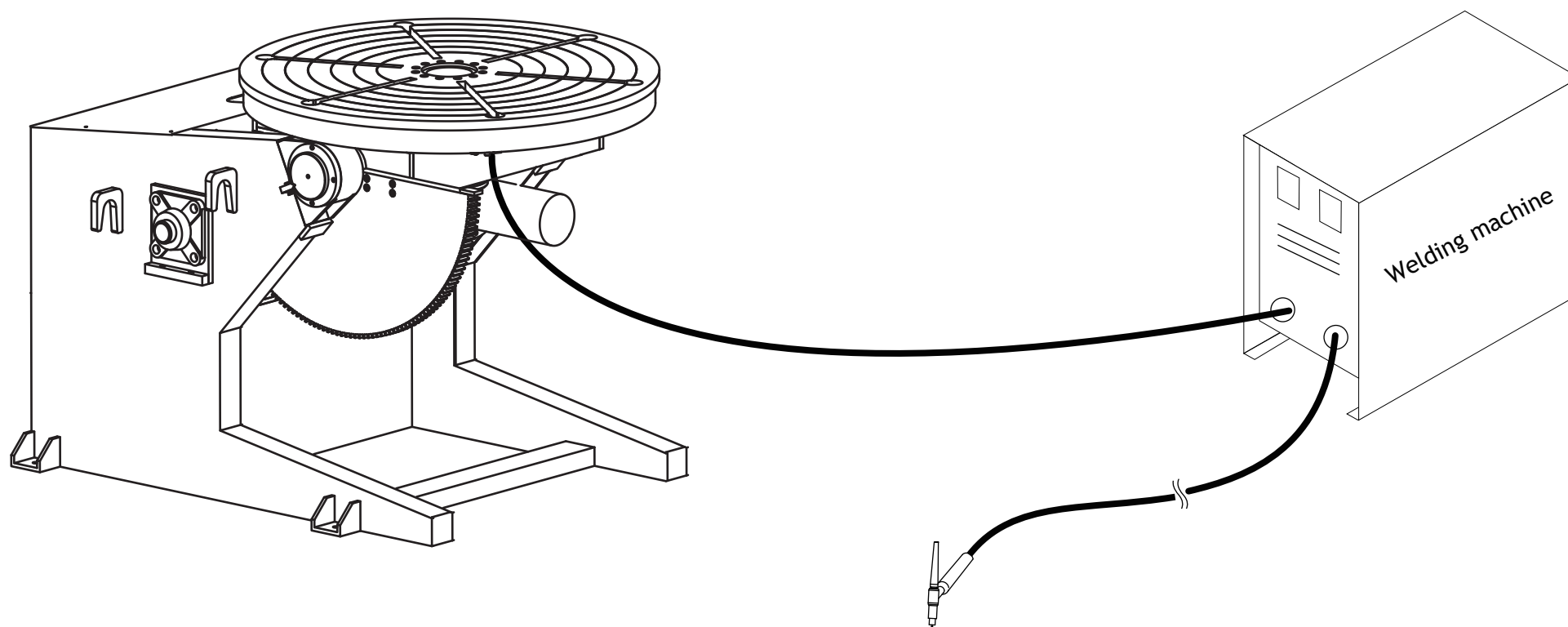
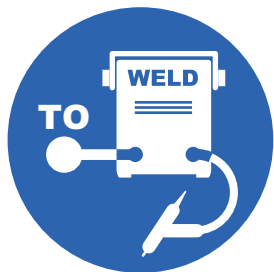


		
300MCA	M12x40mm	M14
500MCA	M12x40mm	M14
750MCA	M12x40mm	M14



3.4 銑機接地

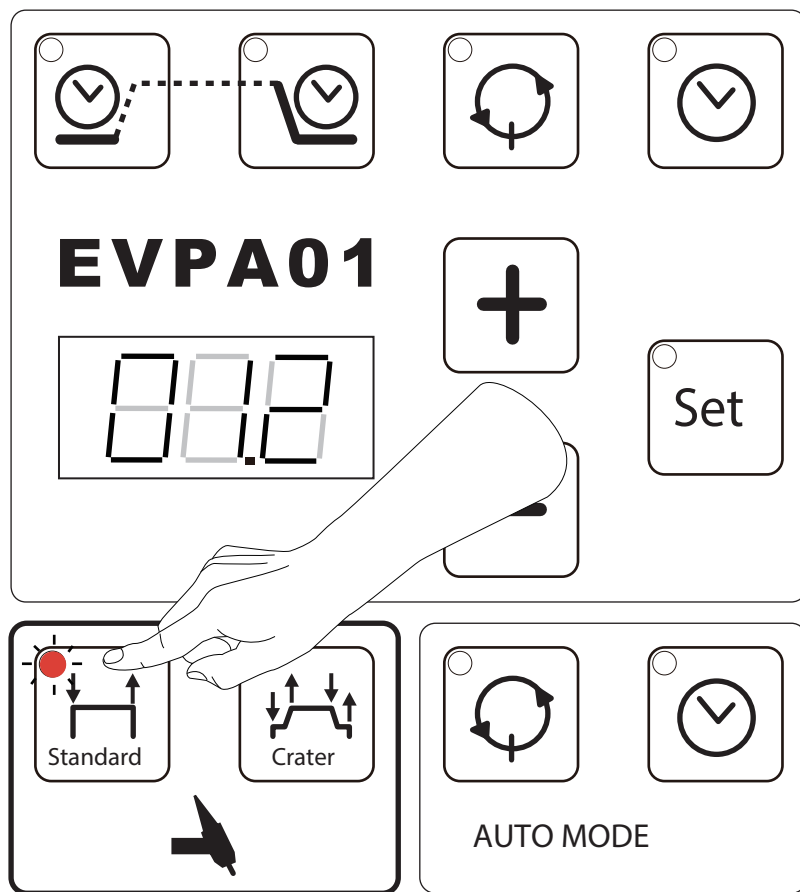
3.4.1 請鎖定電纜，電焊機接觸，破刷牢固。



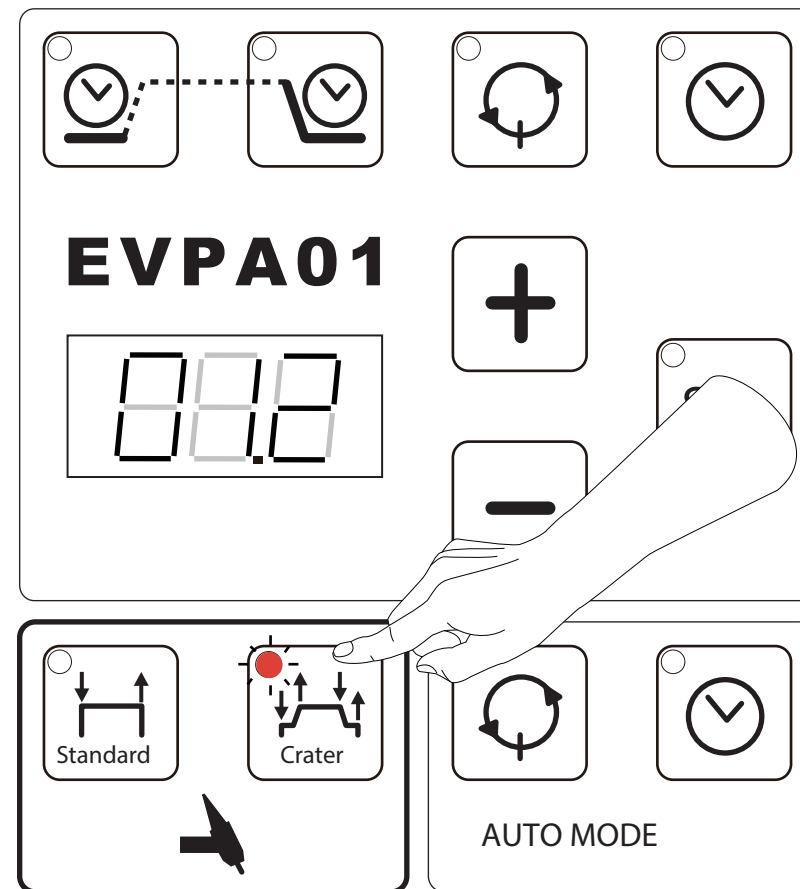
Chapter 4: 手動操作

4.1 電弧方式的鐸機

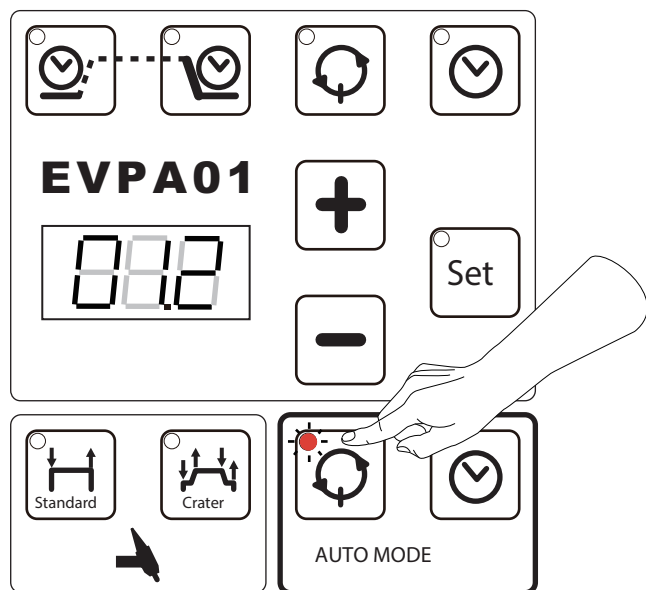
2T(2 CYCLE)



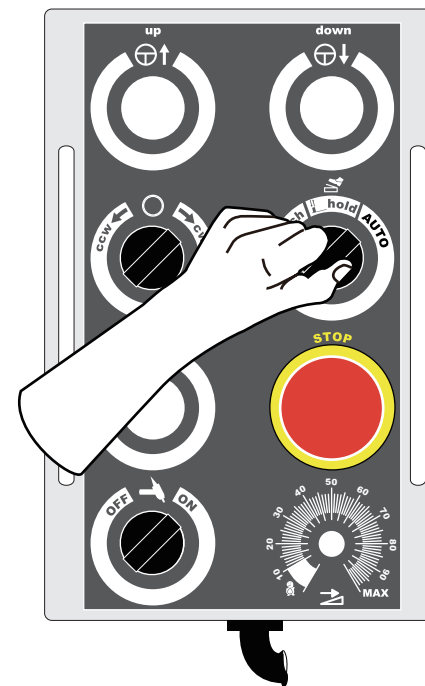
4T(4 CYCLE)



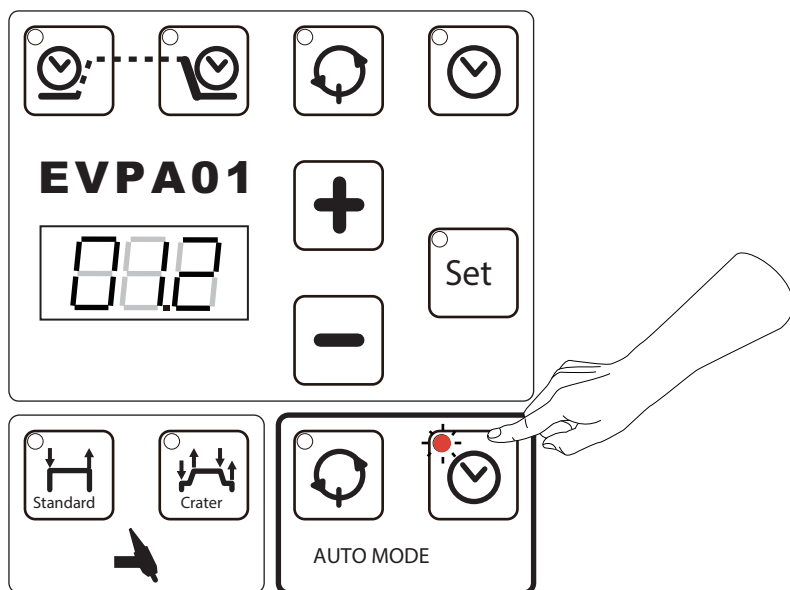
4.2 重疊自動模式



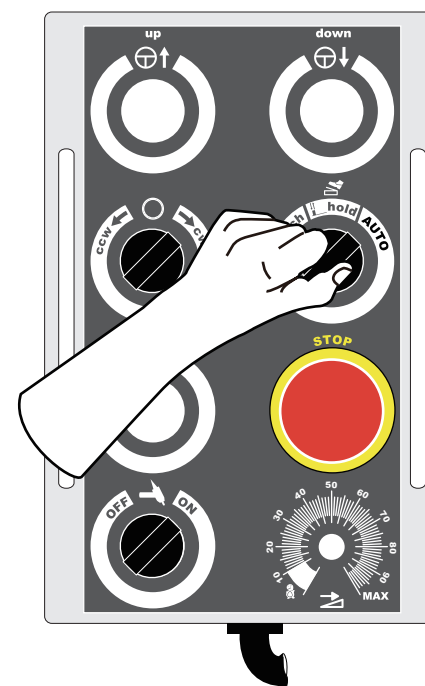
AND



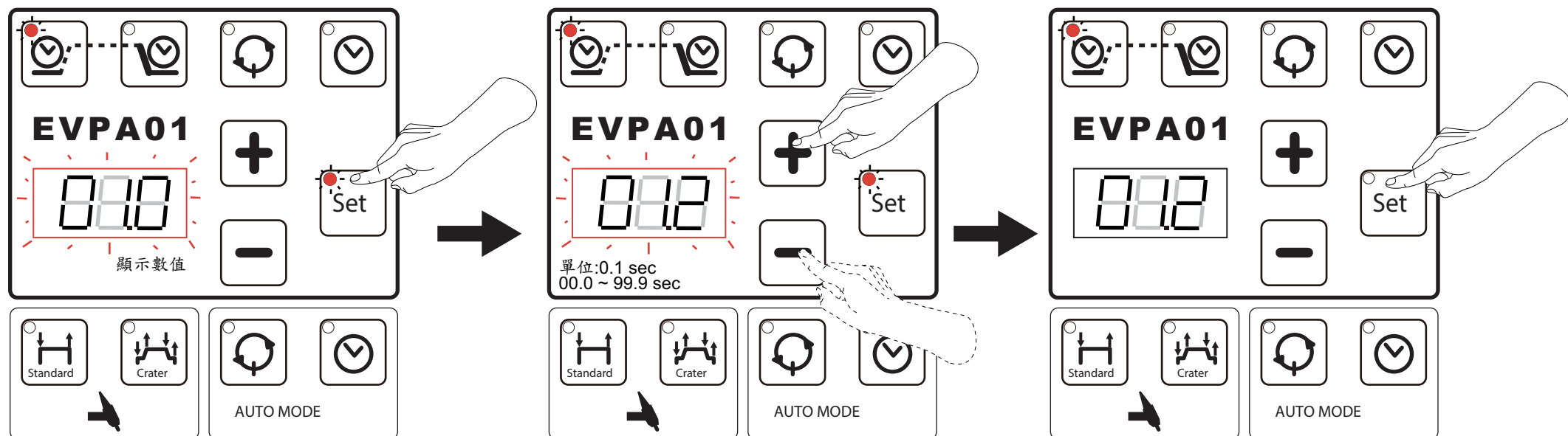
4.3 定時器自動模式



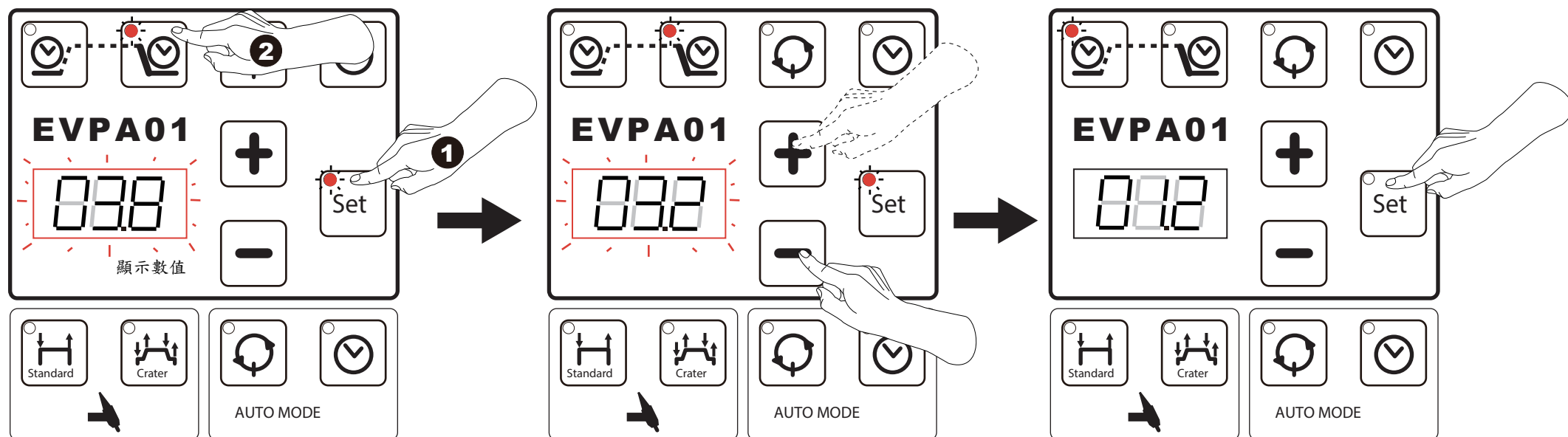
AND



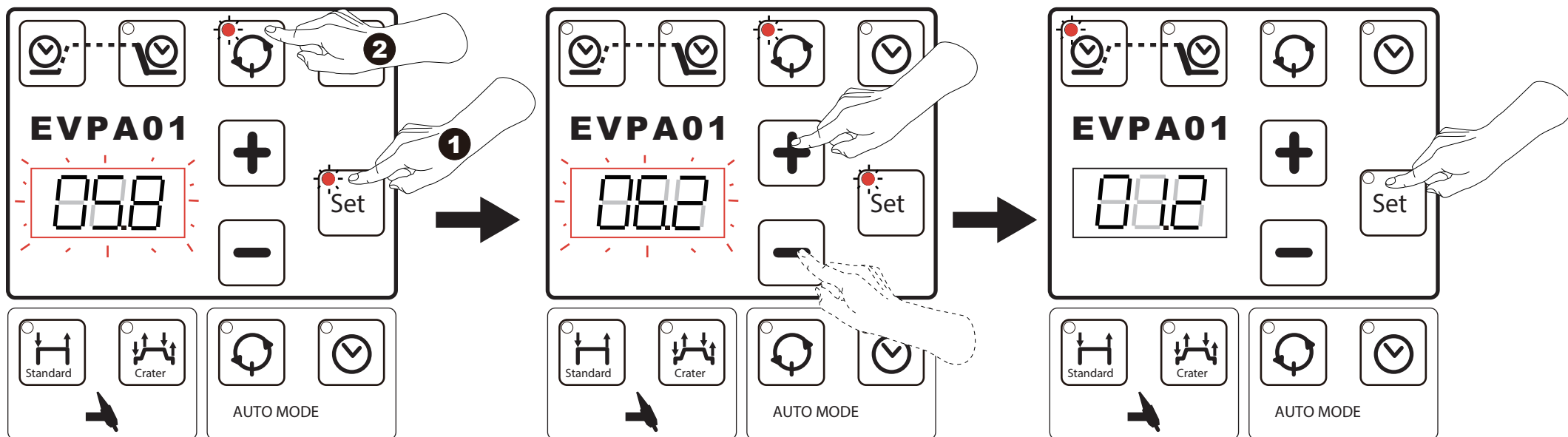
4.4 電弧路的開始時間設置



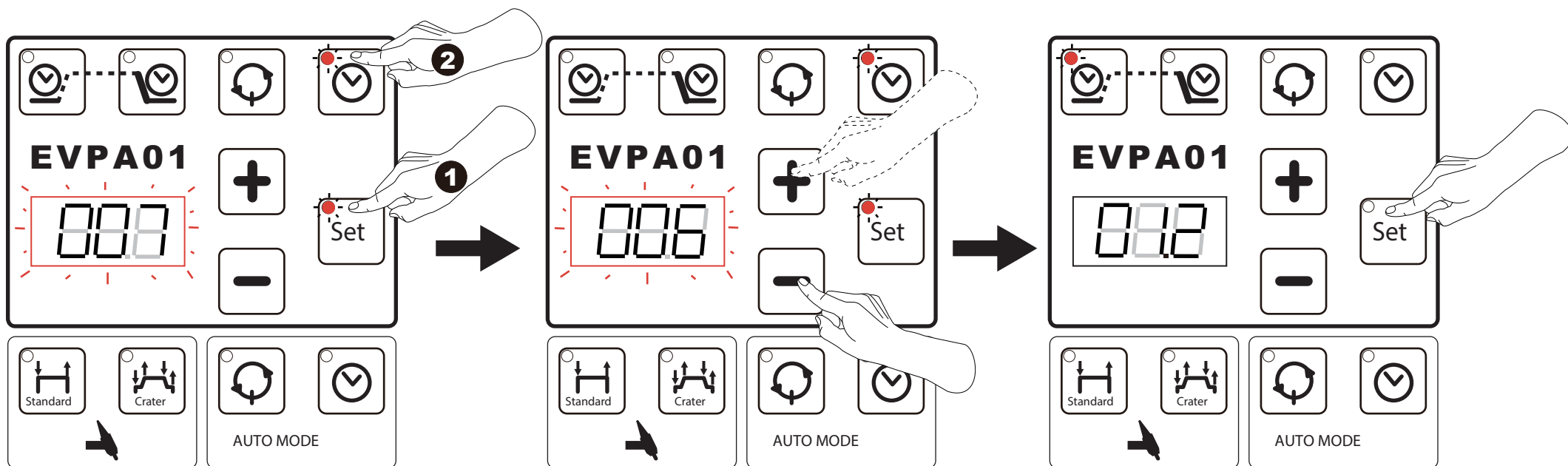
4.5 起弧時間設定方式



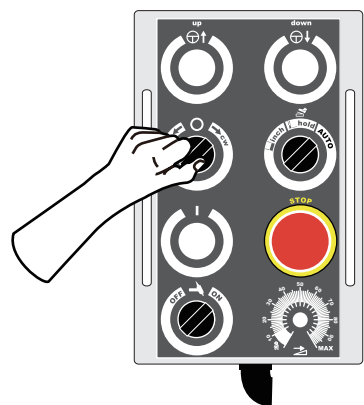
4.6 原點覆歸時間設置



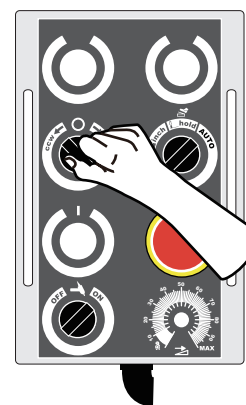
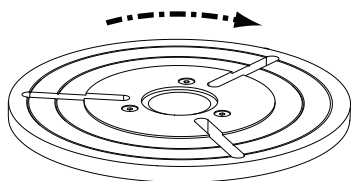
4.7 定時時間設置



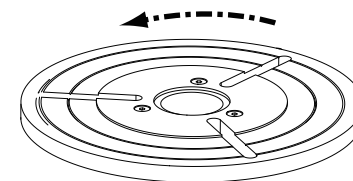
4.8 盤面旋轉方向



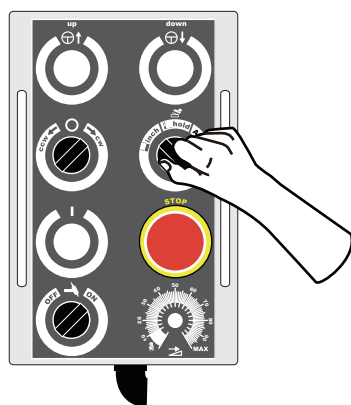
切換 CW 模式



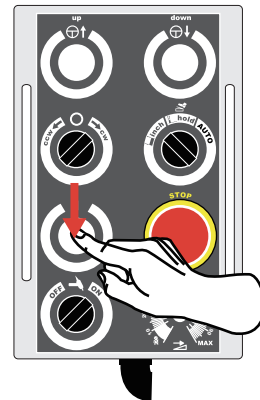
切換 CCW 模式



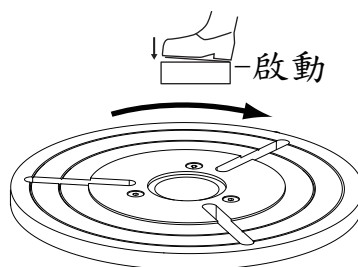
4.9 轉盤寸動旋轉



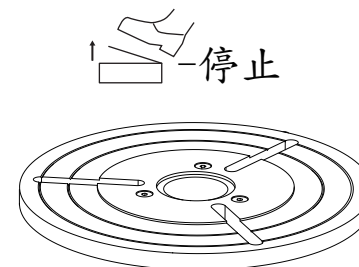
切換 Inch 模式



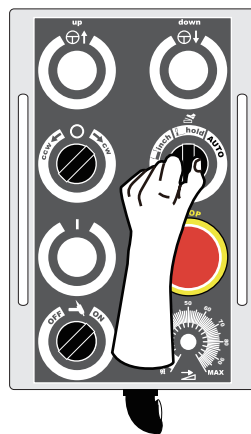
OR



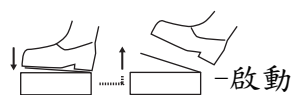
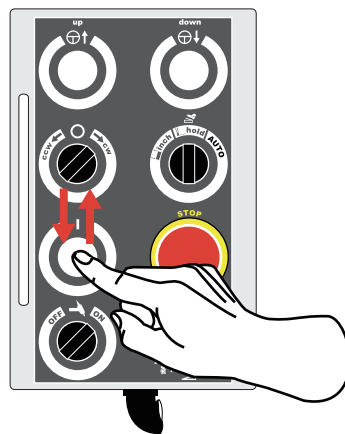
OR



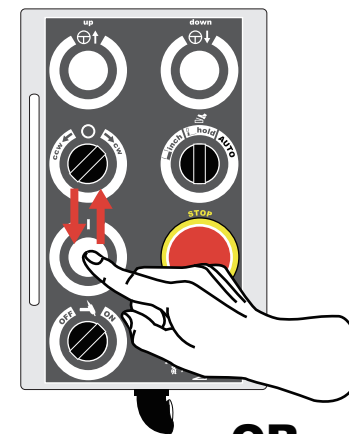
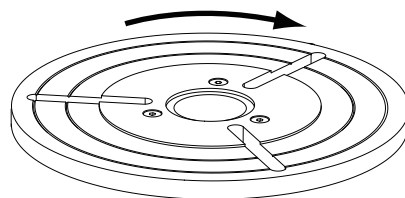
4.10 轉盤自保持旋轉



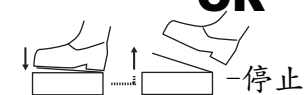
切換hold模式



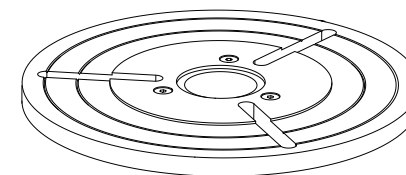
-啟動



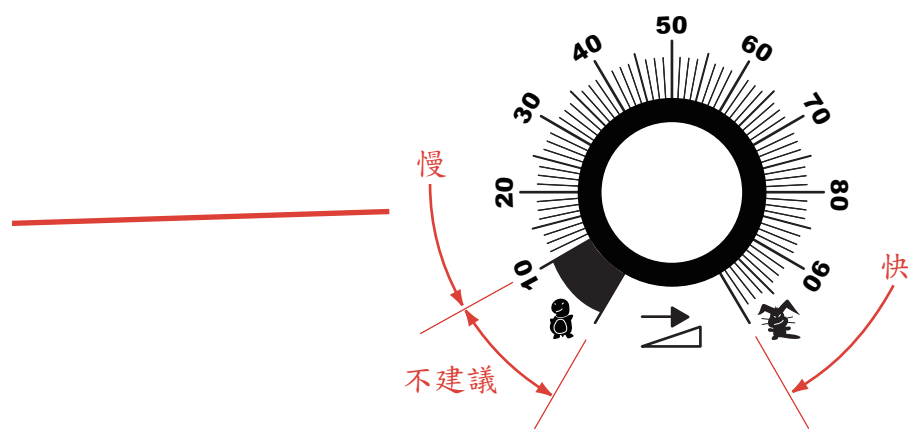
OR



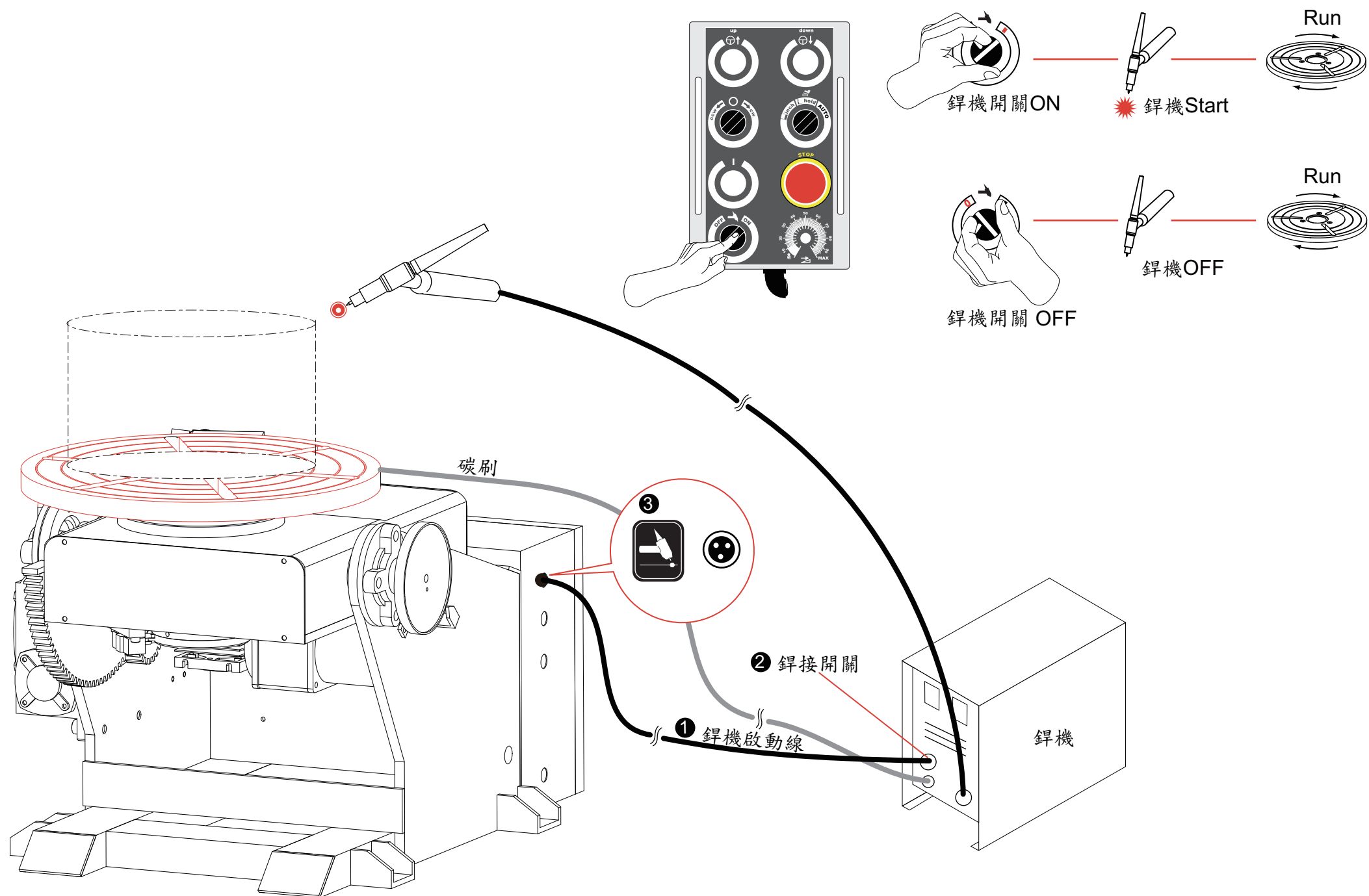
-停止



4.11 轉盤旋轉速度



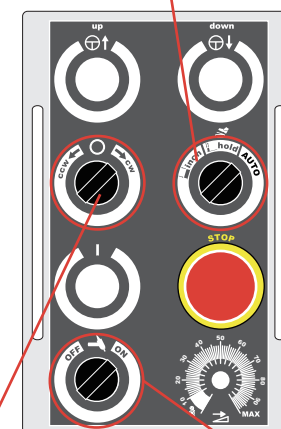
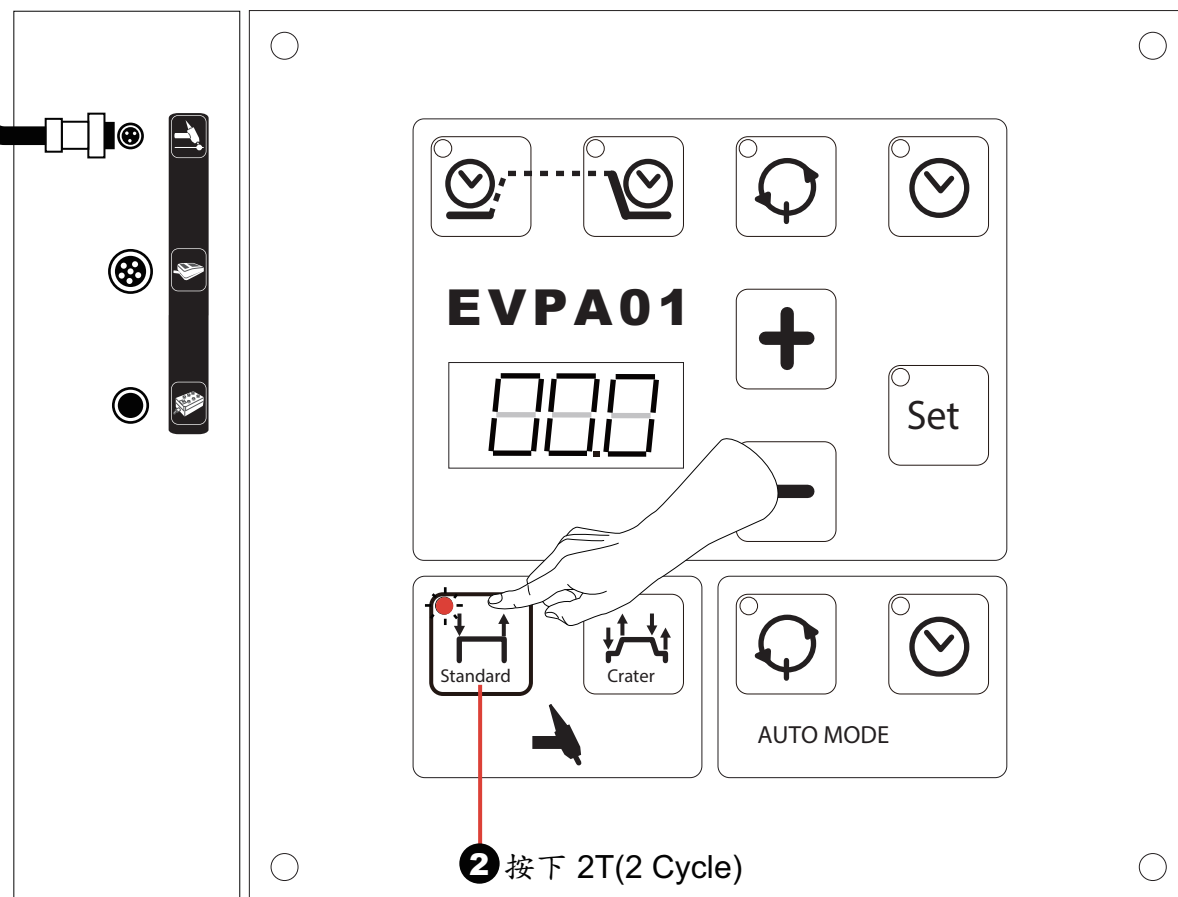
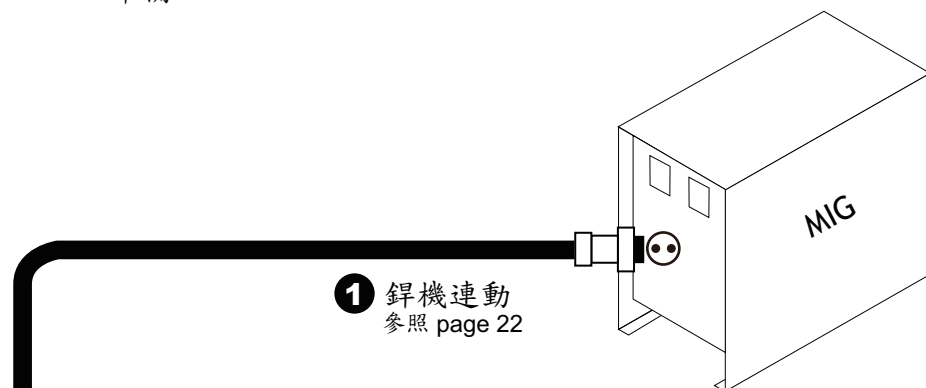
4.12 鐸機啟動步驟



2T(2 cycle) 機器操作

4.13 2T(2 Cycle) / 自保持(HOLD)/ MIG

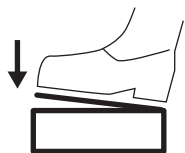
4.13.1 準備



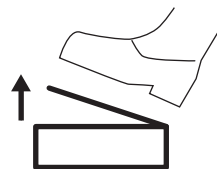
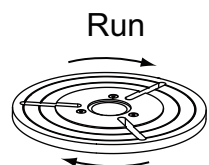
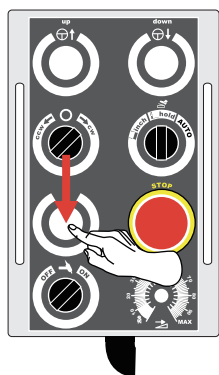
4.13 2T(2 Cycle) / 自保持(HOLD) / MIG

4.13.2 銲接啟動

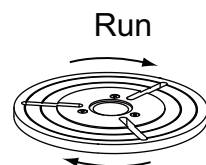
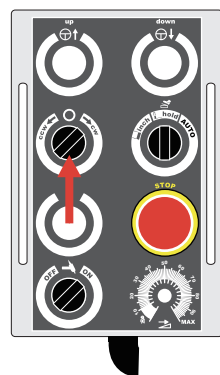
❶ 啟動



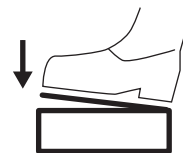
or



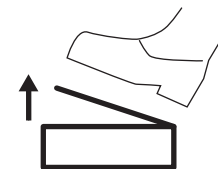
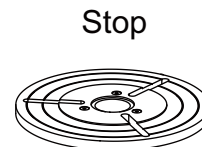
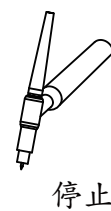
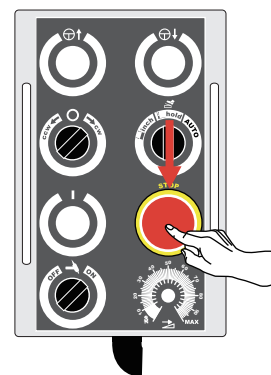
or



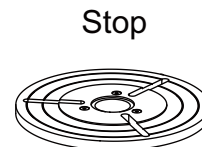
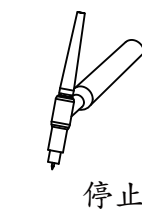
❷ 停止



or

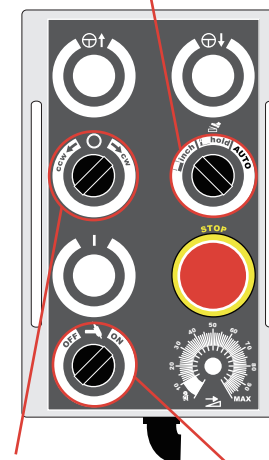
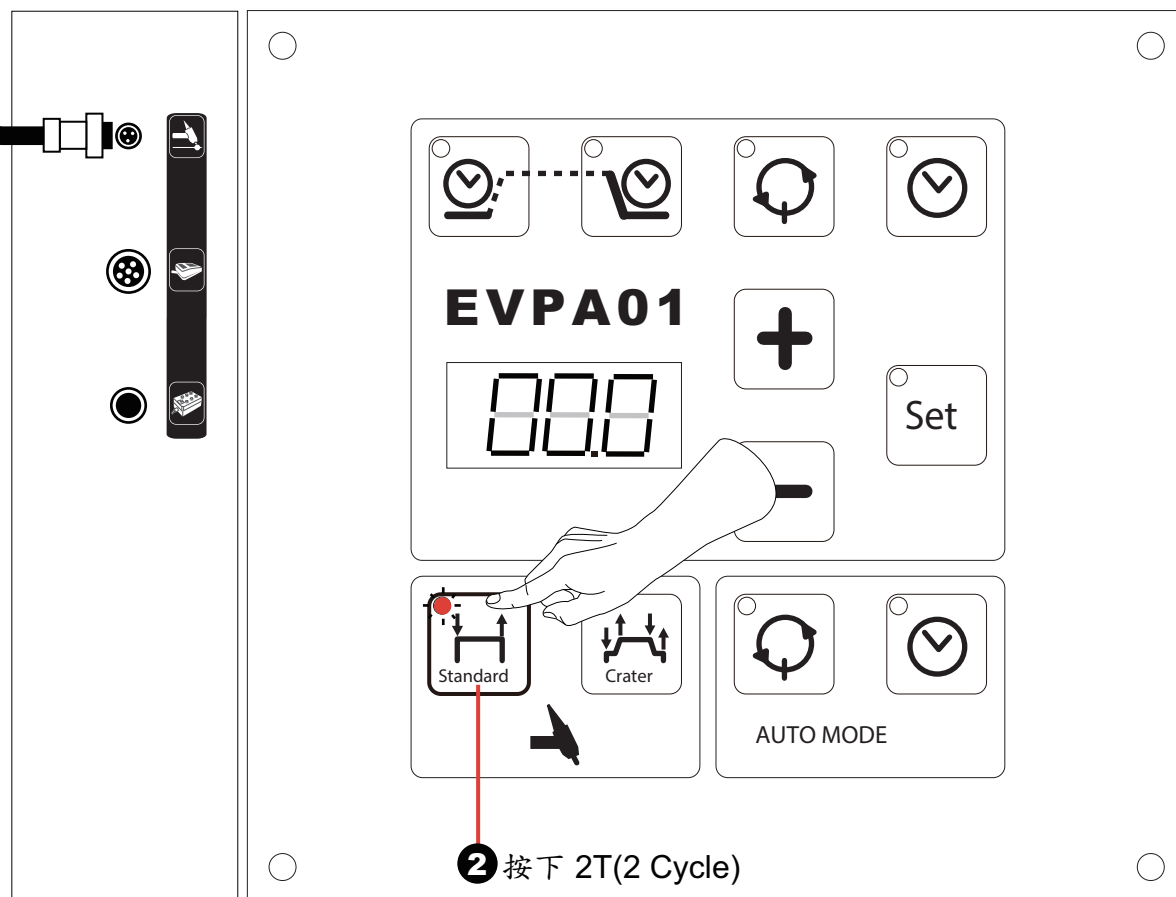
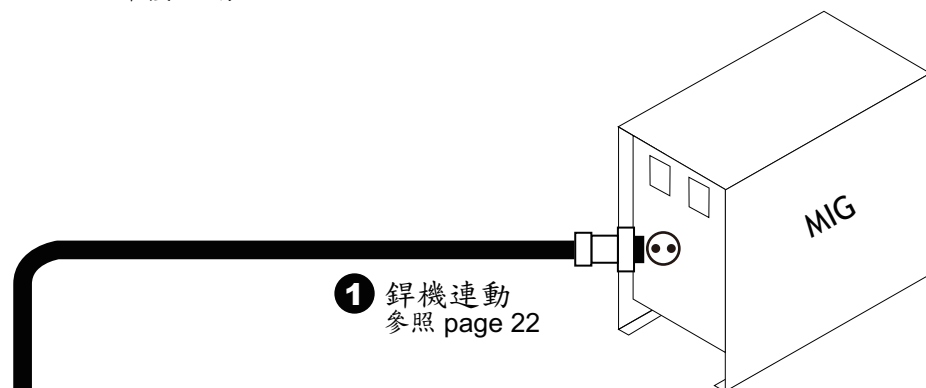


or



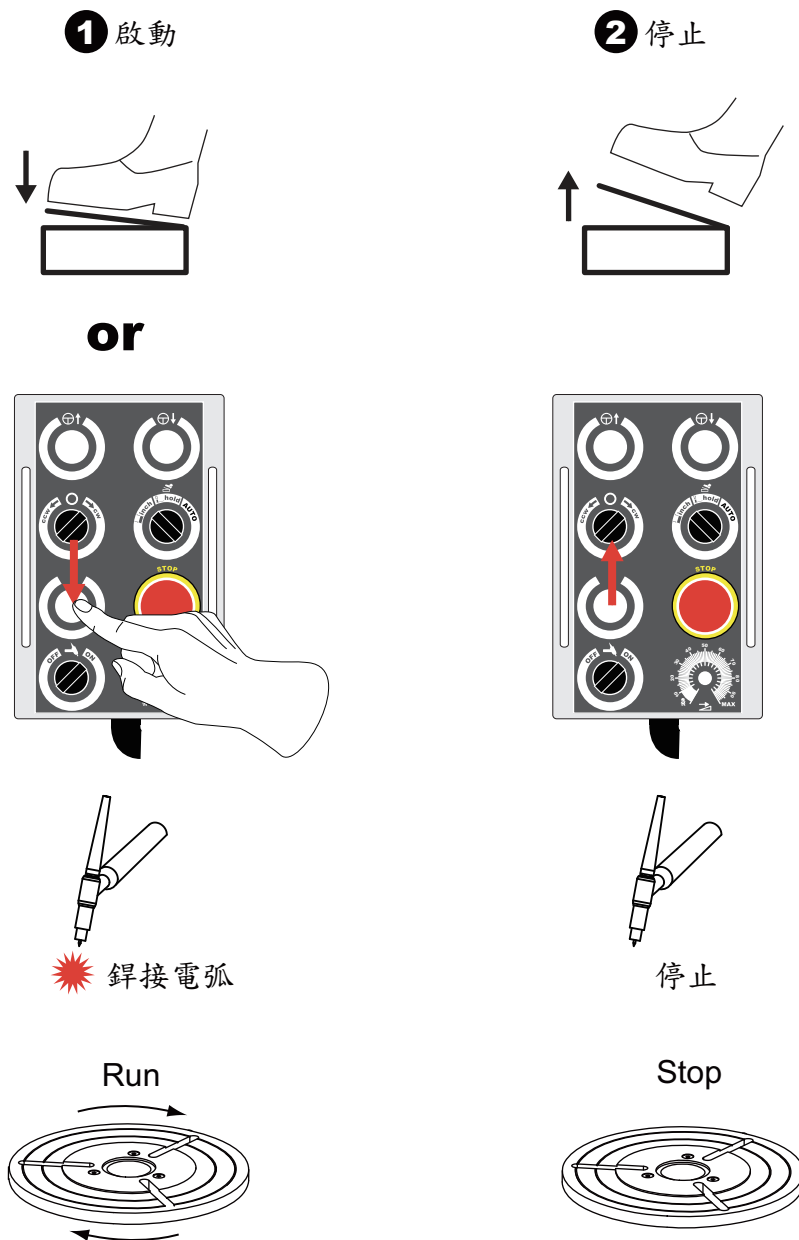
4.14 2T(2 Cycle) / 寸動(INCH) / MIG

4.14.1 銲接啟動



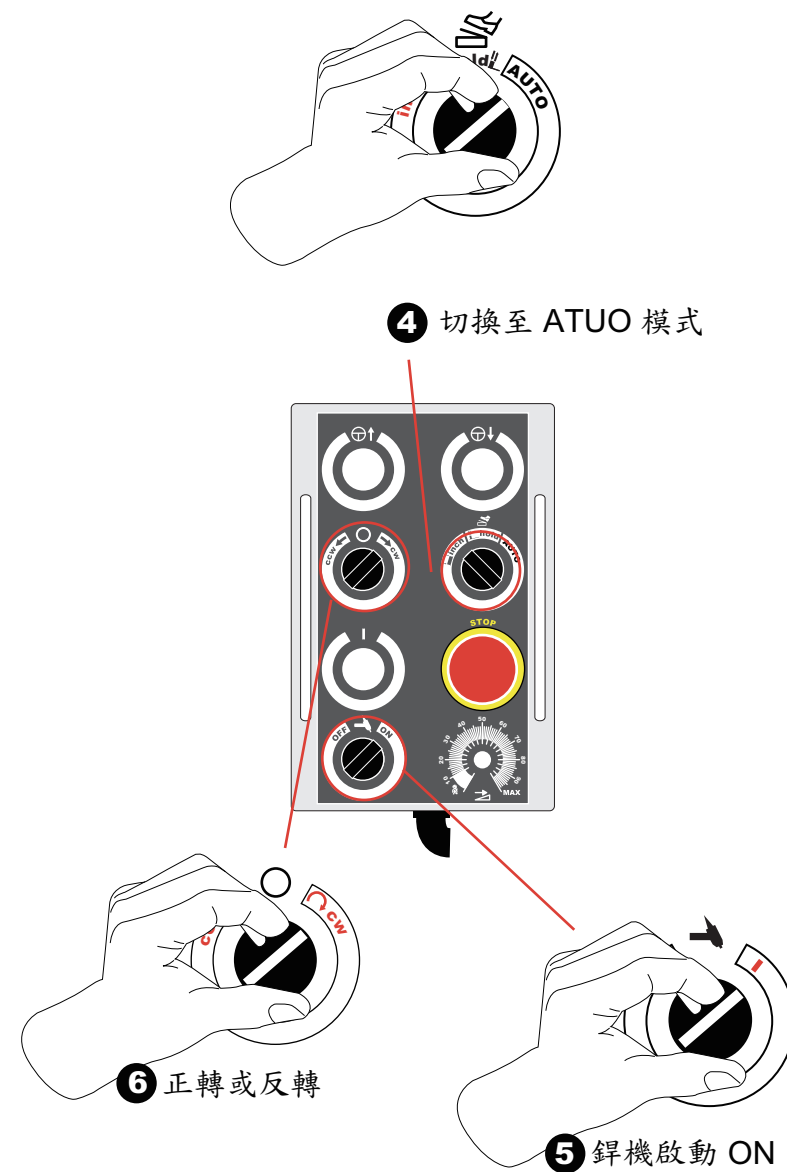
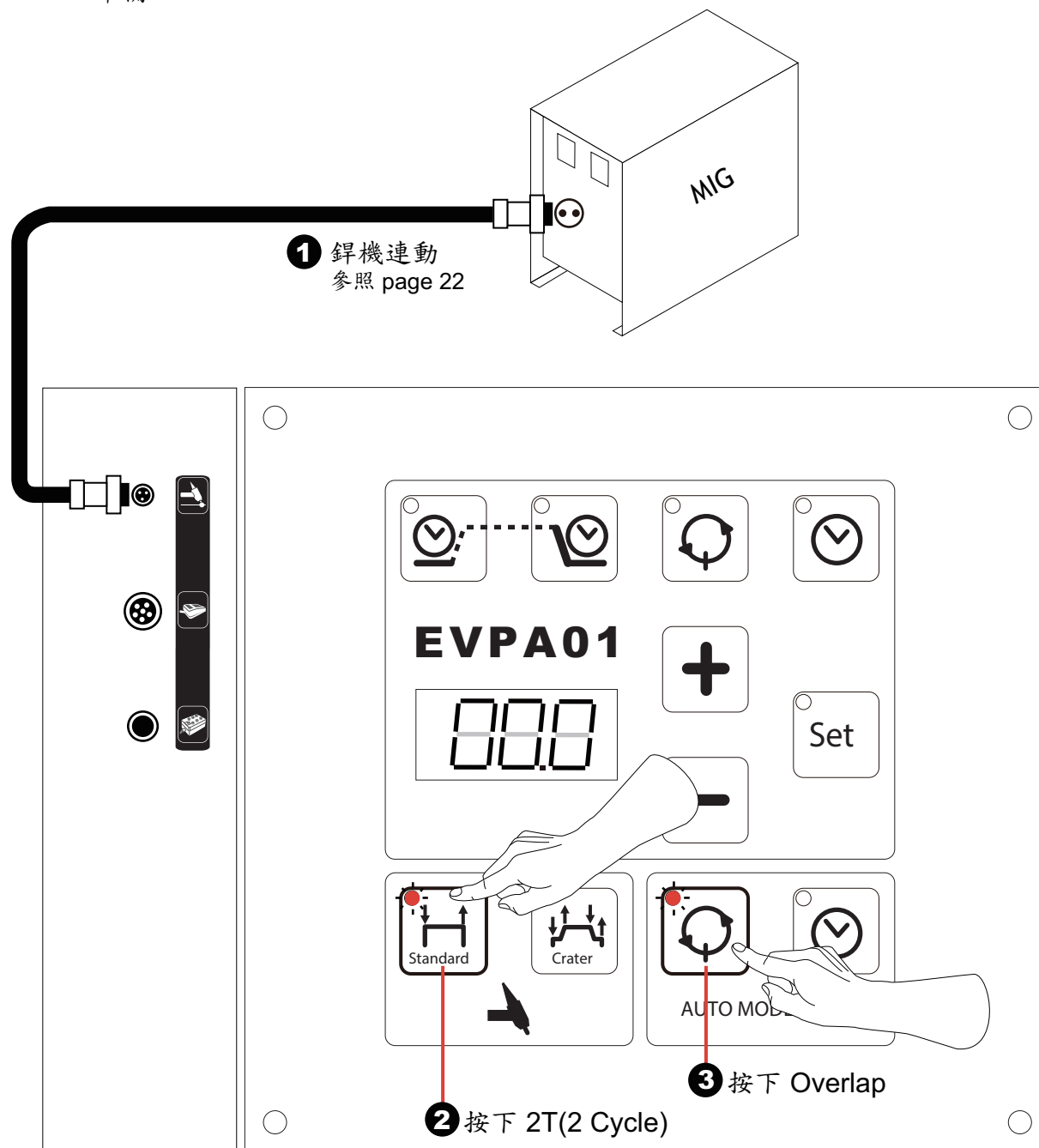
4.14 2T(2 Cycle) / 寸動(INCH) / MIG

4.14.2 銲接啟動



4.15 2T(2 Cycle) / 交疊(OVERLAP) / MIG

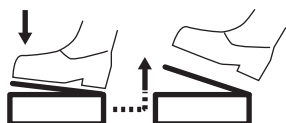
4.15.1 準備



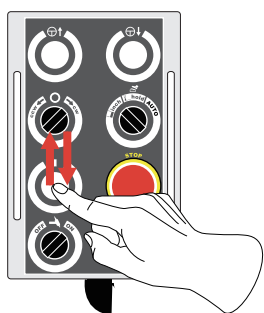
4.15 2T(2 Cycle) / 交疊(OVERLAP) / MIG

4.15.2 銲接啟動

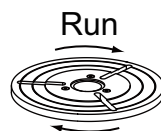
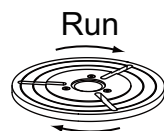
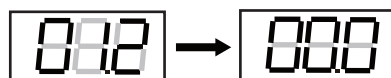
❶ 啟動



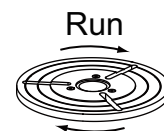
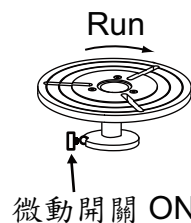
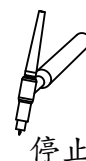
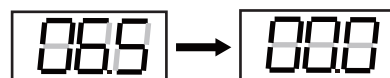
or



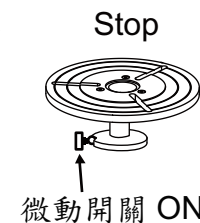
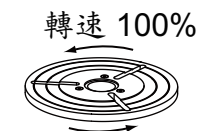
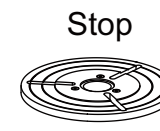
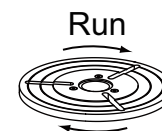
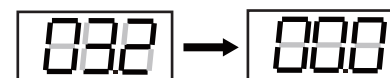
❷ 開始時間



❸ 交疊(Overlap)

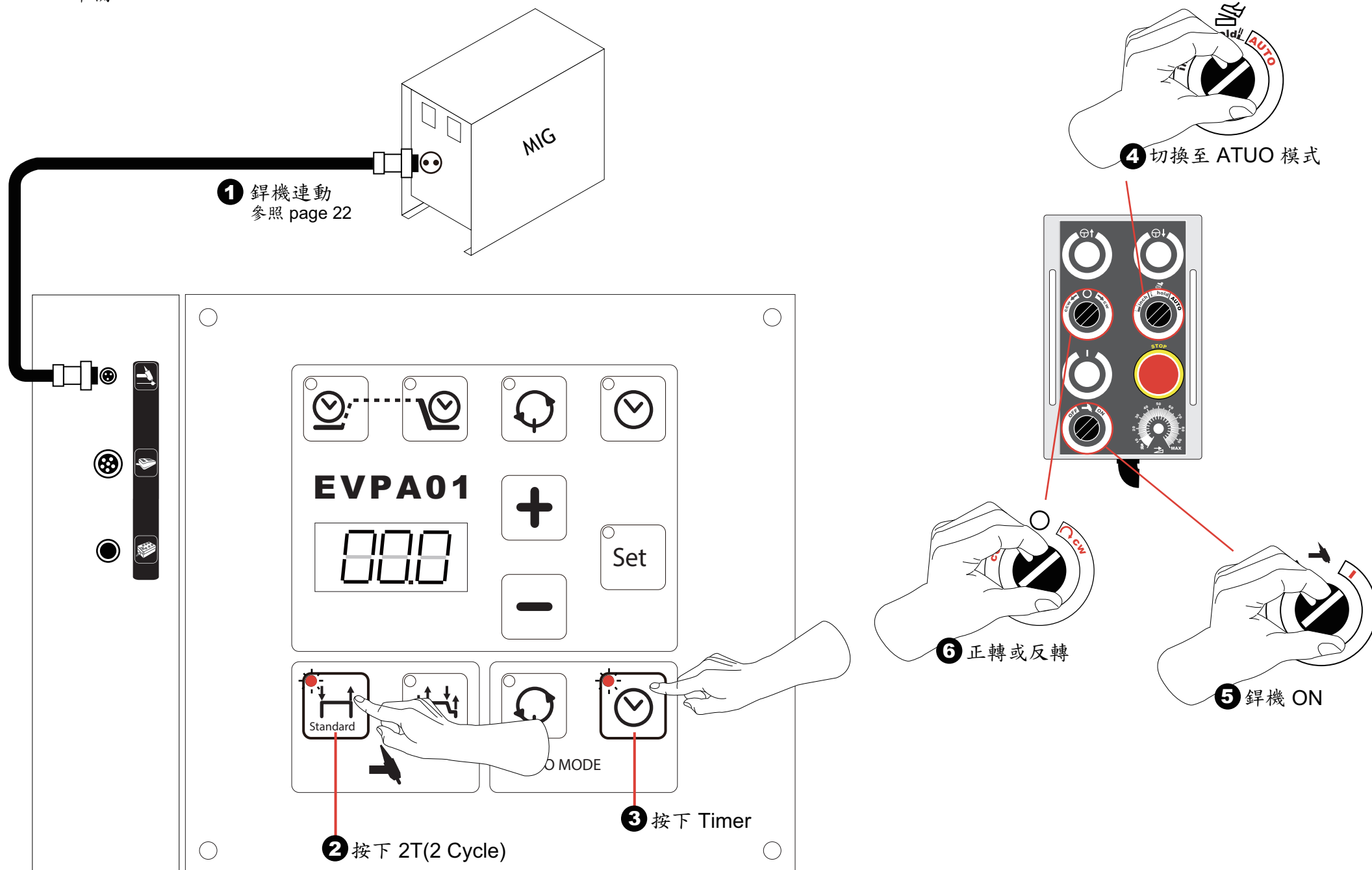


❹ 起弧時間



4.16 2T(2 Cycle) / 計時器(TIMER) / MIG

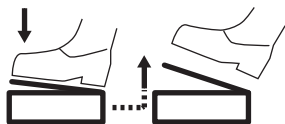
4.16.1 準備



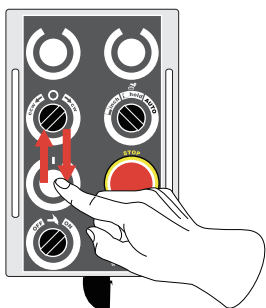
4.16 2T(2 Cycle) / 計時器(TIMER) / MIG

4.16.2 銲機啟動

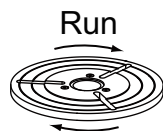
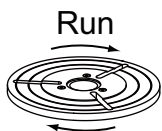
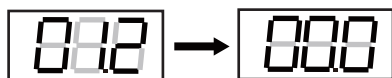
① 啟動



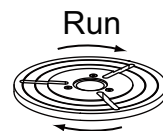
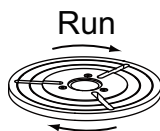
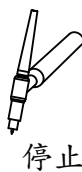
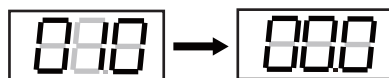
or



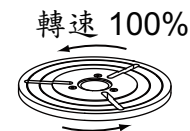
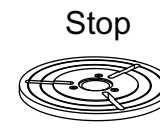
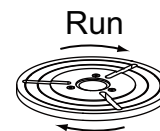
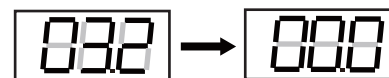
② 啟動時間



③ 計時器時間



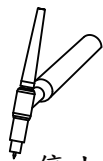
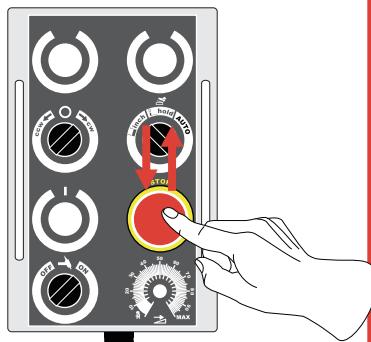
④ 起弧時間



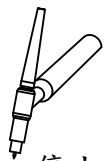
4.17 (2 Cycle)

重疊而停止工作

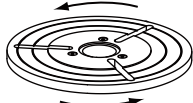
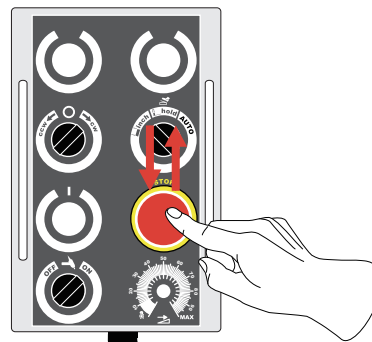
4.17.1 禁止運行



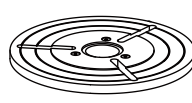
停止



停止

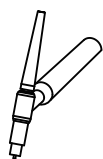
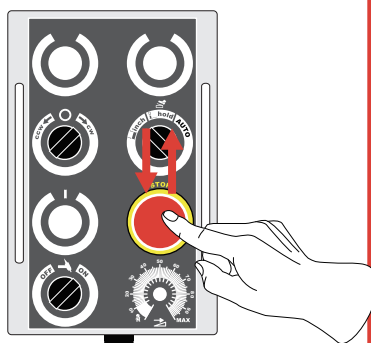


轉速100%

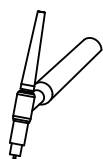


停止

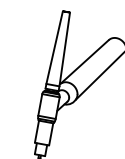
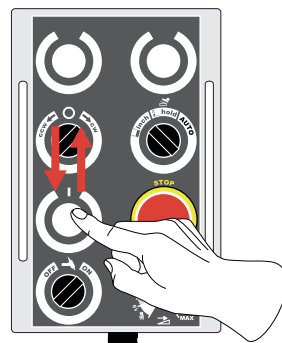
4.17.2 重新啟動



停止

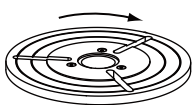


停止



銲接電弧

Run

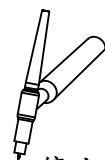
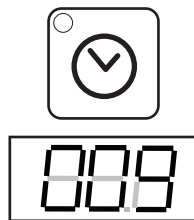
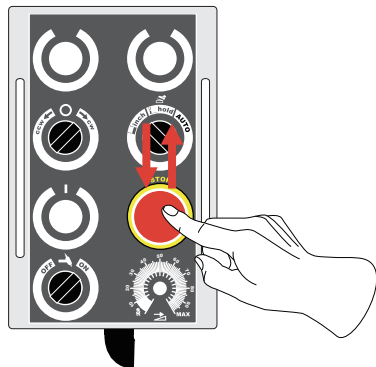


銲接 page 28 動作



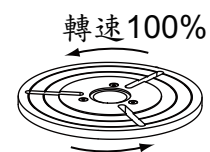
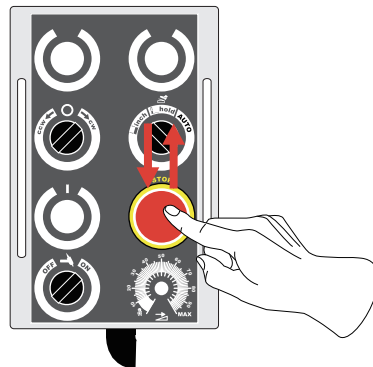


4.18.1 禁止運行

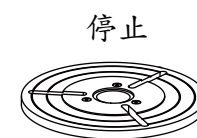


停止

停止

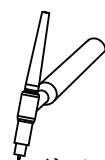
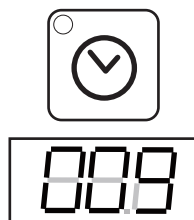
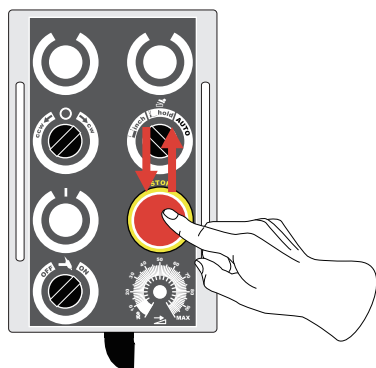


轉速100%



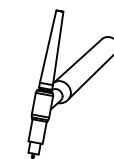
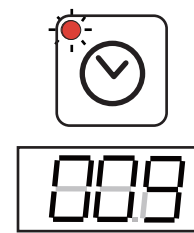
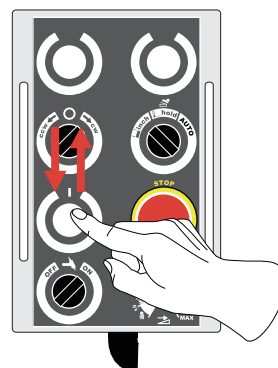
停止

4.18.2 重新啟動

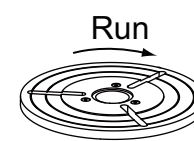


停止

停止



銲接電弧



Run

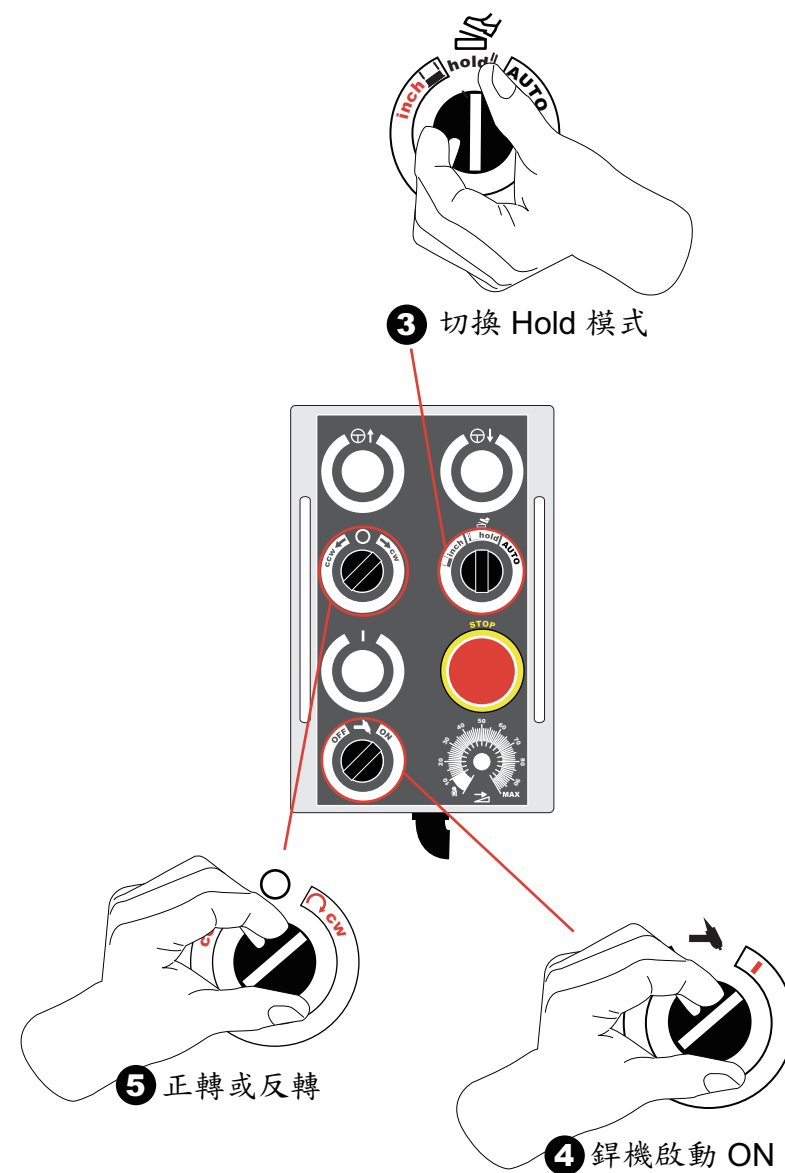
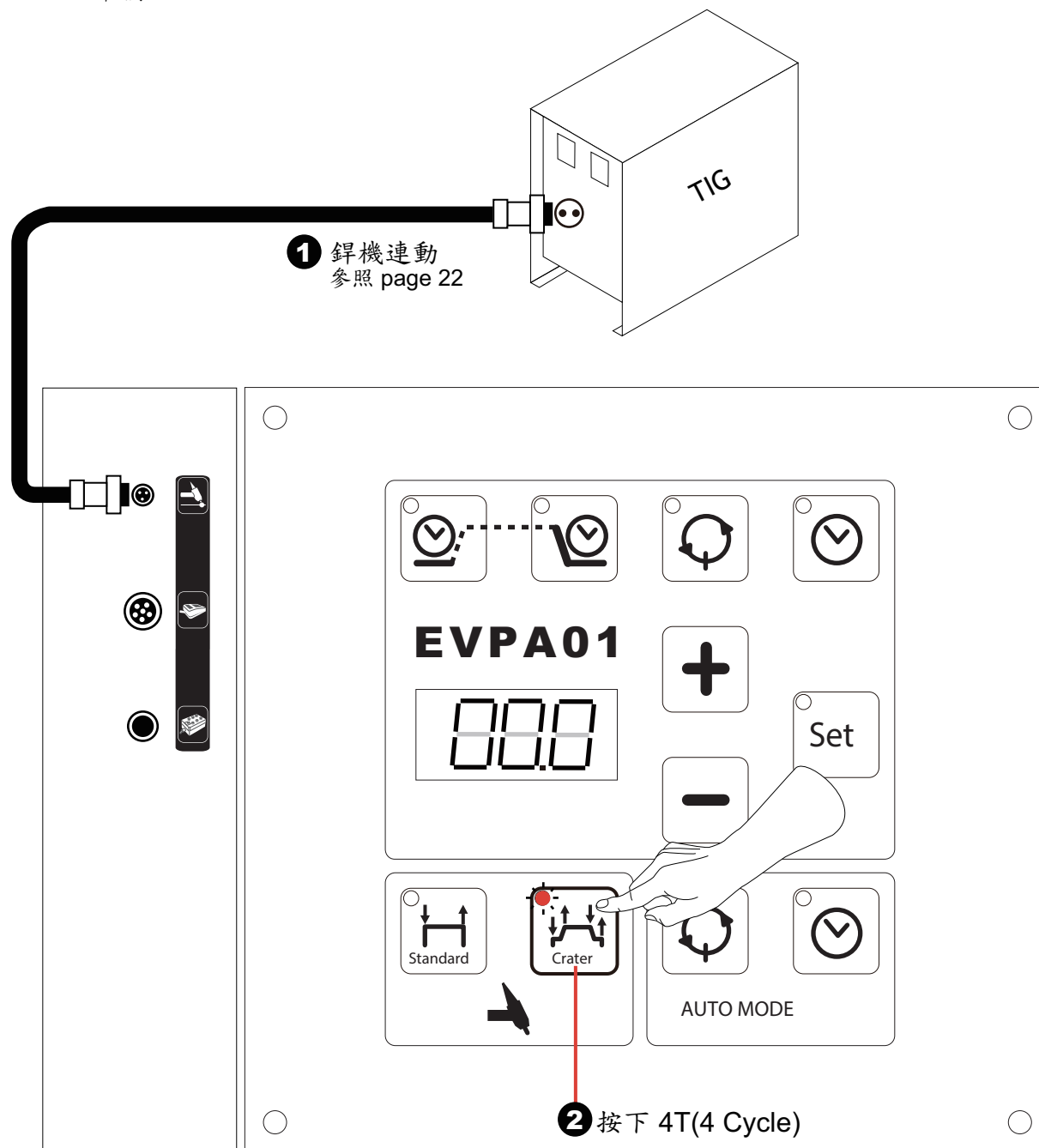
銜接 page 30 動作



4T(4 cycle) 機器操作

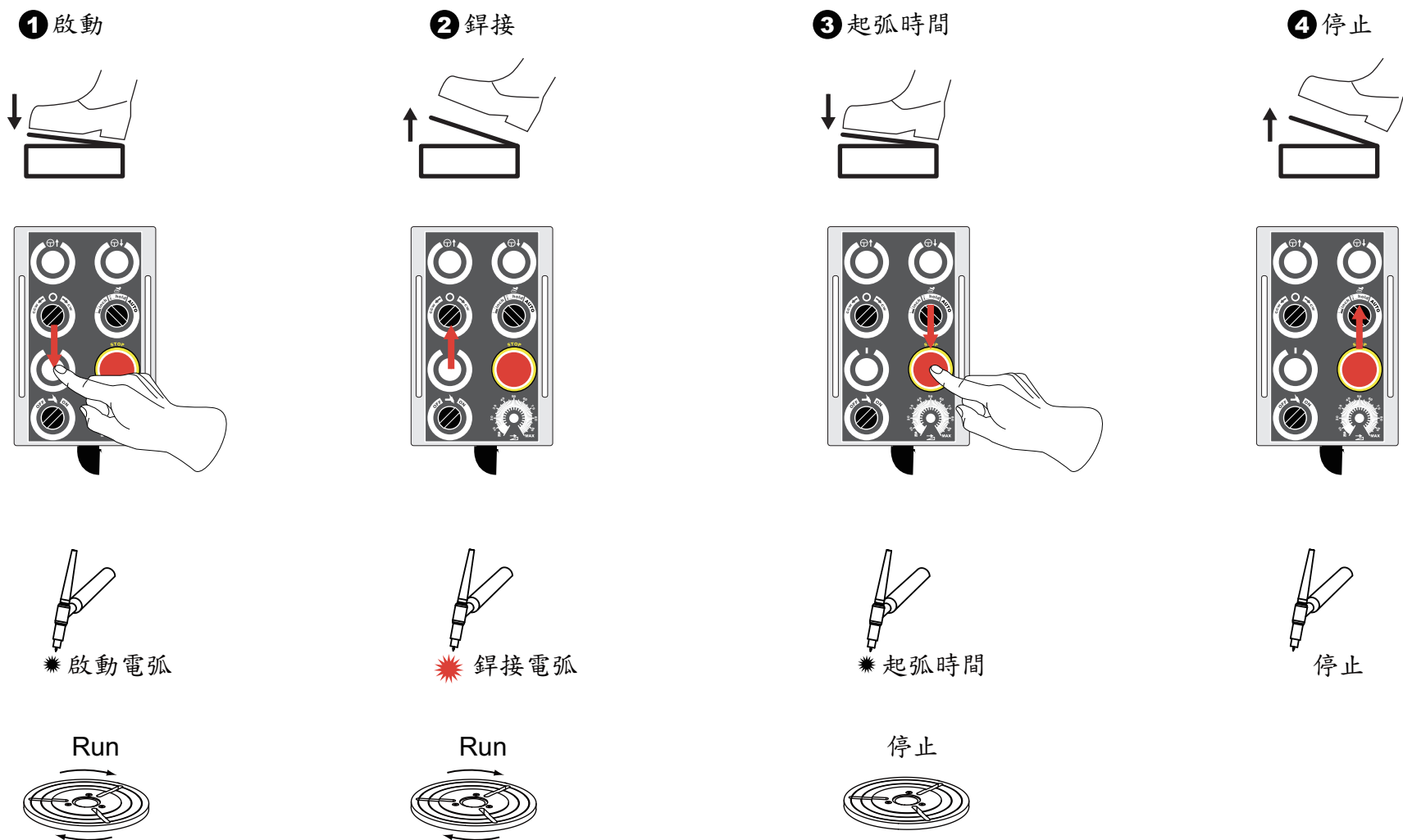
4.19 4T(4 Cycle) / (自保持)HOLD / TIG

4.19.1 準備



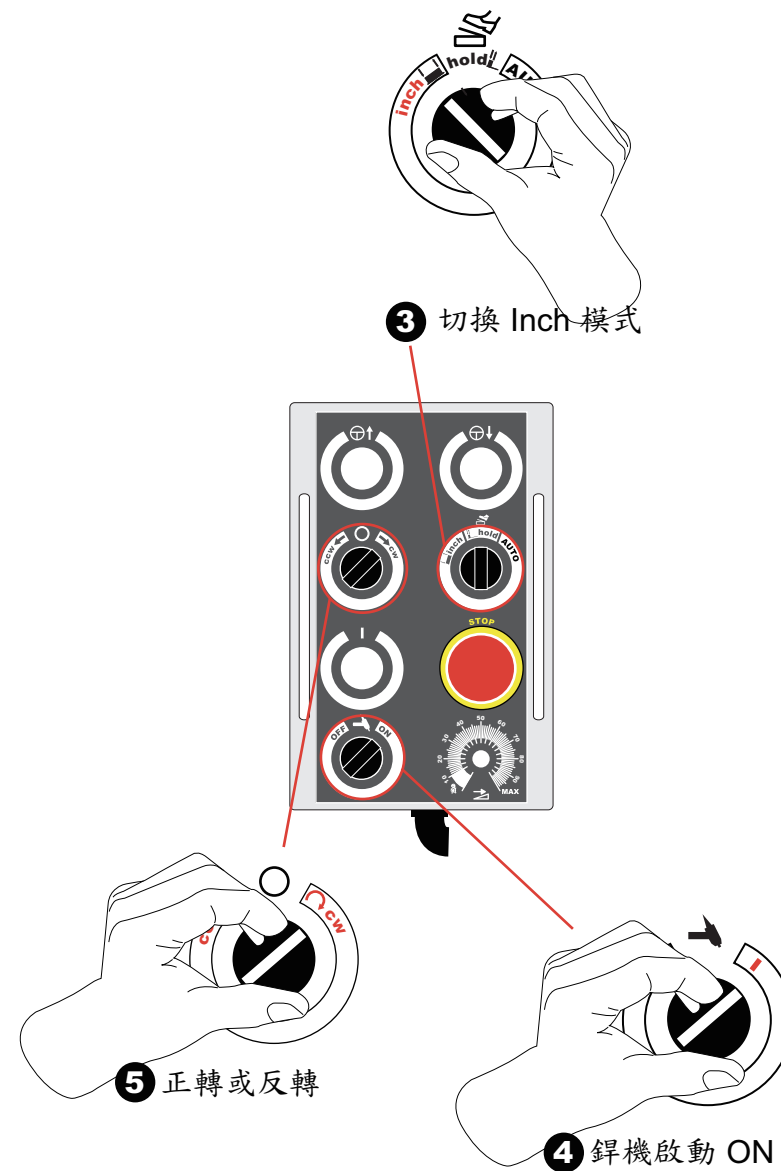
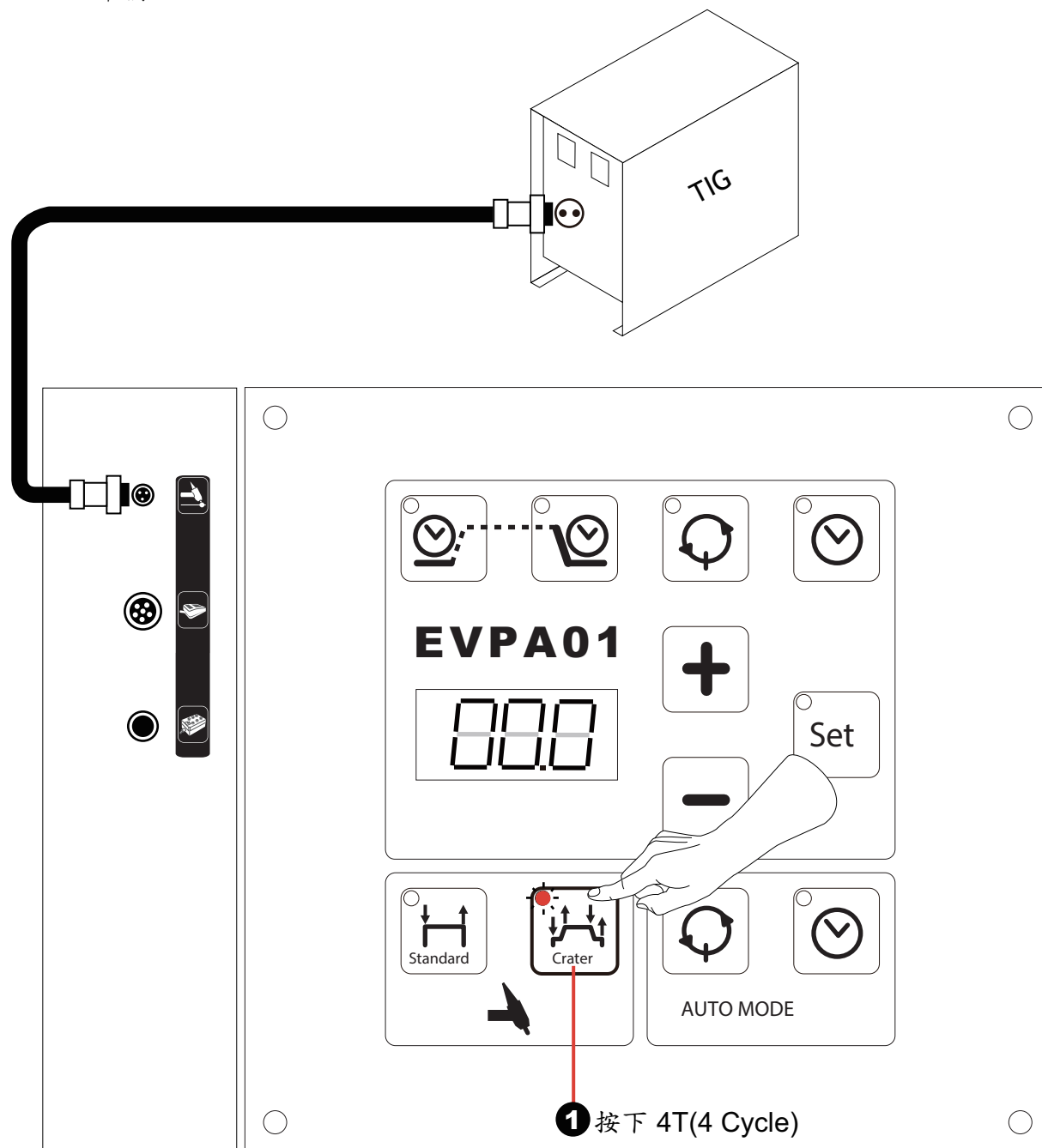
4.19 4T(4 Cycle) / 自保持(HOLD) / TIG

4.19.2 鐸接啟動



4.20 4T(4 Cycle) / 寸動(INCH)

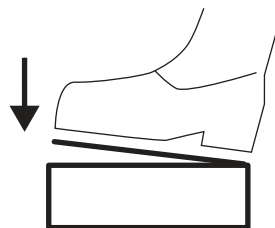
4.20.1 準備



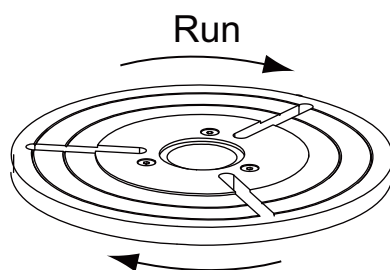
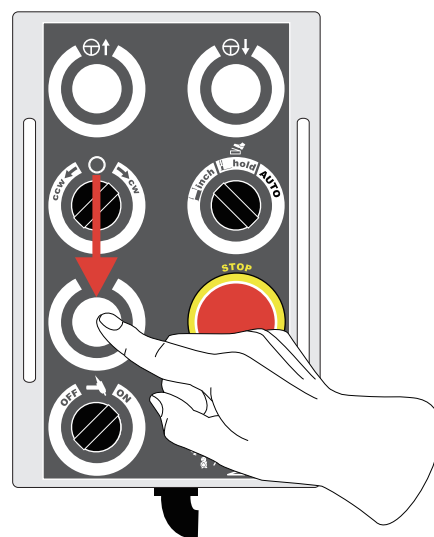
4.20 4T(4 Cycle) / 寸動(INCH)

4.20.2 啟動

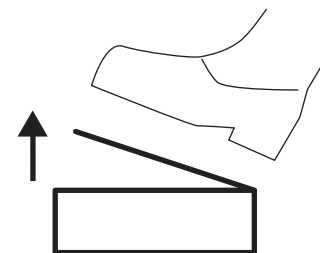
1 啟動



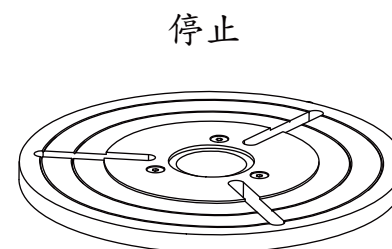
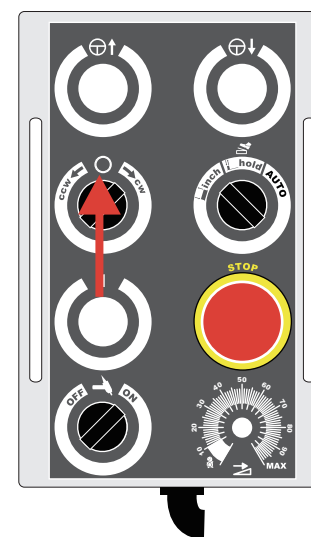
or



2 停止

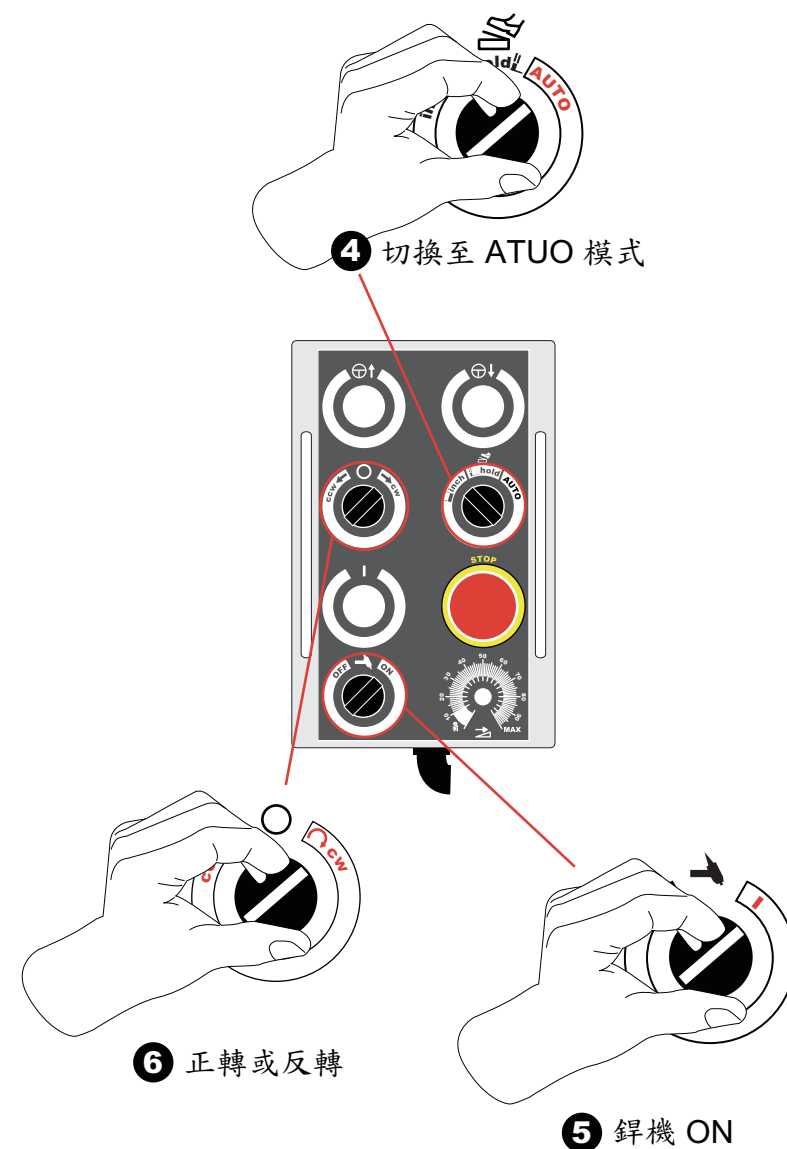
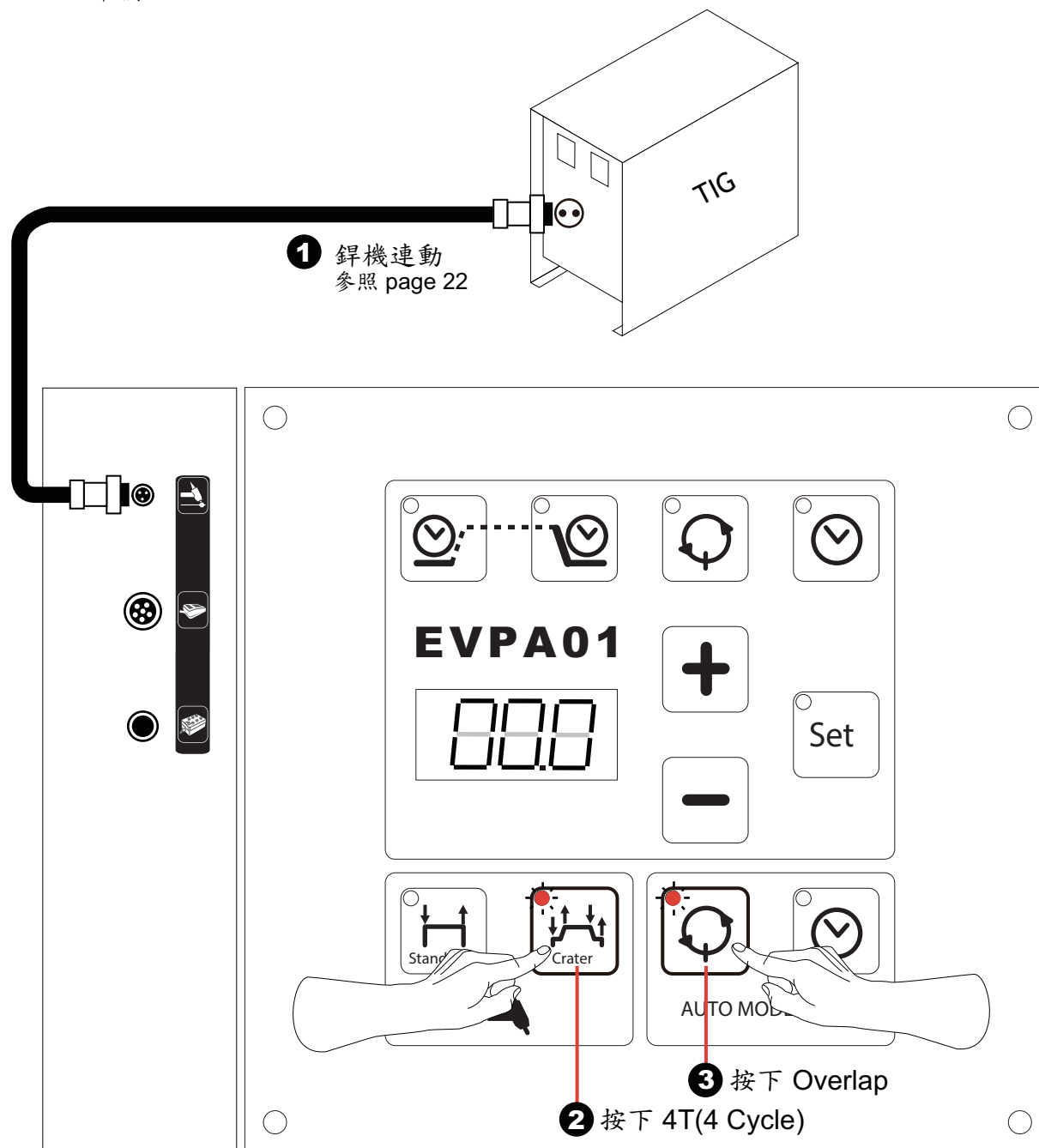


or



4.21 4T(4 Cycle) / 交疊OVERLAP / TIG

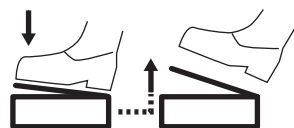
4.21.1 準備



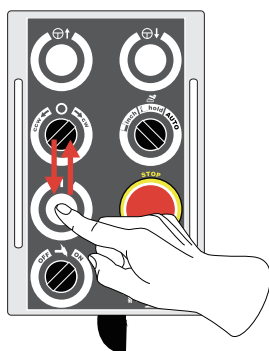
4.21 4T(4 Cycle) / 交疊(OVERLAP) / TIG

4.21.2 銲接啟動

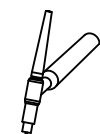
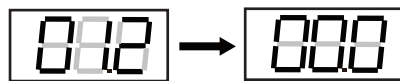
① 啟動



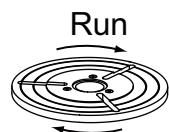
or



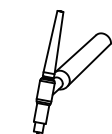
② 啟動時間



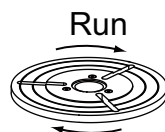
✱ 啟動電弧



Run

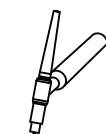
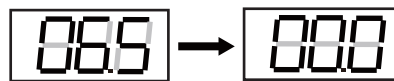


✱ 銲接電弧

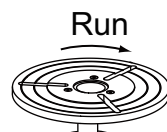


Run

③ 交疊(Overlap)

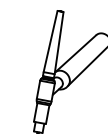


✱ 銲接電弧

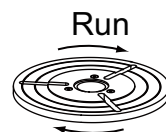


Run

微動開關 ON

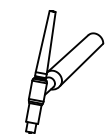
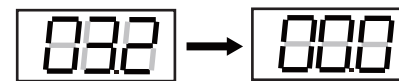


✱ 銲接電弧

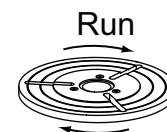


Run

④ 起弧時間



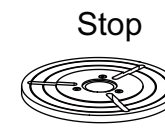
✱ 起弧時間



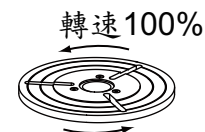
Run



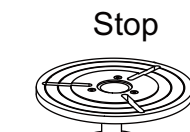
停止



Stop



轉速100%

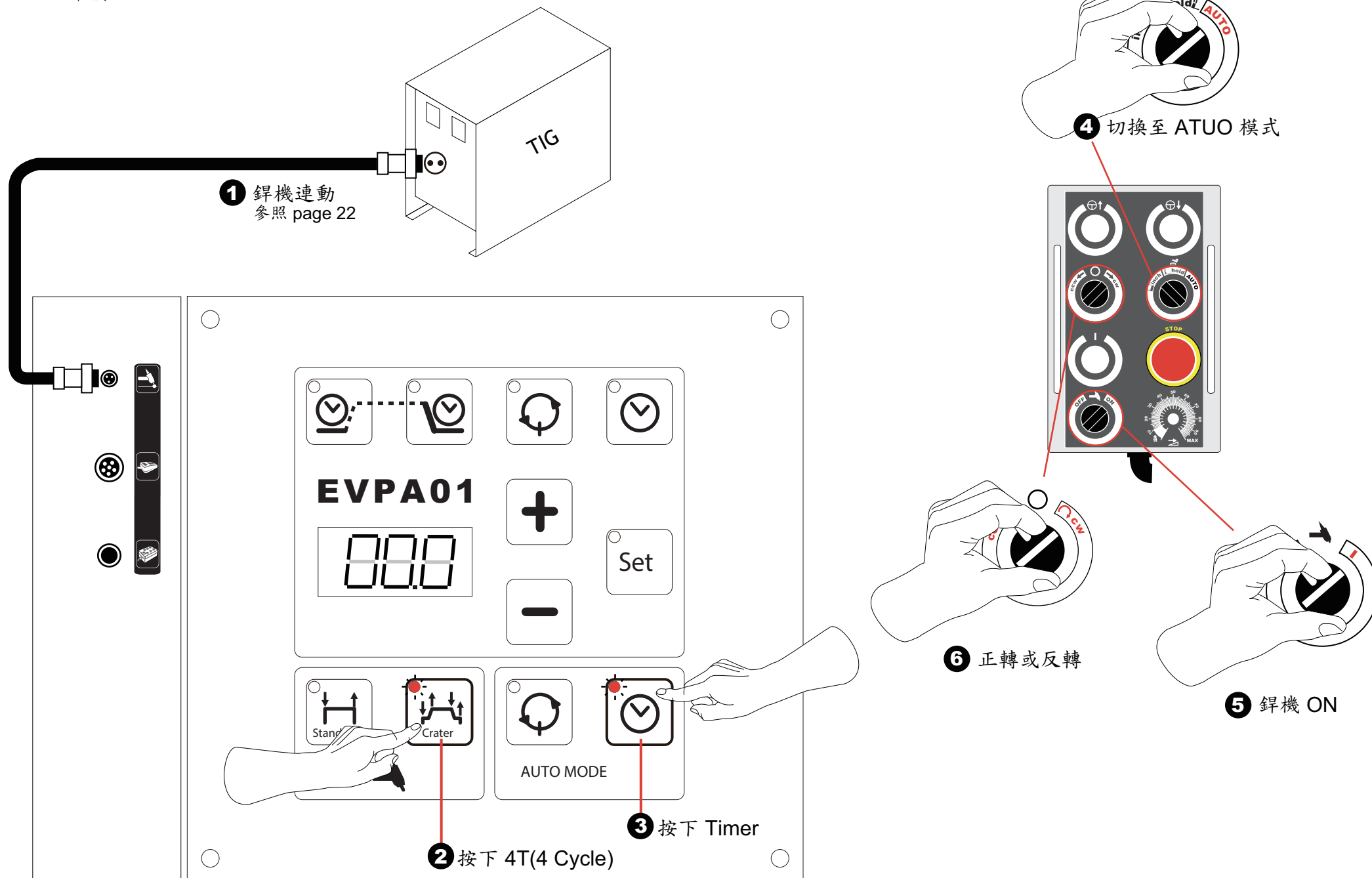


Stop

微動開關 ON

4.22 4T(4 Cycle) / 計時器(TIMER) / TIG

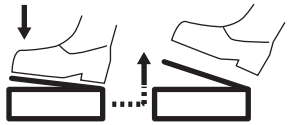
4.22.1 準備



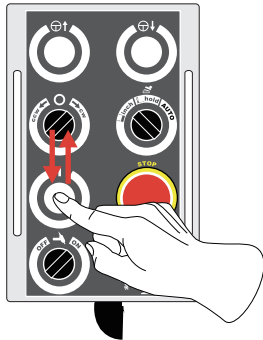
4.22 4T(4 Cycle) / 計時器(TIMER) / TIG

4.22.2 銲機啟動

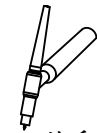
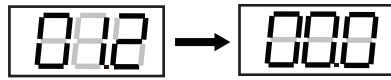
① 啟動



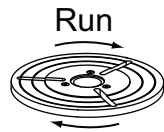
or



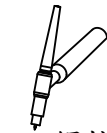
② 啟動時間



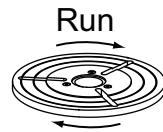
✱ 啟動電弧



Run

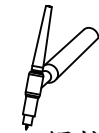
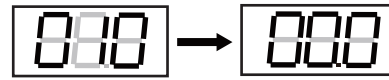


✱ 銲接電弧

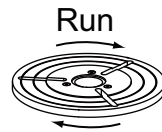


Run

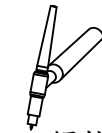
③ 計時器時間



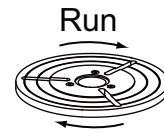
✱ 銲接電弧



Run

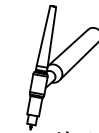
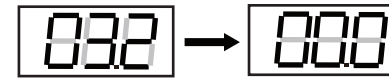


✱ 銲接電弧

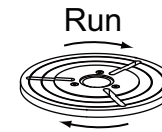


Run

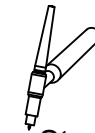
④ 起弧時間



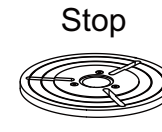
✱ 收弧



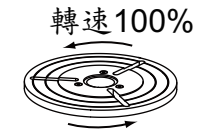
Run



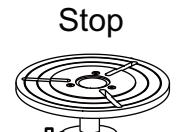
Stop



Stop



轉速 100%



Stop

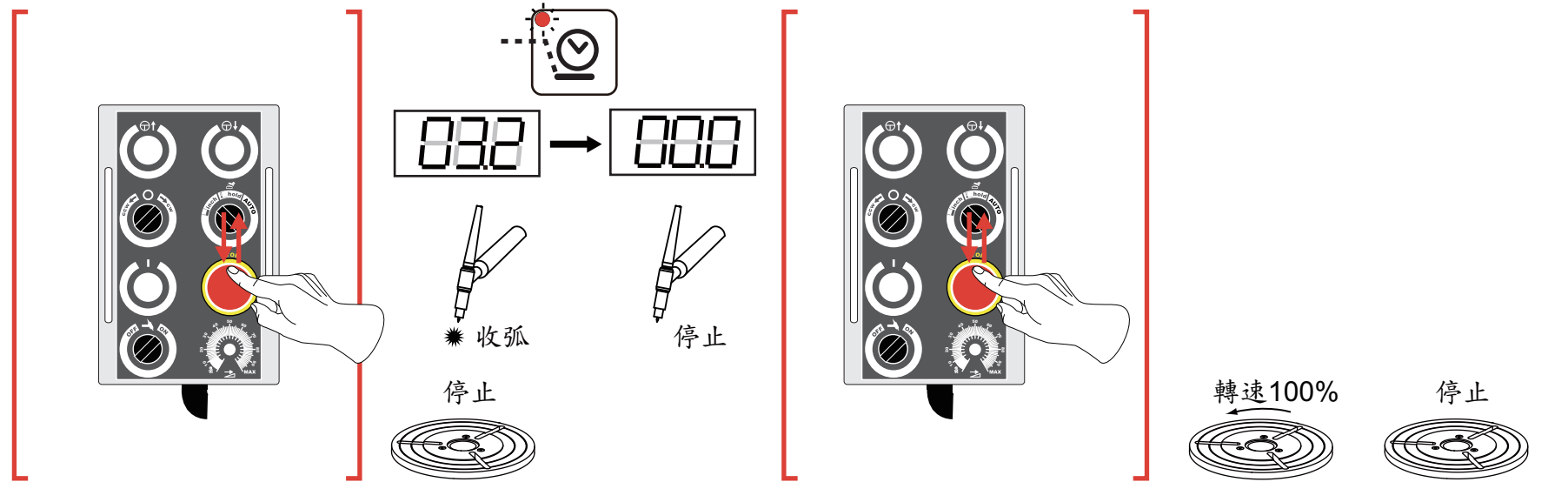
微動開關 ON

4.23 (4 Cycle)

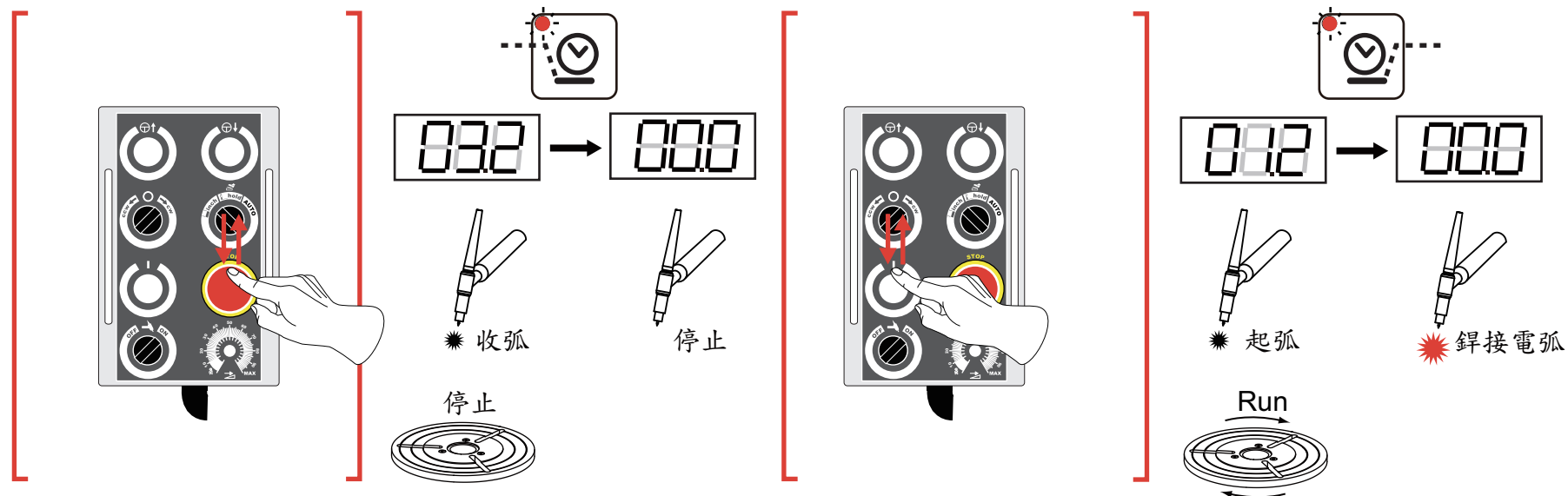


重疊而停止工作

4.23.1 禁止運行



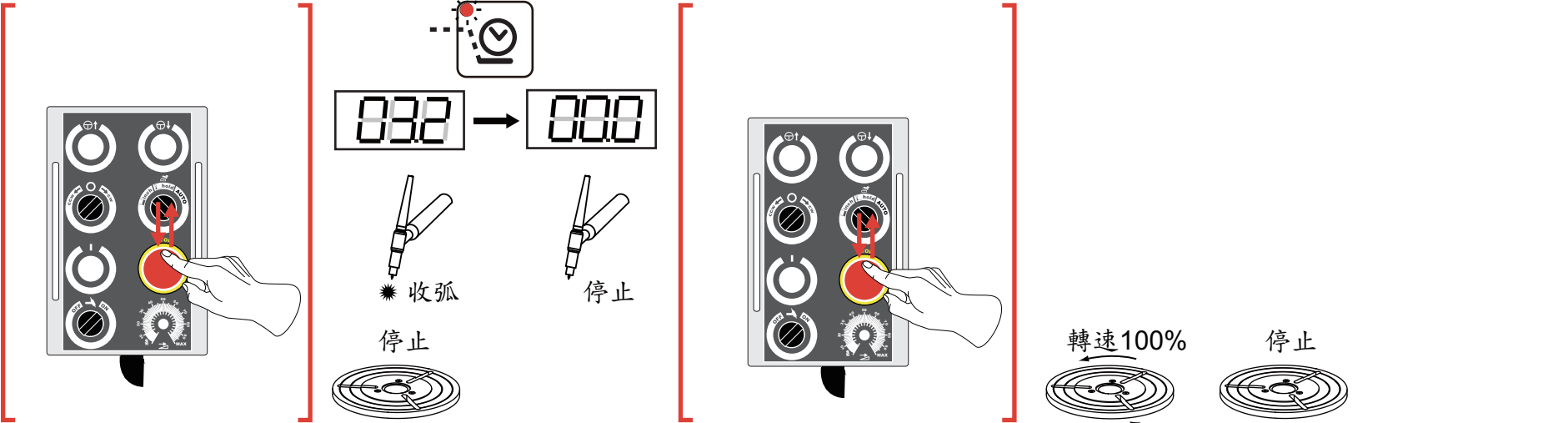
4.23.2 重新啟動



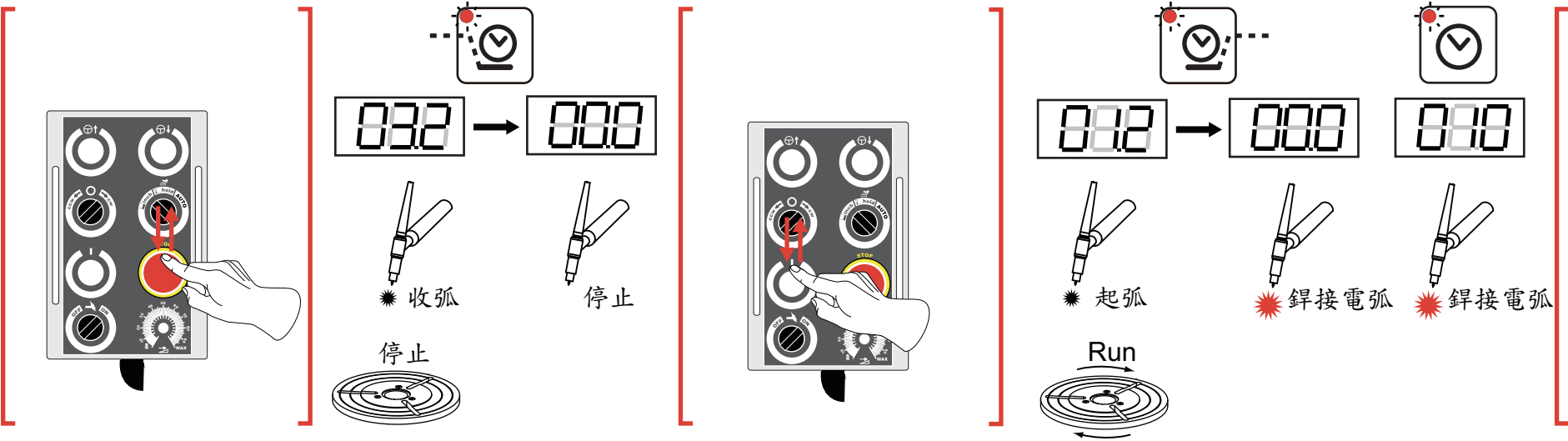
銲接 page 38 動作



4.24.1 禁止運行



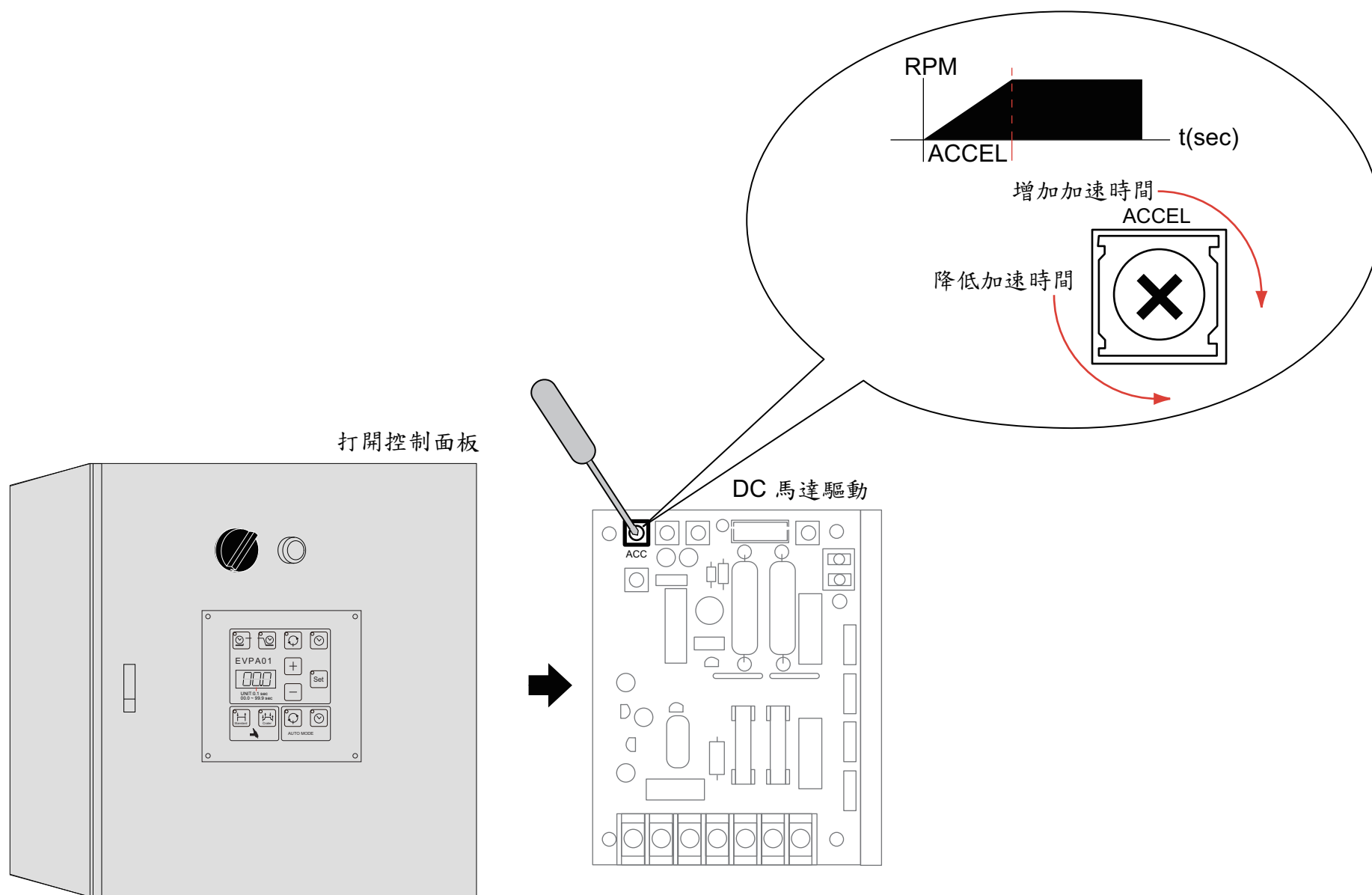
4.24.2 重新啟動



銲接 page 40 動作
I

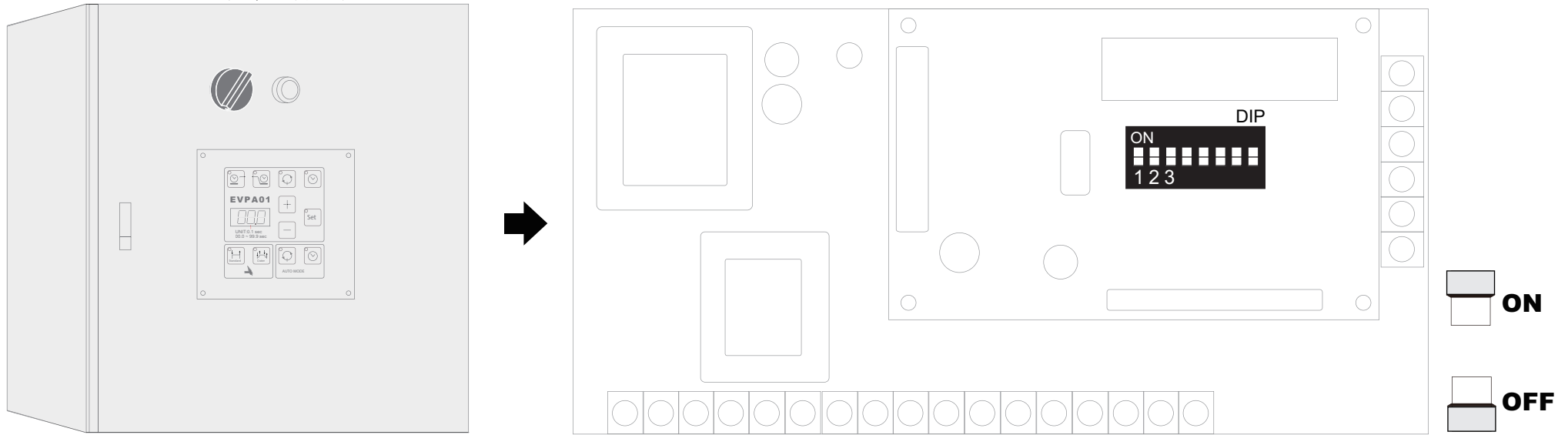
Chapter 5: 設置步驟

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

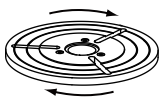
啟動時間



00.2 → 00.0



Run

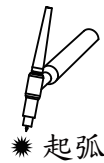


DIP1
OFF

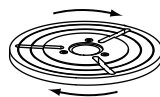
啟動時間



00.2 → 00.0



Run



5.2.2 DIP2 (4 Cycle) Mode

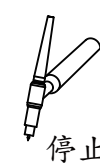


DIP2
ON

起弧時間



03.2 → 00.0



停止

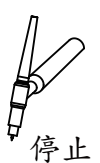


DIP2
OFF

起弧時間



03.2 → 00.0

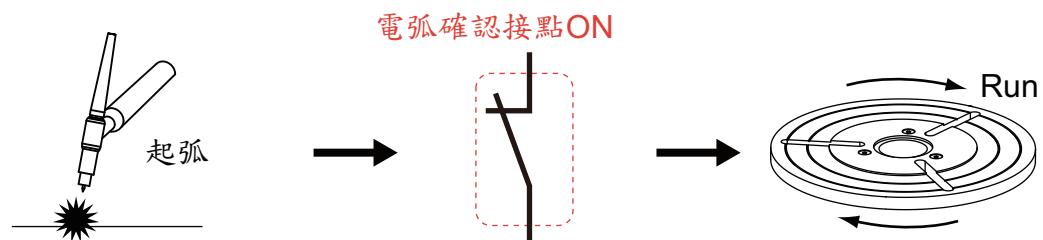
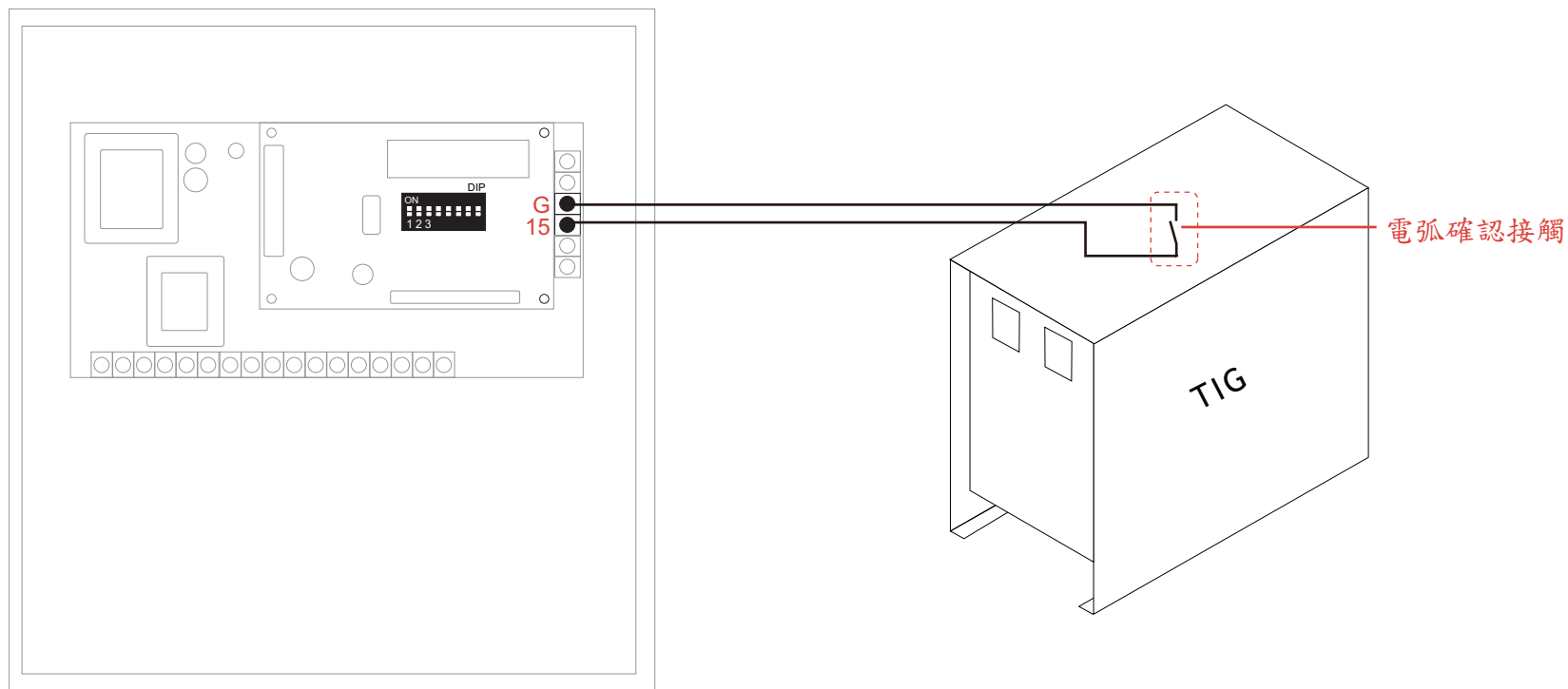


停止



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)

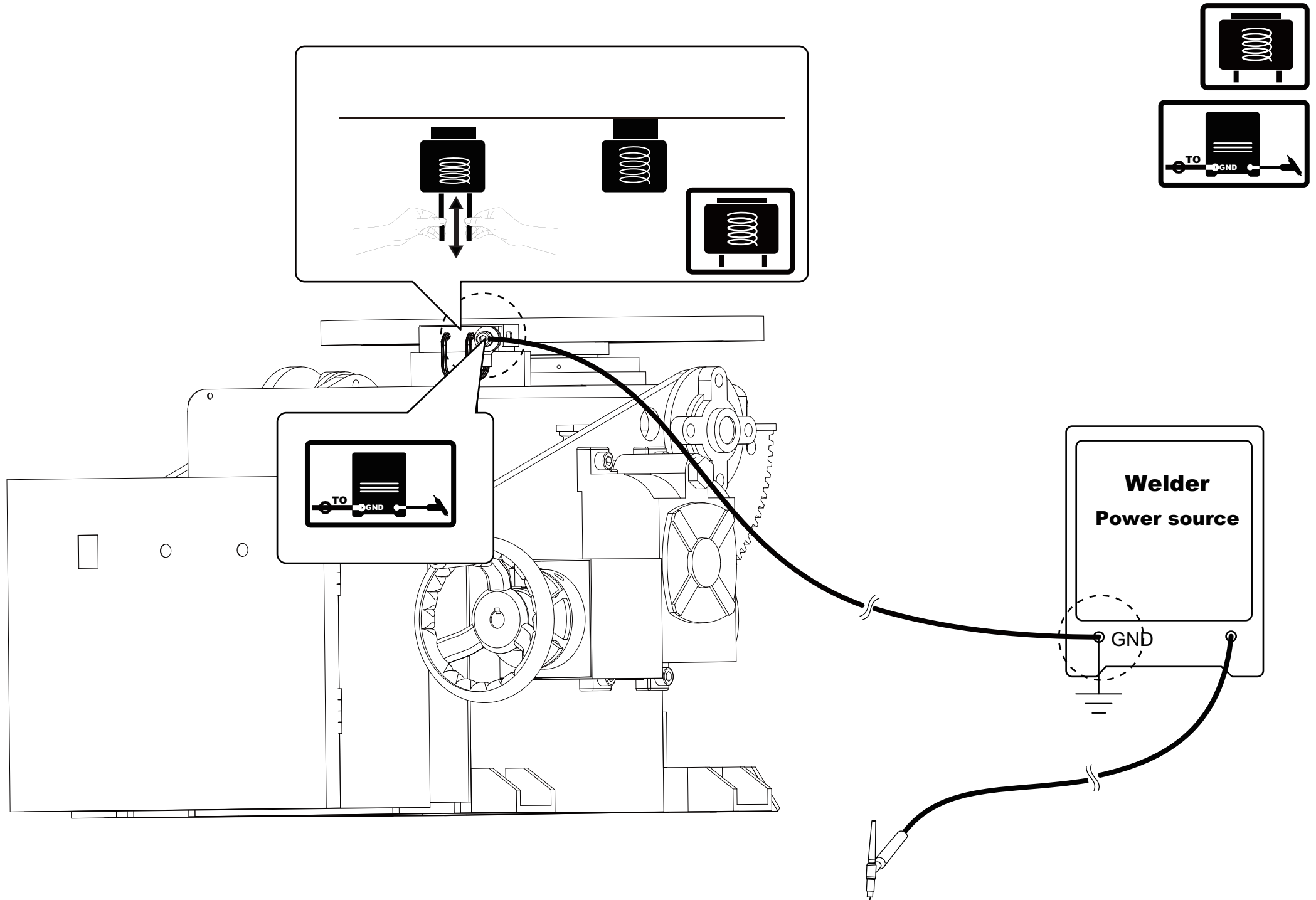


DIP3 ☐ OFF (不接觸)

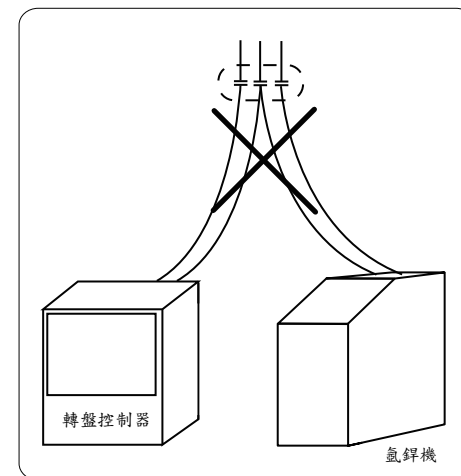
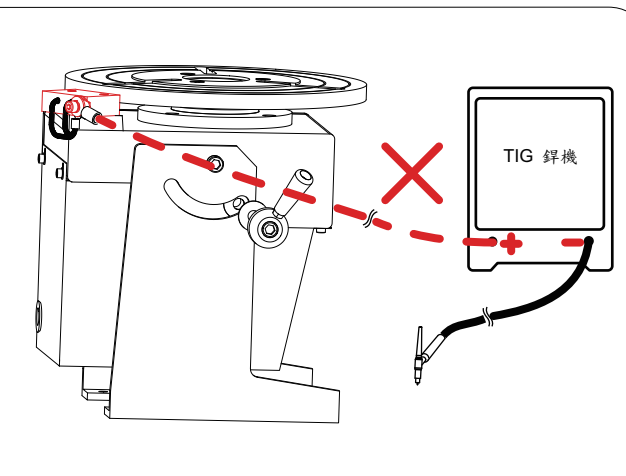
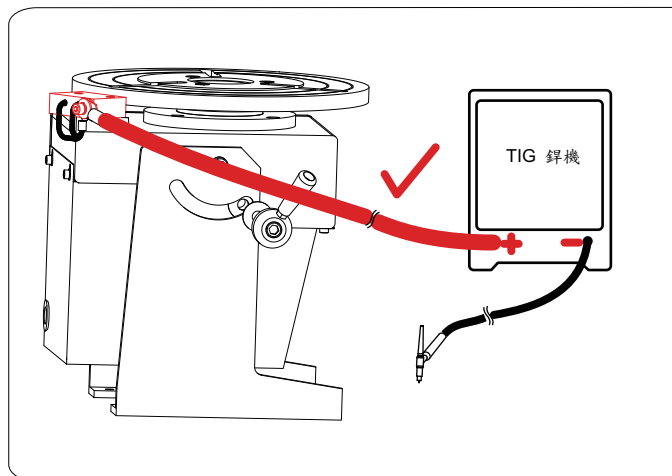
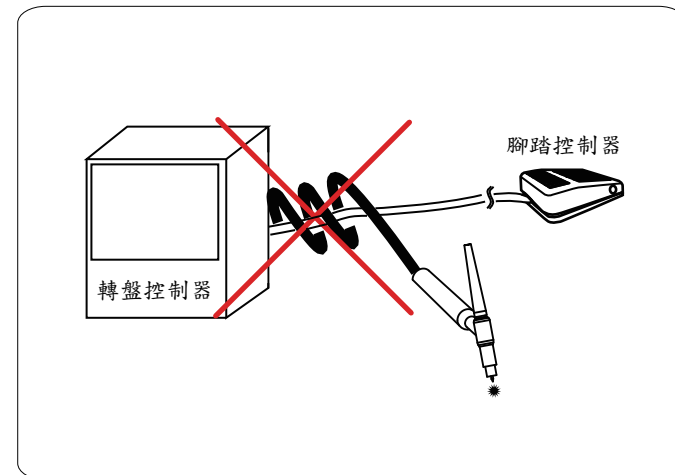
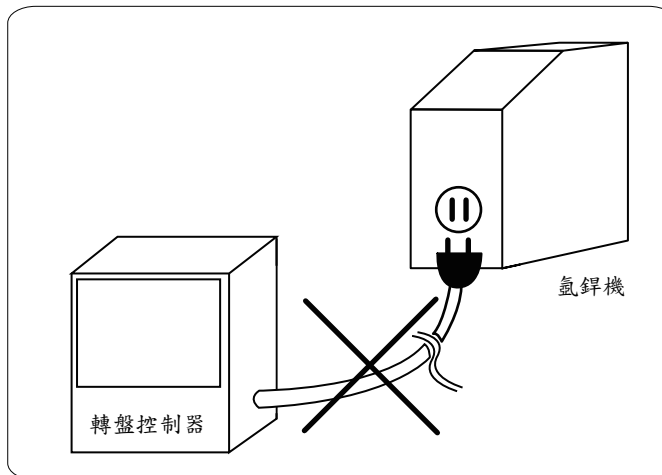
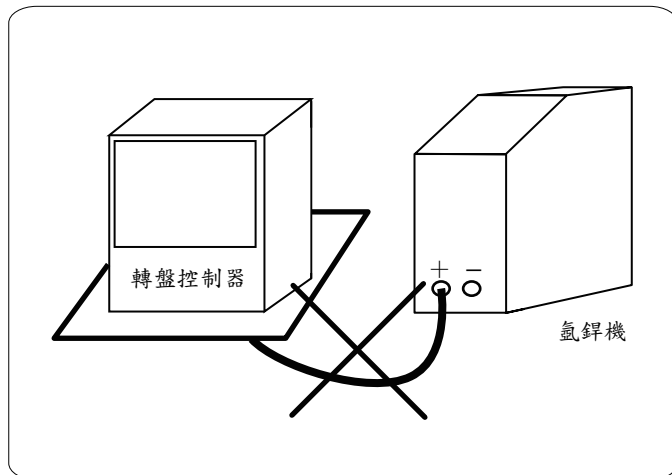
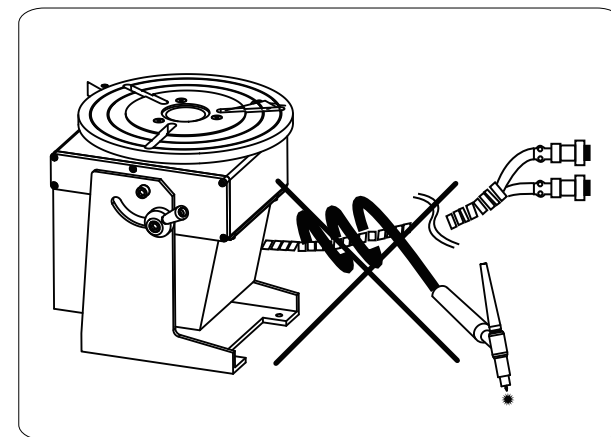
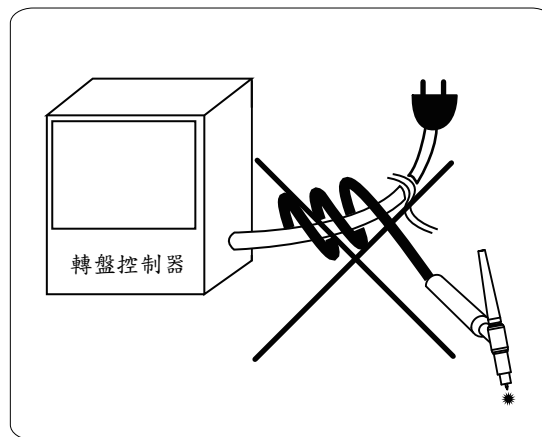
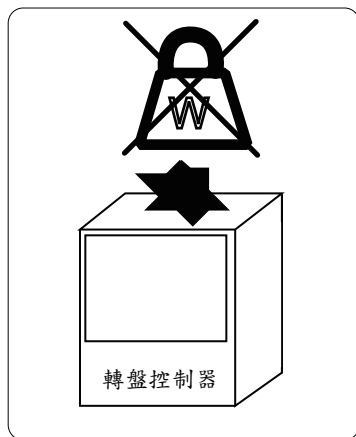
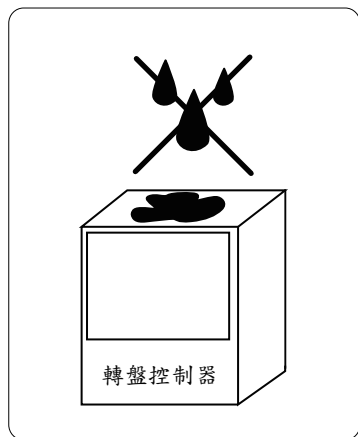


附錄

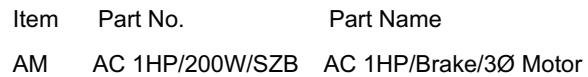
注意碳刷及接地



注意事項



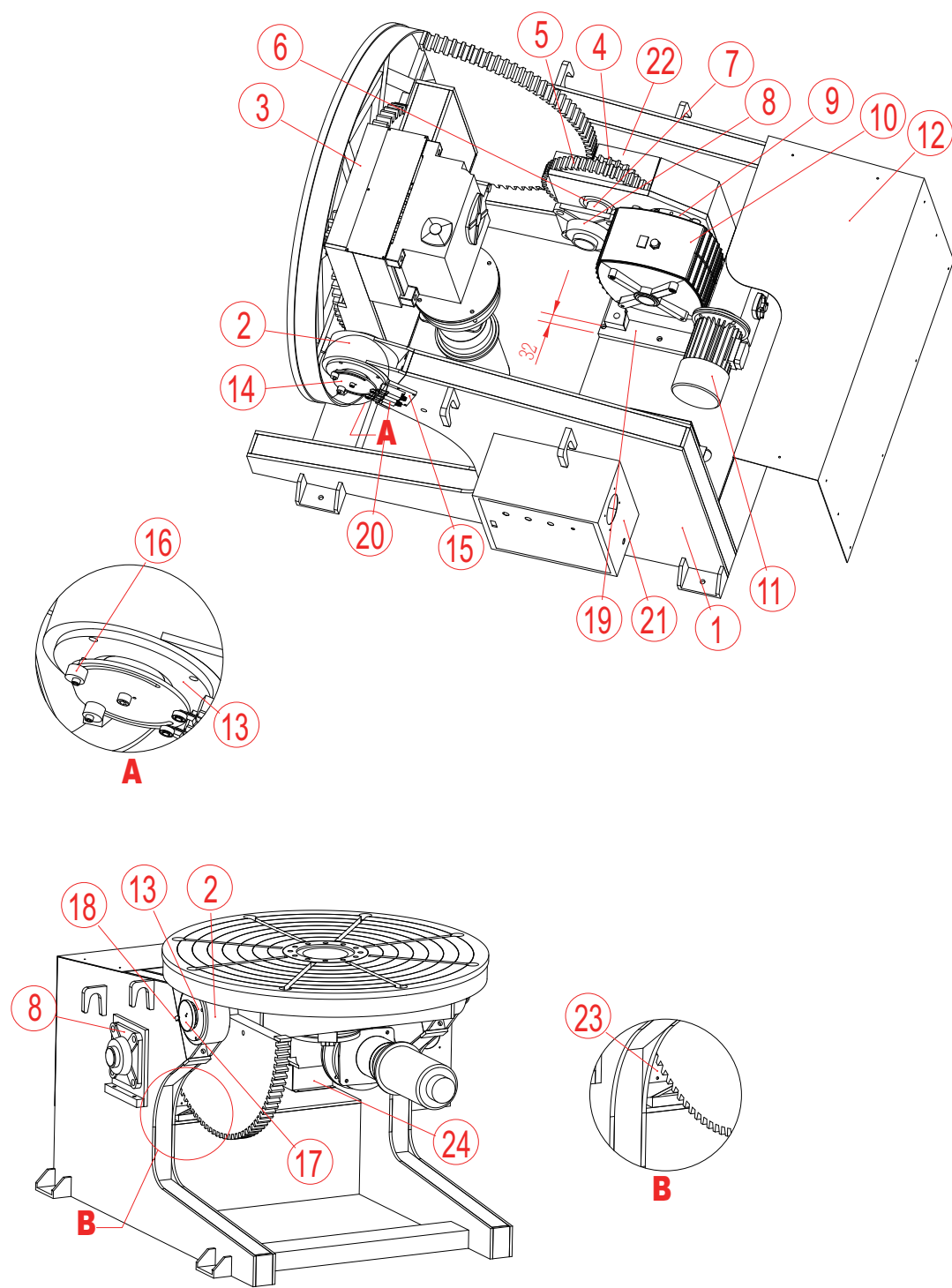




Item	Part No.	Part Name	Q`TY
P1	E1001	Control P.C.B	1
P2	DC 90/230/	DC Power driver P.C.B	1
M1	CU16/220 / 4A	Power Relay	1
M2	CU16/220 / 3A1B	Angle Power Relay	1
M3	CU16/220 / 3A1B	Angle Power Relay	1
M4	CU16/220 / 3A1B	Table Power Relay	1
M5	CU16/220 / 3A1B	Table Power Relay	1
SW1	SW22(R)	D22 Switch(power)	1
SW2	SW22(G)	D22 Switch(welder)	1
SW3	SW22(R)	D22 Switch(cw/ccw)	1
SW4	SW22(B)	D22 Switch(inch/hold)	1
SW5	SNAP1421	9pin Switch	1
BD1	RB22(R)	D22 Button(stop)	1
BD2	RB22(G)	D22 Button(start)	1
BD3	RB22(Y)	D22 Button(up)	1
BD4	RB22(Y)	D22 Button(down)	1
VR1	PC-VR1	Resistance 5kΩ	1
LS1	TZ-8104	Limit Switch	1
LS2	TZ-8104	Limit Switch	1
FS1	TFS-101Z(4M)	Foot Switch	1
FM	FM5A2	Fan motor 5"/220V	1
DM	DC 90V/150W/5GX	DC 90V/150W Motor	1
AM			1
VRK	VRK01-V2	VR Link P.C.B (AC 220)	1

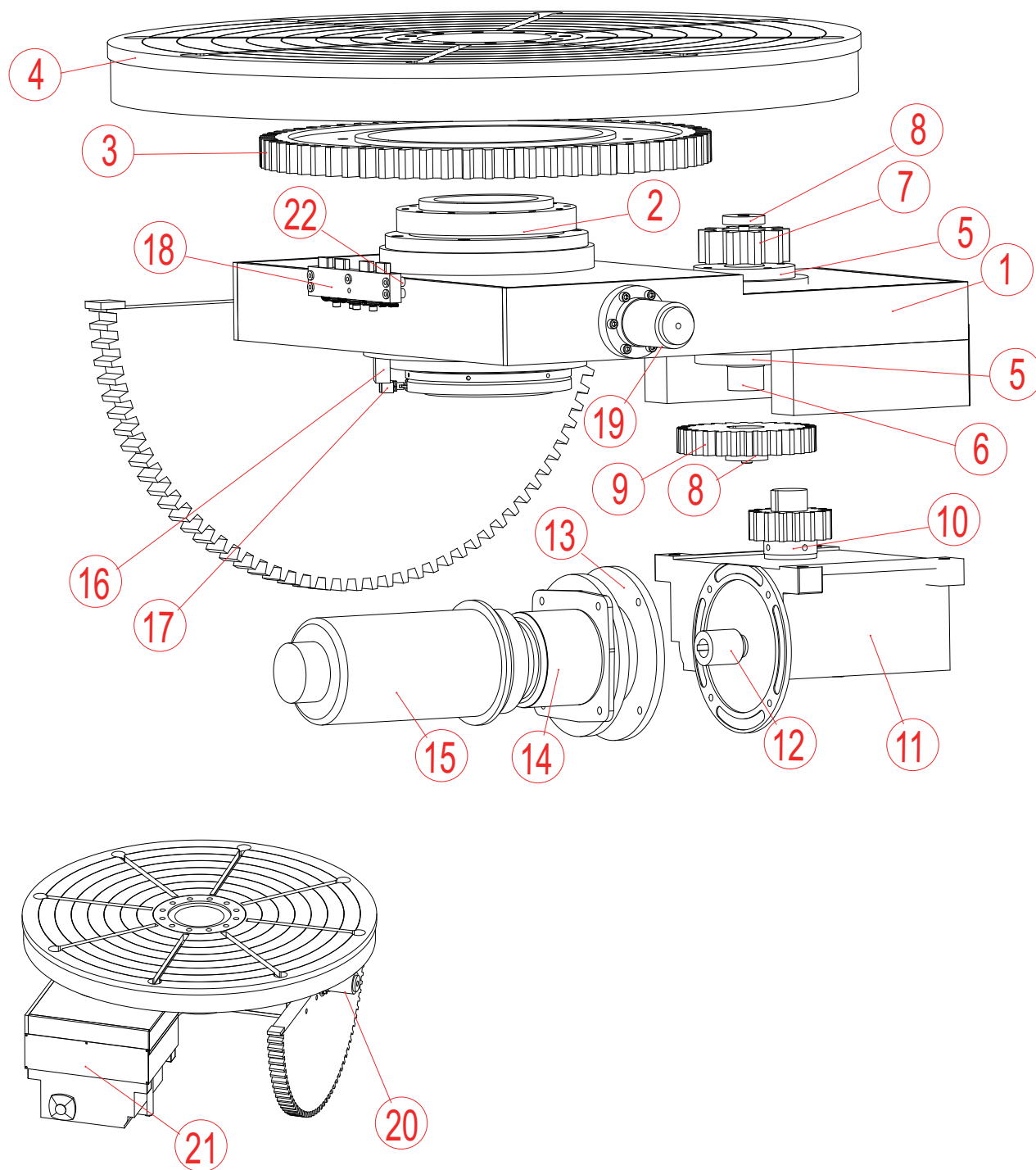
適用以下系列 **EVPOS-1TA & 2TA & 3TA & 5TA**
AC220V/3Ø

組合圖



件號	料號	名稱	數量
1	EV3T-18	基座組	1
2	EV3T-25	翻轉軸承座	2
3	WPT60FB-A1	主體箱組合	1
4	EV3T-08	18T齒輪	1
5	EV3T-09	50T齒輪	1
6	EV3T-24	墊環	1
7	EV3T-23	翻轉惰輪軸	1
8	UCF314	軸承座	2
9	EV3T-10	翻轉驅動齒輪	1
10	02OM-BHE155R-300B-2HP	雙段蝸輪減速機	1
11	02ACM-2HP24-3-B	交流馬達	4
12	EV3T-26	後護蓋	1
13	EV3T-21	軸承蓋	2
14	EV750A-01	微調板	1
15	EV3T-22	微動座	1
16	EV750A-02	碰觸塊	2
17	EV750-16	角度板	1
18	EV1T-24	32刻度指針	1
19	EV3T-15	減速機座	1
20	03YJ-8104	微動開關	1
21	EV-02	控制箱450*400	1
22	EV3T-30	後齒輪護蓋	1
23	EV3T-29	前齒輪護蓋	1
24	EV3T-28	變電箱護蓋	1

組合圖



件號	料號	名稱	數量
1	EV3T-01	主體齒輪組	1
1-1	01BL-HR32036	軸承HR32036	1
1-2	01BL-HR32034	軸承HR32034	1
2	EV3T-33	主軸	1
3	EV3T-35	上油封座	1
4	EV3T-34	170襯套	1
5	EV3T-36	下油封座	1
6	EV3T-37	主軸螺帽	1
7	EV3T-03	轉盤齒輪	1
8	EV3T-02	平盤	1
9	EV3T-11	軸承座	2
10	EV3T-16	惰輪軸	1
11	EV3T-04	10T齒輪	1
12	EV3T-17	墊片	2
13	EV3T-05	30T齒輪	1
14	EV3T-06	驅動齒輪	1
15	02OM-KE155RD-30B-10HP	蝸輪減速機	1
16		游星式齒輪減速機	1
17	02ACM-2HP24-3	交流馬達	1
18	EV3T-1-1	接地銅座組	1
19	EV3T-13	加長轉位軸心	1
20	EV3T-12	轉位軸心	1
21	EV3T-14	主體後護蓋	1
22	EV3T-32	銅座絕緣墊塊	5