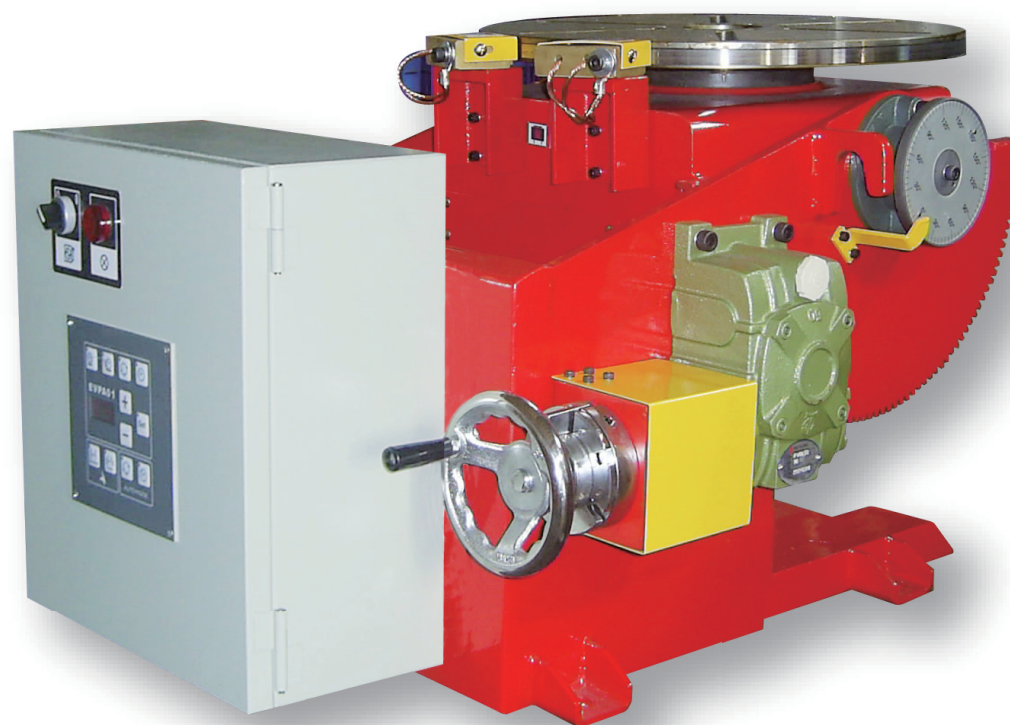




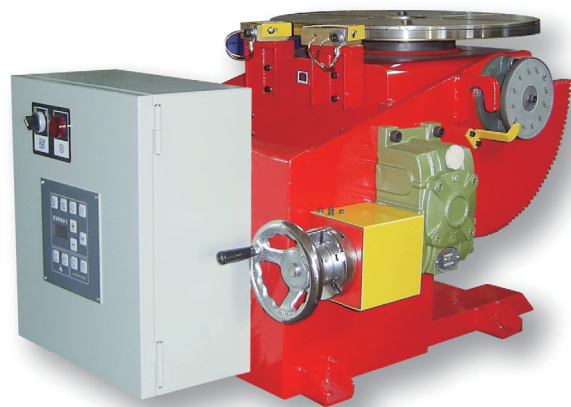
操作手冊

EVPOS-500MCA 銲接定位器

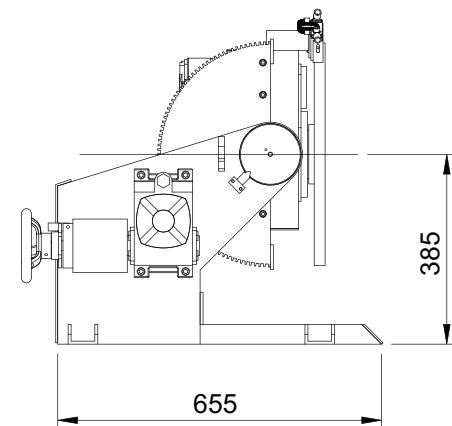


Chapter 1: 諸元

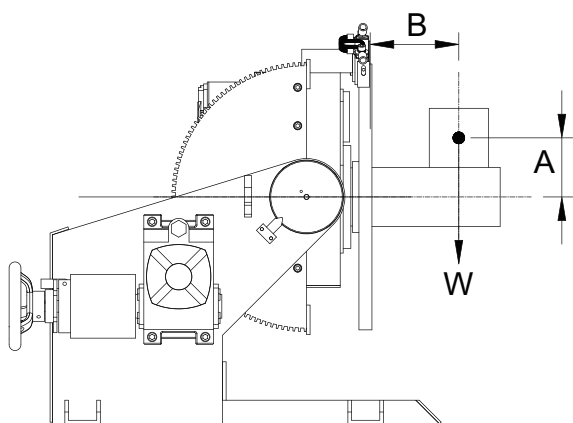
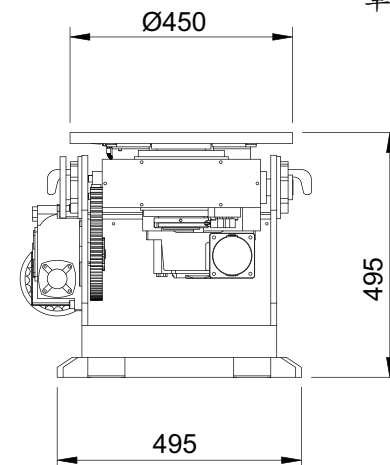
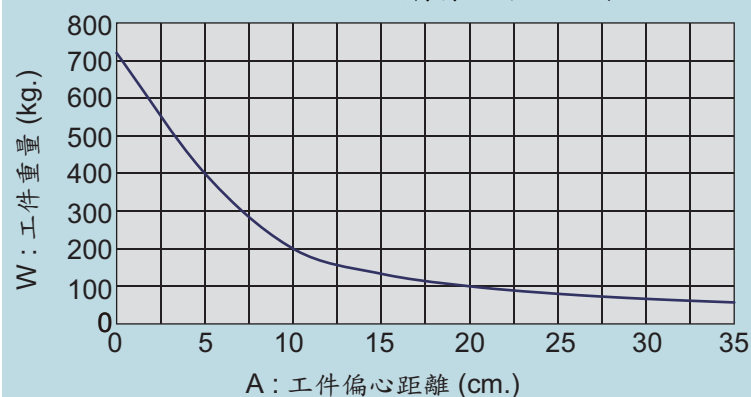
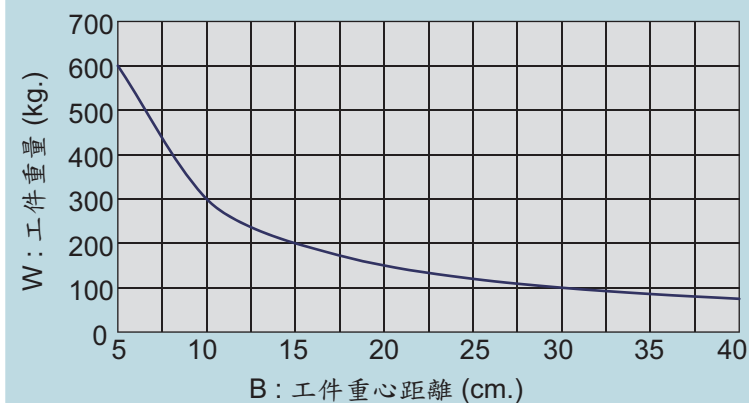
1.1 諸元



型號	EVPOS-500MCA
入力電源	AC 220V / 5A / 50;60Hz / 1Ø
轉盤馬達	DC 90V / 100W
工件重量(W)	500Kg.
工件偏心距離(A)	60mm.
工件重心距離(B)	60mm.
盤面直徑	450mm.
軸心孔徑	60mm.
盤面轉數	0.26~2.6 RPM
盤面傾斜角度	0°- 90°
盤面傾斜速度	手動
盤面傾斜安全鎖	機械卡榫
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)
銲機啟動模式	□ 標準(二週期) / ▽ 收尾(四週期)
接地效率	400A / 100%
盤面啟動	腳踏開關(3M長)
控制操作	有線控制器(3M長)



單位:mm

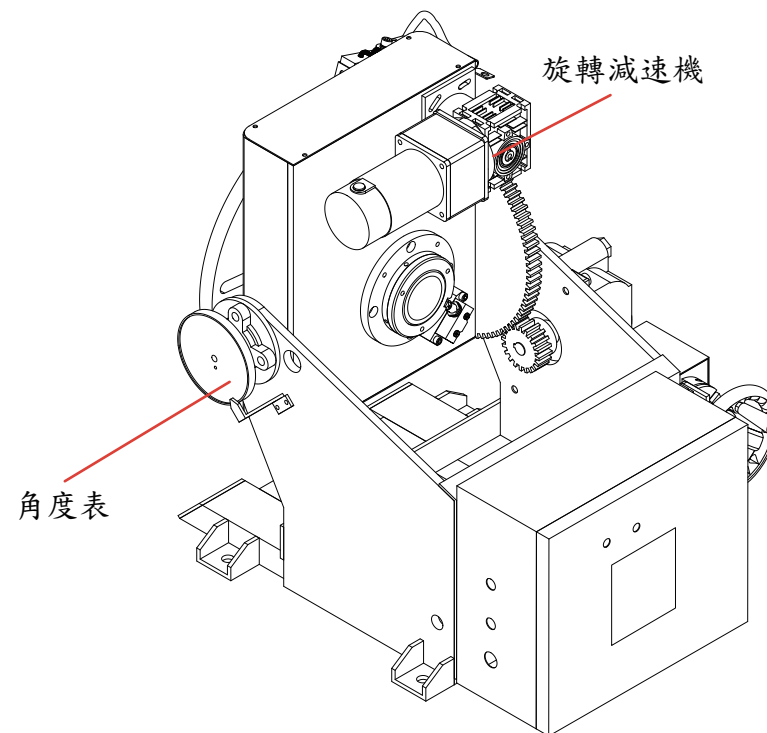
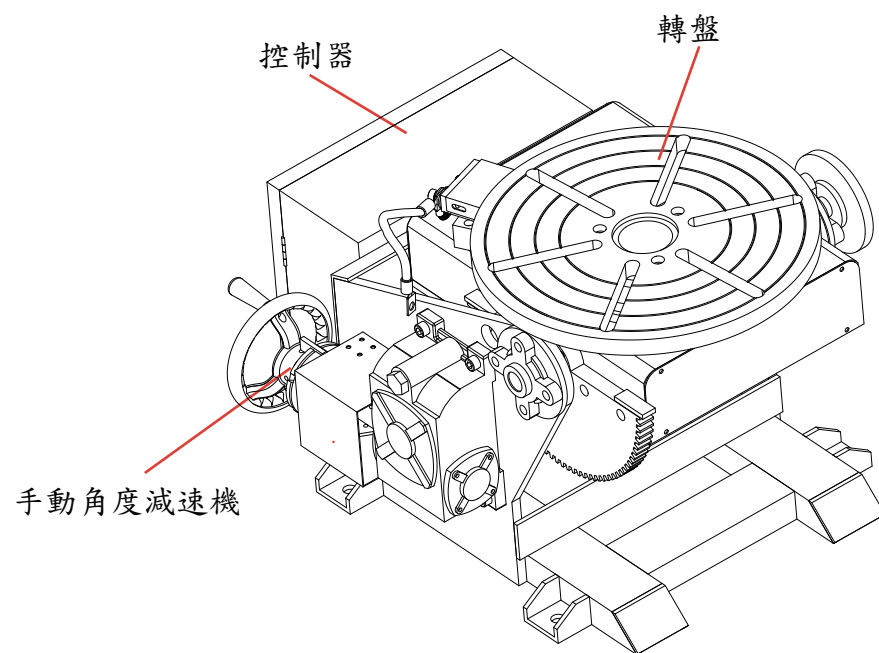
**EVPOS-500MCA** 旋轉荷重偏心距離表**EVPOS-500MCA** 盤面傾斜重心高度表

1.2 結構說明

1.2.1 標準配件

部件名稱	數量
踏板開關 	1
鉸機起動線 	1

1.2.2 EVPOS for MCA 系列結構



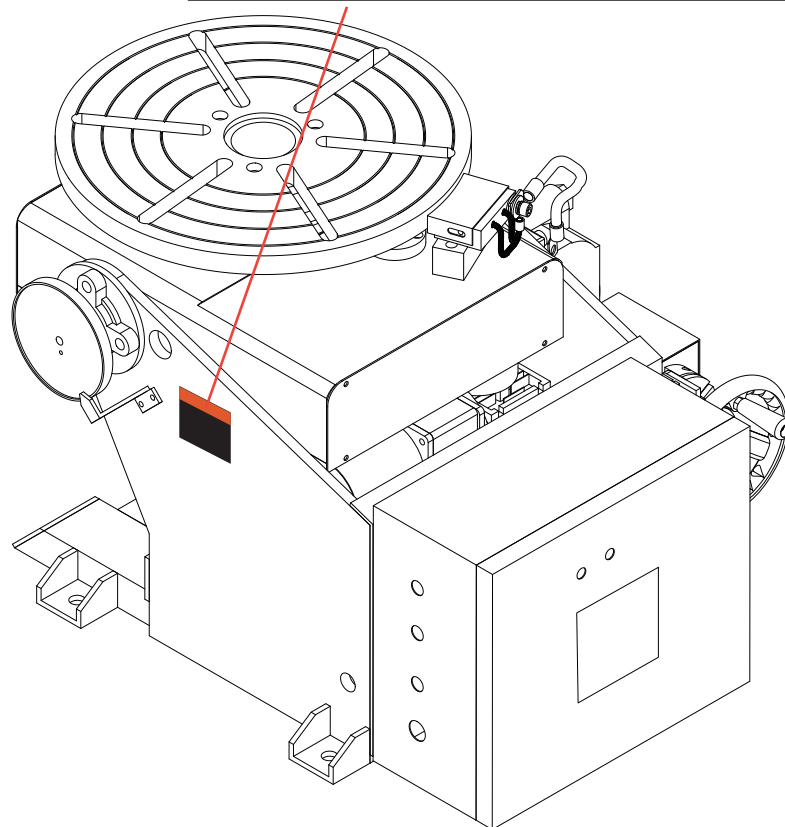
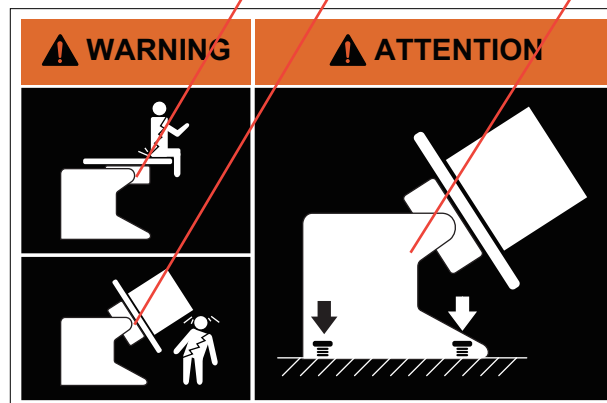
Chapter 2: 安全與說明

2.1 安全標籤

機器運轉或靜止請勿坐在上面。

當機器翻轉移動或靜止狀態下請勿在工件底下。

機座與地面固定確實。



2.2 電力危險和高溫

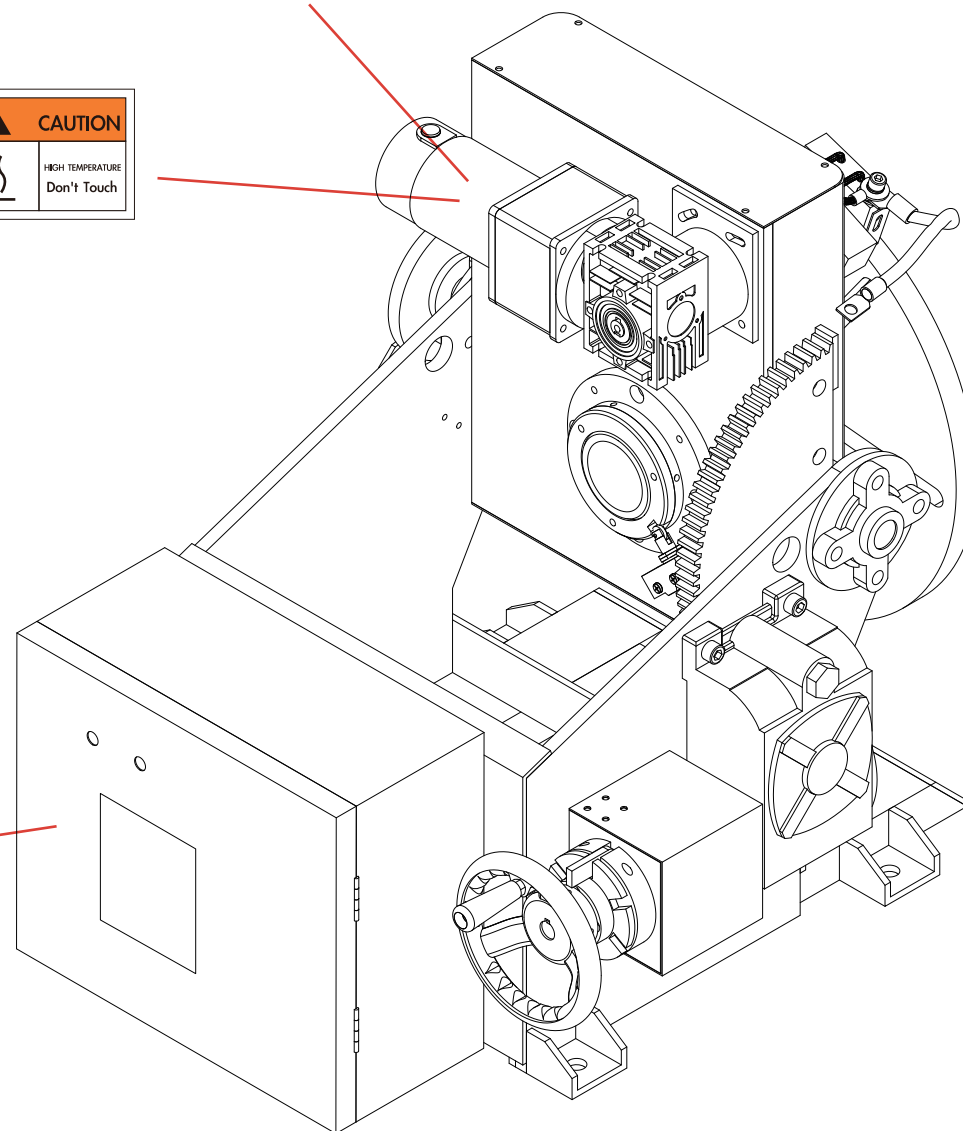


-電力危險標誌。



-高溫危險標誌。

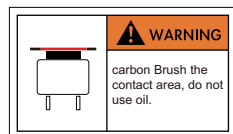
高溫請勿觸摸



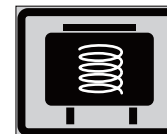
2.3 夾手及其他



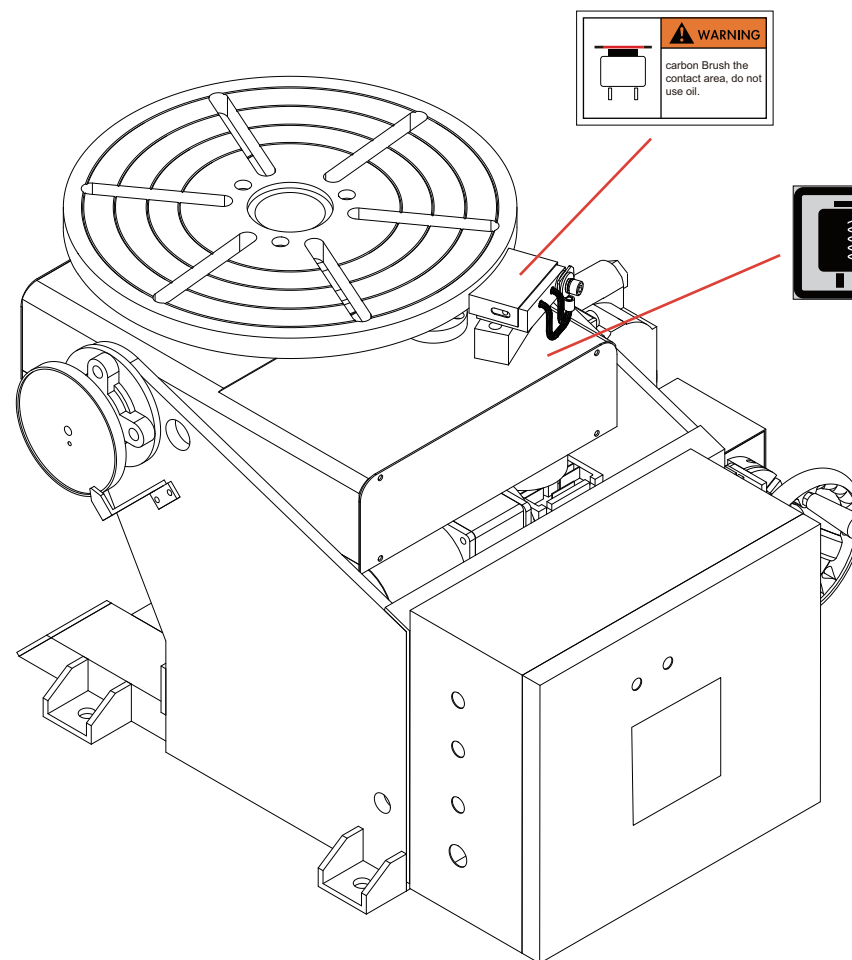
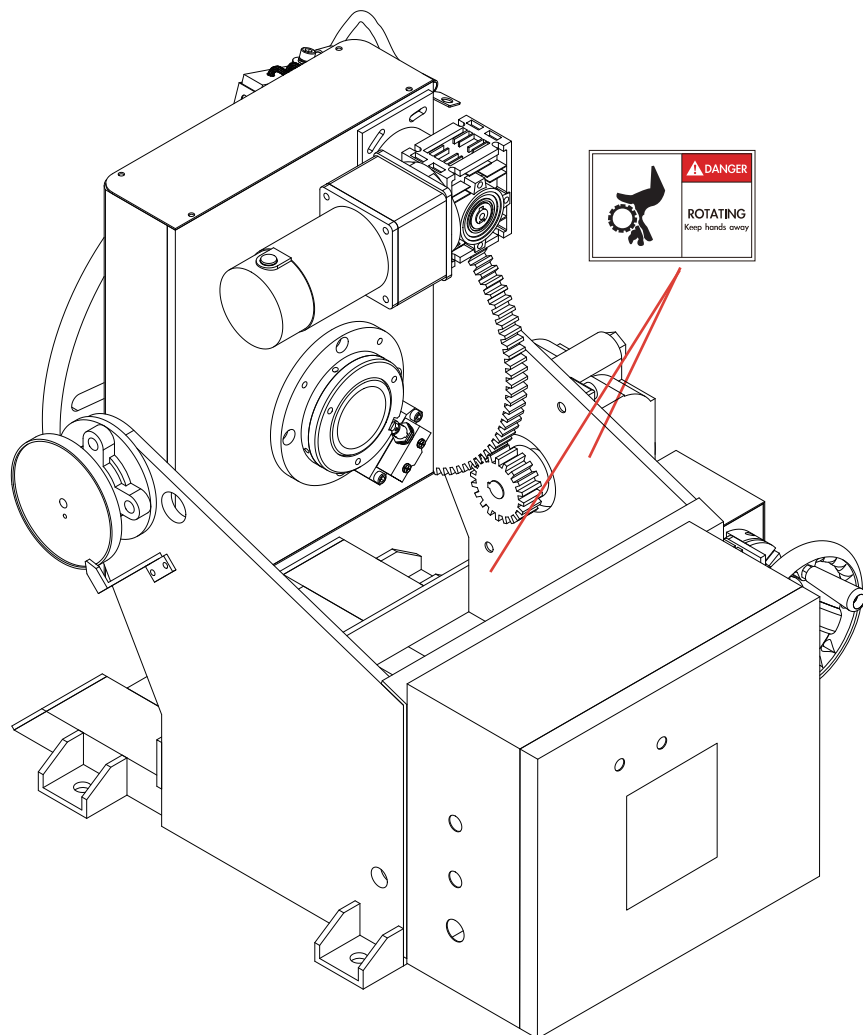
—旋轉中，切勿觸碰標誌。



—碳刷接觸面積，不要油標誌。

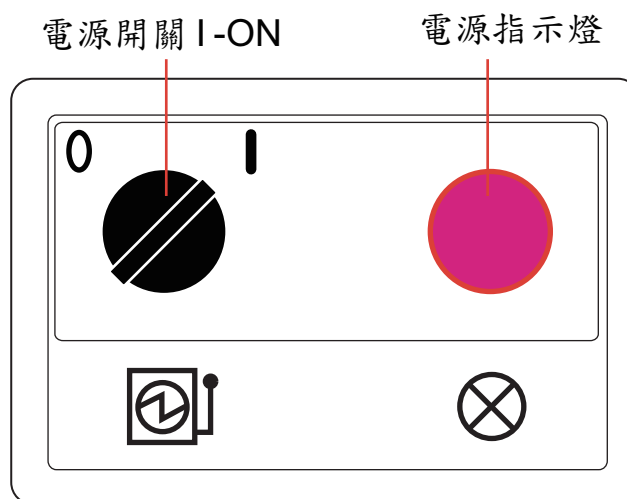
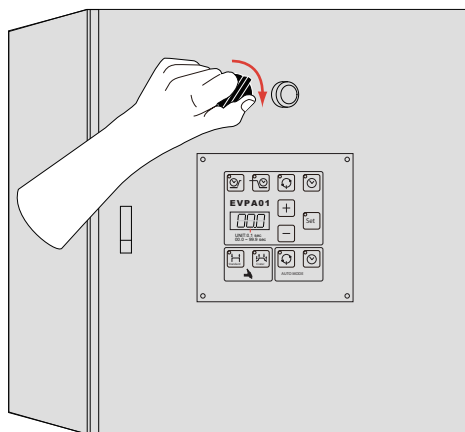


檢查碳刷標誌。

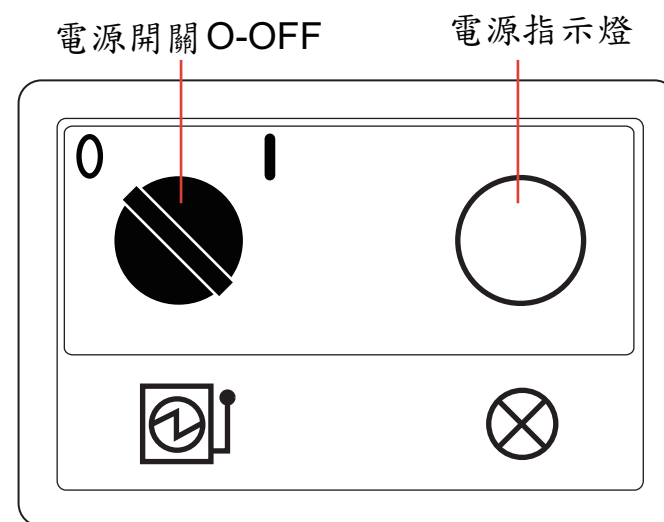
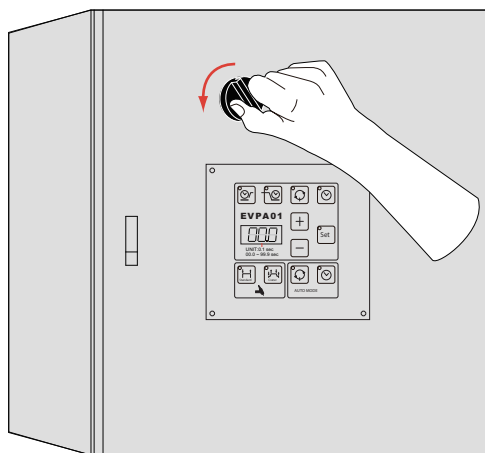


2.4 電源

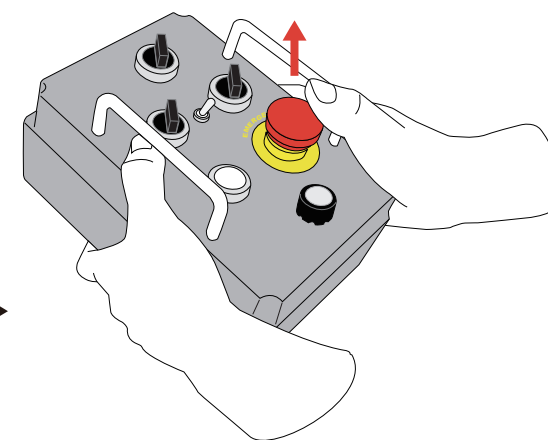
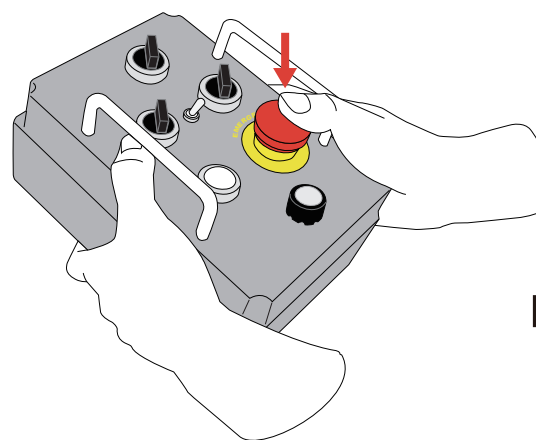
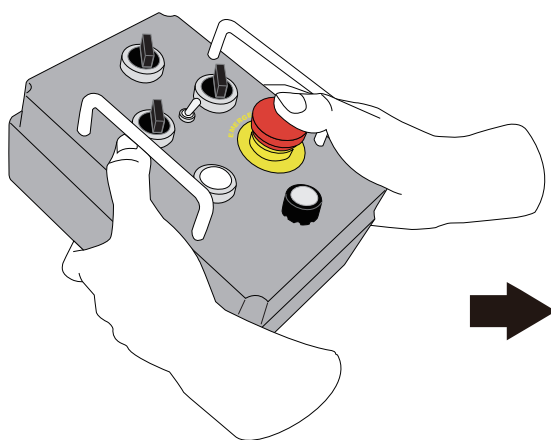
2.4.1 啟動電源



2.4.2 關閉電源



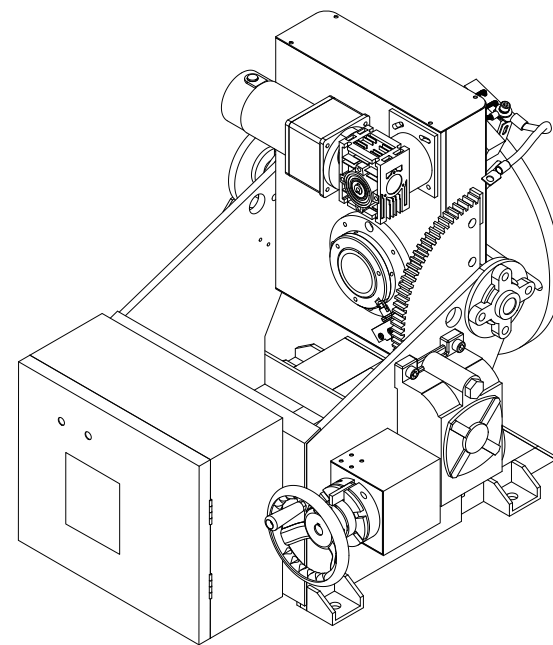
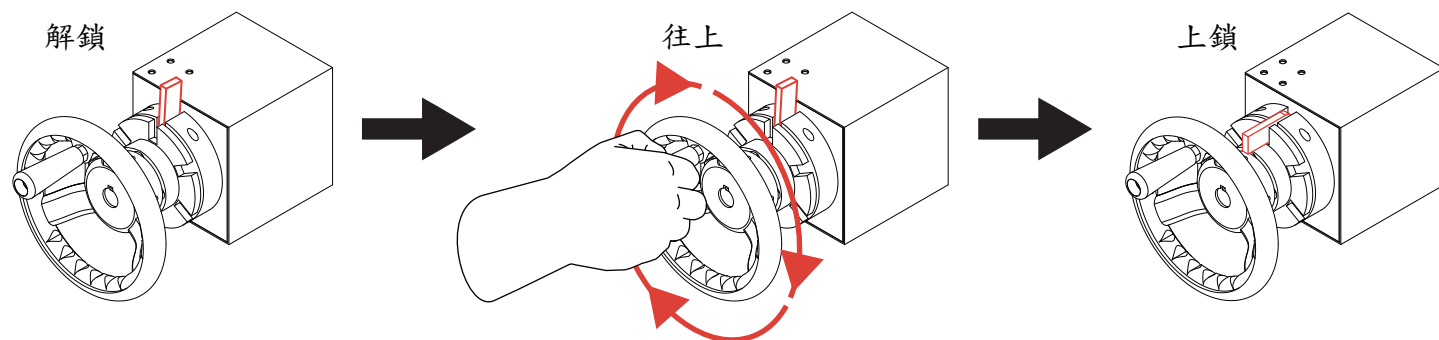
2.5 停止



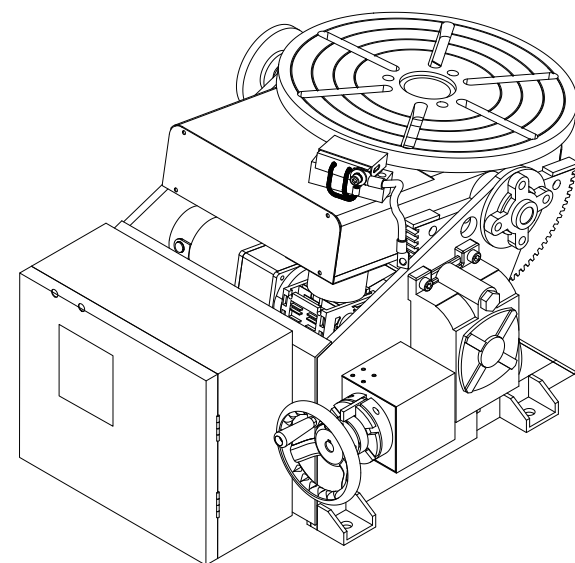
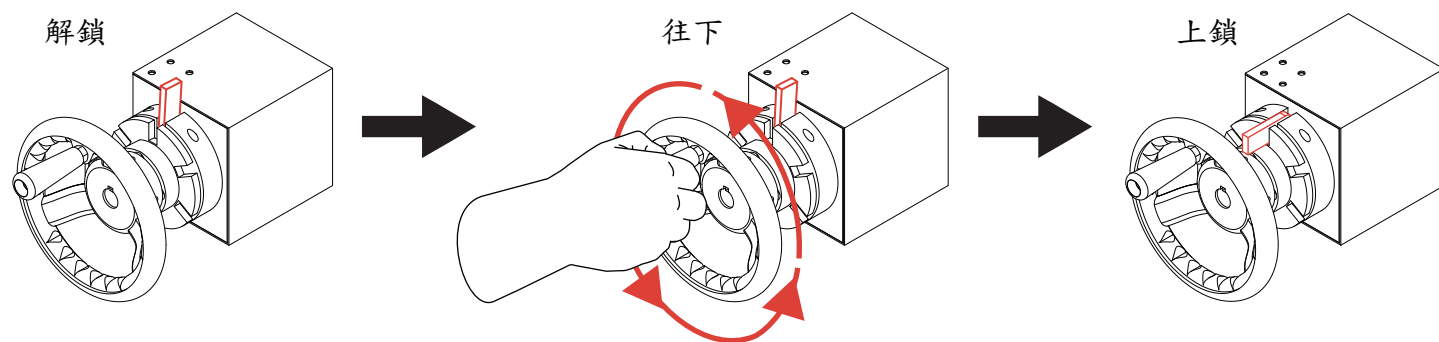
中止結果與繼續操作，請參考 31,32,41,42頁。

2.6 盤面角度

2.6.1 往上角度



2.6.2 往下角度



2.7 控制面板

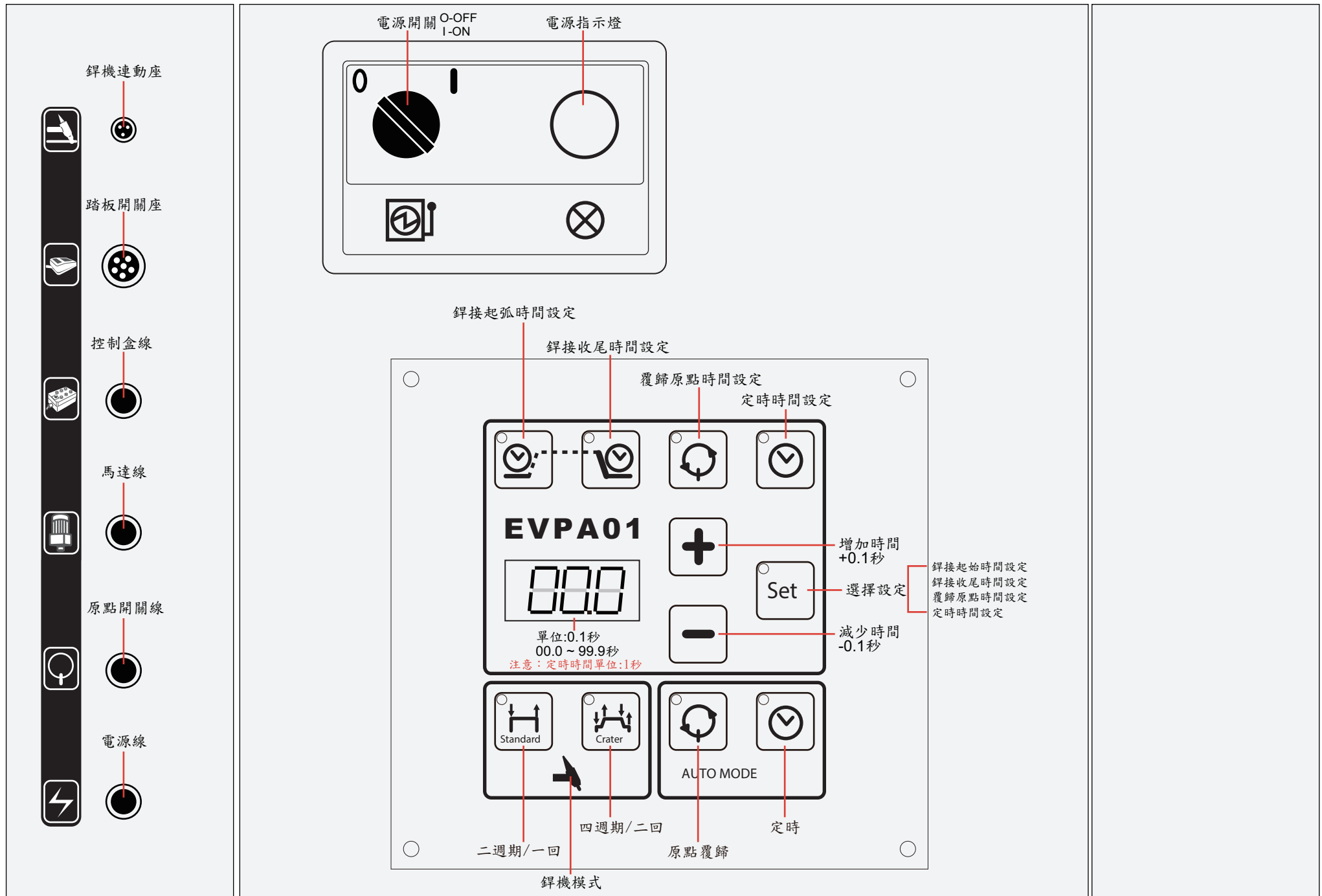
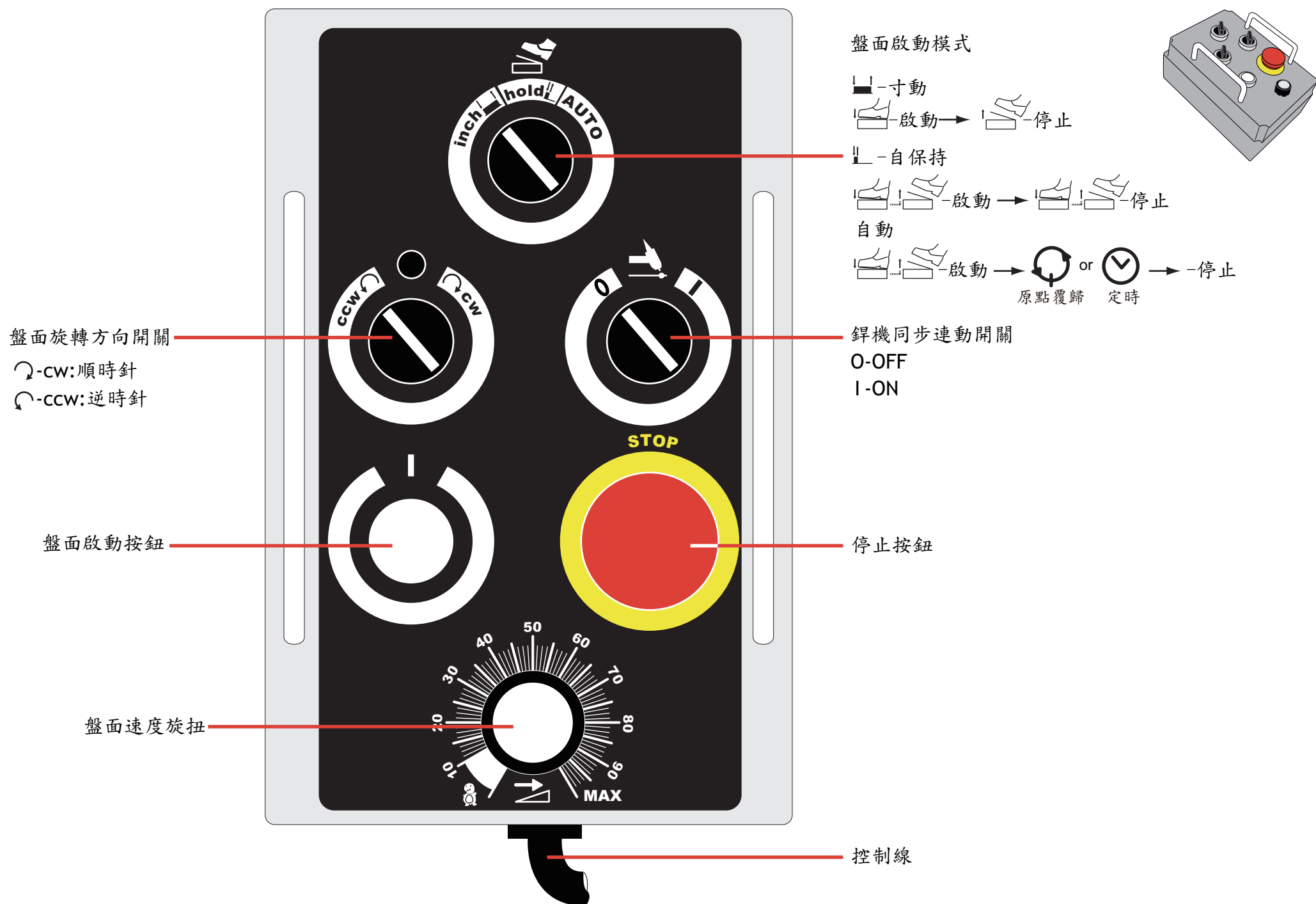


Figure:2.8-1

2.8 遙控面板說明



Chapter 3: 安裝

3.1 電源安裝說明

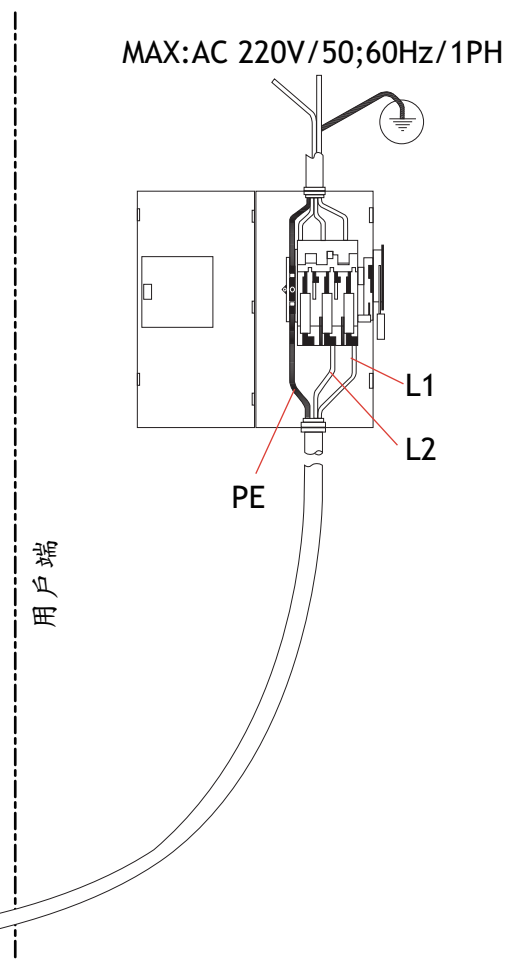
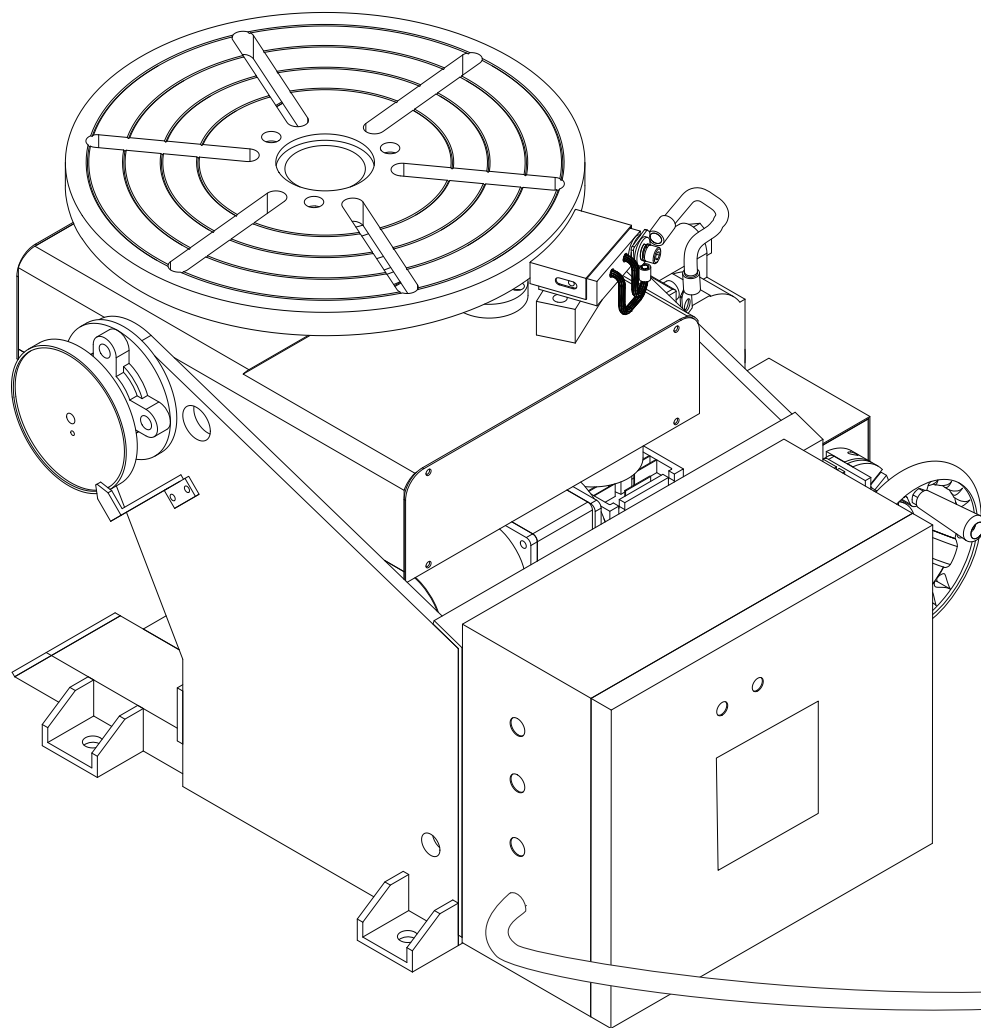
3.1.1 電源 AC 220V / 50;60Hz / 1Ø.

3.1.2 使用電源保護開關(電流 10A).

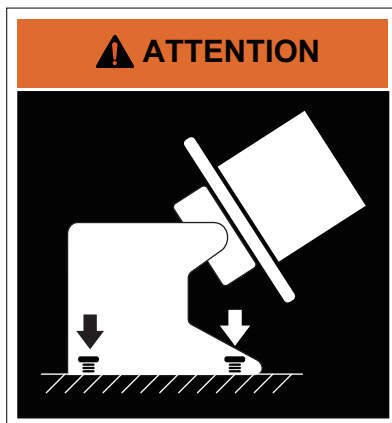
3.1.3 使用正當的工具，安裝電線和電力中斷的電路開關.

3.1.4 不能使用破損或老舊的電線.

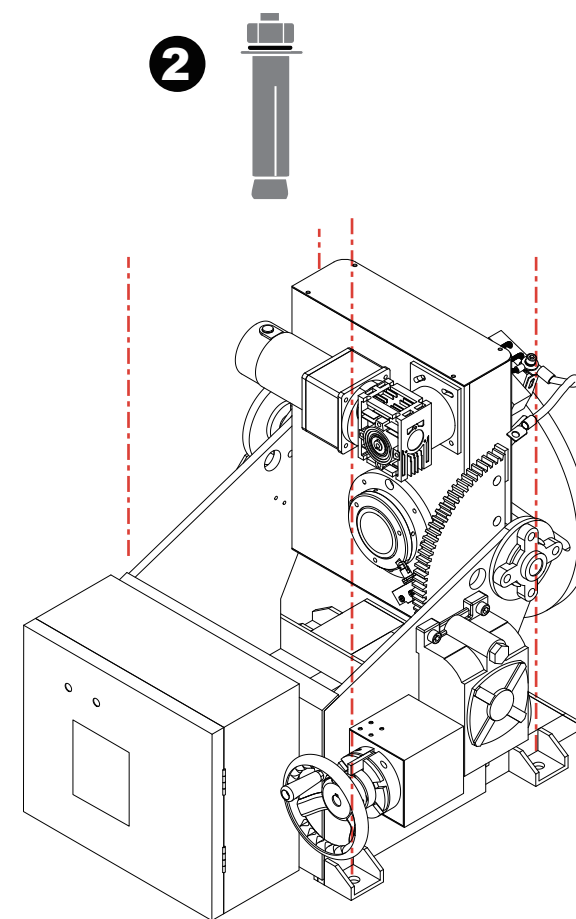
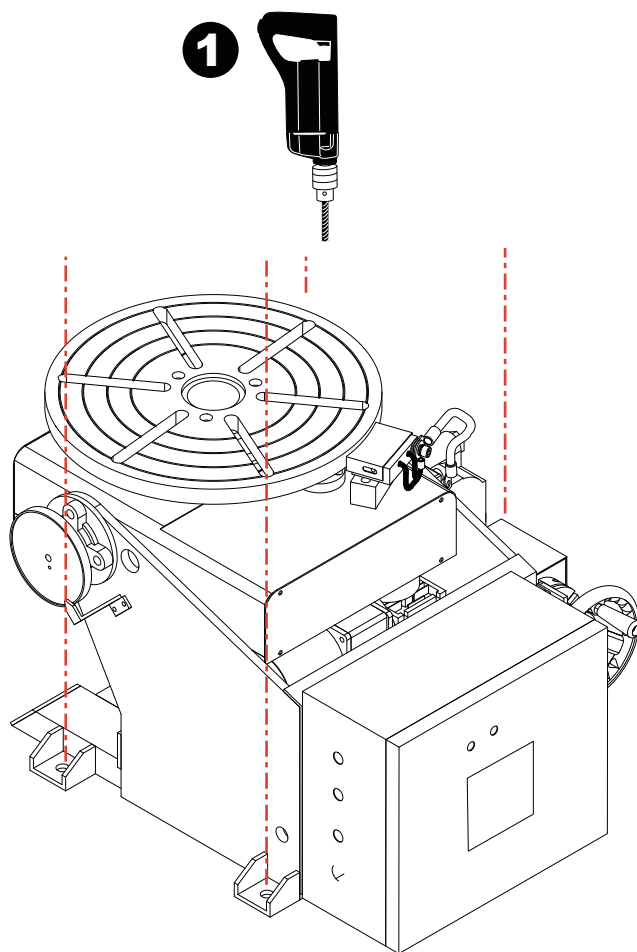
3.1.5 不要與其它機器根本機共用電源開關.



3.2 固定機座

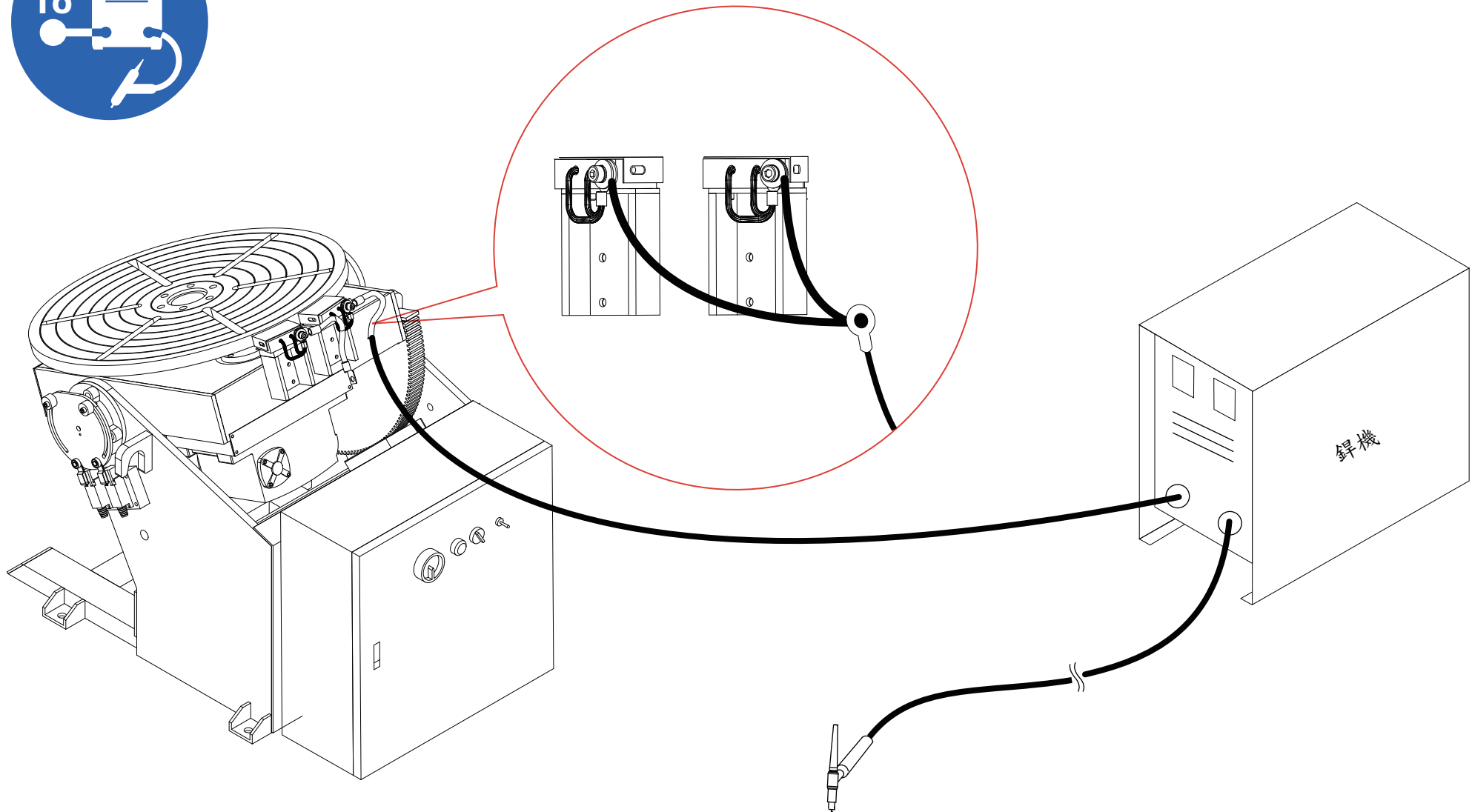
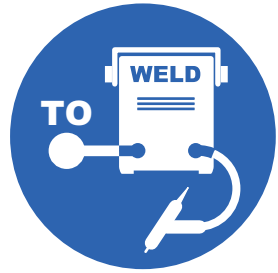


		
300MCA	M12x40mm	M14
500MCA	M12x40mm	M14
750MCA	M12x40mm	M14



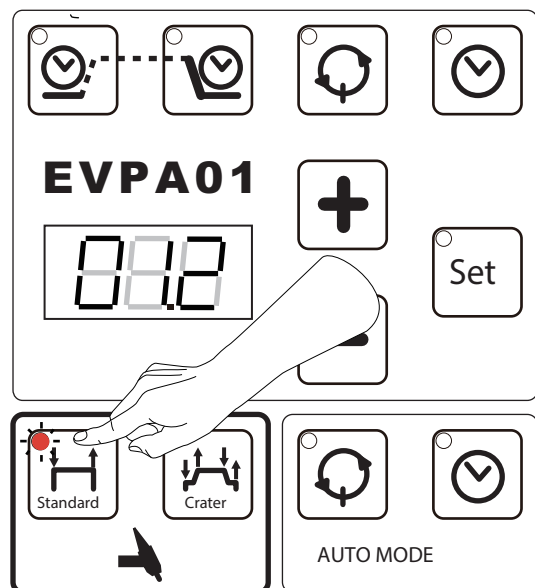
3.3 接地碳刷與鐸機連線配合

3.3.1 碳刷與鐸機之間電纜請確實鎖緊。

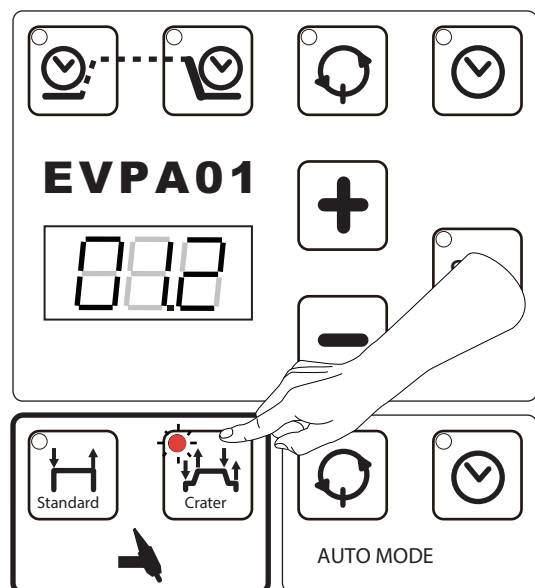


Chapter 4: 操作

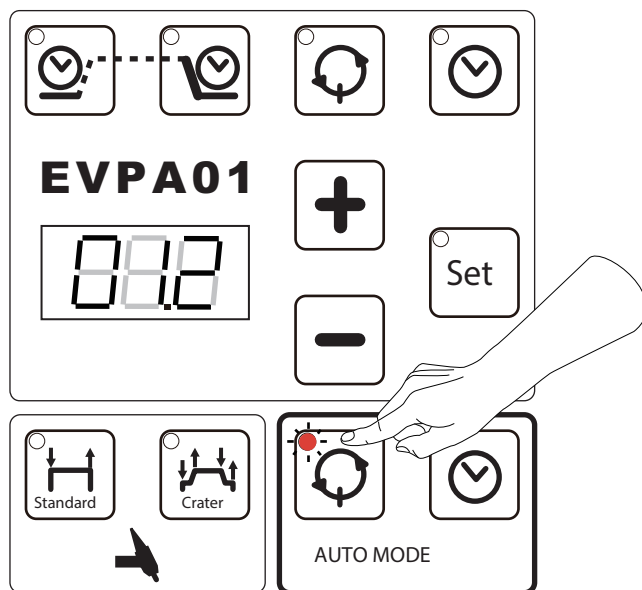
4.1 鐳機模式-2T(二週期/一回)



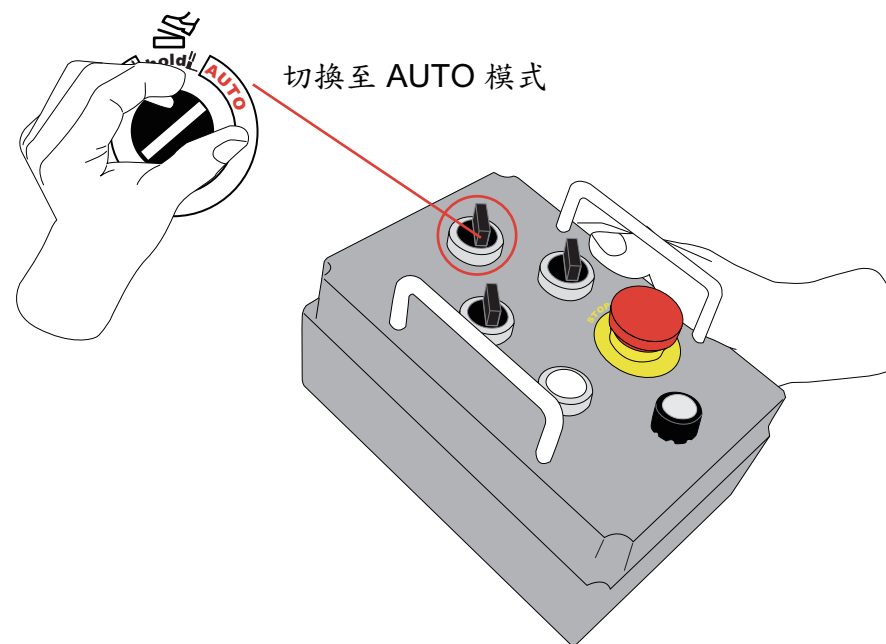
4.2 鐳機模式-4T(四週期/二回)



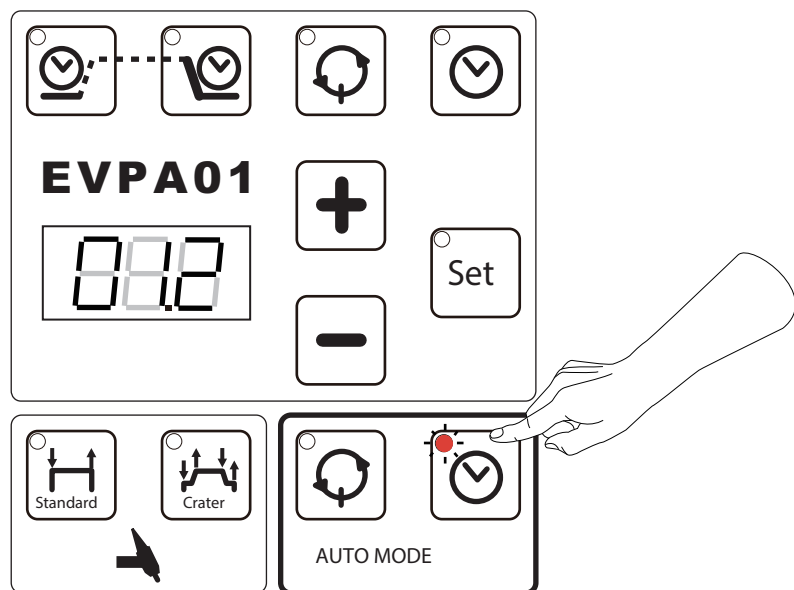
4.3 復歸原點自動模式



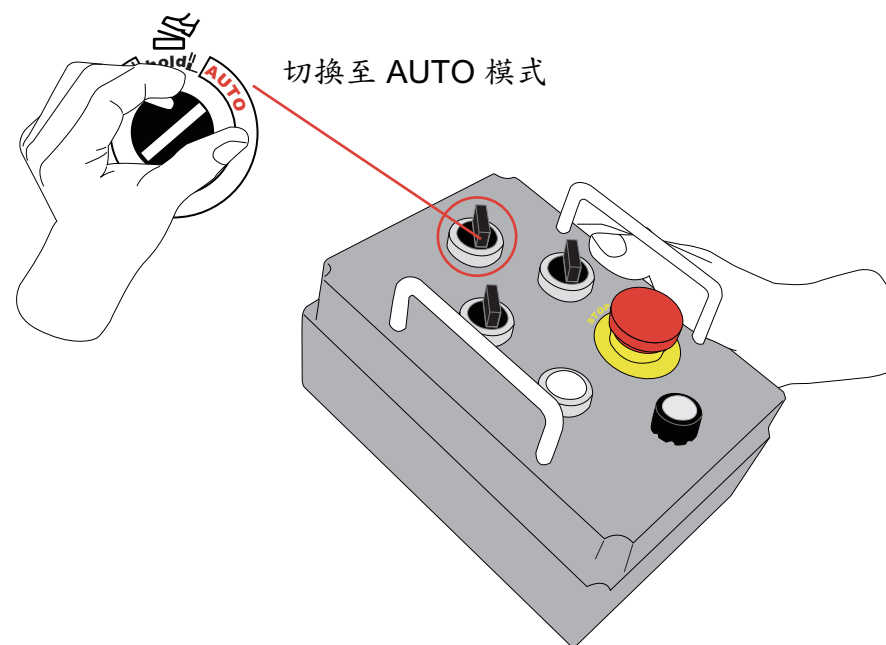
與



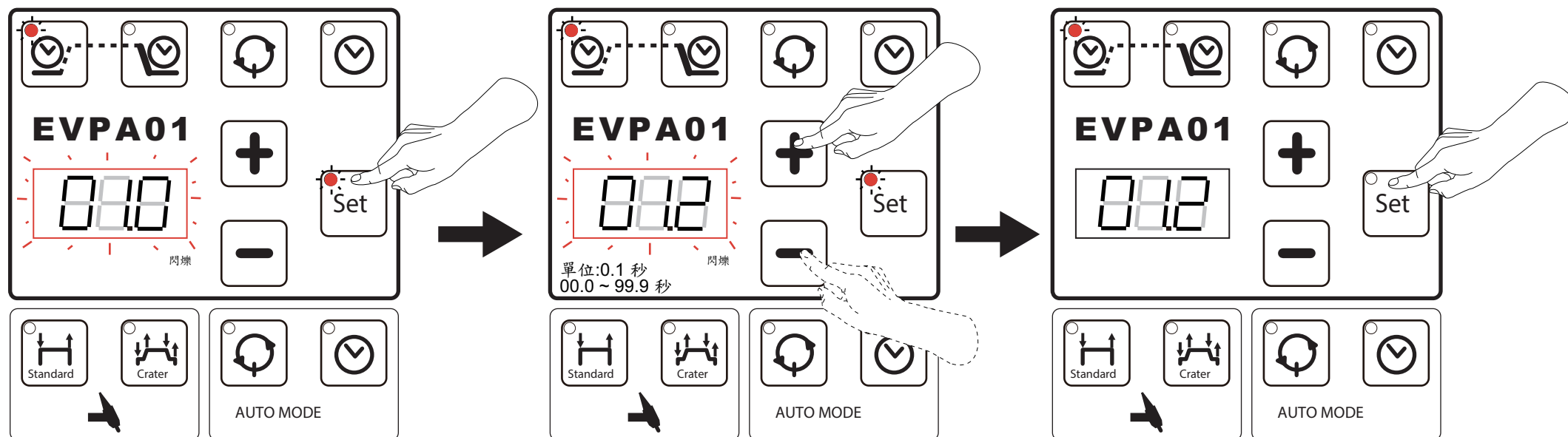
4.4 定時自動模式



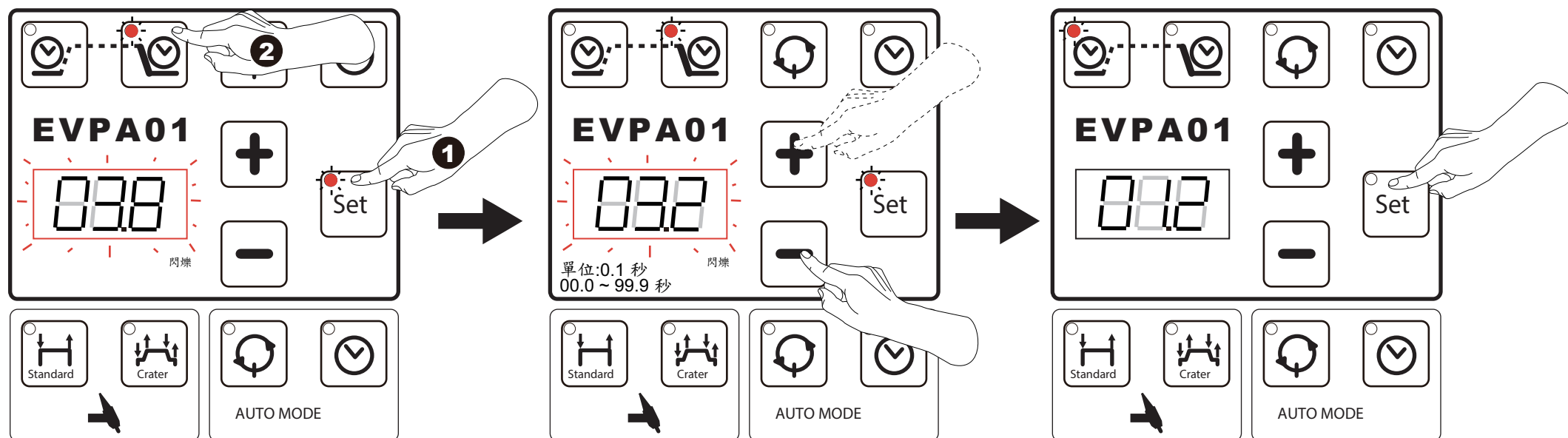
與



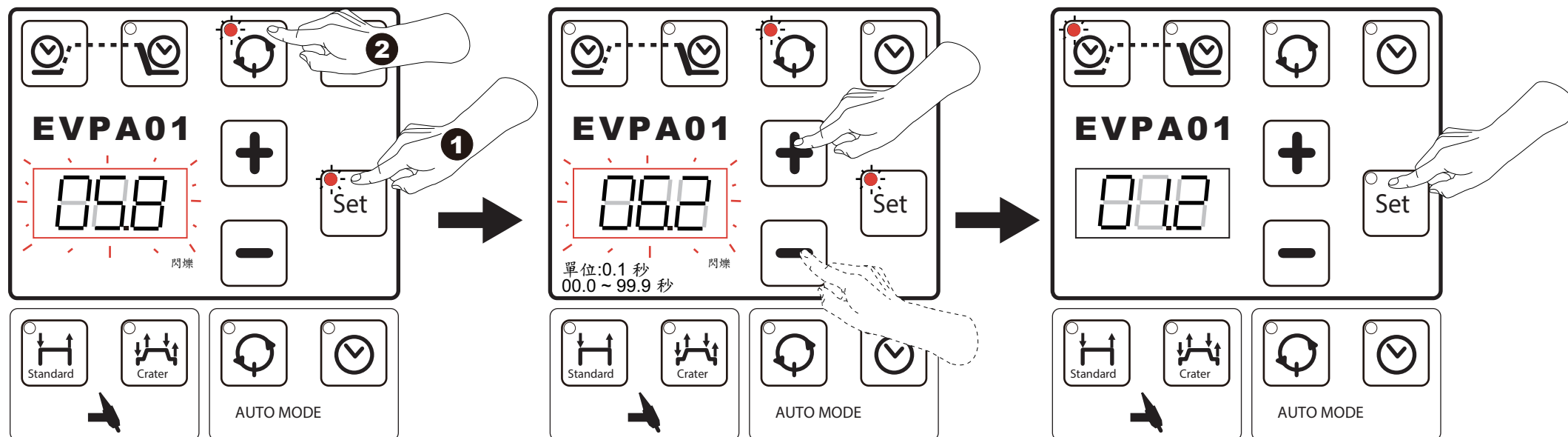
4.5 鐸機起弧時間設定



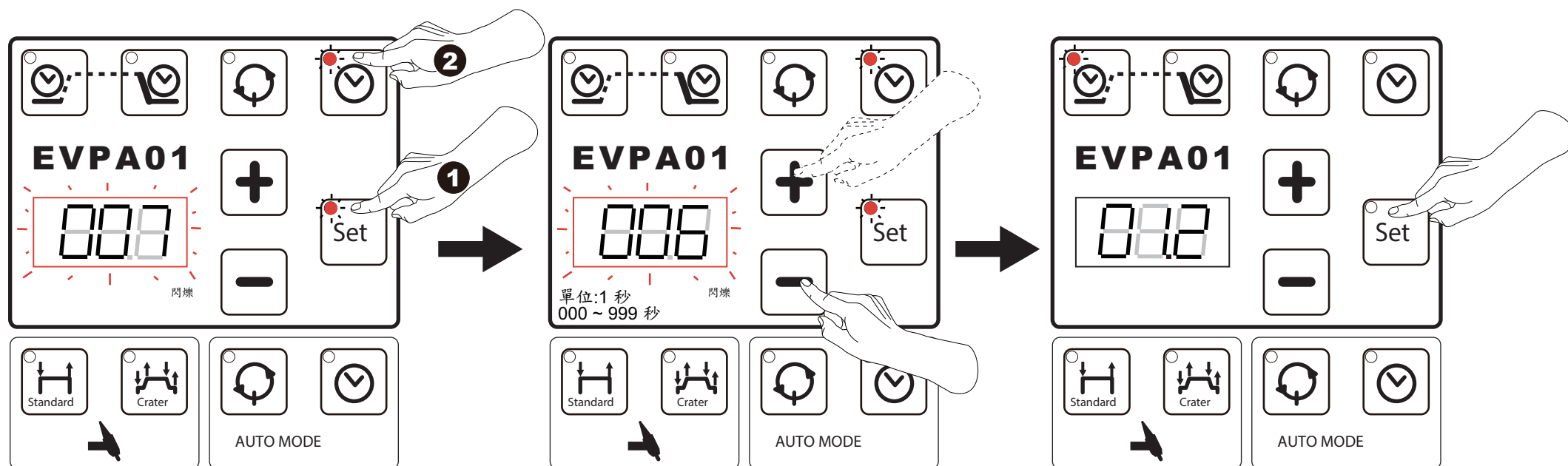
4.6 鐸機收尾時間設定



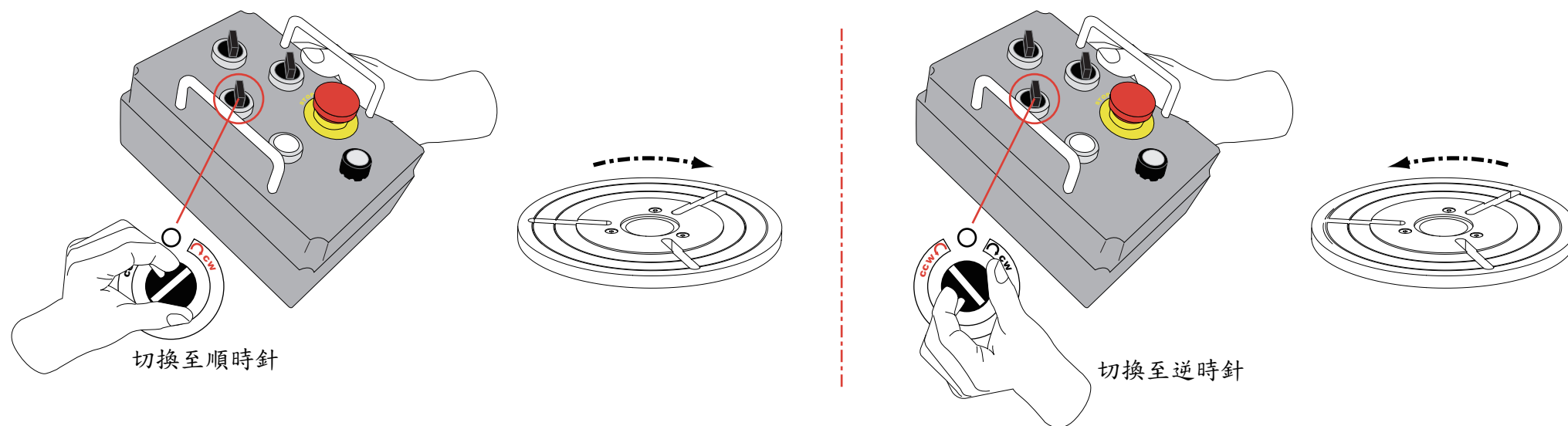
4.7 覆歸原點時間設定



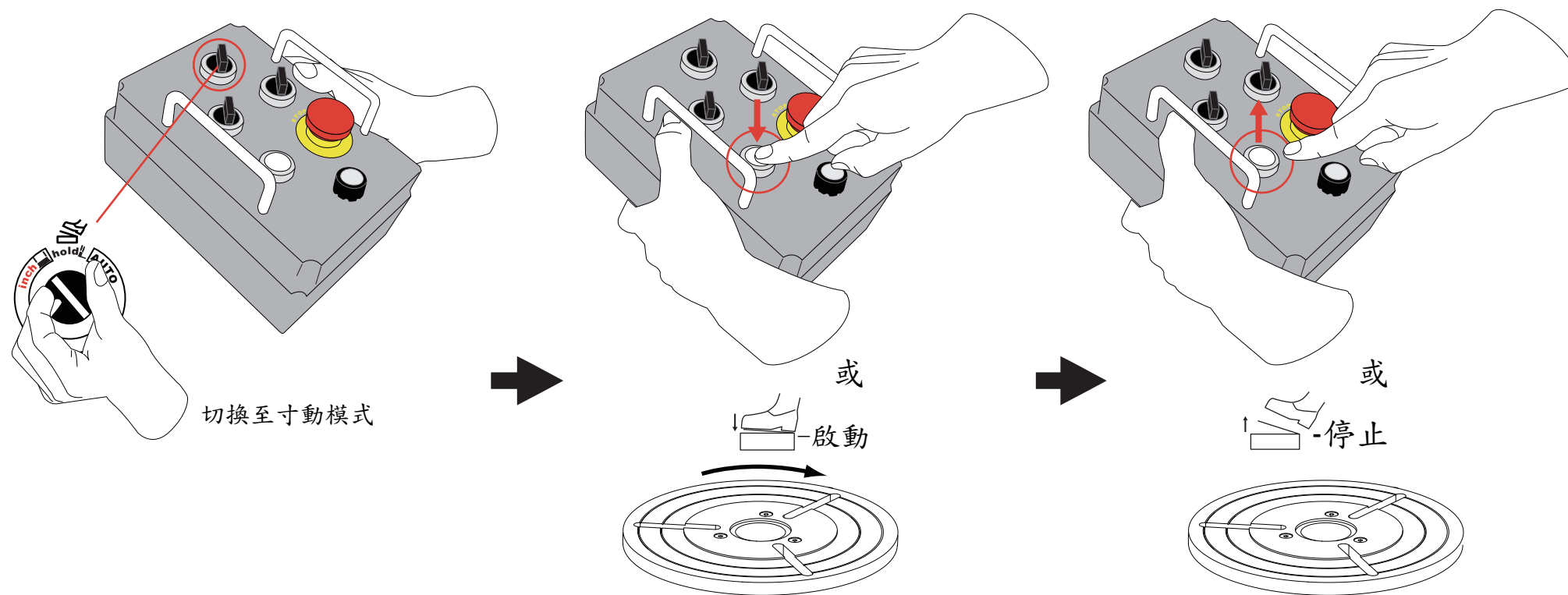
4.8 定時時間設定



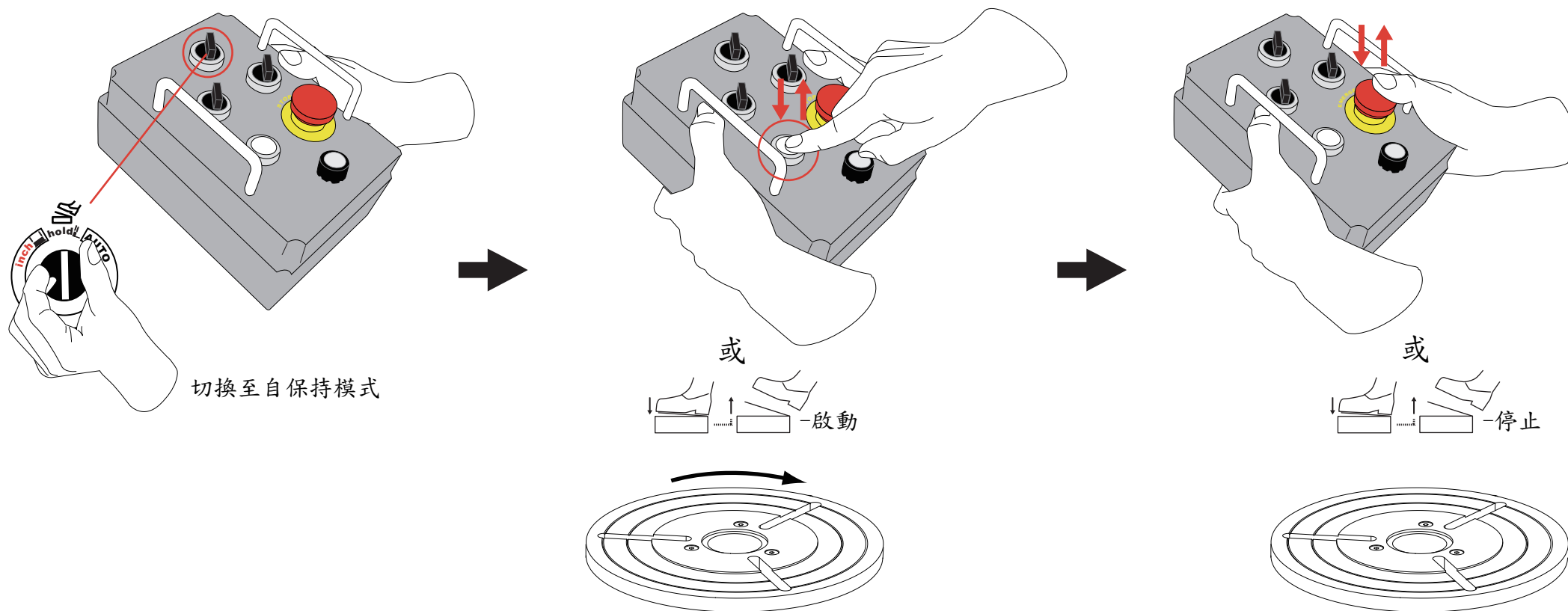
4.9 盤面旋轉方向



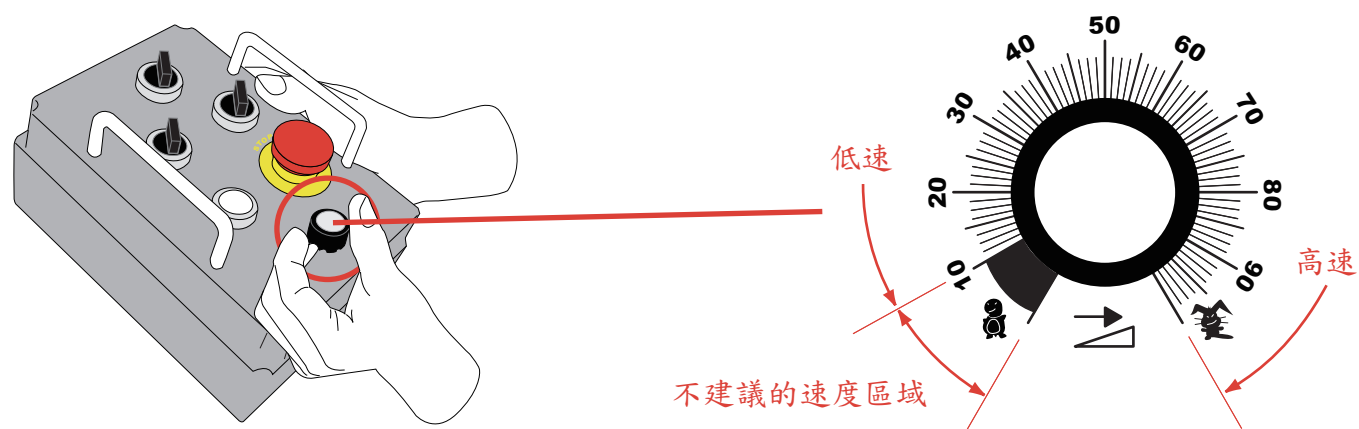
4.10 盤面寸動式旋轉



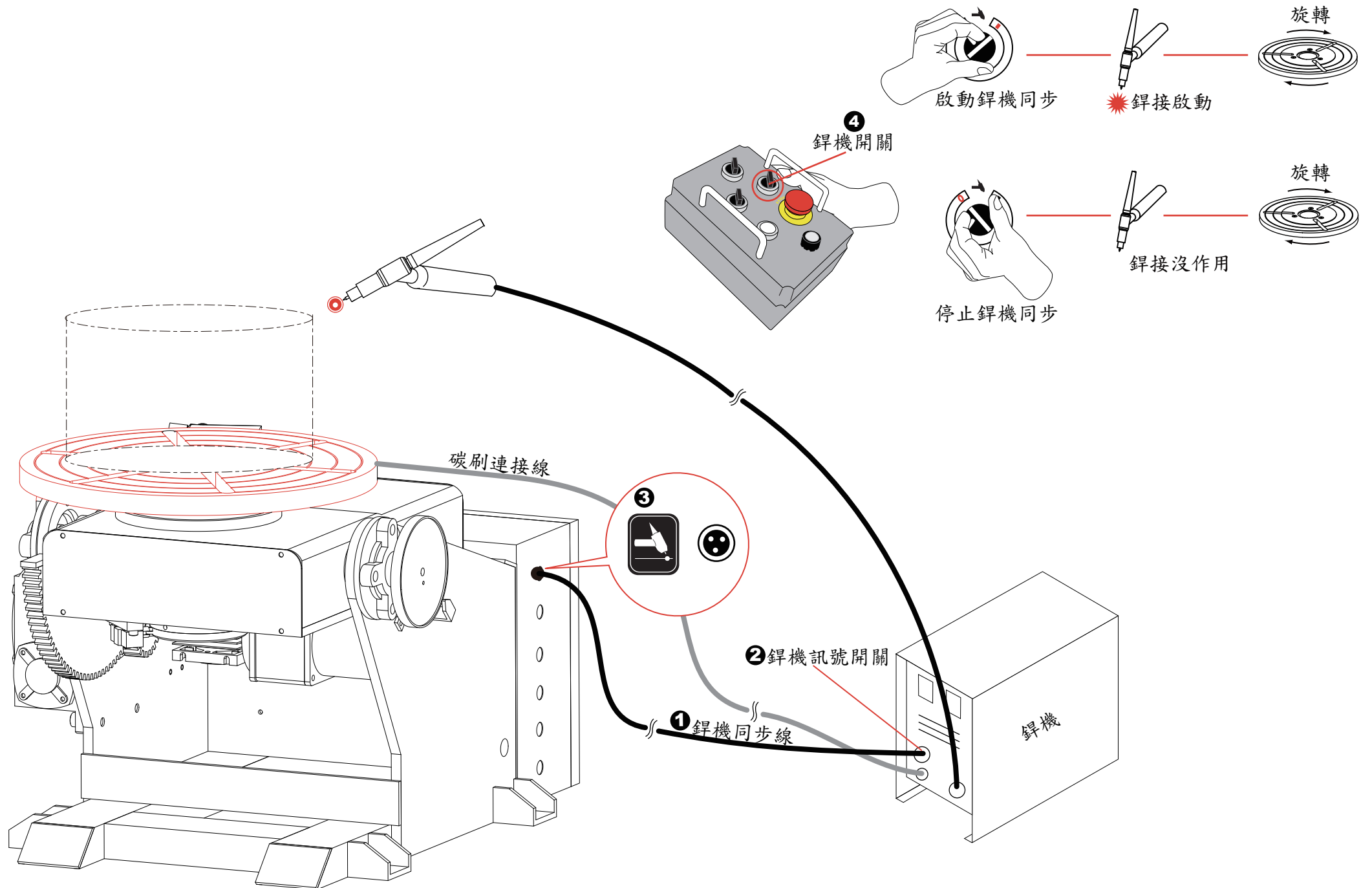
4.11 盤面自保持旋轉



4.12 盤面速度調整



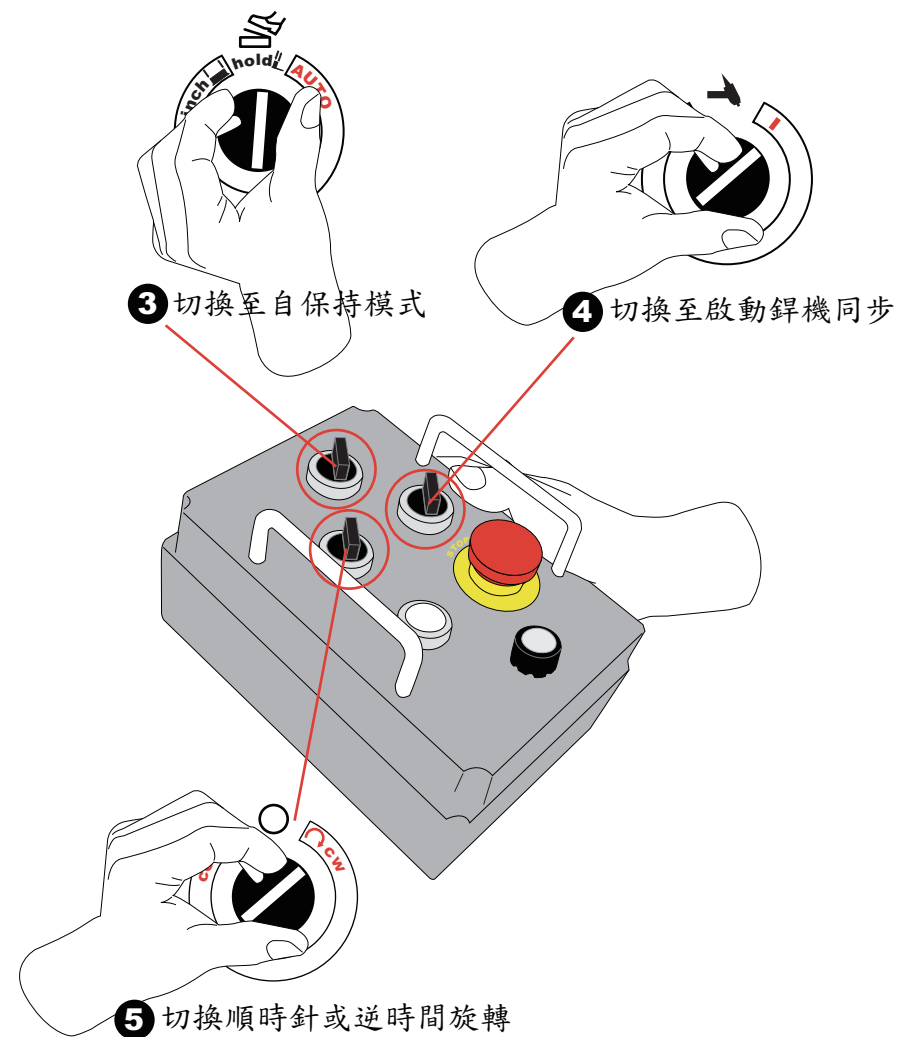
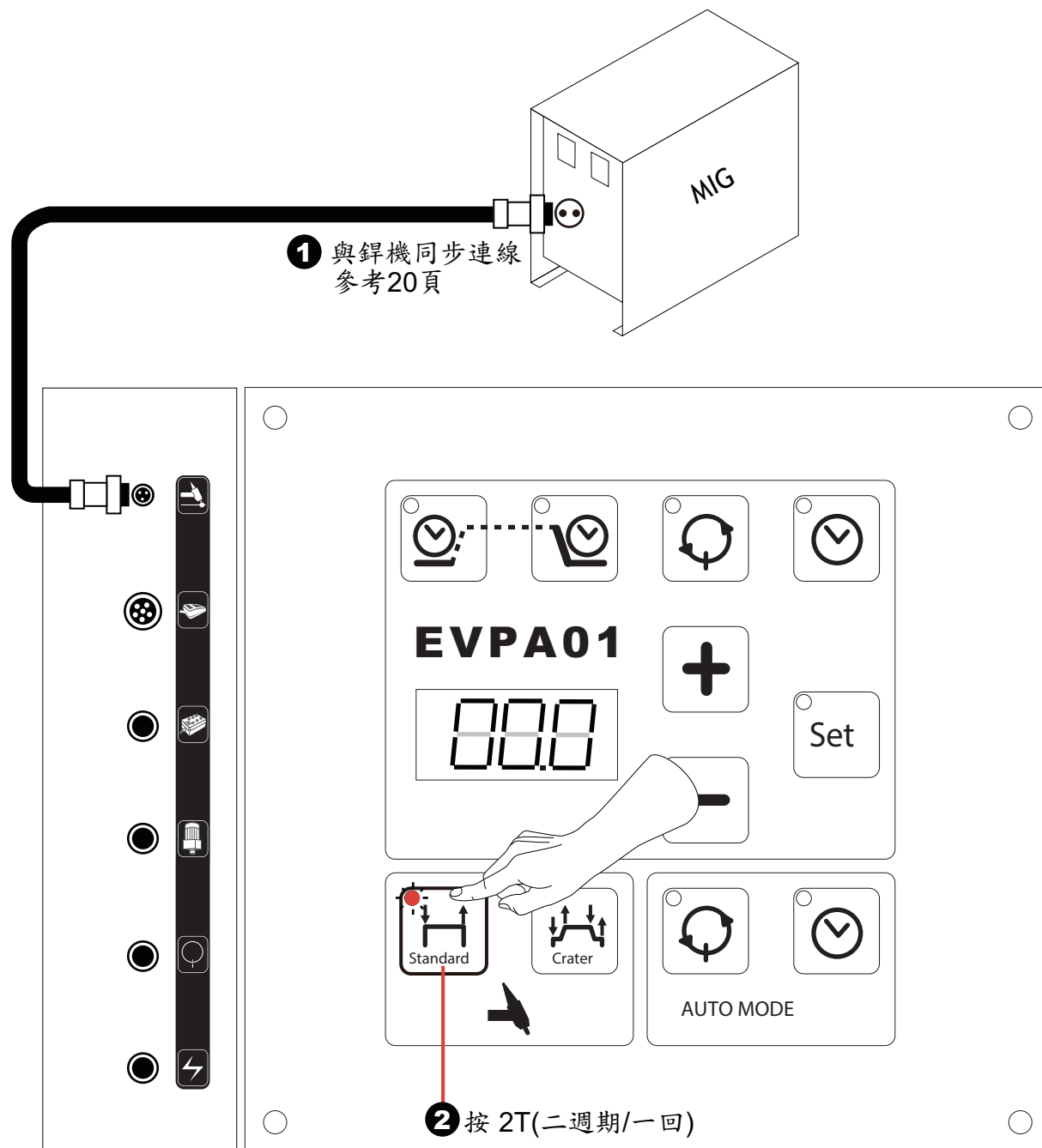
4.13 鐳機同步連線方法



2T(二週期/一回) 操作

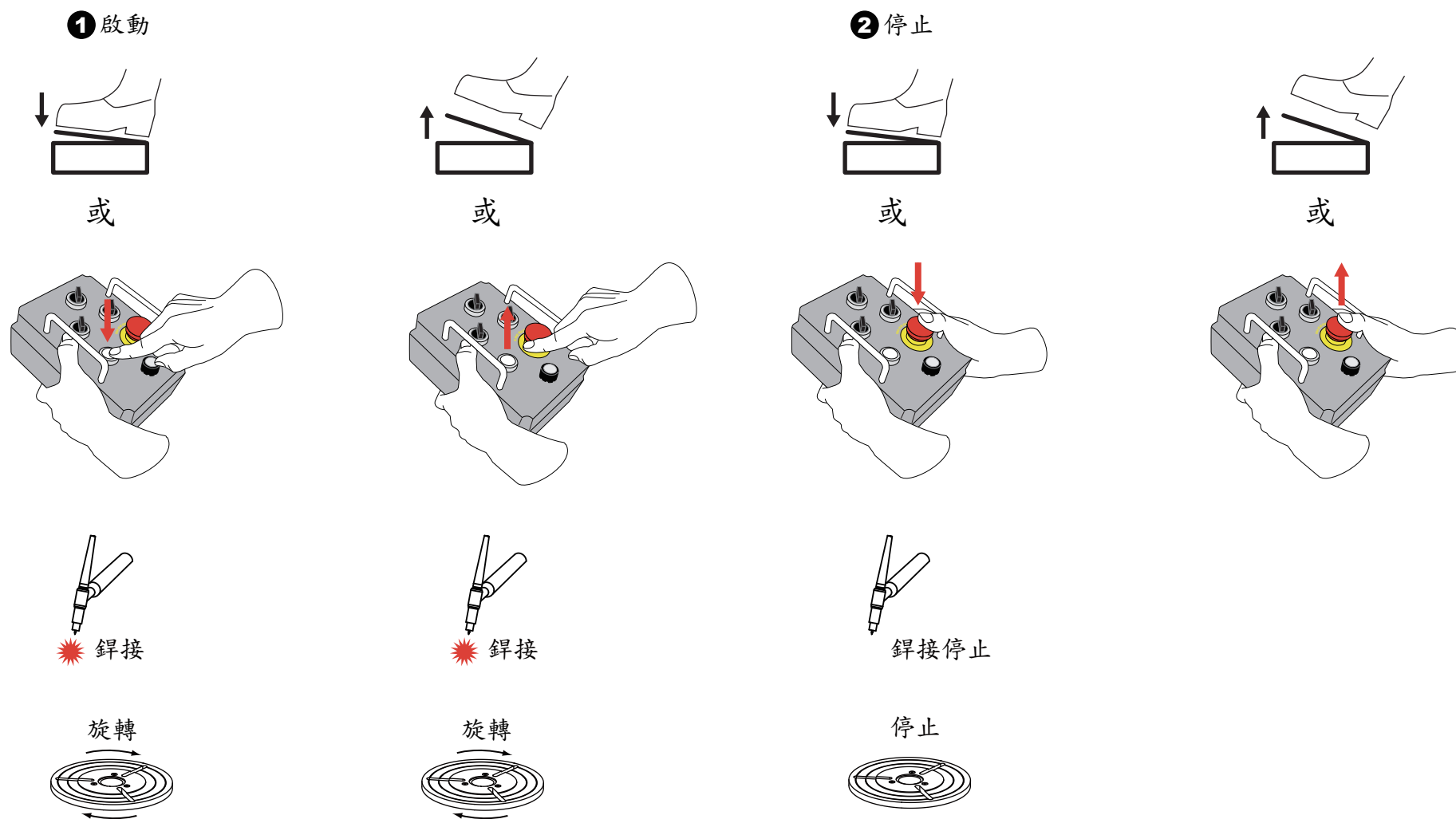
4.14 2T(二週期/一回) / 自保持 / MIG

4.14.1 準備



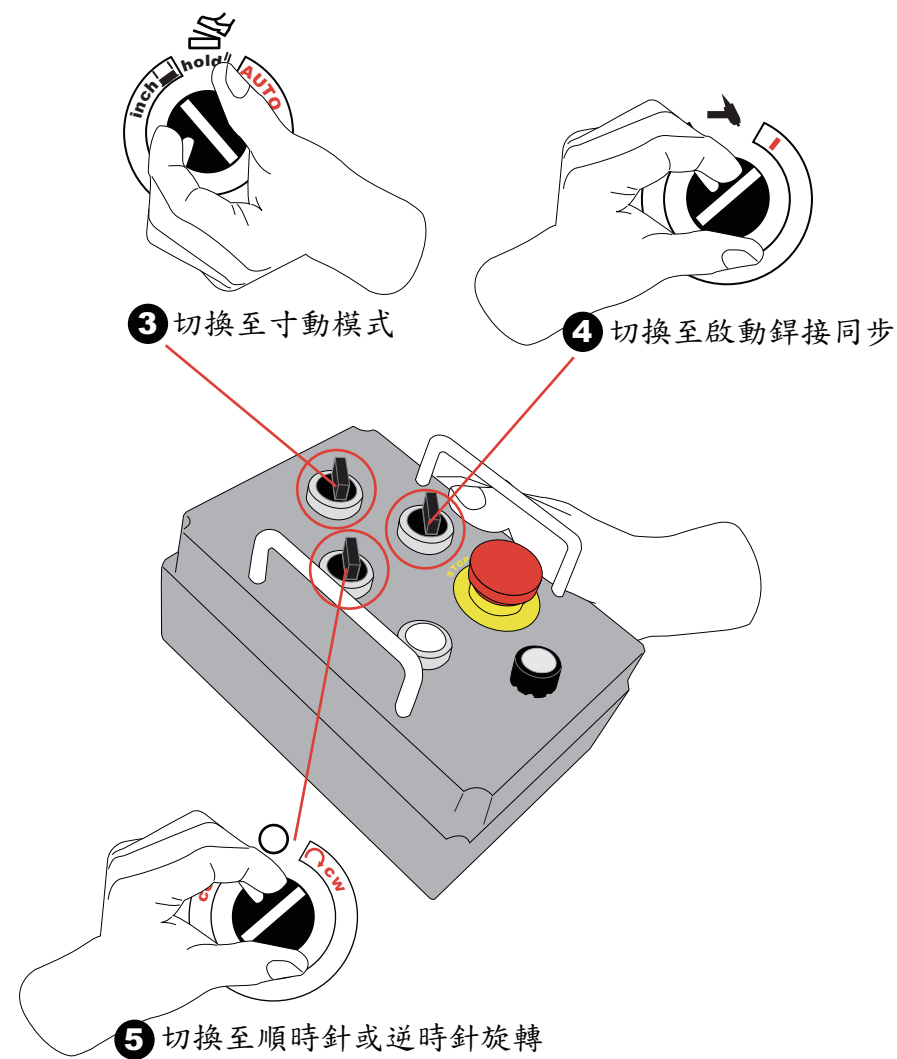
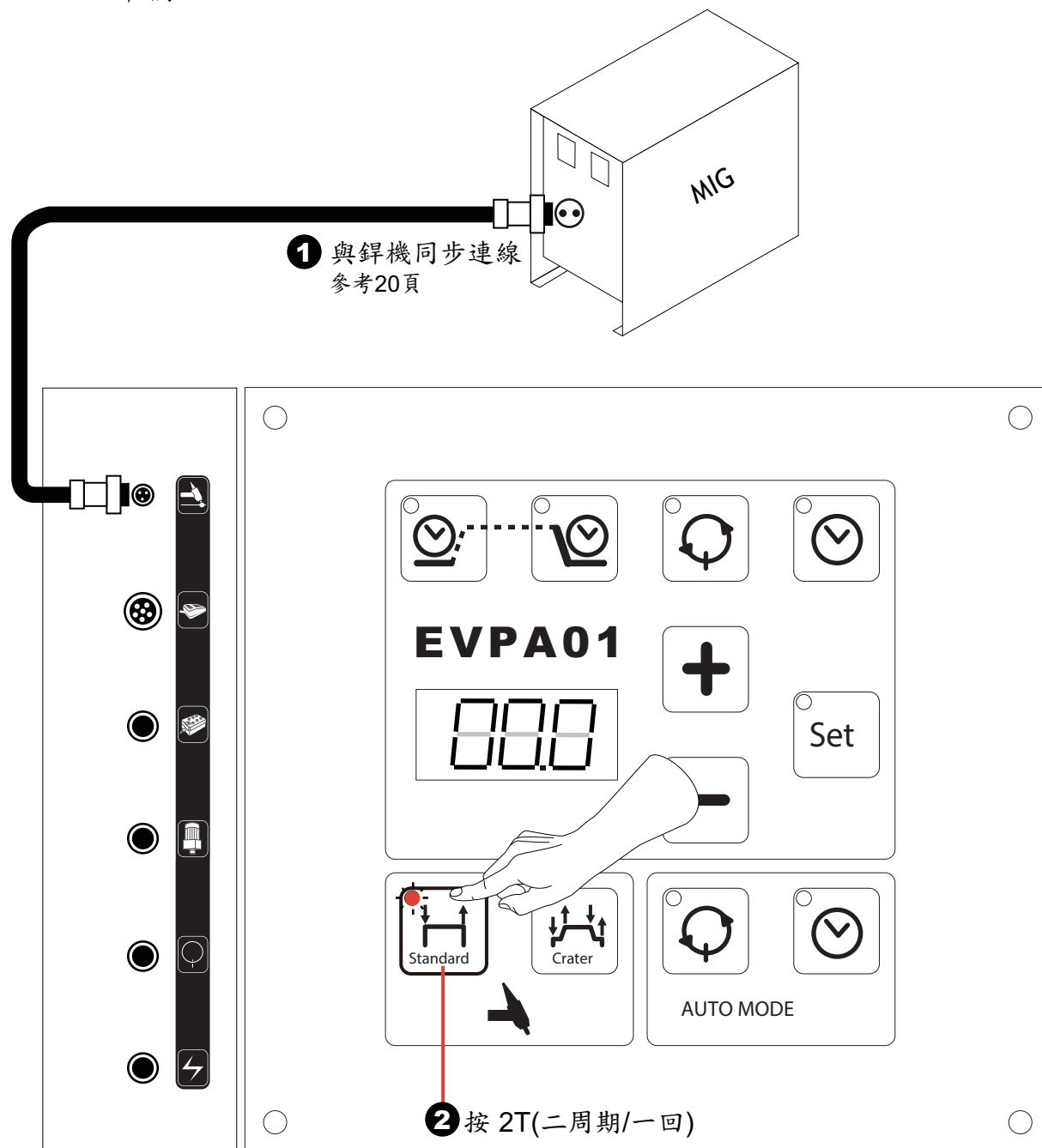
4.14 2T(二週期/一回) / 自保持 / MIG

4.14.2 鐸接啟動



4.15 2T(二週期/一回) / 寸動 / MIG

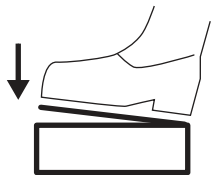
4.15.1 準備



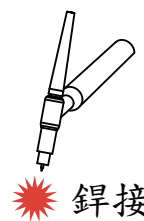
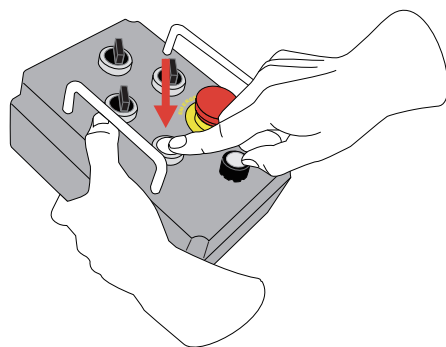
4.15 2T(二週期/一回) / 寸動 / MIG

4.15.2 銲接啟動

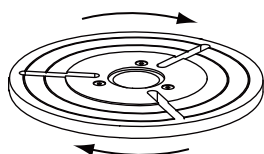
① 啟動



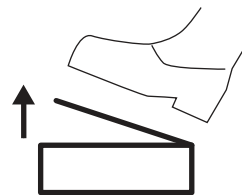
或



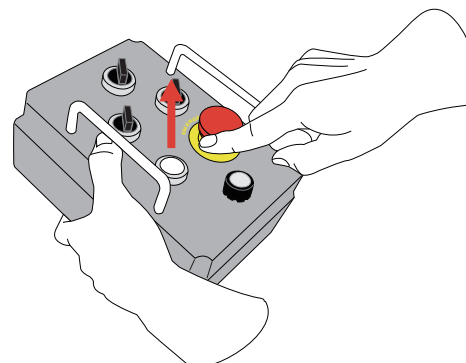
旋轉



② 停止



或

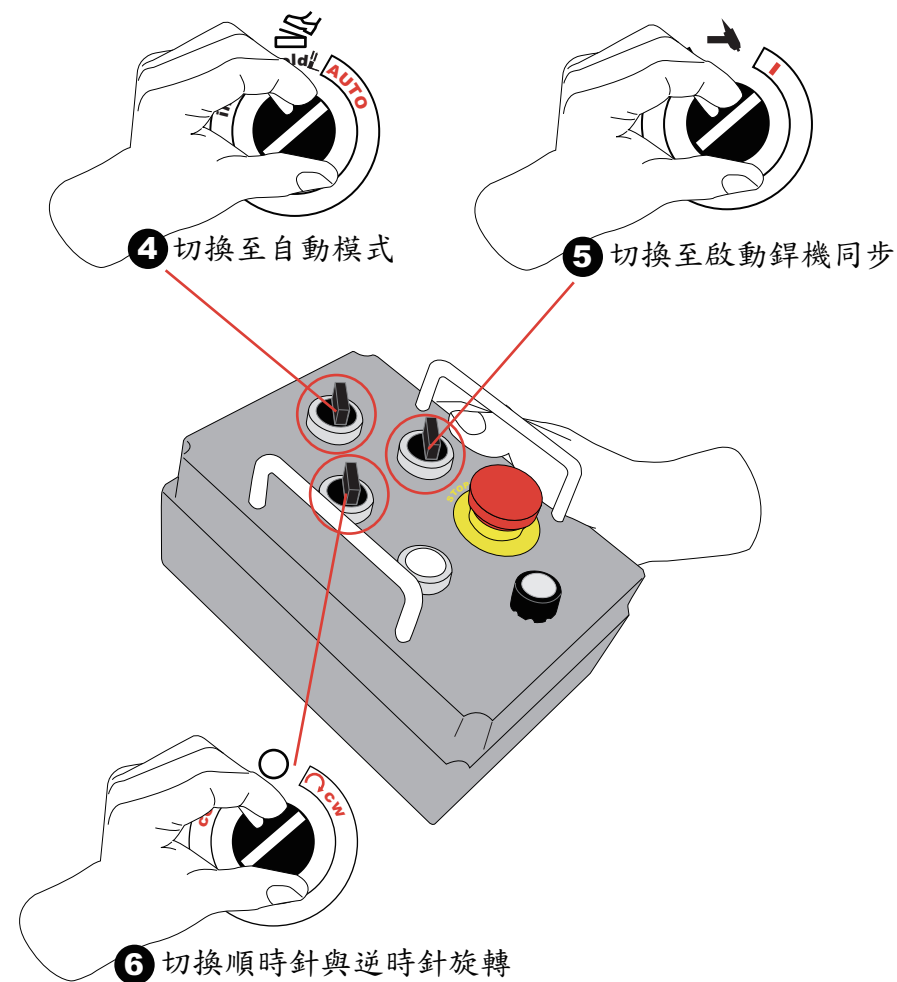
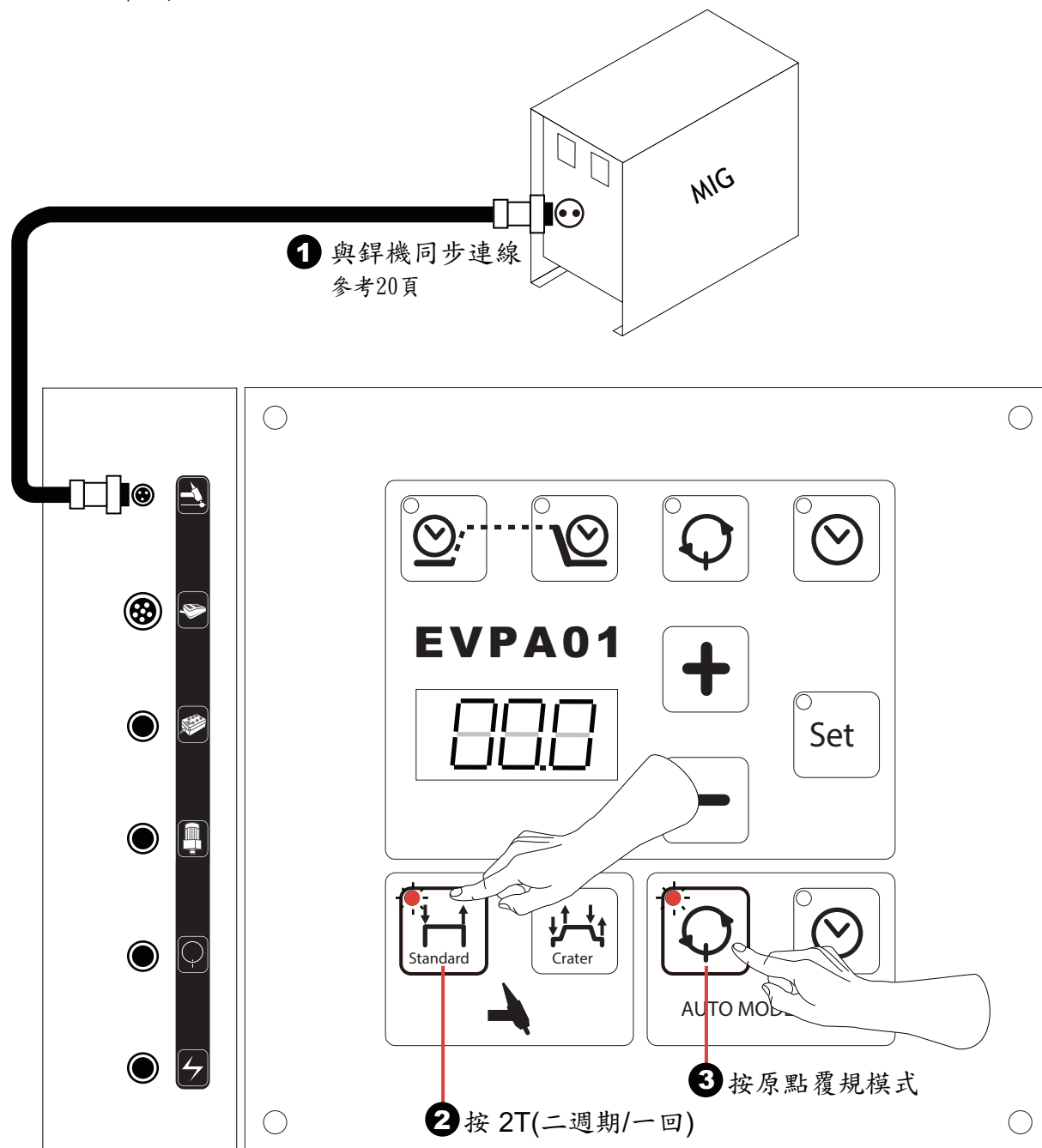


停止



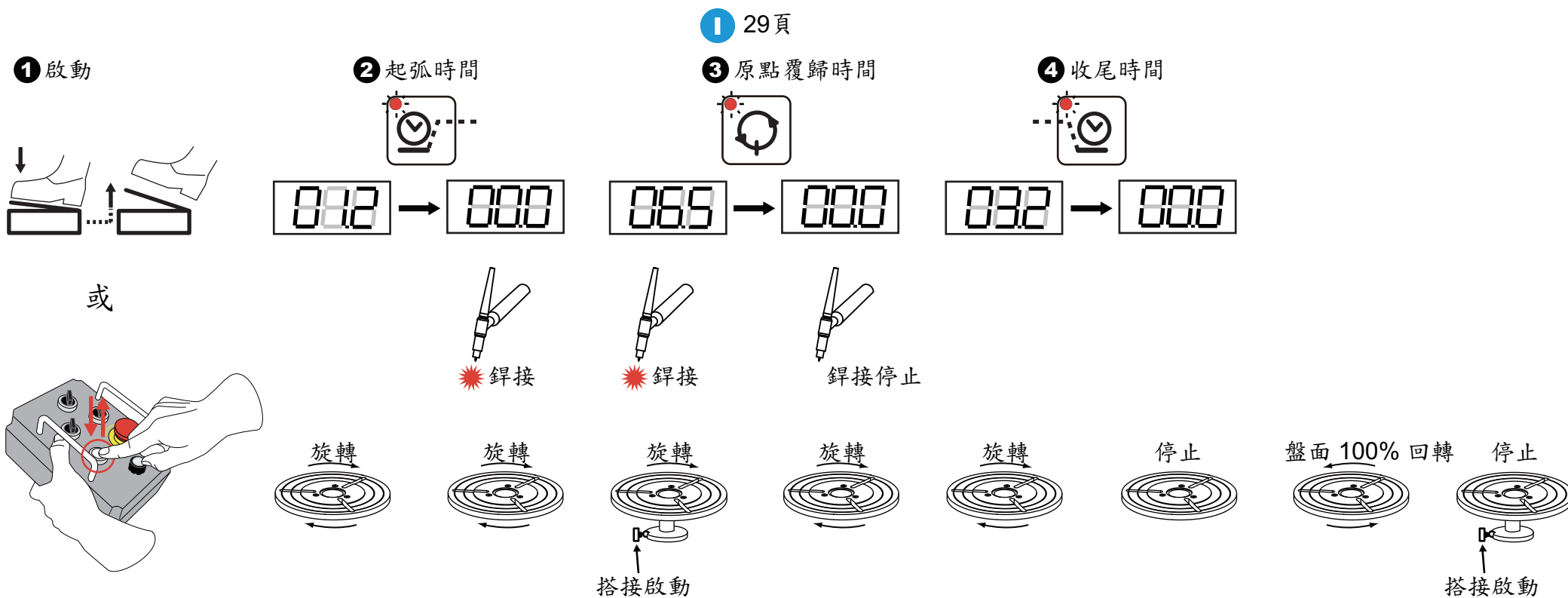
4.16 2T(二週期/原點覆歸)/寸動/MIG

4.16.1 準備



4.16 2T(二週期/原點覆歸)/寸動/MIG

4.16.2 銲接啟動



起弧時間設定16頁



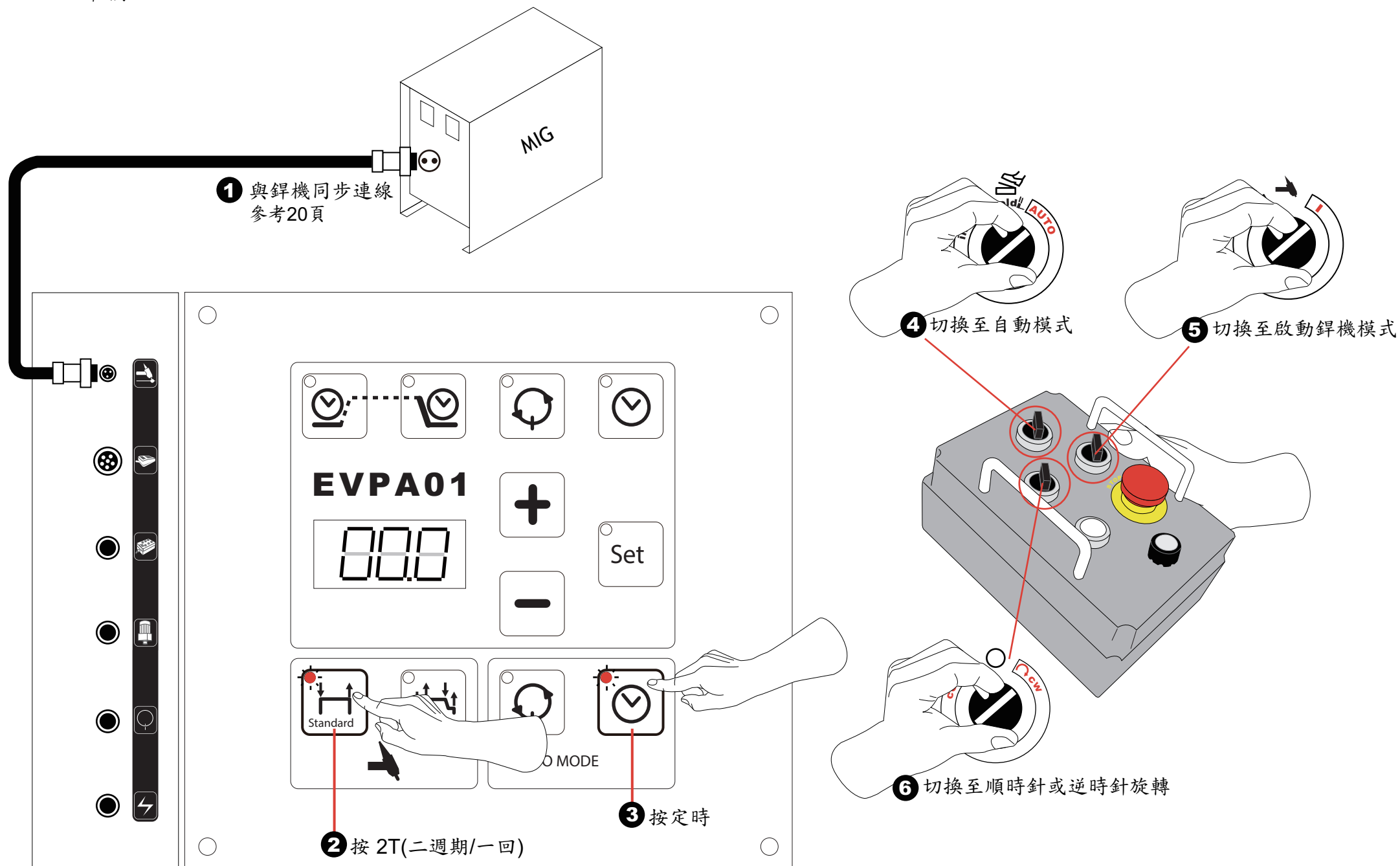
原點覆歸時間設定17頁



收尾時間設定16頁

4.17 2T(二週期/一回) / 定時 / MIG

4.17.1 準備



4.17 2T(二週期/一回) / 定時 / MIG

4.17.2 銲接啟動

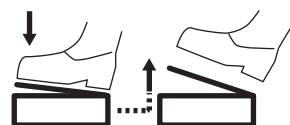
I 30頁

① 啟動

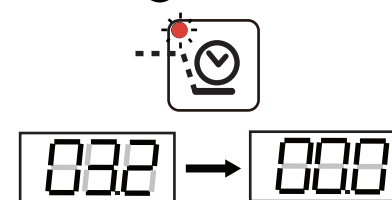
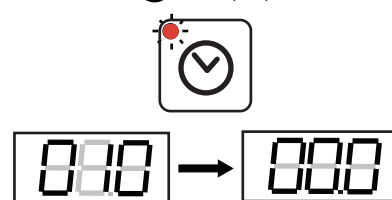
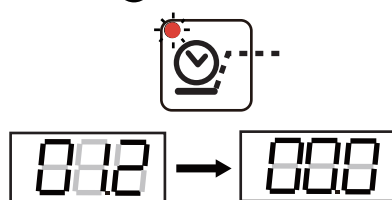
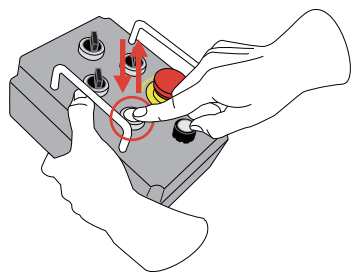
② 起弧時間

③ 定時時間

④ 收尾時間



或



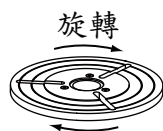
銲接



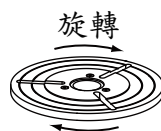
銲接



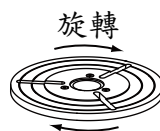
銲接停止



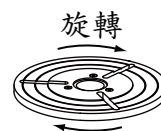
旋轉



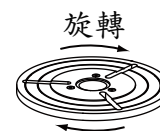
旋轉



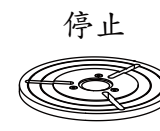
旋轉



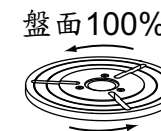
旋轉



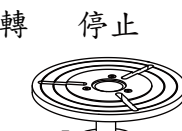
旋轉



停止



盤面100% 回轉



停止

搭接啟動



起弧時間設定16頁



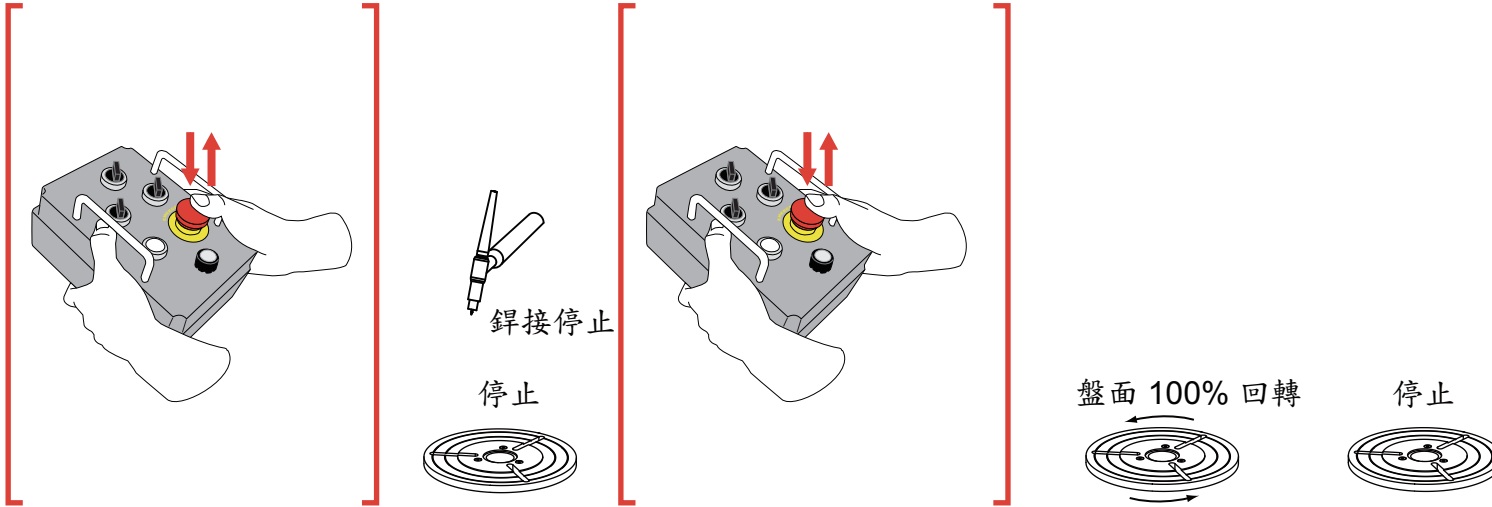
定時時間設定17頁



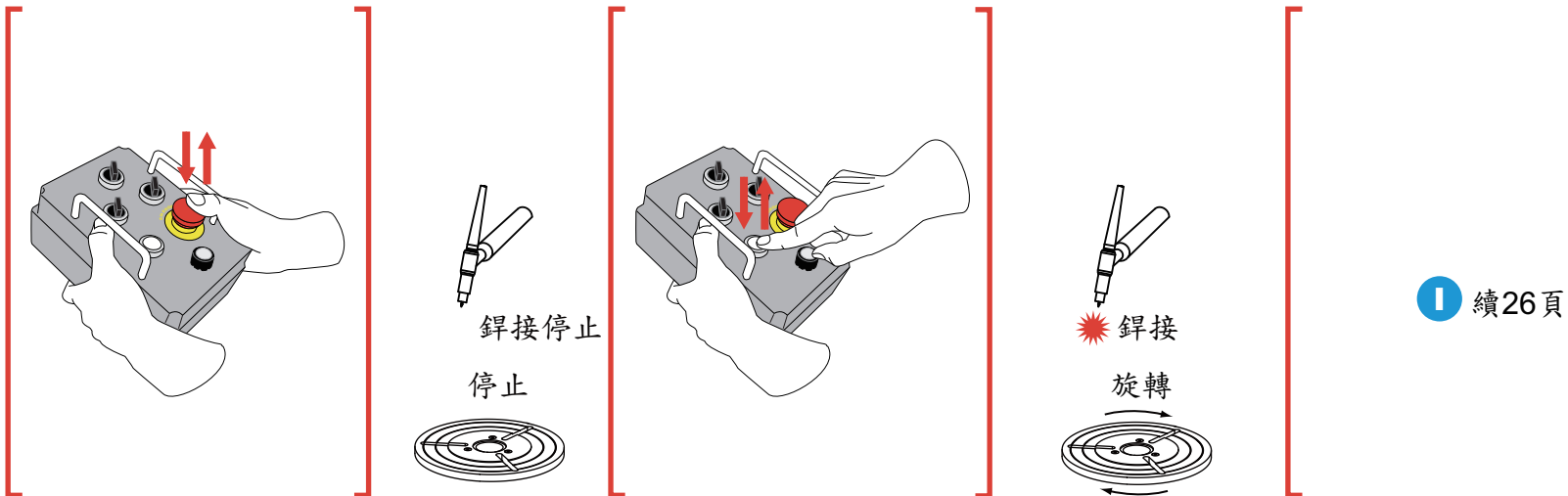
收尾時間設定16頁

4.18 (二週期/一回) 原點復歸停止與繼續銲接

4.18.1 停止銲接



4.18.2 中斷後繼續銲接



I 續26頁



起弧時間



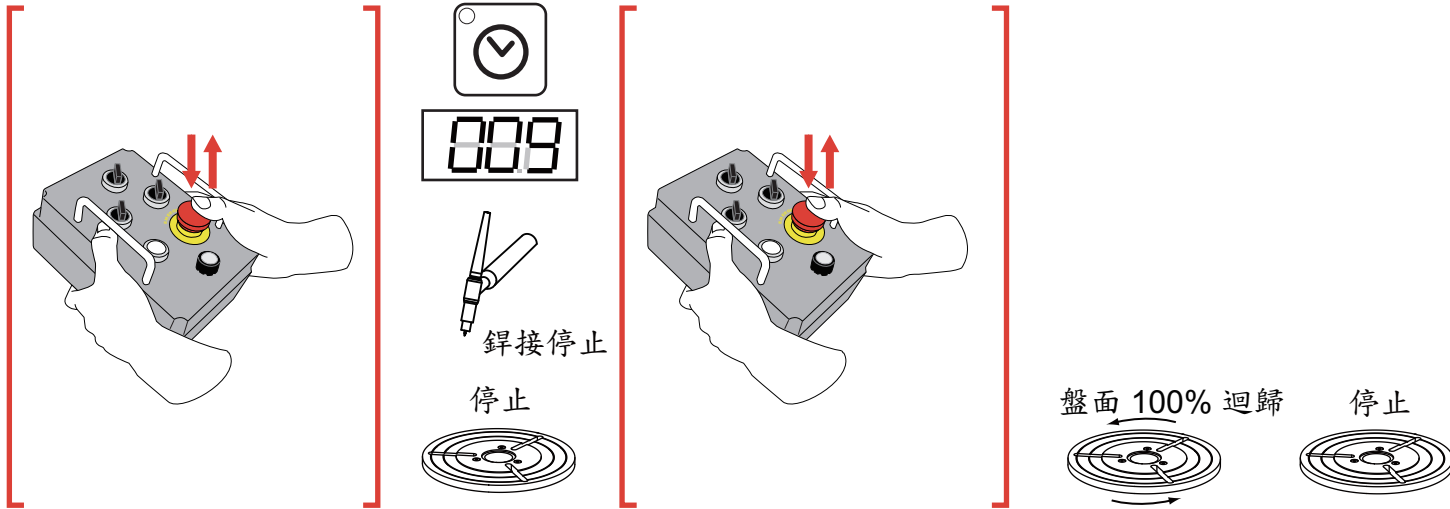
收尾時間



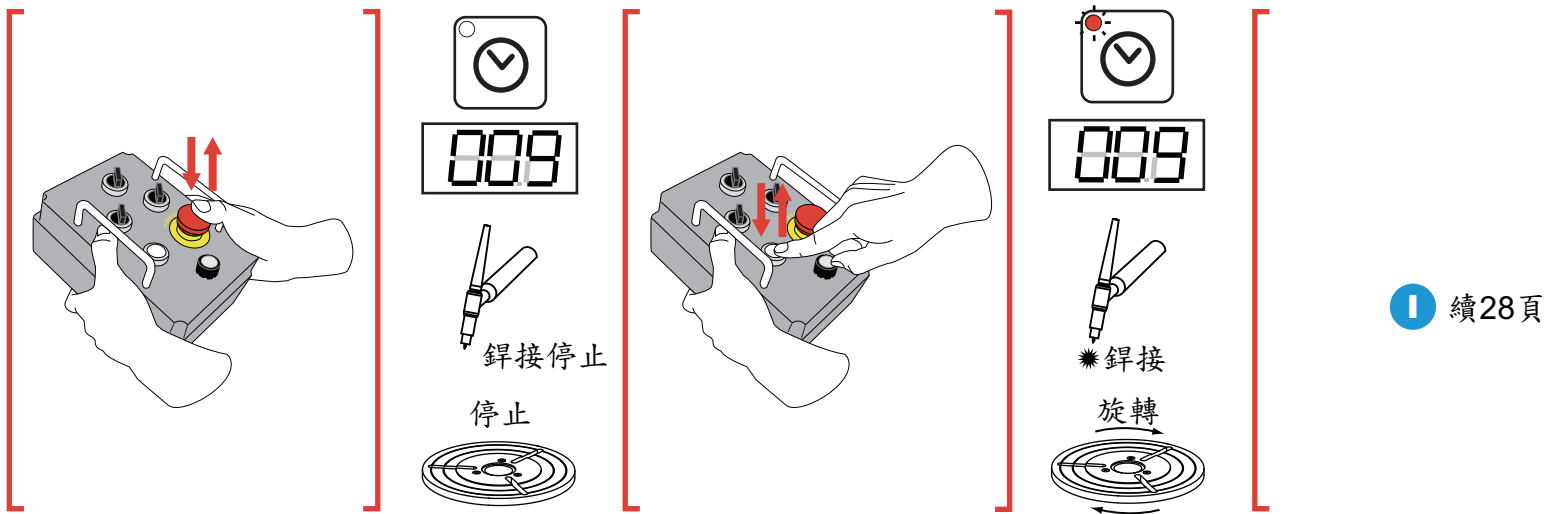
起弧與收尾計時中，中斷無效。

4.19 (二週期/一回) 定時停止與繼續銲接

4.19.1 停止銲接



4.19.2 中斷後繼續銲接



I 續28頁



起弧時間



收尾時間

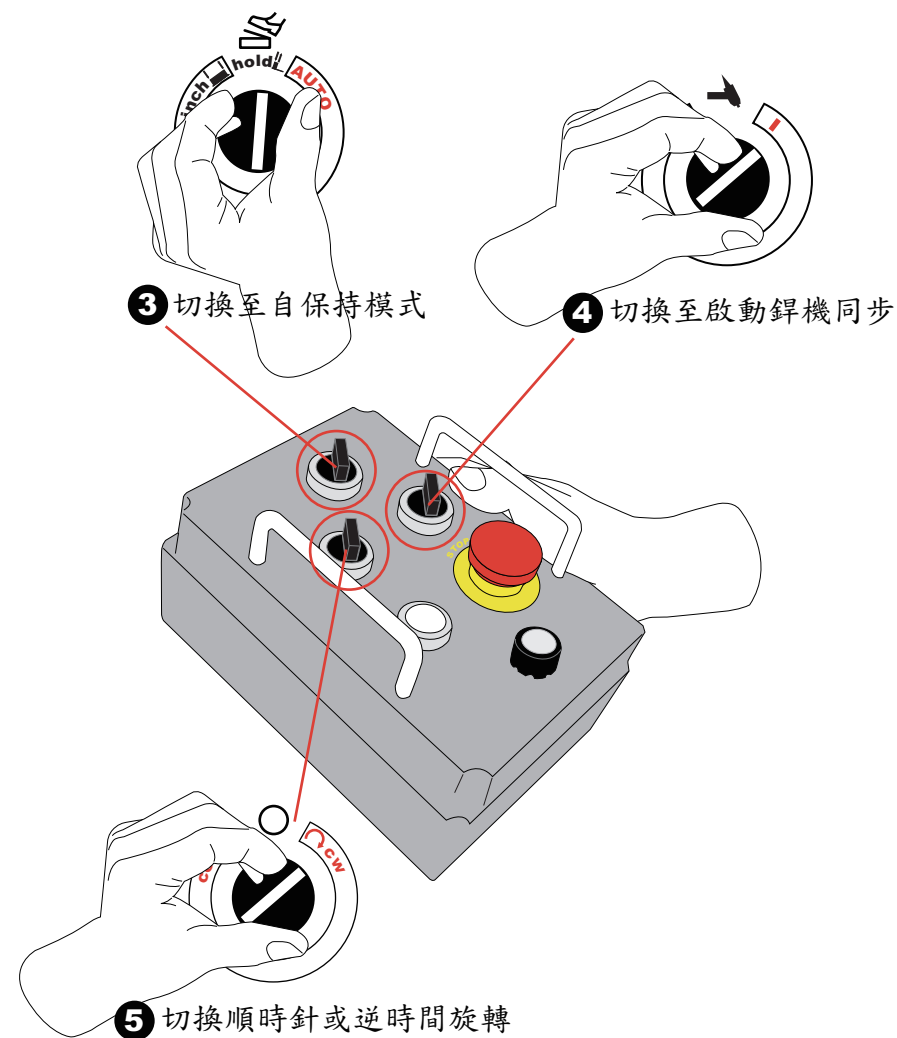
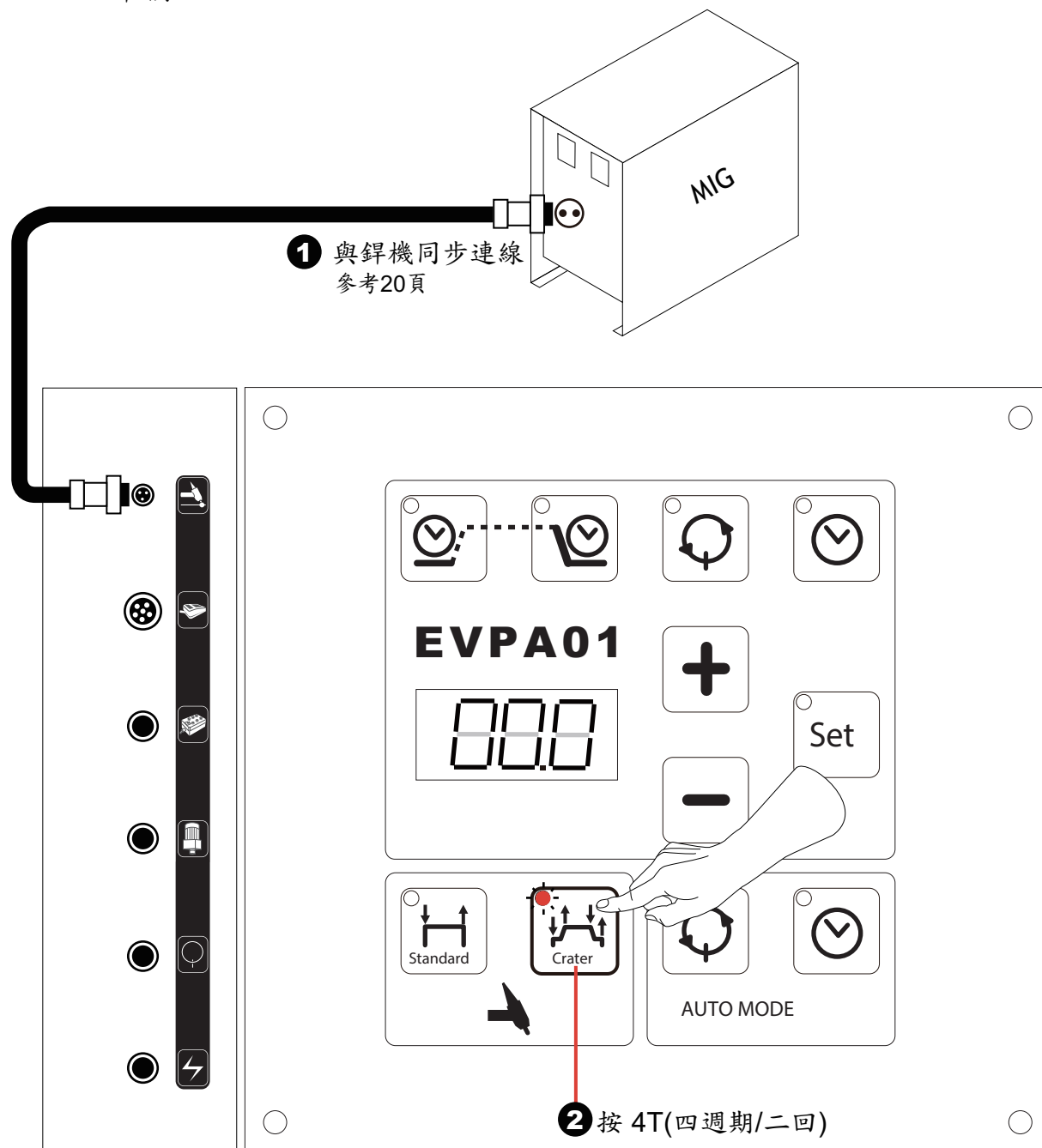


起弧與收尾計時中，中斷無效。

4T(四週期/二回) 操作

4.20 4T(四週期/二回) / 自保持 / MIG

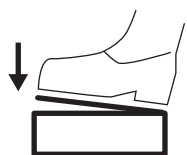
4.20.1 準備



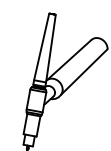
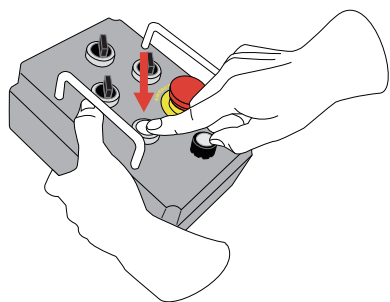
4.20 4T(四週期/二回)/自保持/MIG

4.20.2 銲接啟動

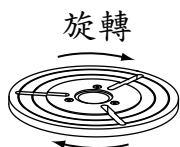
❶ 啟動



or

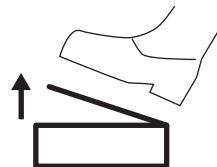


✱ 起弧銲接

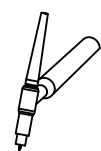
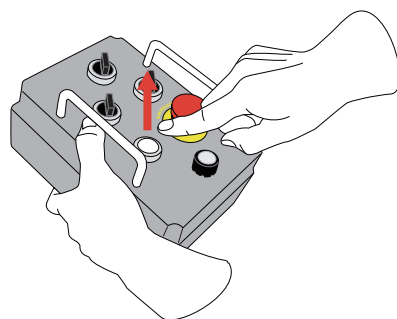


旋轉

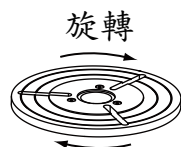
❷ 銲接



or

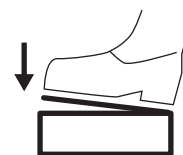


✱ 銲接

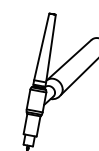
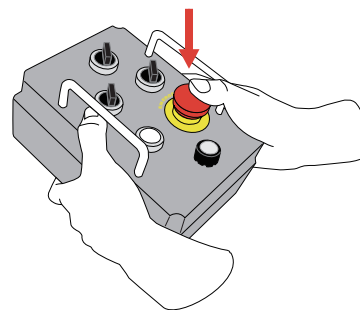


旋轉

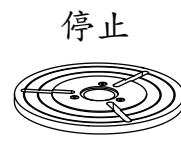
❸ 收尾時間



or

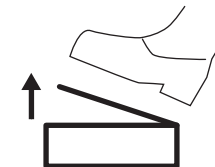


✱ 收尾銲接

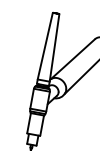
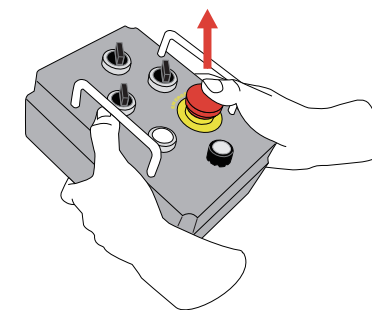


停止

❹ 停止



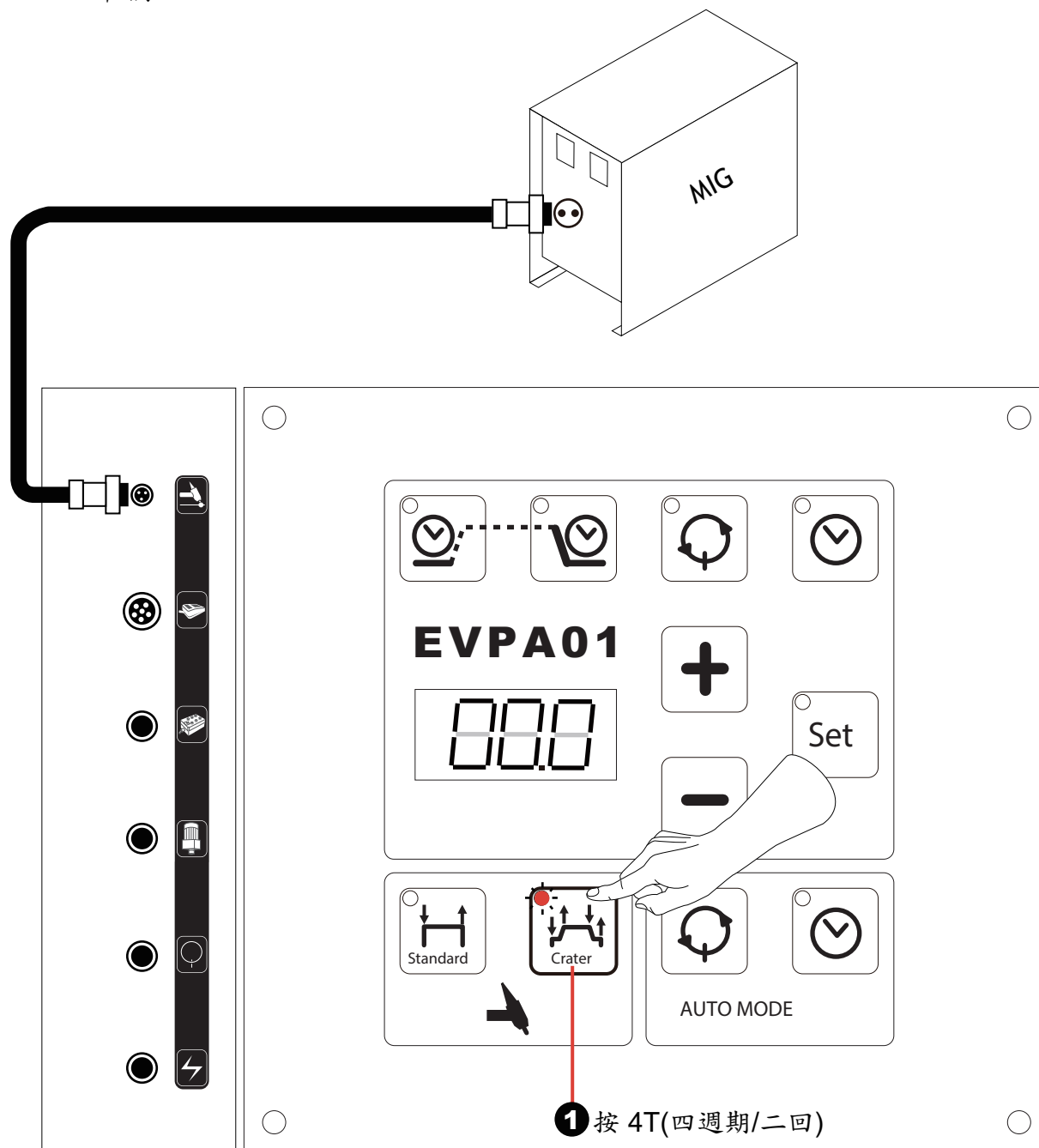
or



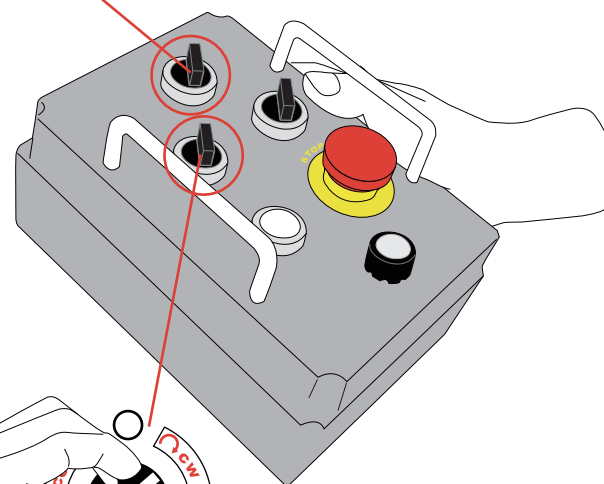
銲接停止

4.21 4T(四週期/二回)/寸動/MIG

4.21.1 準備



2 切換至寸動模式

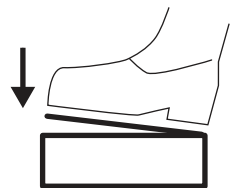


3 切換至瞬時針或逆時針旋轉

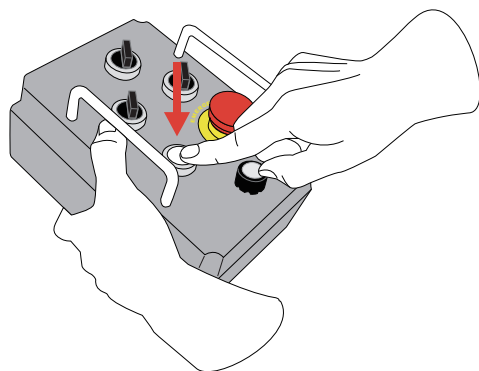
4.21 4T(四週期/二回)/寸動/MIG

4.21.2 鐸接啟動

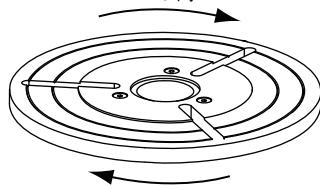
① 啟動



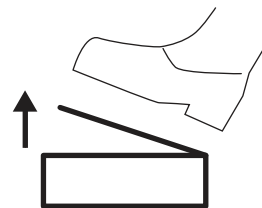
或



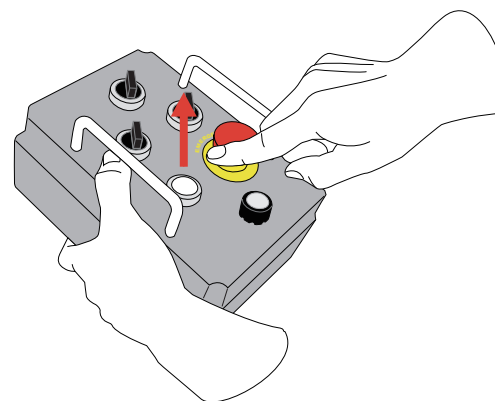
旋轉



② 停止



或

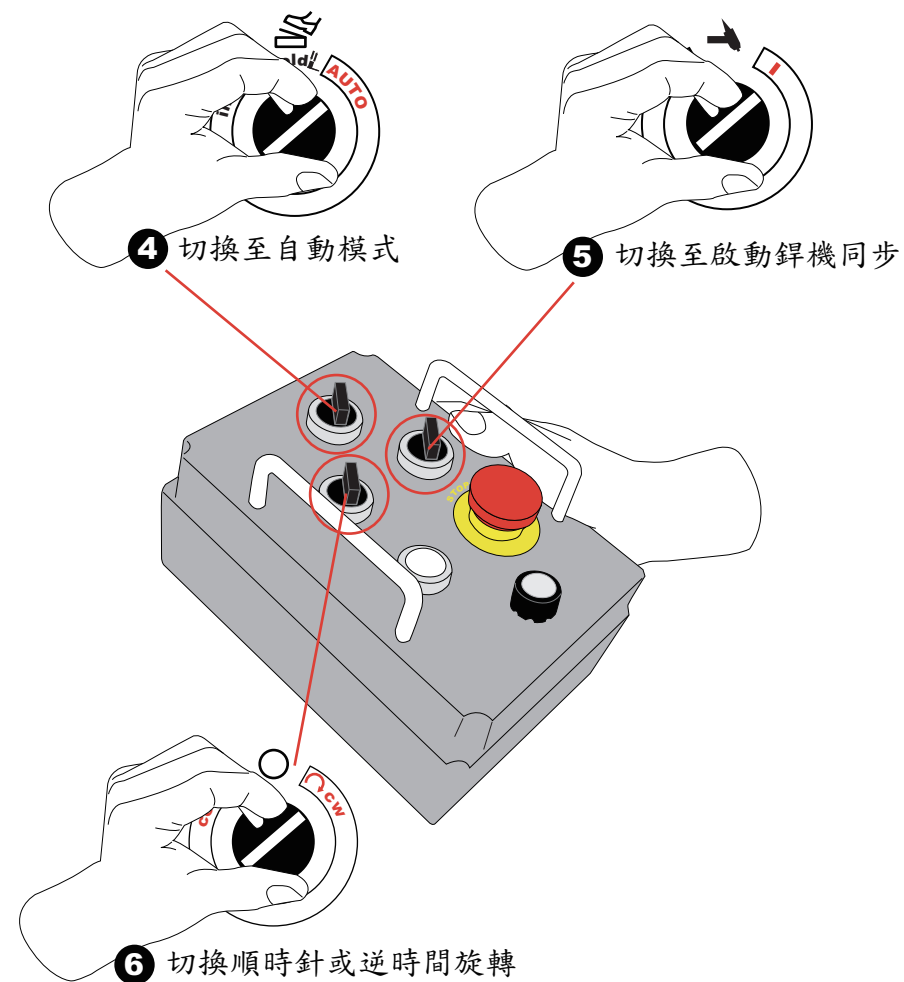
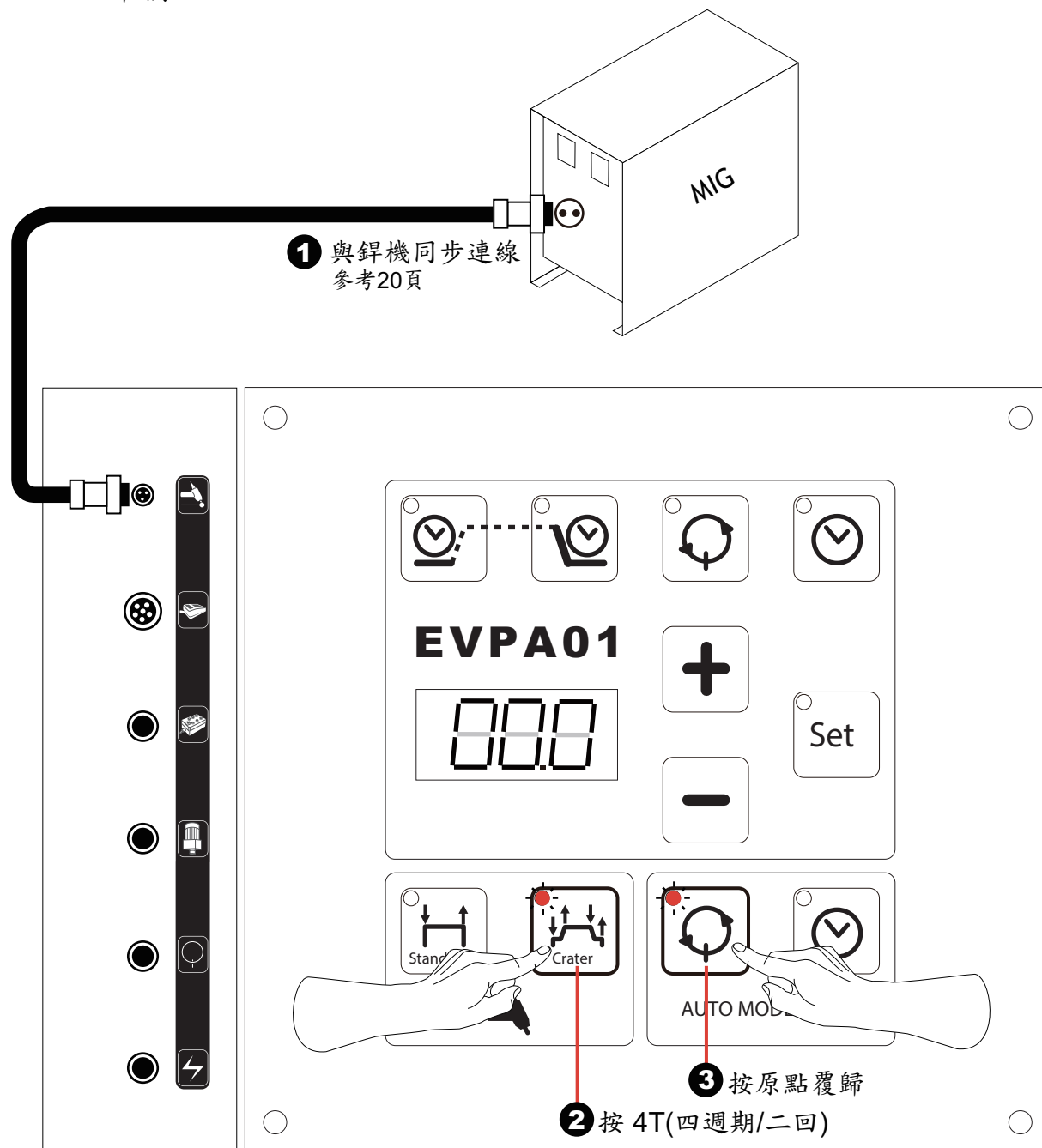


停止



4.22 4T(四週期/二回)/原點覆歸/TIG

4.22.1 準備



4.22 4T(四週期/二回)/原點覆歸/TIG

4.22.2 準備

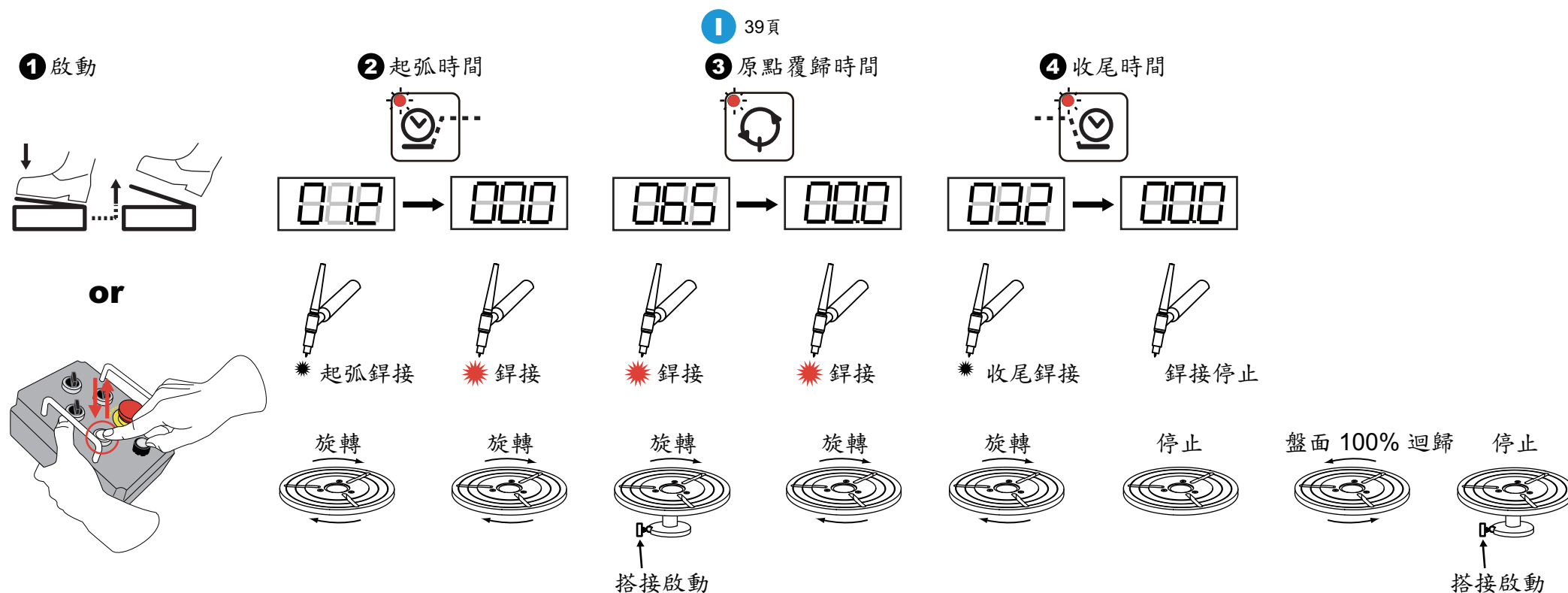


Figure:4.22-2



起弧時間設定16頁



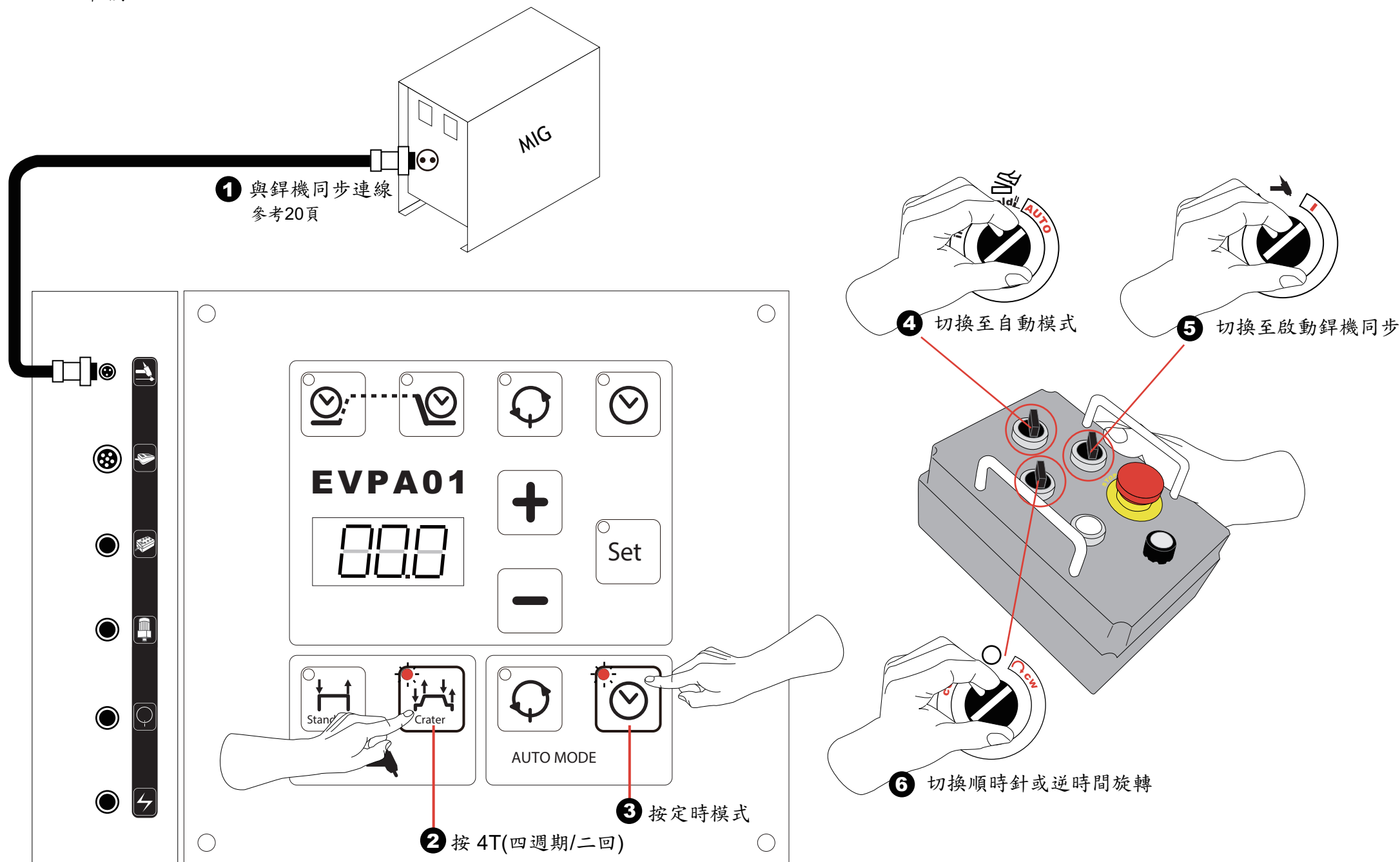
原點覆歸時間設定17頁



收尾時間設定16頁

4.23 4T(四週期/二回) / 定時 / TIG

4.23.1 準備

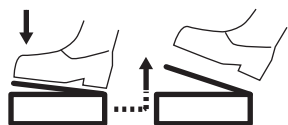


4.23 4T(四週期/二回) / 定時 / TIG

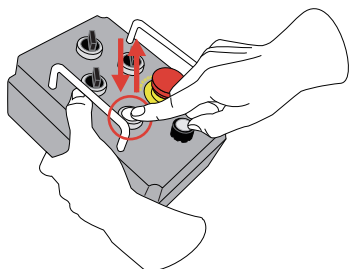
4.23.2 銲接啟動

I Page 40

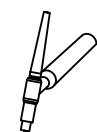
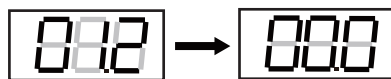
1 啟動



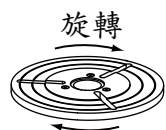
或



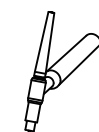
2 起弧時間



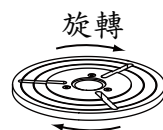
* 起弧銲接



旋轉

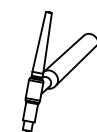
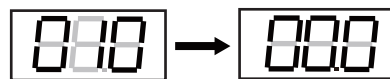


* 銲接

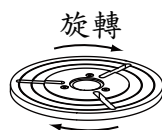


旋轉

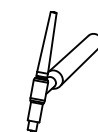
3 定時時間



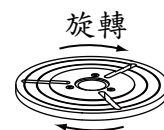
* 銲接



旋轉

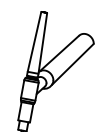
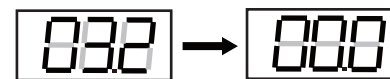


* 銲接

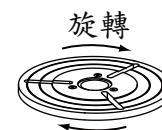


旋轉

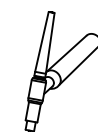
4 收尾時間



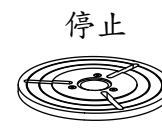
* 收尾銲接



旋轉

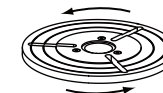


銲接停止



停止

盤面 100% 回轉



停止



搭接啟動



起弧時間設定16頁



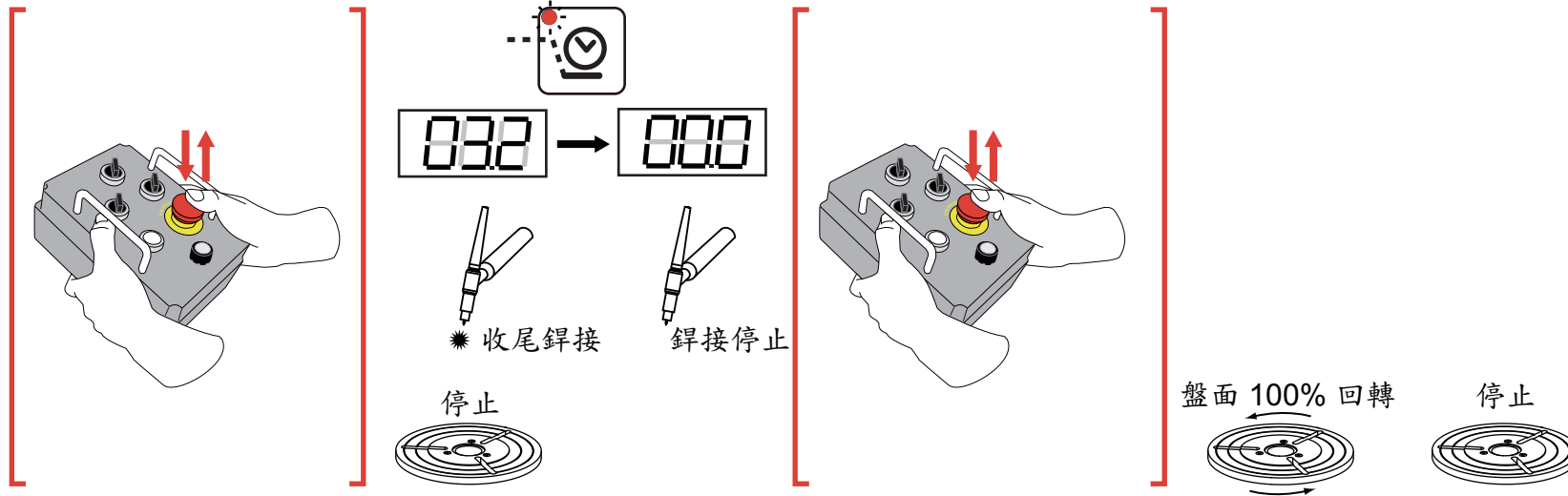
原點覆歸時間設定17頁



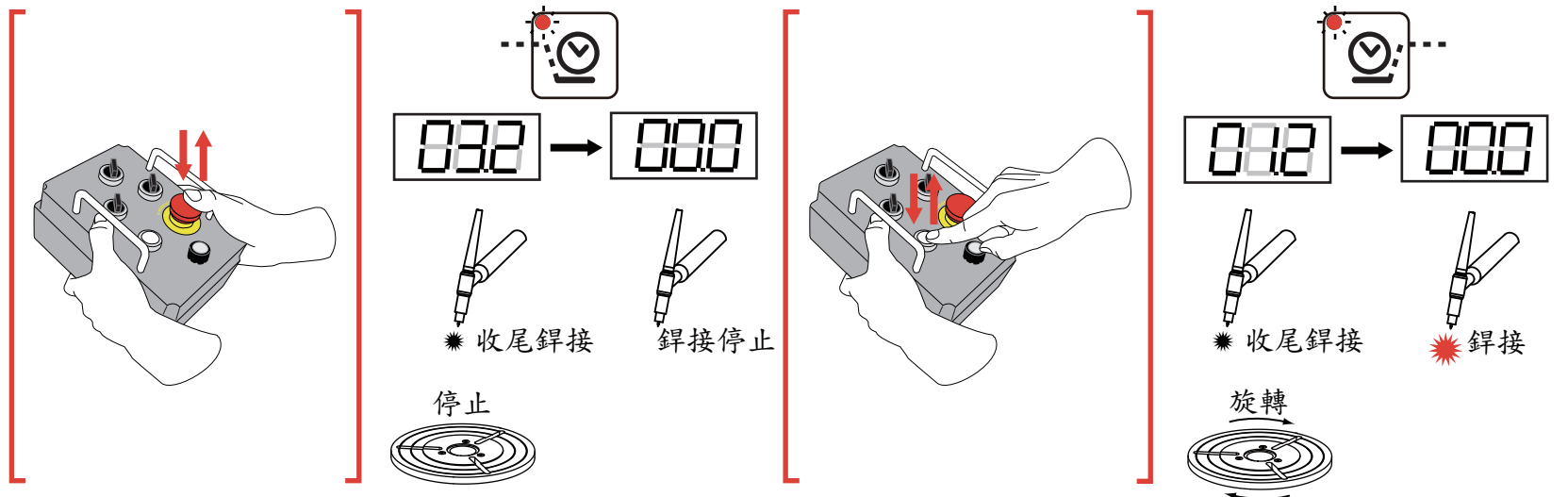
收尾時間設定16頁

4.24 (四週期/二回) 原點復歸停止與繼續銲接

4.24.1 停止銲接



4.24.2 中斷後繼續銲接



I 續 36 頁



起弧時間



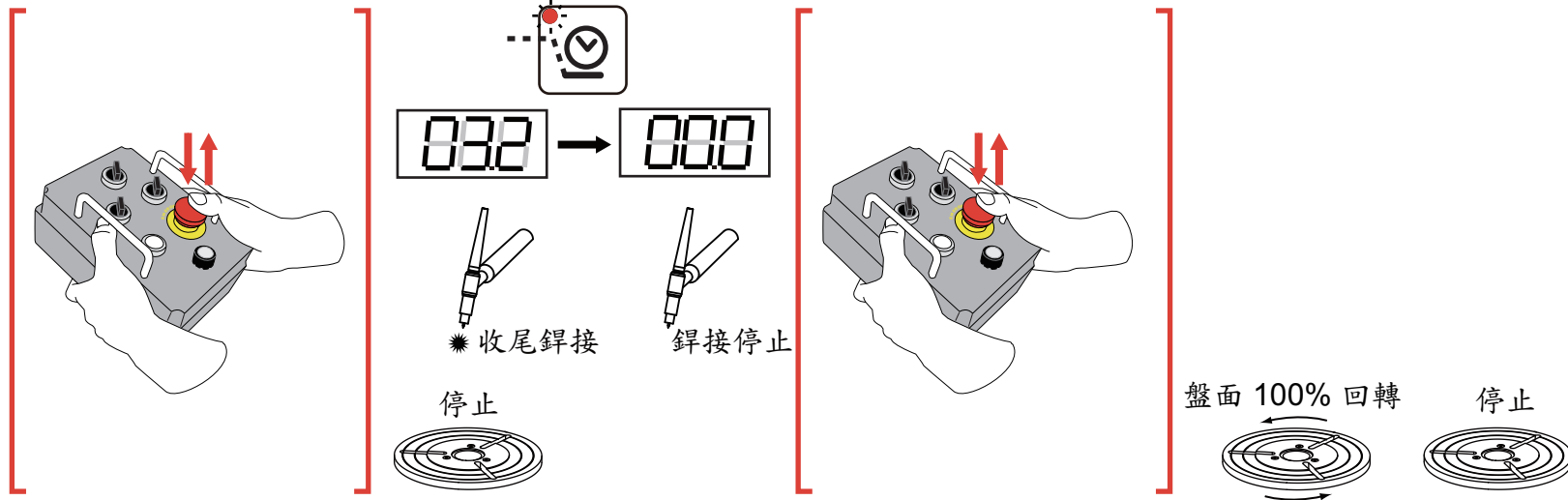
收尾時間



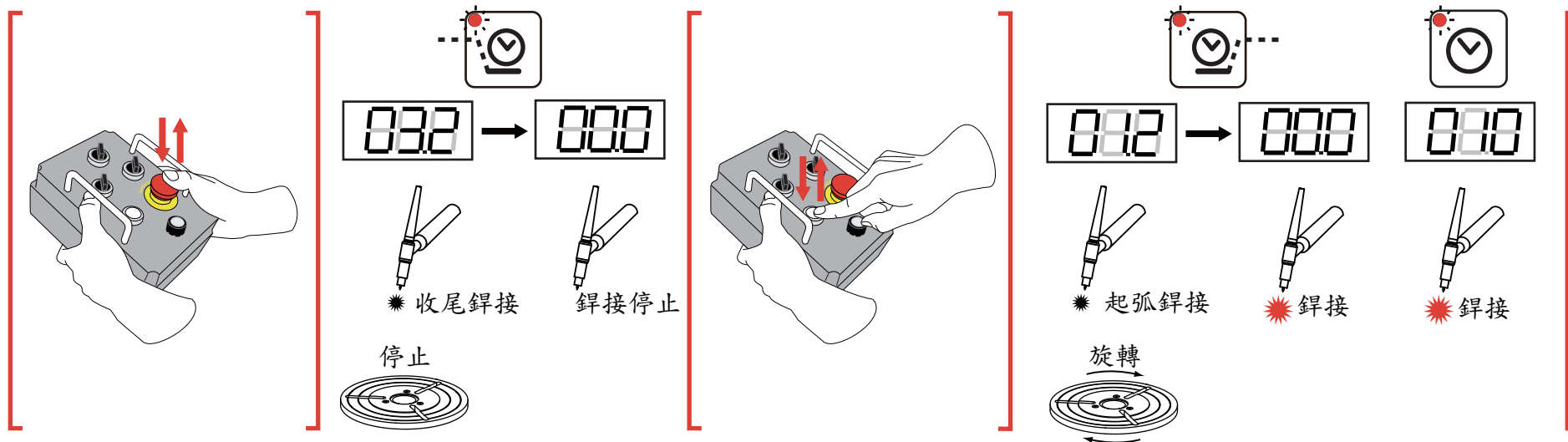
起弧與收尾計時中，中斷無效。

4.24 (四週期/二回) 定時停止與繼續銲接

4.25.1 停止銲接



4.25.2 中斷後繼續銲接



續 38 頁



起弧時間



收尾時間

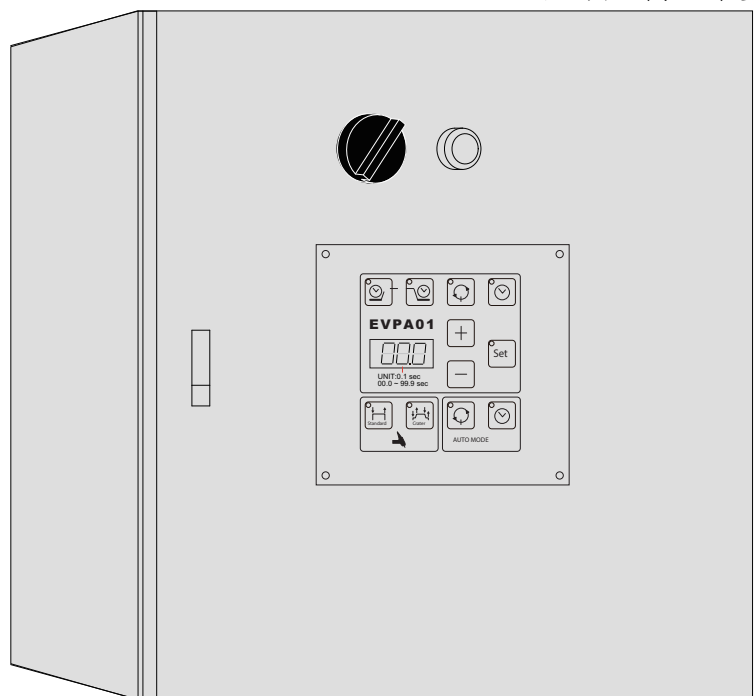


起弧與收尾計時中，中斷無效。

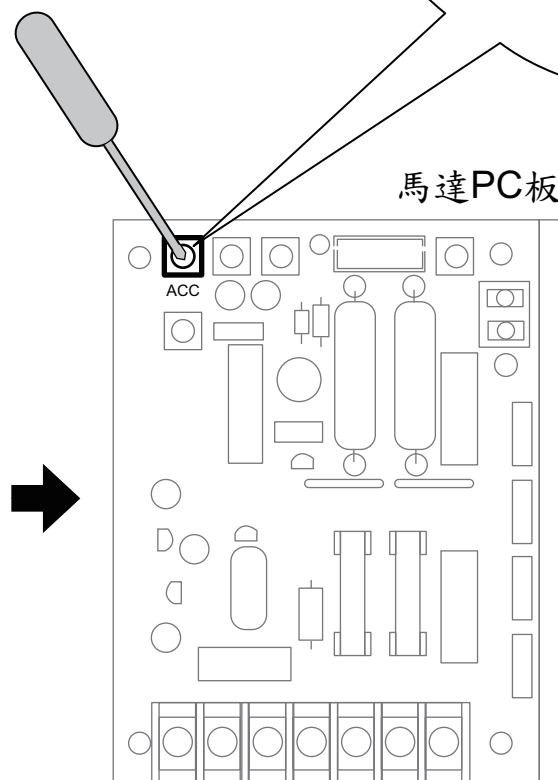
Chapter 5: 設定程序

5.1 轉盤啟動加速時間調整

打開控制面板



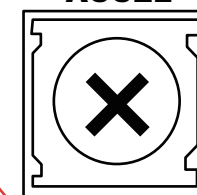
馬達PC板



加速時間愈長

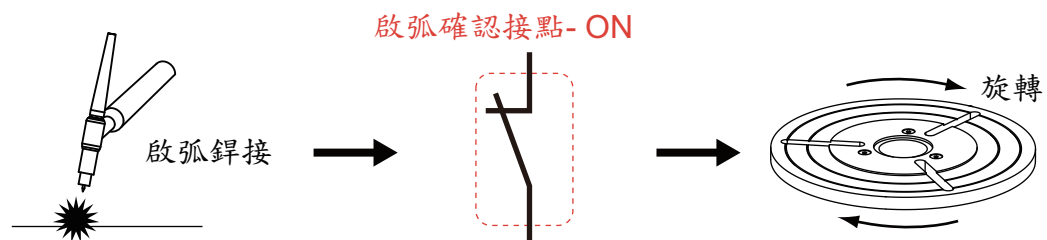
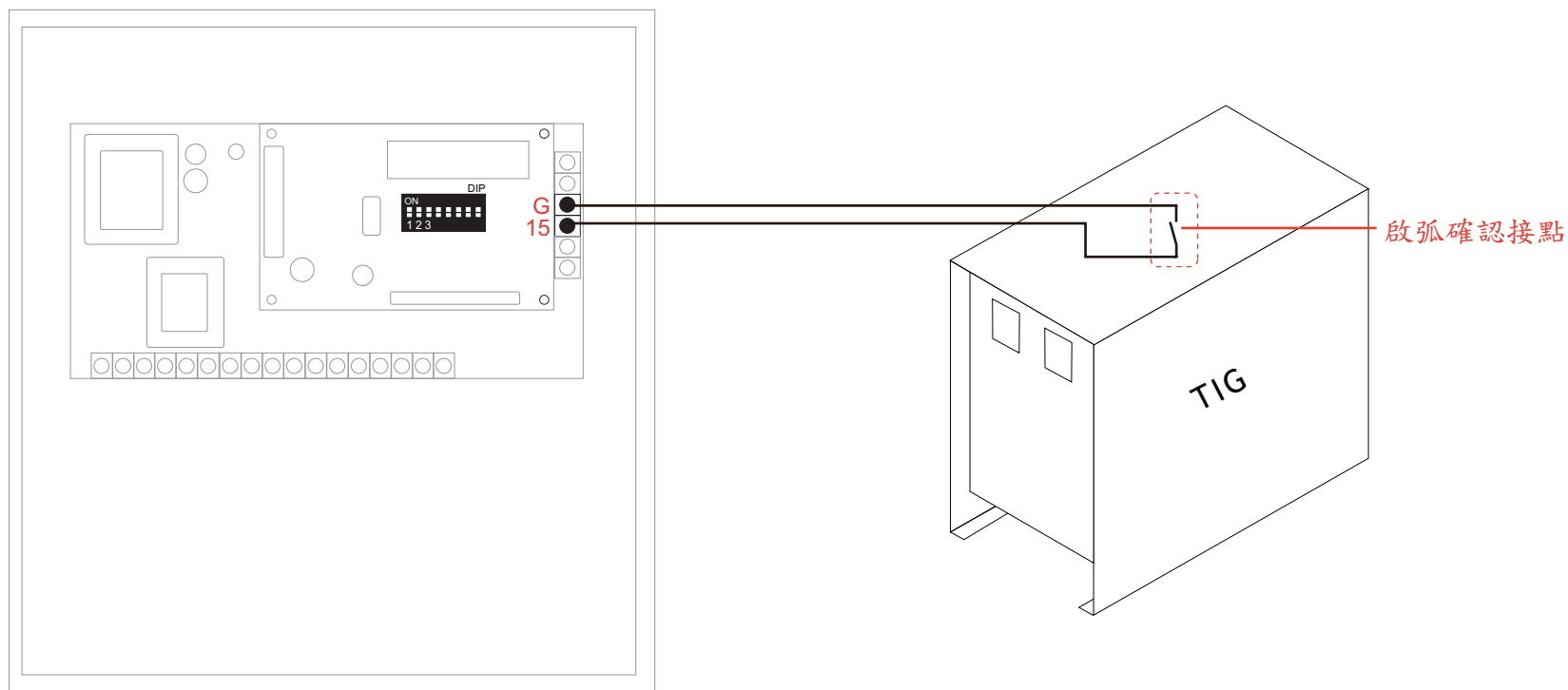
ACCEL

加速時間愈短



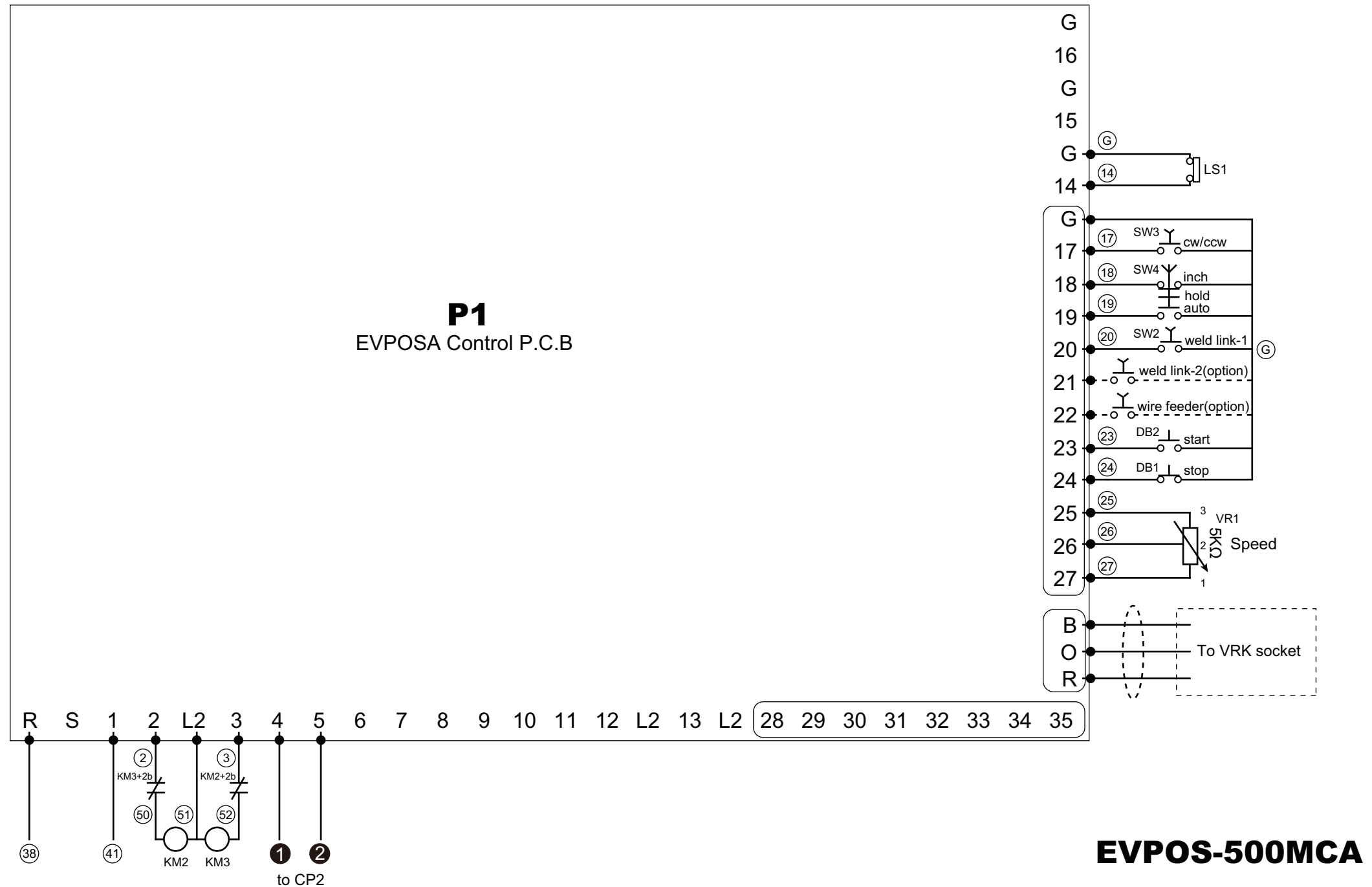
5.2 控制電路板撥鍵開關功能說明

5.2.3 DIP3 ON (只使用在TIG銲機作啟弧確認)



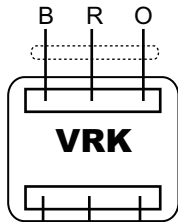
DIP3  OFF (不連接)

Chapter 6: 附錄

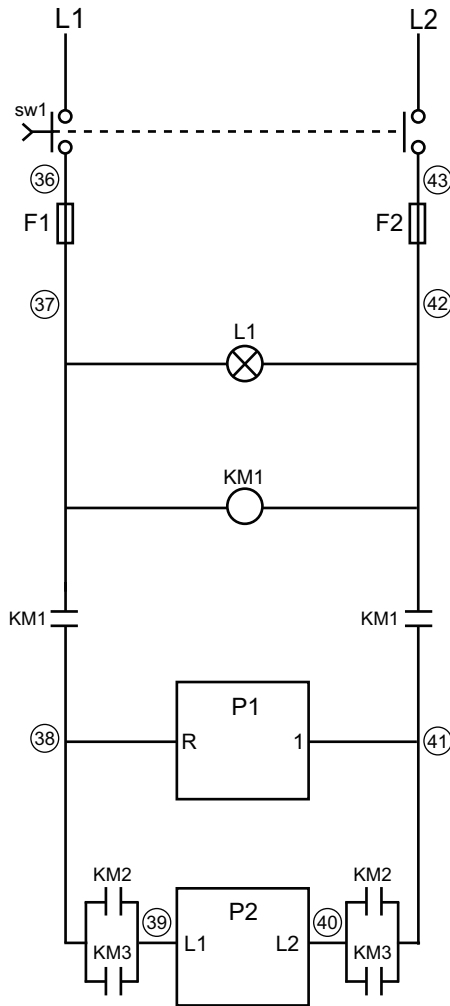
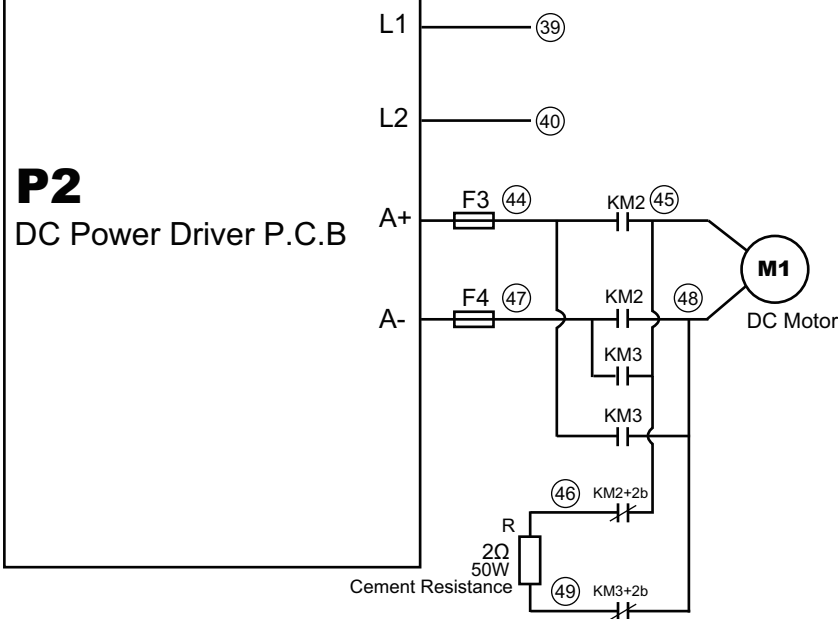


電路圖

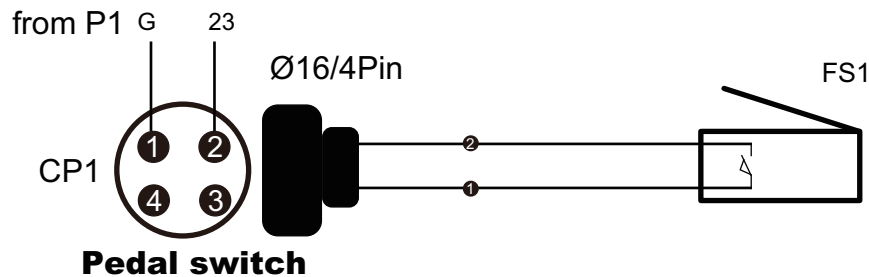
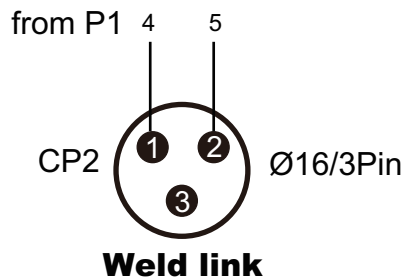
EVPOSA pin line(B,R,O) to VRK socket



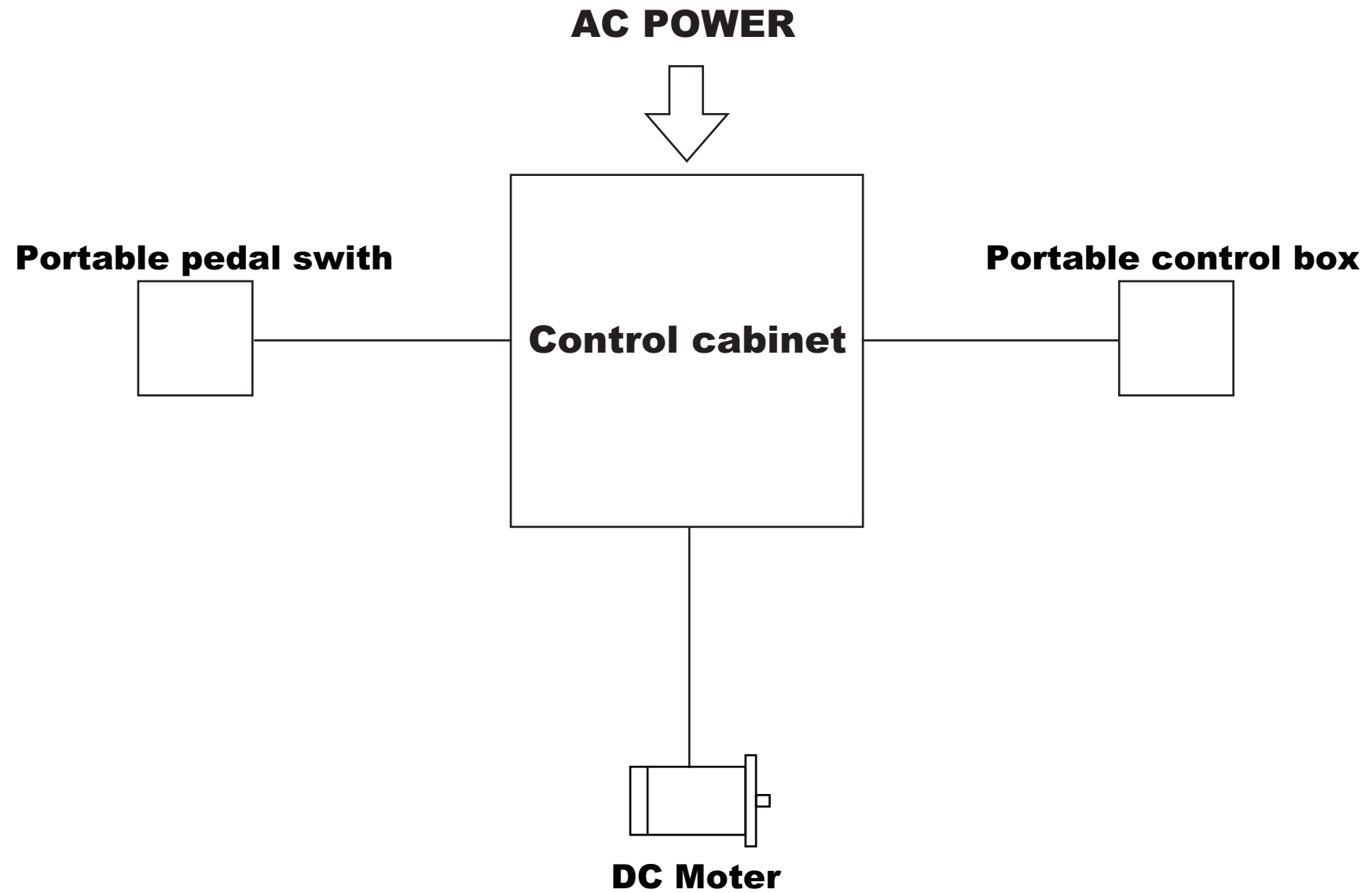
VRK pin line to DC Moter driver socket



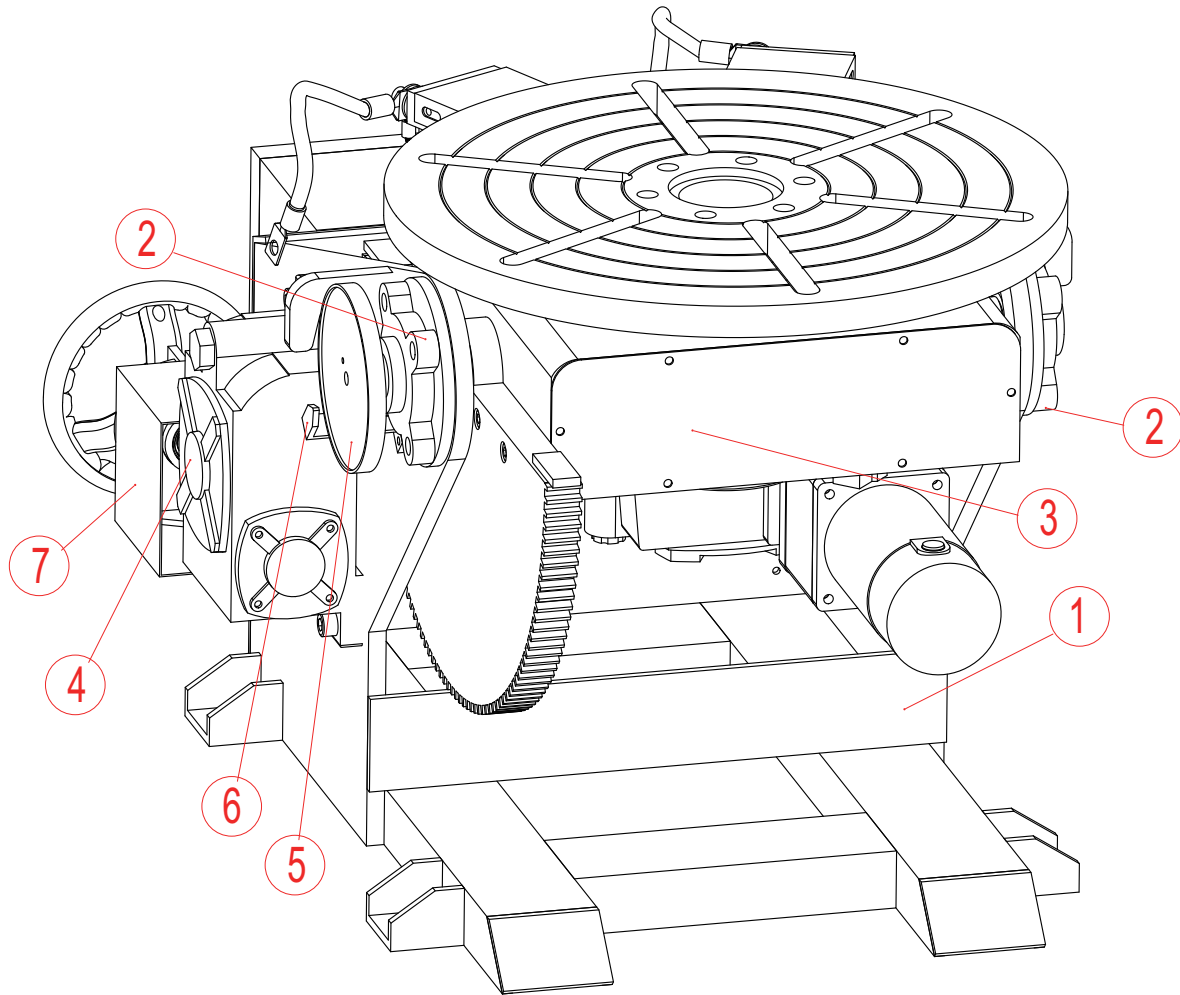
Item	Part No.	Part Name	Q'TY
P1	EVPOSA	Control P.C.B	1
P2	CP-200V9A12	DC Power driver P.C.B	1
KM1	CU16/220/3a1b	Power Relay	1
KM2	CU16/220/4a	Table Relay	1
KM2+2b	202/2b	Table Relay(Additional point)	1
KM3	CU16/220/4a	Table Relay	1
KM3+2b	202/2b	Table Relay(Additional point)	1
SW1	SW 22/2a	Power switch	1
SW2	SW 22/1a	Welding link switch	1
SW3	SW 22/1a	ccw/cw	1
SW4	SW 22/1a/0/1a	inch/hold/AUTO	1
BD1	RB 22/1b	Stop	1
BD2	RB 22/1a	Start	1
FS1	TFS-201	Pedal switch(4M)	1
VR1	VR24YN 20S/5KVΩ	Resistance	1
R	2Ω/50W	Brake motors	1
L1	NPL-22	Light	1
CP1	Ø16/4P	Pedal switch Socket	1
CP2	Ø16/3P	Welding link Socket	1
LS1	TM-1308	Limit switch	1
VRK	VRK01-V2	VR Link P.C.B	1
F1	TFBR-101	6A	1
F2	TFBR-101	6A	1
F3	TFBR-101	2A	1
F4	TFBR-101	2A	1
M1	EVPOS-500MCA	DC 90V/100W Moter	1



EVPOS-500MCA
AC 220V/1Ø

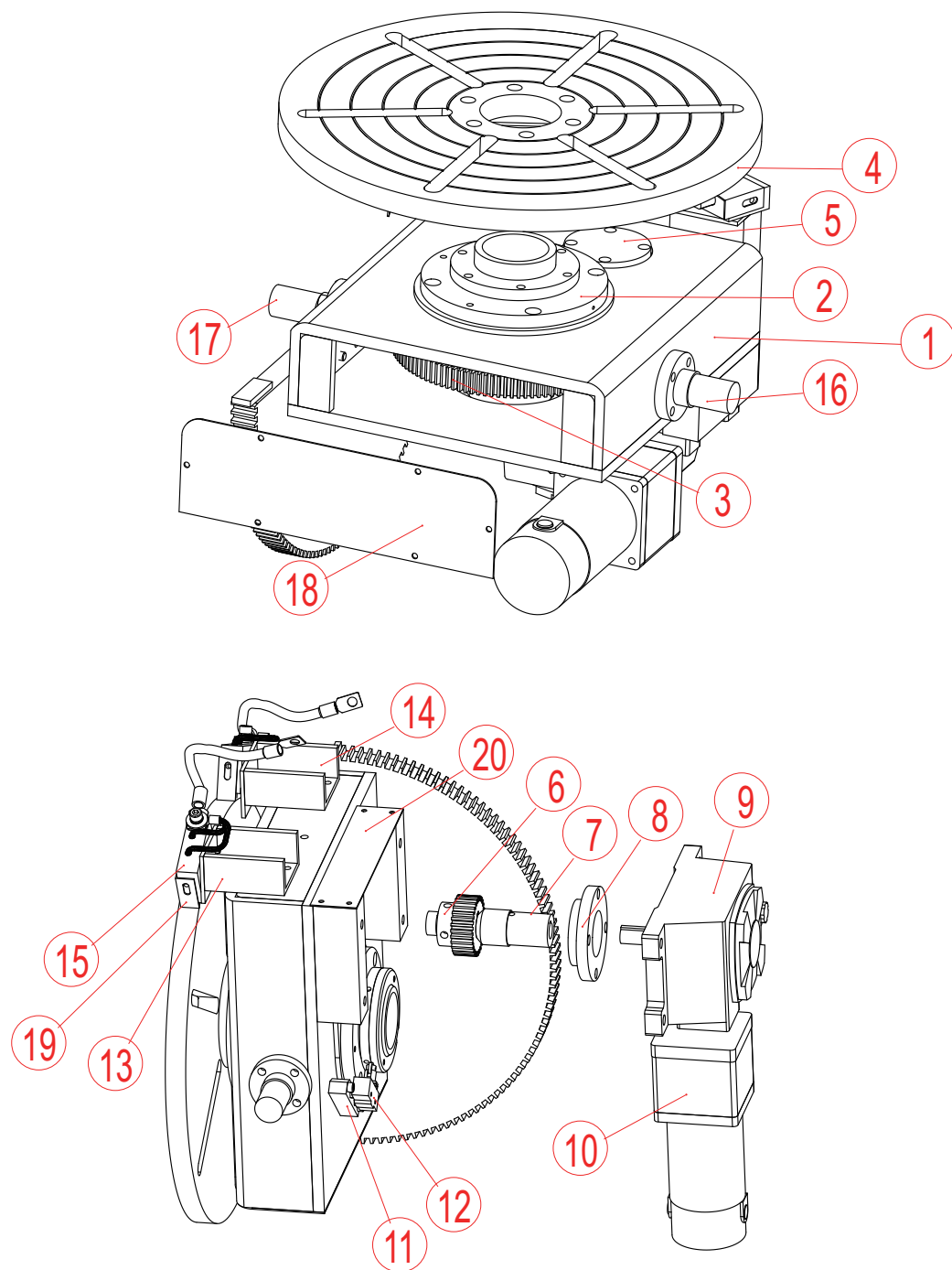


組合圖



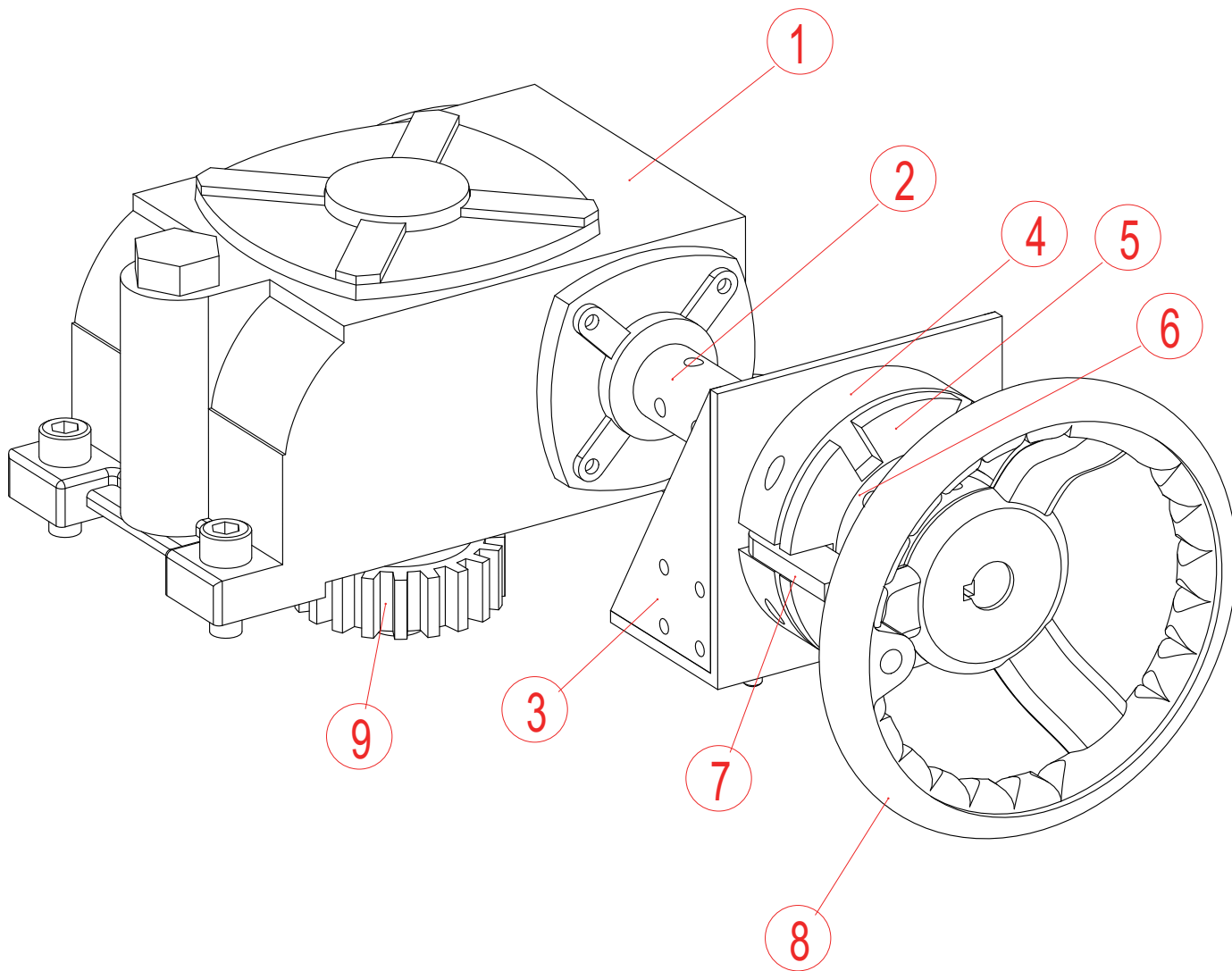
件號	料號	名稱	數量
1	EV500-01	基座	1
2	UCFC206	軸承座	2
3	EV500M-1	主體箱組合	1
4	EV500M-2	轉位減速機組	1
5	EV750-16	角度板座	1
6	EV750-17	68刻度指針	1
7	EV301-10	轉位組護蓋	1
8		350*300控制箱	1

組合圖



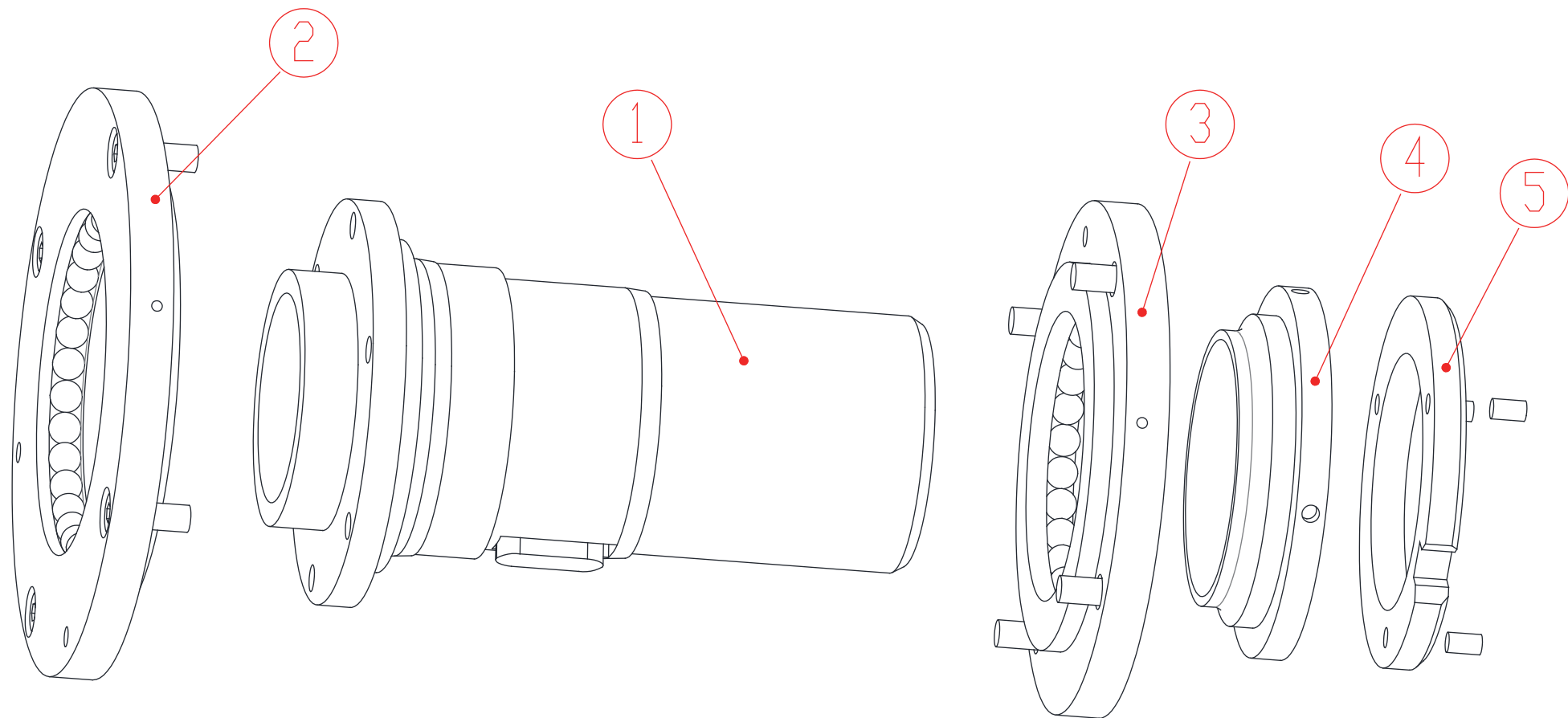
件號	料號	名稱	數量
1	EV500-02	主體齒輪組	1
2	P100A1-1	主軸總成	1
3	EV500-03	110T齒輪	1
4	EV500-11	平盤	1
5	EV500-08	上軸承蓋	1
6	EV500-04	30T齒輪	1
7	EV500-10	驅動軸心	1
8	EV500-09	下軸承蓋	1
9		蝸輪減速機	1
10	5GX	5GX減速機	1
11	P1010	微動塊	1
12	TM1308	微動開關	1
13	EV500-12(A)	右接地固定座	1
14	EV500-12(B)	左接地固定座	1
15	P100A2	接地銅座組	2
16	EV500-07	轉位軸心	1
17	EV500-06	齒輪轉位軸心	1
18	EV500-16	主體箱側板	1
19	EV500-13	302銅座護蓋	2
20	EV500-14	主體後護蓋	1

組合圖



件號	料號	名稱	數量
1		蝸輪減速機	1
2	EV301-15	轉位軸	1
3	EV301-16	轉軸固定座	1
4	EV301-20	擋片塊	1
5	EV301-18	定位盤	1
6	EV301-19	定位座	1
7	EV301-17	定位擋片	1
8	EV301-21	5"電鍍手輪	1
9	EV500-15	轉位齒輪	1

組合圖



件號	料號	名稱	數量
1	P1001-1	主軸筒	1
2	P1001-2	主軸承座	1
3	P1001-3	副軸承座	1
4	P1001-4	副軸承片	1
5	P1001-5	鎖環	1