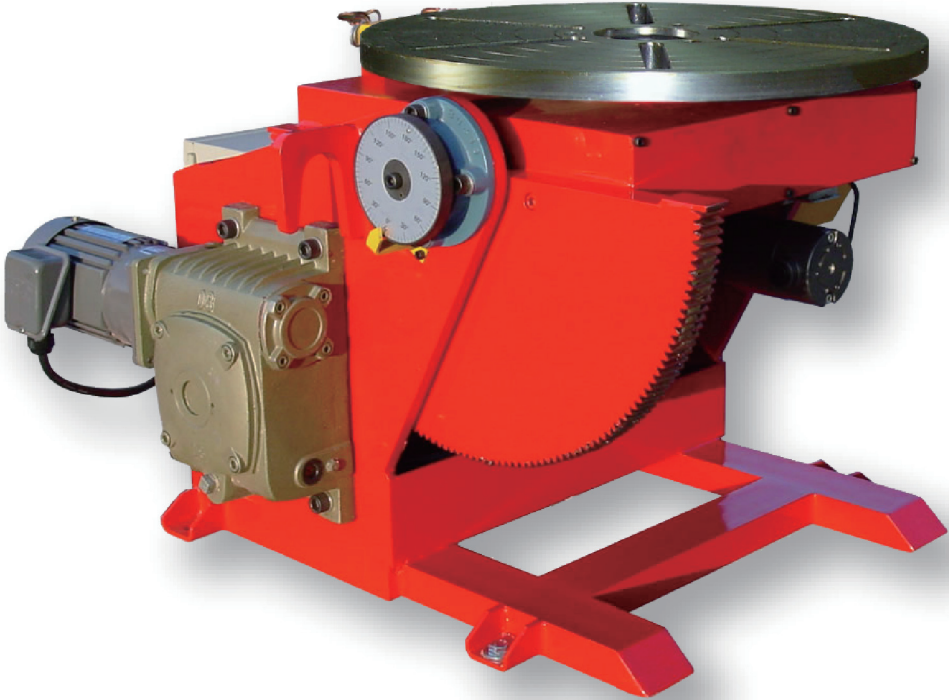




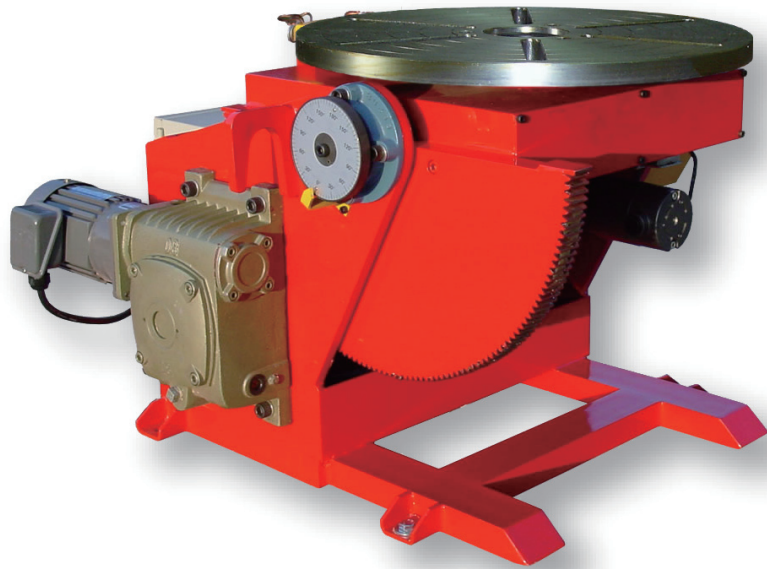
操作手冊

EVPOS-750ACA 銲接定位器

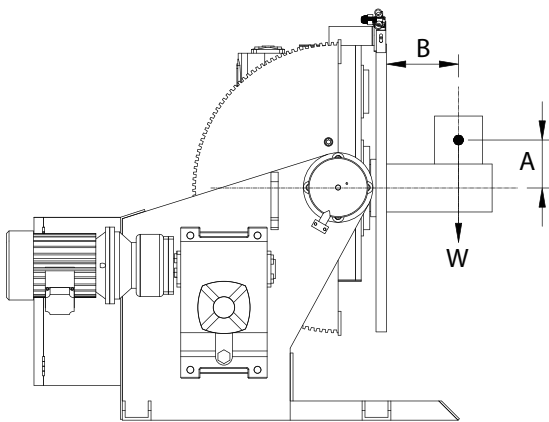


Chapter 1: 諸元

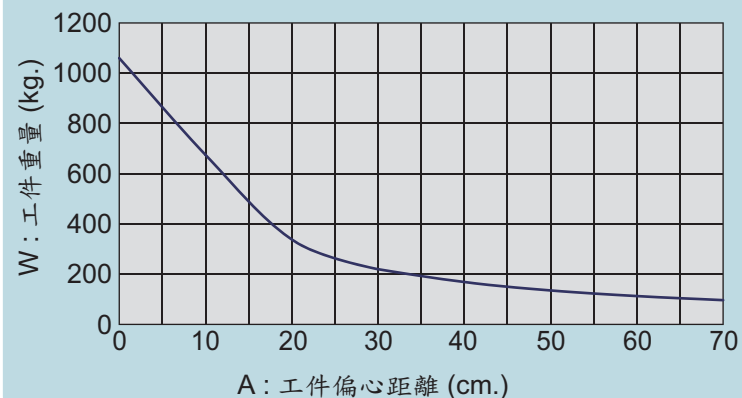
1.1 諸元



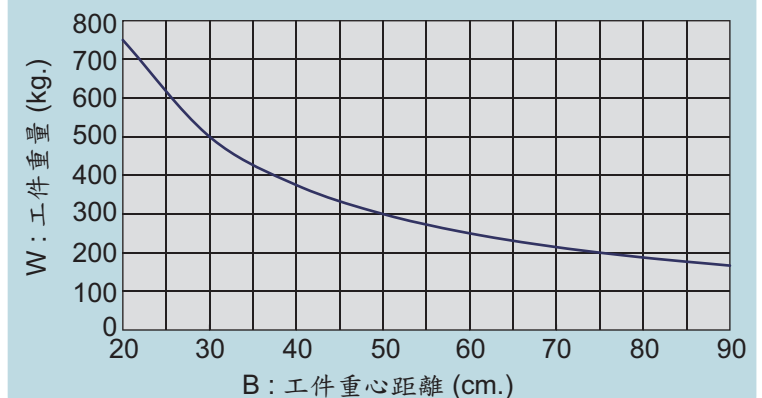
型號	EVPOS-750ACA
入力電源	V1:AC 220V / 10A / 50;60Hz / 3Ø V2:AC 380V / 8A / 50Hz / 3Ø
轉盤馬達	DC 90V / 150W
偏心承載荷重(W)	750Kg.
旋轉荷重偏心距(A)	70mm.
盤面傾斜重心高(B)	180mm.
盤面直徑	600mm.
軸心孔徑	60mm.
盤面轉數	0.12~1.2 RPM
盤面傾斜角度	0° - 135°
盤面傾斜速度	17 秒 / 135°
盤面傾斜馬達	AC 0.5HP
盤面傾斜安全鎖	強制煞車
操作模式	寸動 / 自保持 / 原點覆歸 / 原點定時
原點覆歸功能	0-99.9秒-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)
鐳機啟動模式	□ 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)



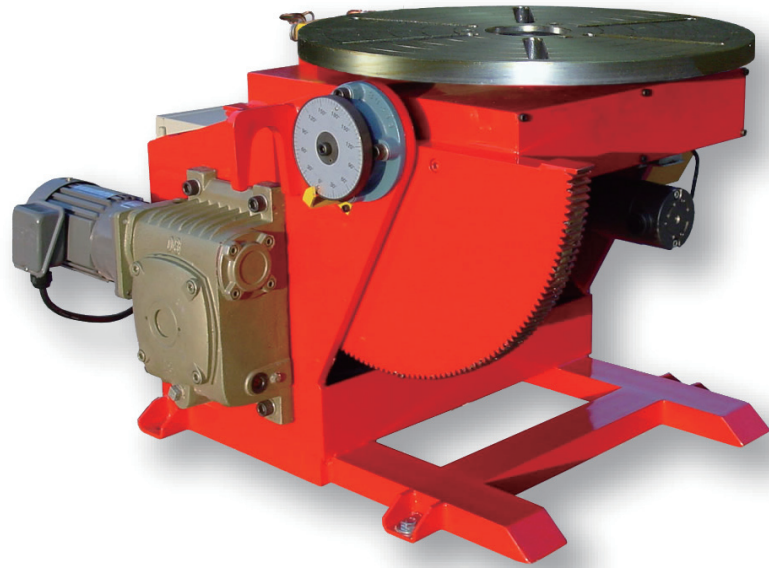
EVPOS-750ACA 旋轉荷重偏心距離表



EVPOS-750ACA 盤面傾斜重心高度表



1.1 諸元

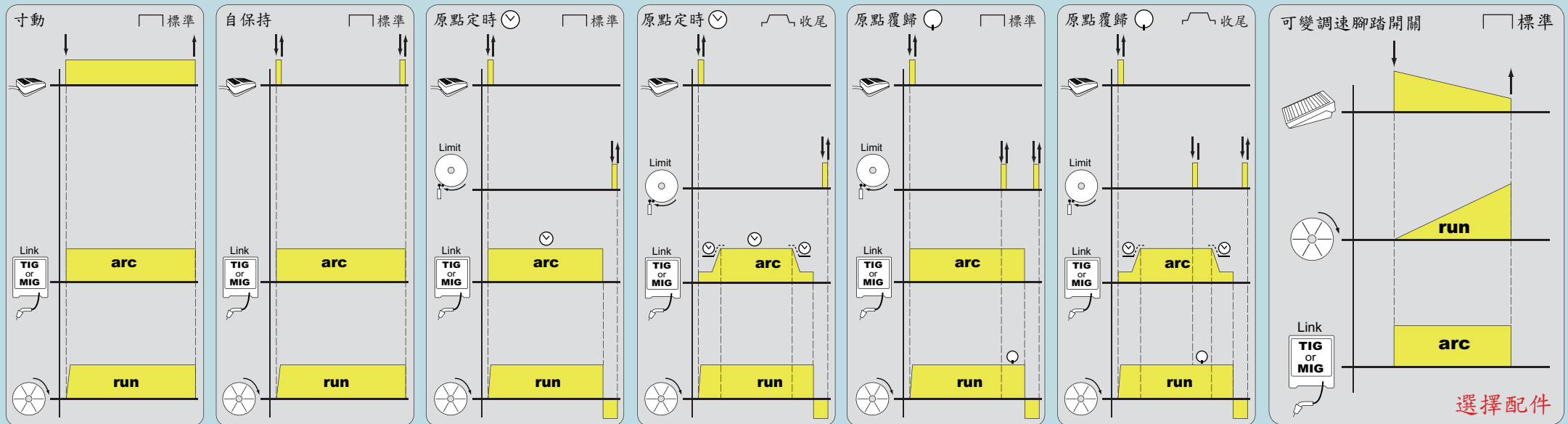


選擇性配件



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

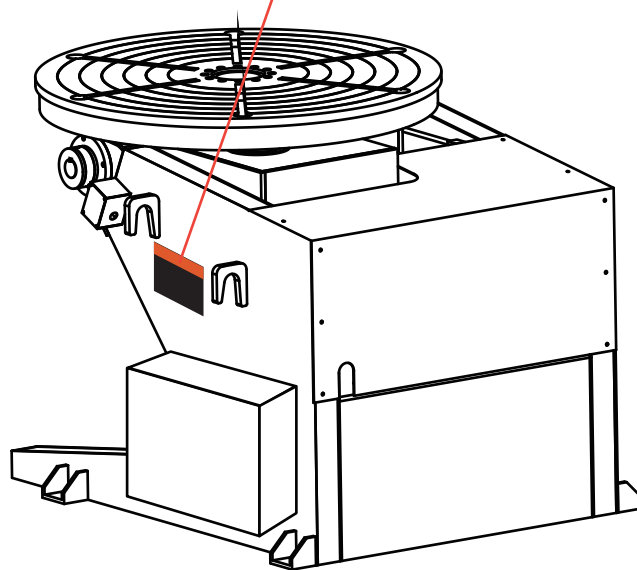
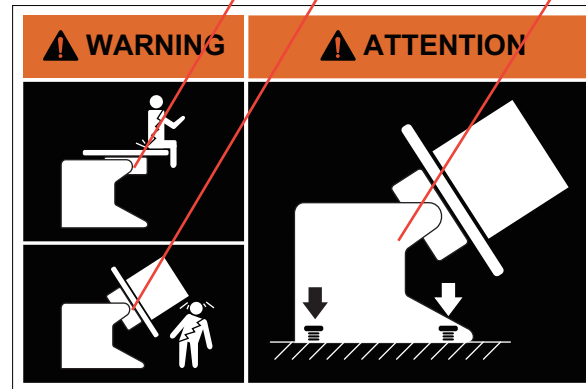
2.1.1.4 不遵守注意事項，將可能導致操作人員受傷，或者機器損壞的部件和/或控制。

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。

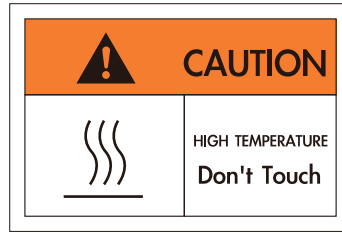
機械固定在地面。



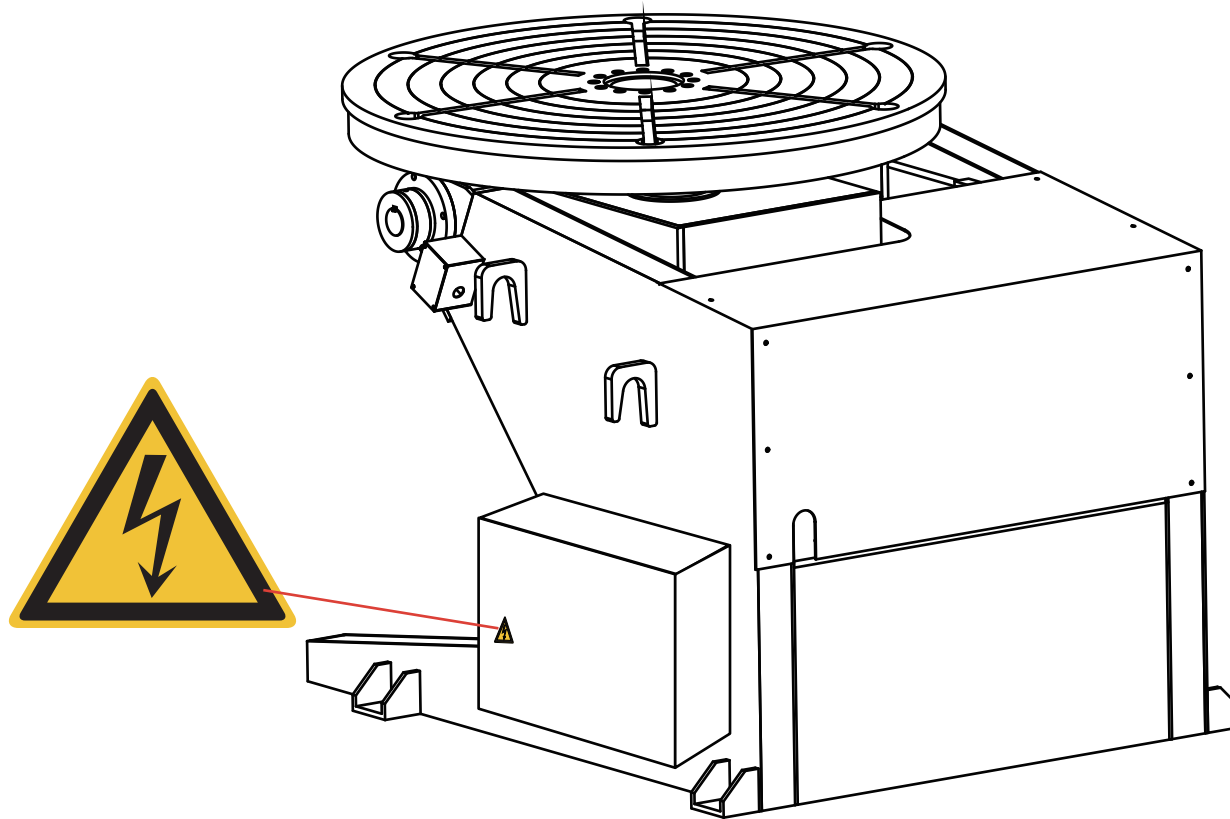
2.3 電氣危險和高溫



電氣危險



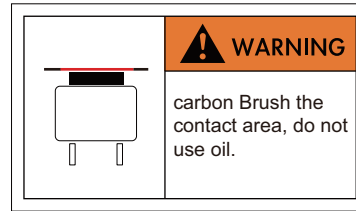
高溫請勿觸摸



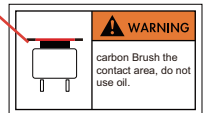
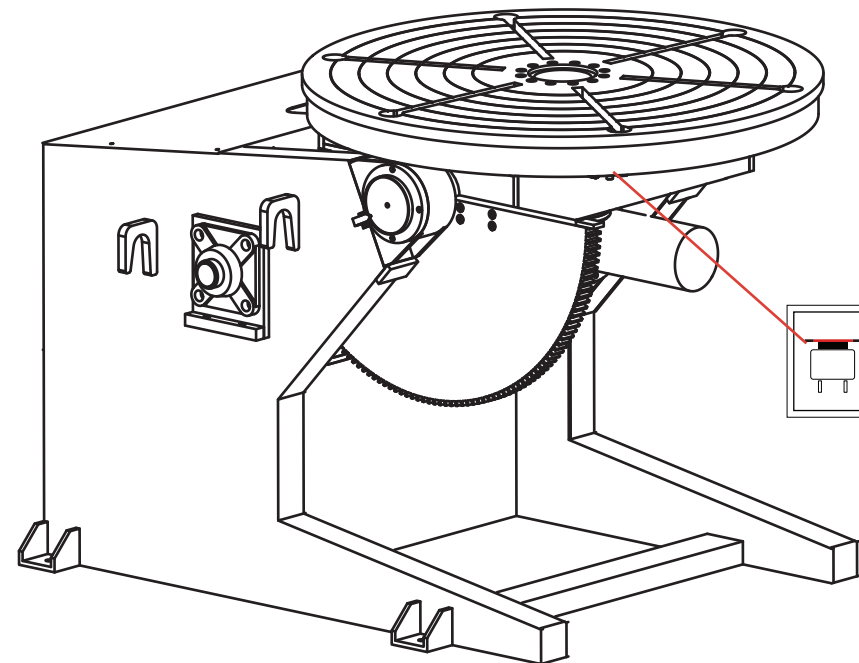
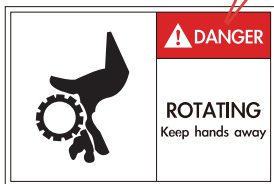
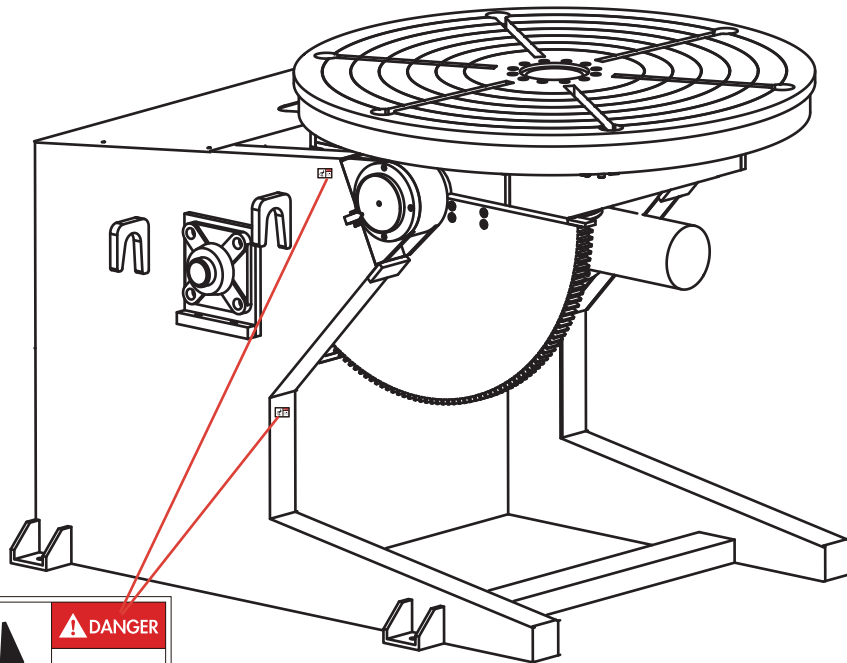
2.4 旋轉及其它



旋轉運作時讓手遠離

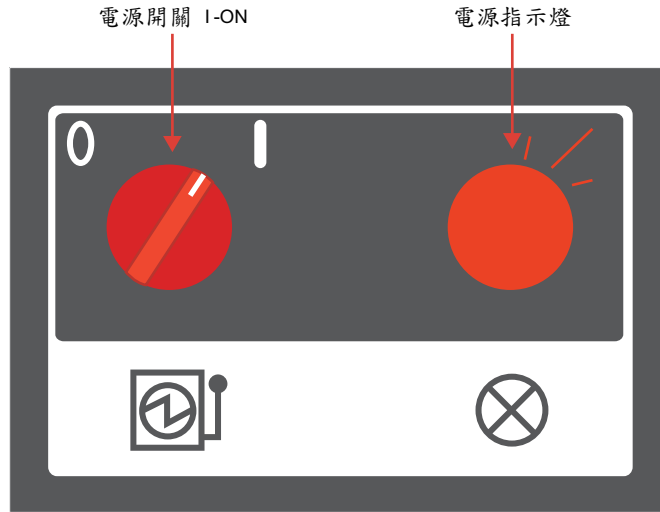
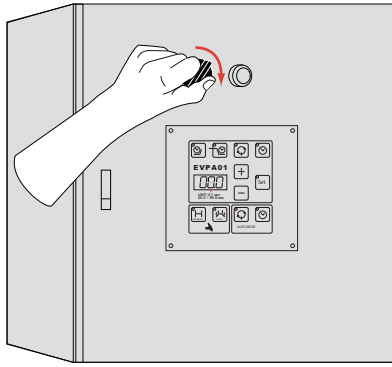


—碳刷接觸面積，不使用油。

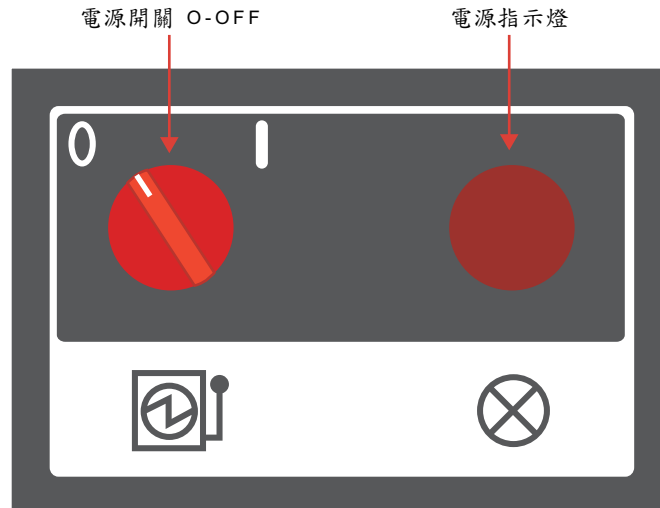
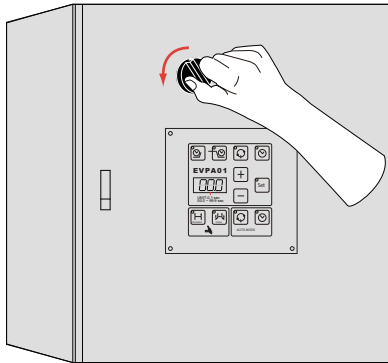


2.5 電源

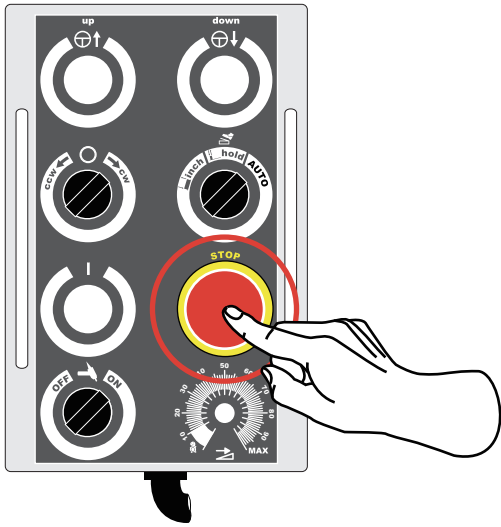
2.5.1 電源 ON



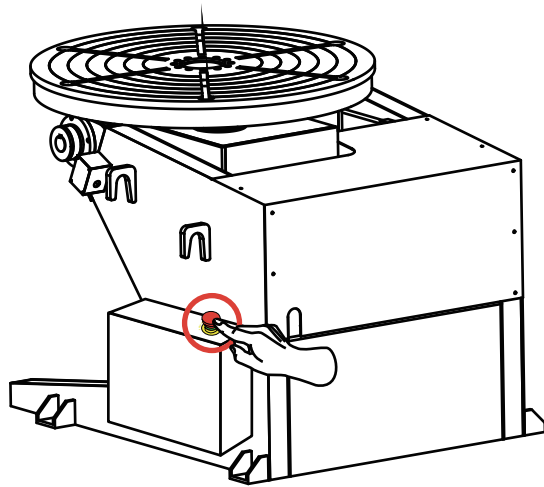
2.5.2 電源 OFF



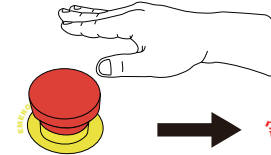
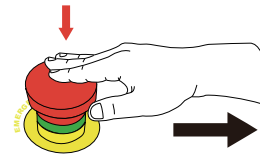
2.6 停止



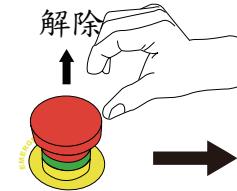
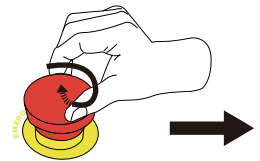
2.6.1 緊急停止



緊急停止



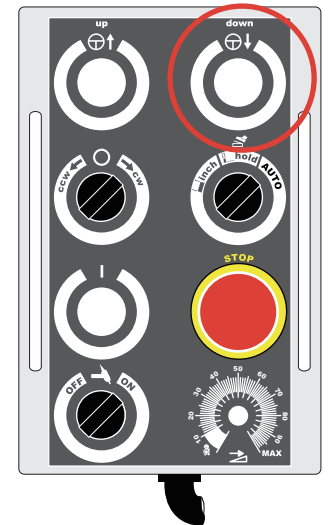
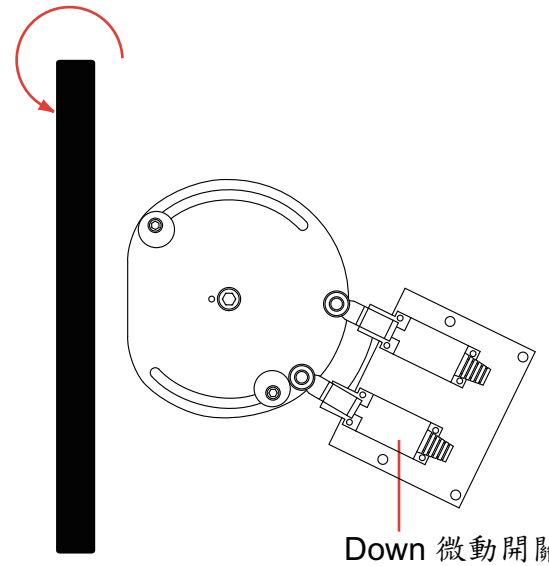
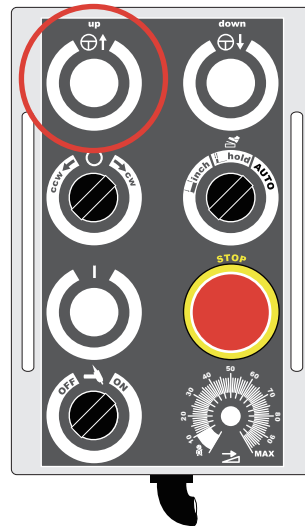
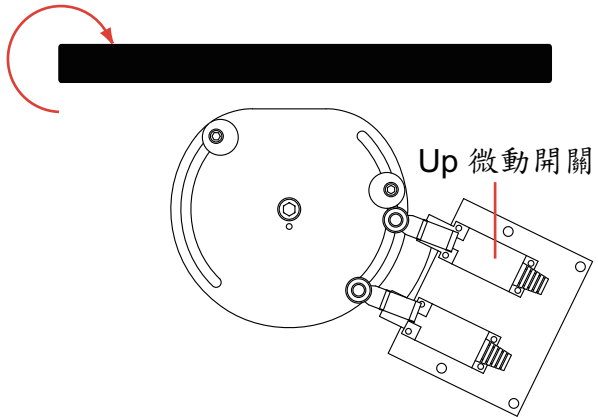
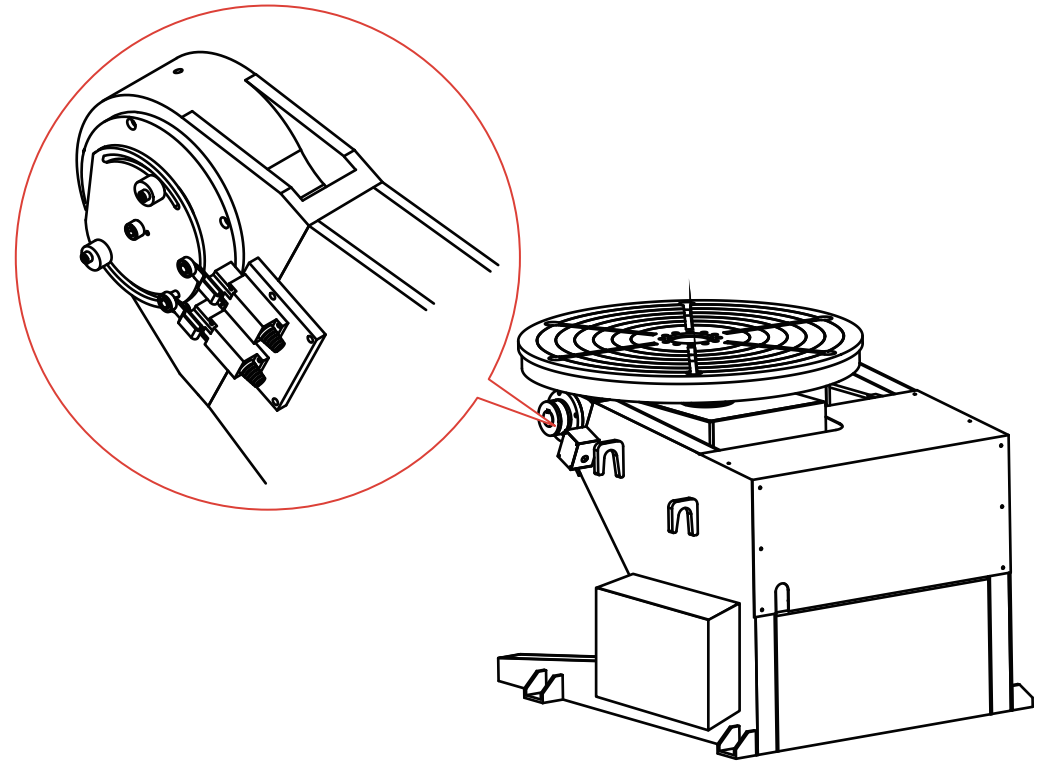
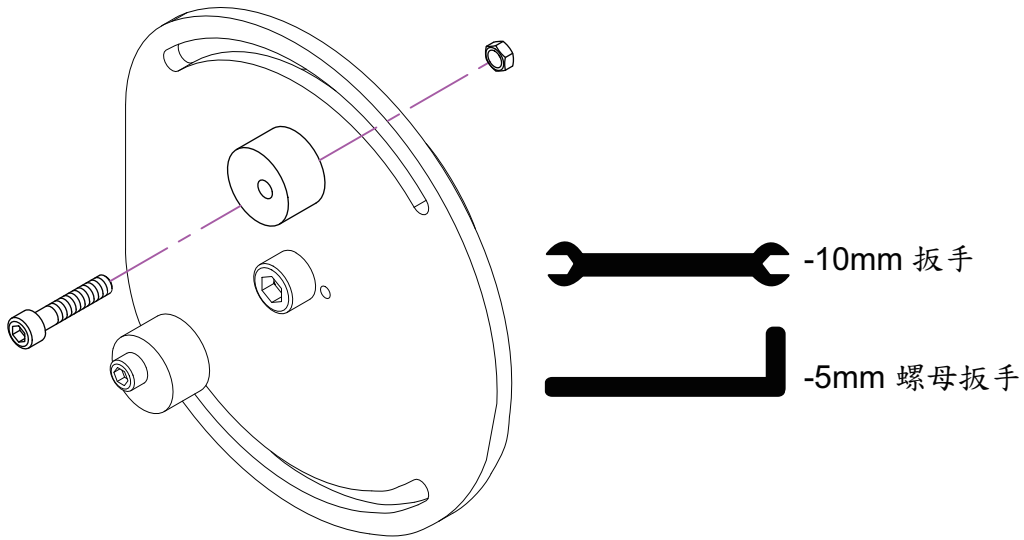
電源跟所有動作強制關閉



解除

電源以及動作重新啟動

2.7 角度傳感器



2.8 控制箱



鋅機接頭



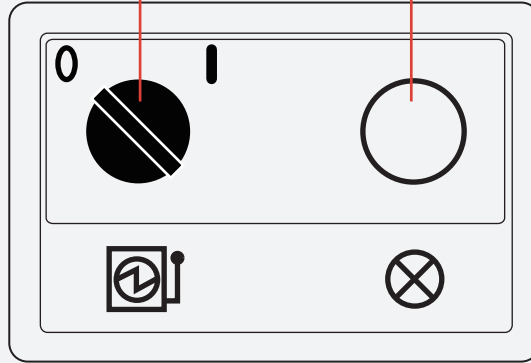
腳踏開關接頭



遙控盒接頭



電源開關 O-OFF I-ON 電源指示燈

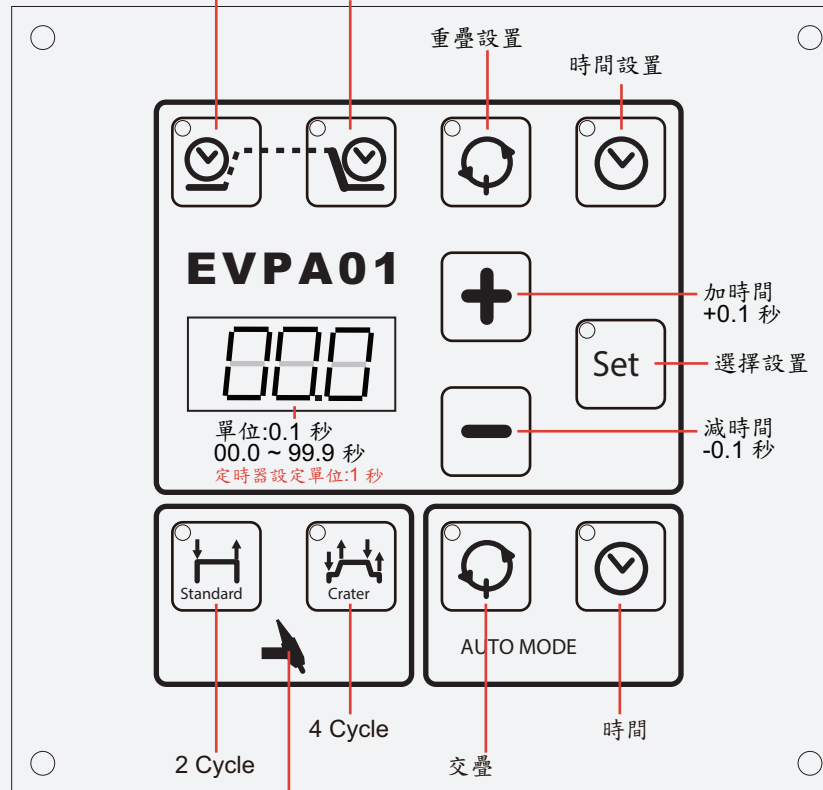


開始焊接電弧的時間設定

焊接電弧的時間設定

重疊設置

時間設置



焊機的電弧方式

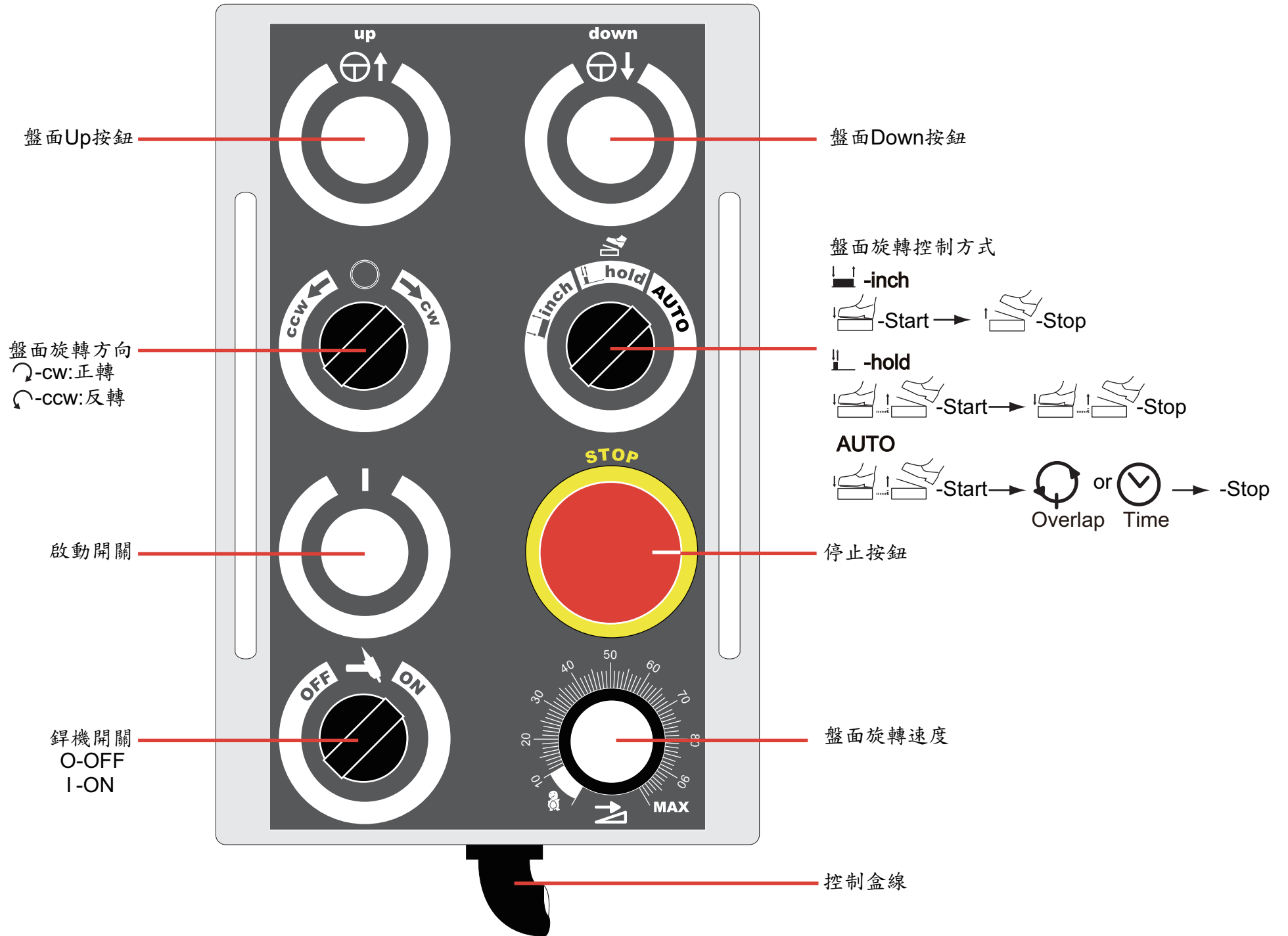
馬達接頭



電源



2.9 控制盒

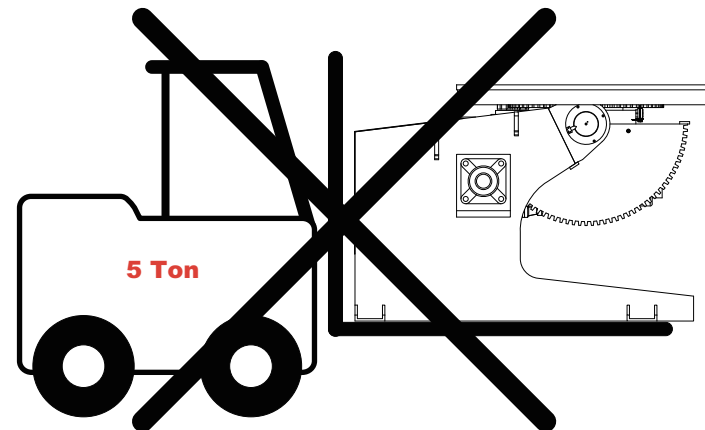
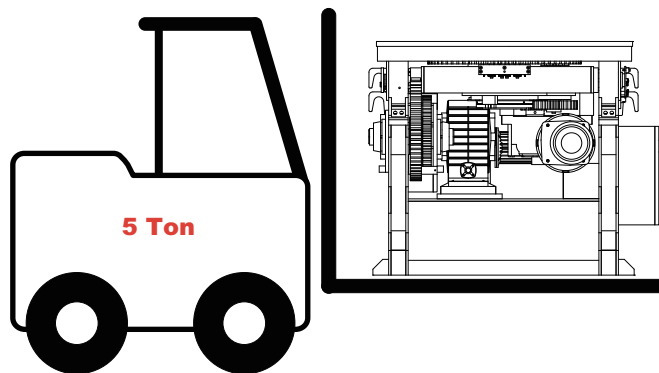
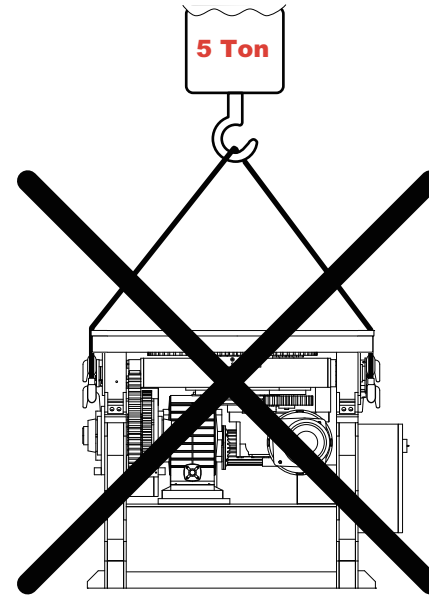
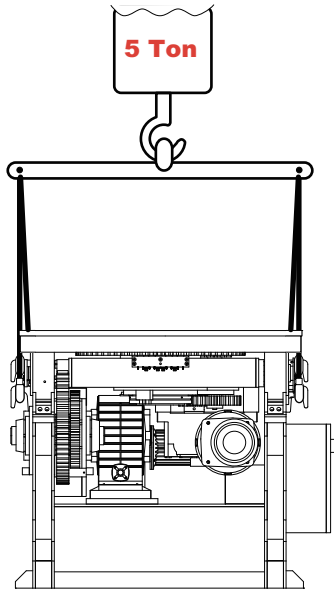


Chapter 3: 安裝說明

3.1 一般

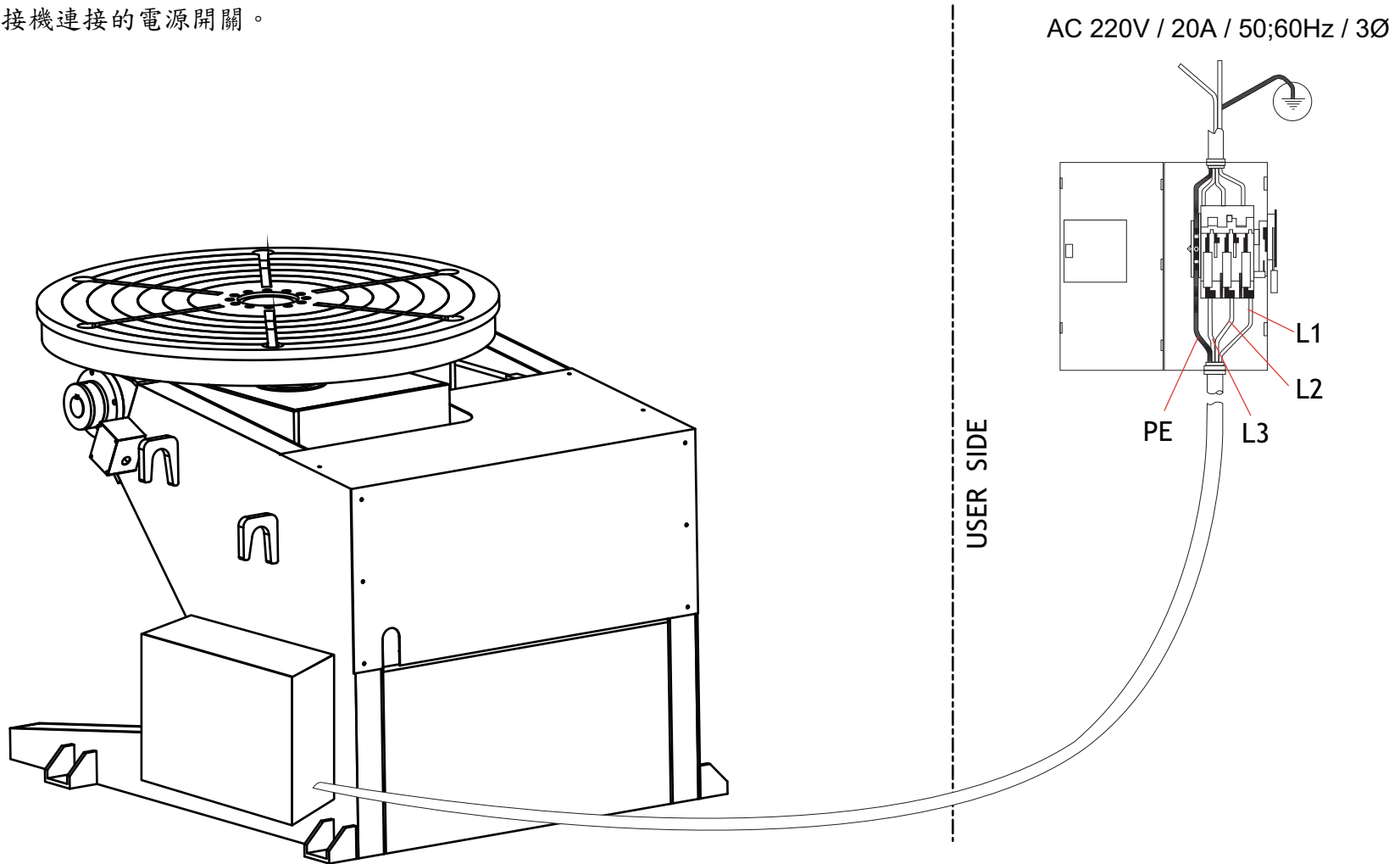
3.1.1 為了保證工件的動作，所以需要真正的安裝POS機的ACA系列定位器的安全性，確認安裝結束後即可操作，請審議這一章的解釋，這樣做。

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。

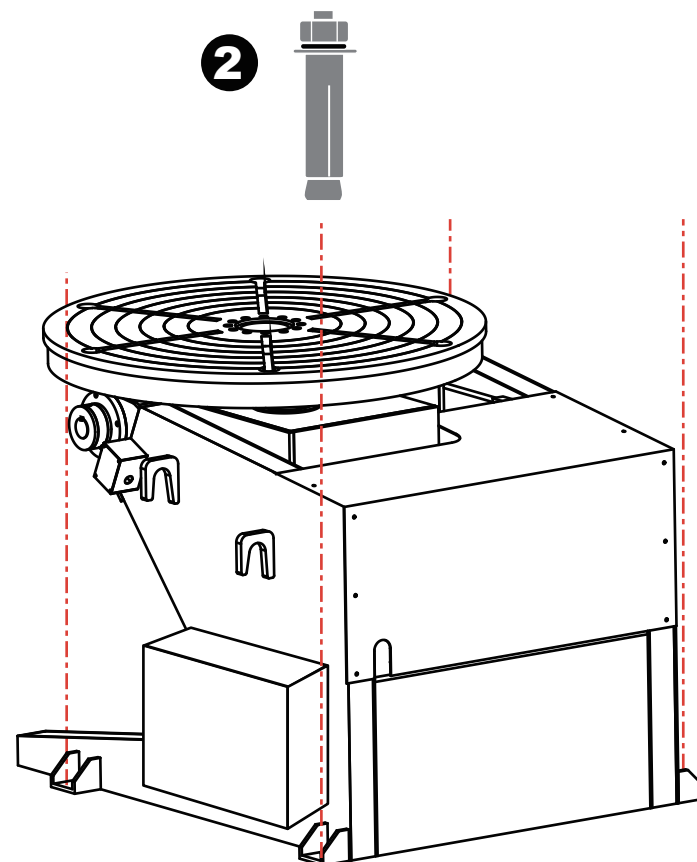
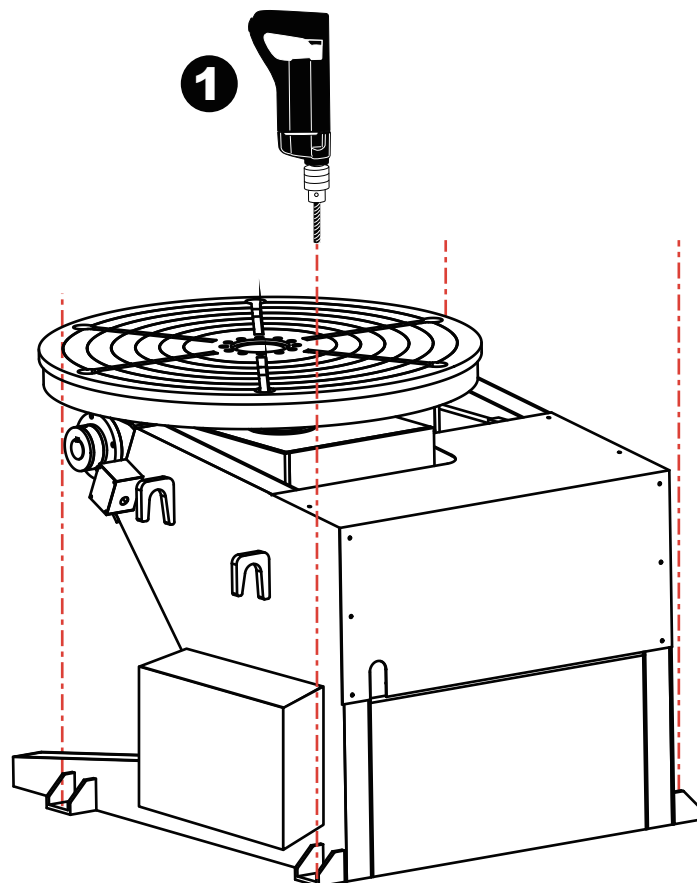


3.3 機械固定安裝

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。

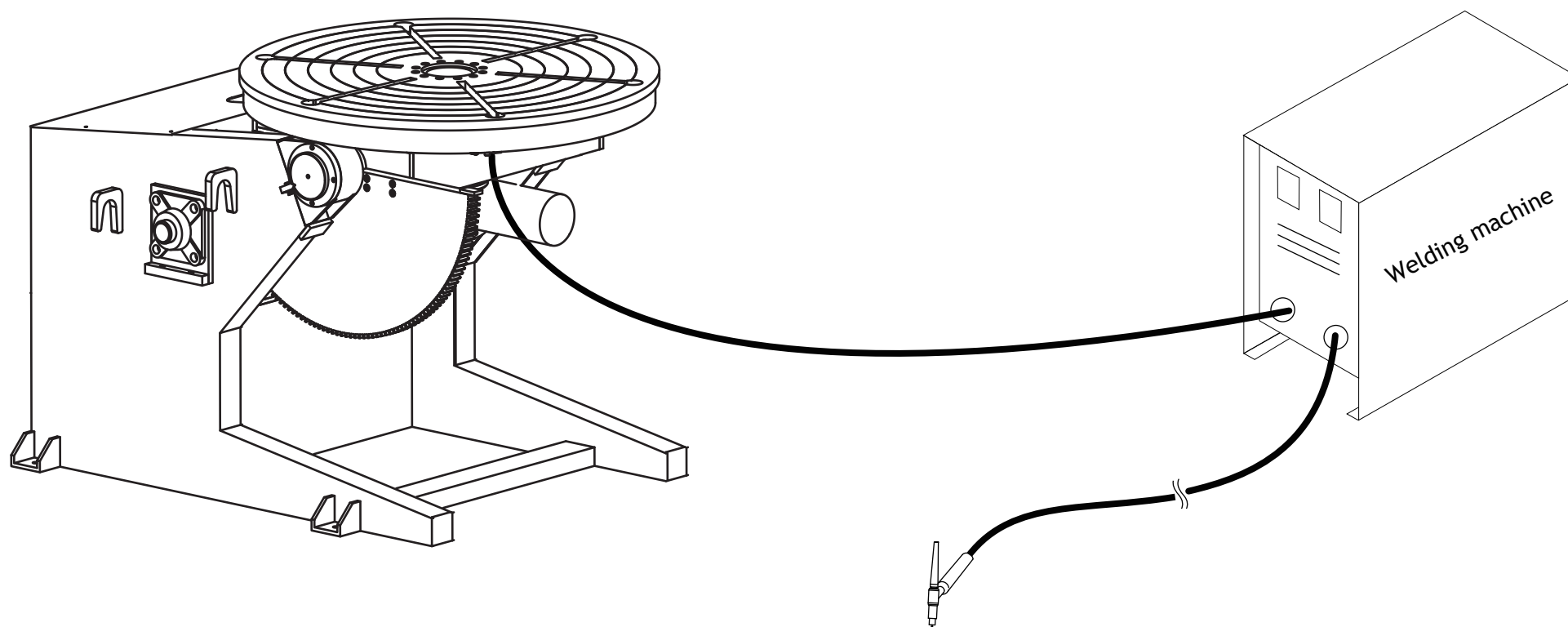


		
300MCA	M12x40mm	M14
500MCA	M12x40mm	M14
750MCA	M12x40mm	M14



3.4 銲機接地

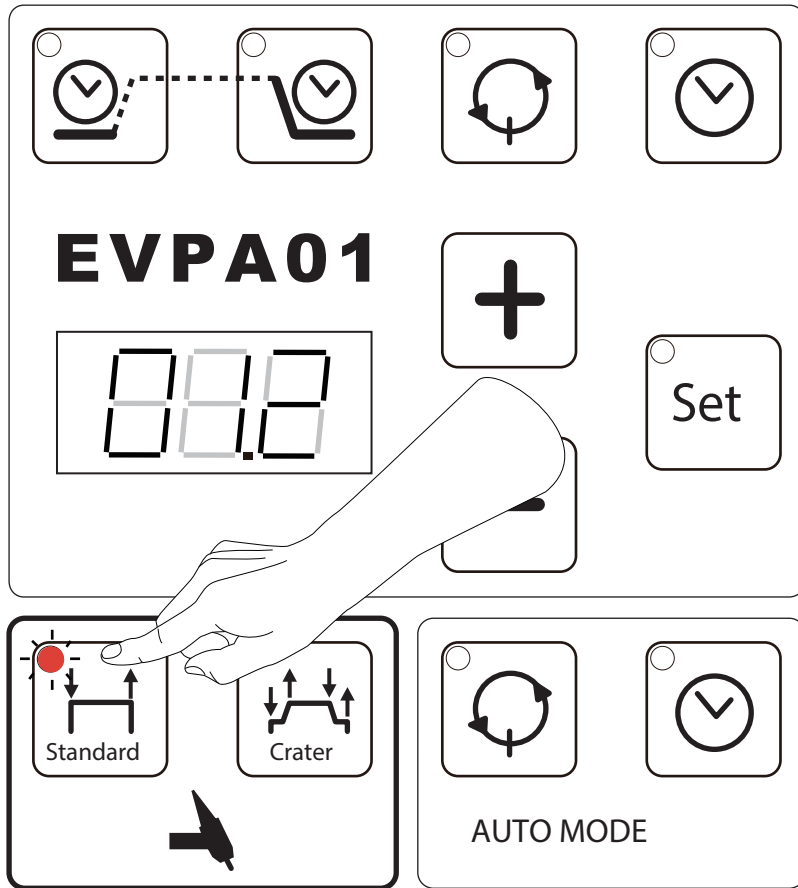
3.4.1 請鎖定電纜，電焊機接觸，碳刷牢固。



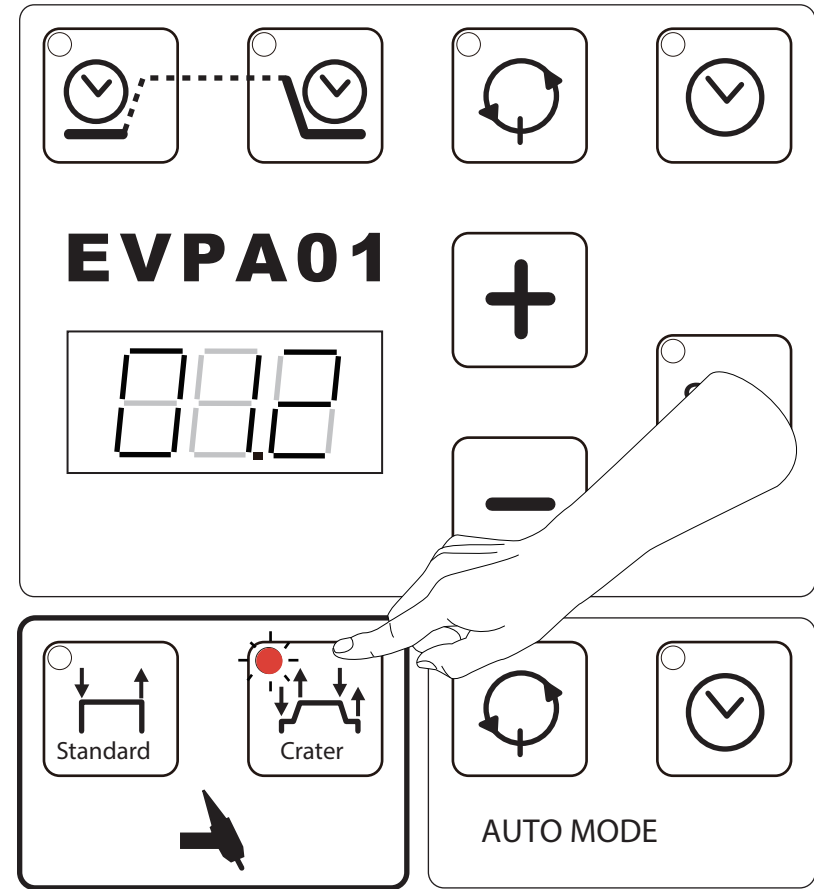
Chapter 4: 手動操作

4.1 電弧方式的鐸機

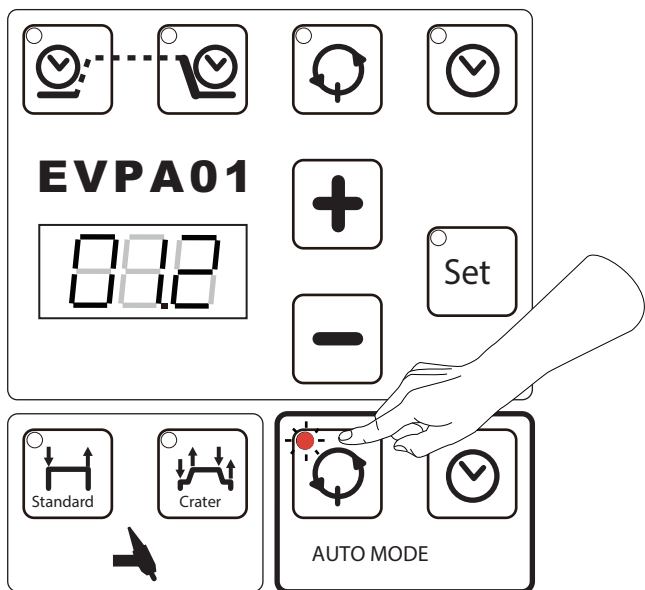
2T(2 CYCLE)



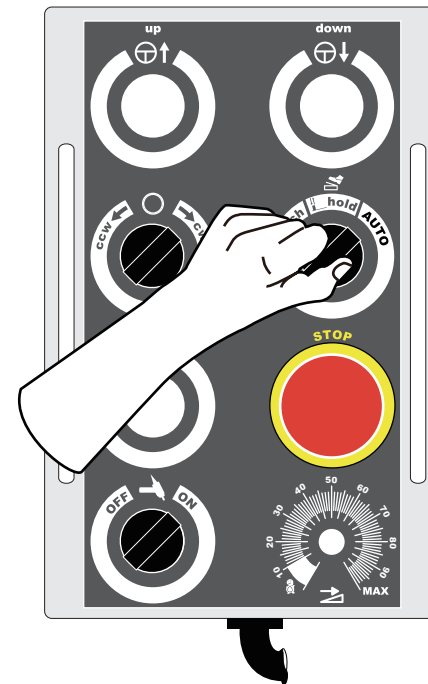
4T(4 CYCLE)



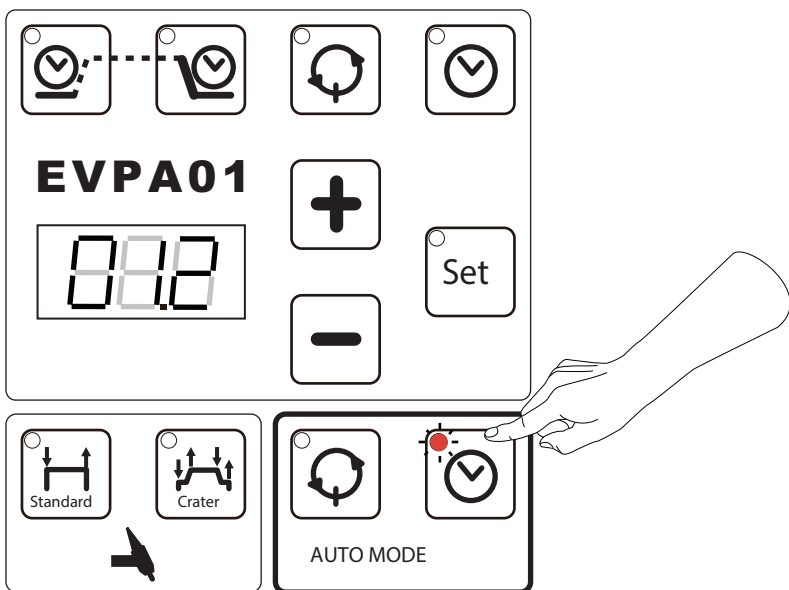
4.2 重疊自動模式



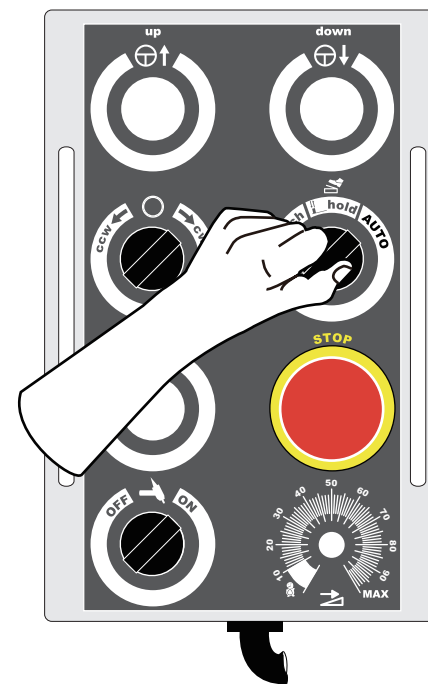
AND



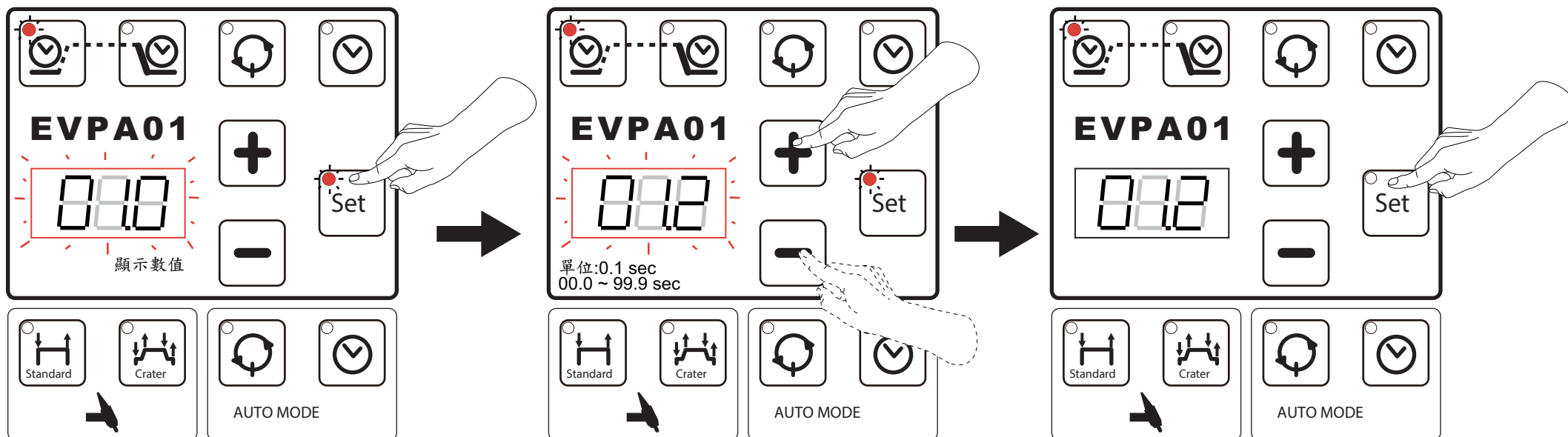
4.3 定時器自動模式



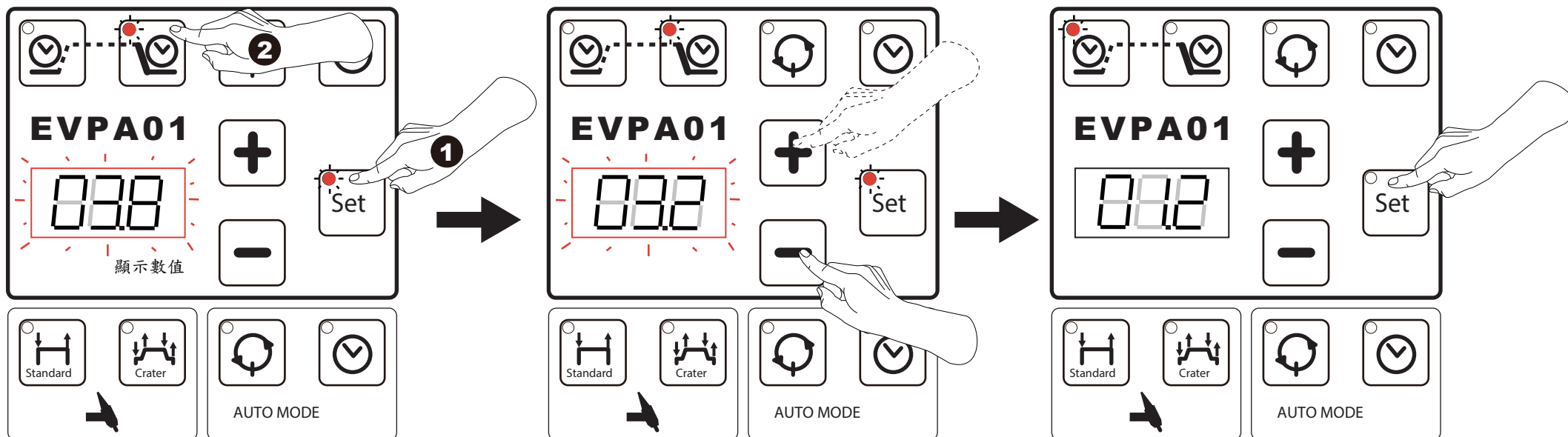
AND



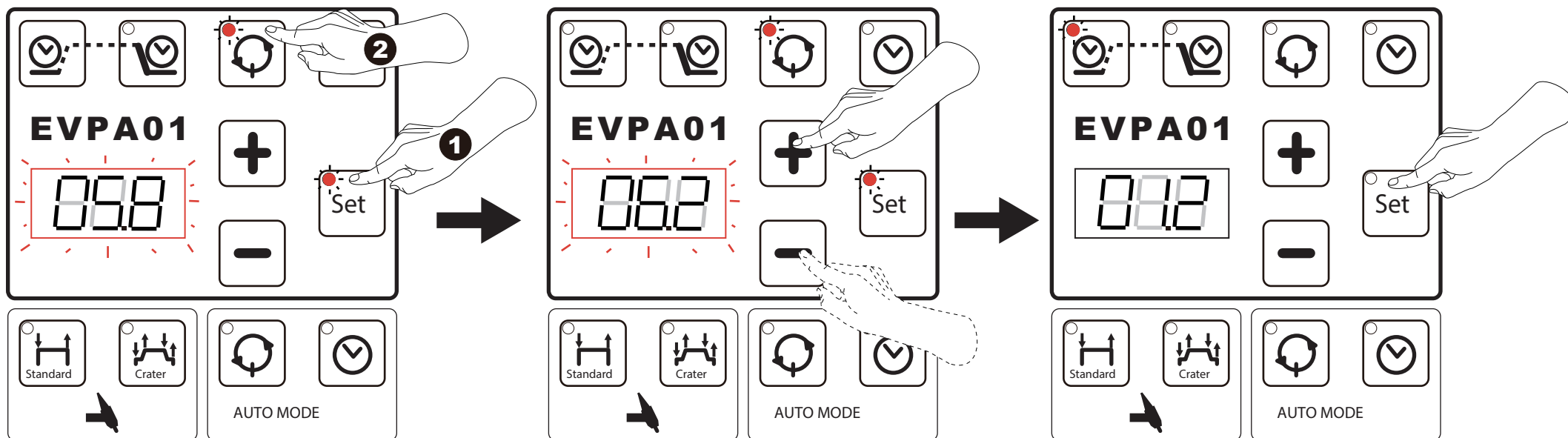
4.4 電弧路的開始時間設置



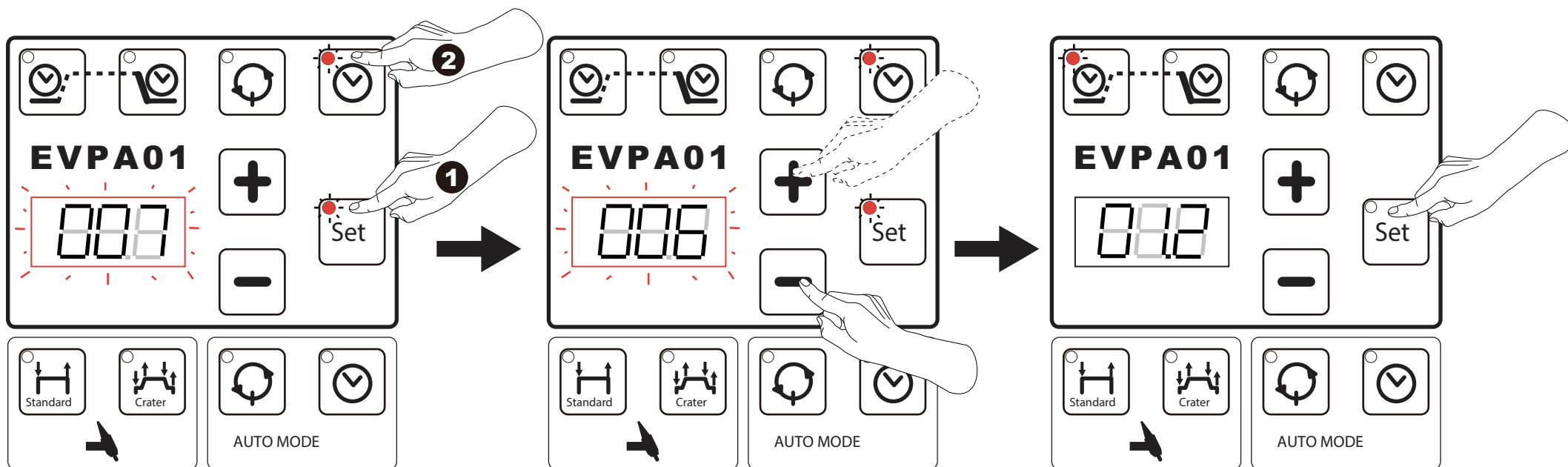
4.5 起弧時間設定的方式



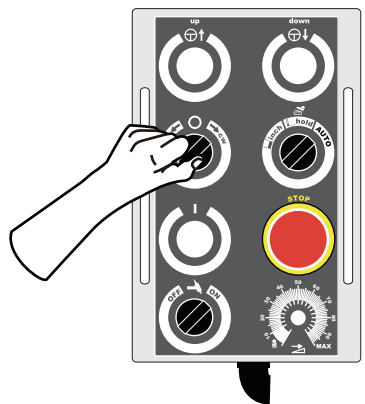
4.6 原點覆歸時間設置



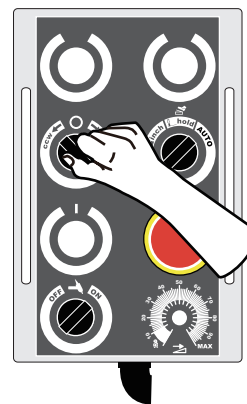
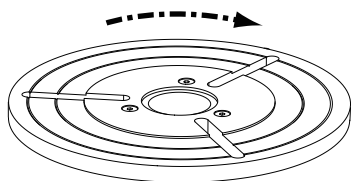
4.7 定時時間設置



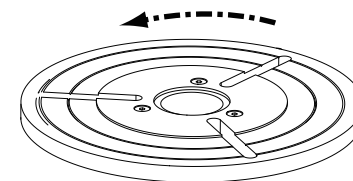
4.8 盤面旋轉方向



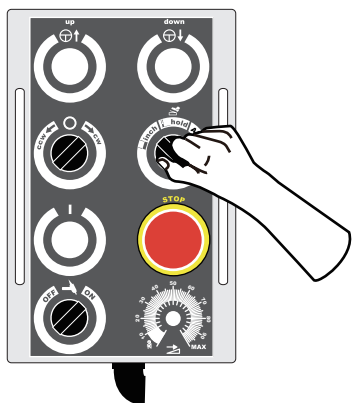
切換 CW 模式



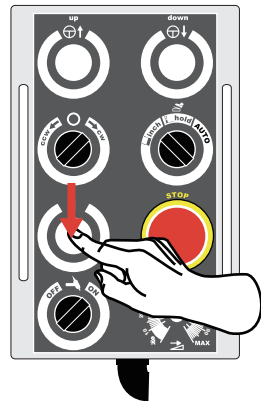
切換 CCW 模式



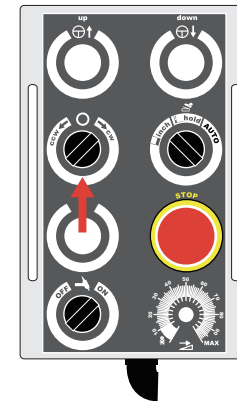
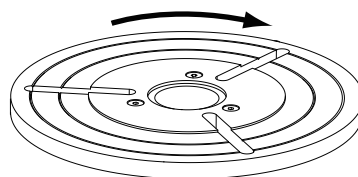
4.9 轉盤寸動旋轉



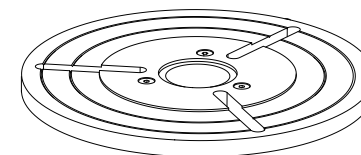
切換Inch 模式



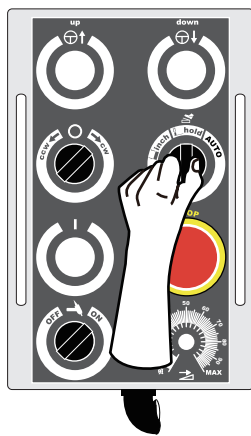
OR



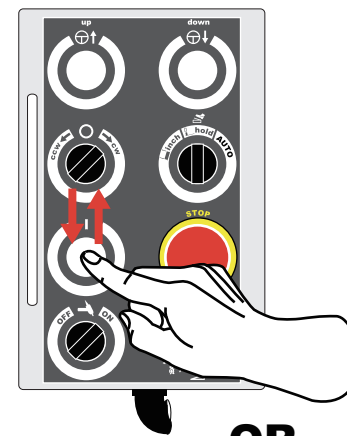
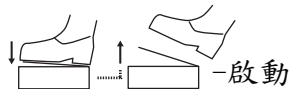
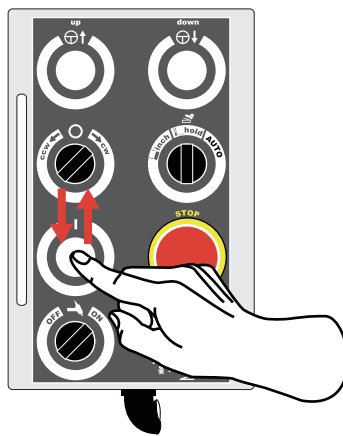
OR



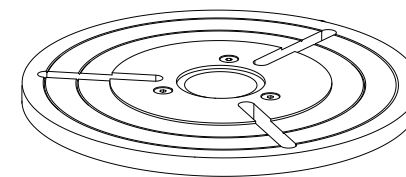
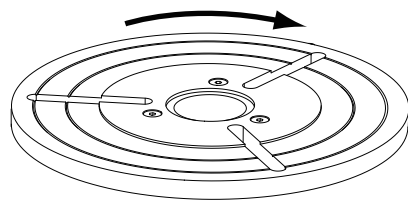
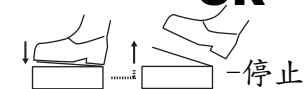
4.10 轉盤自保持旋轉



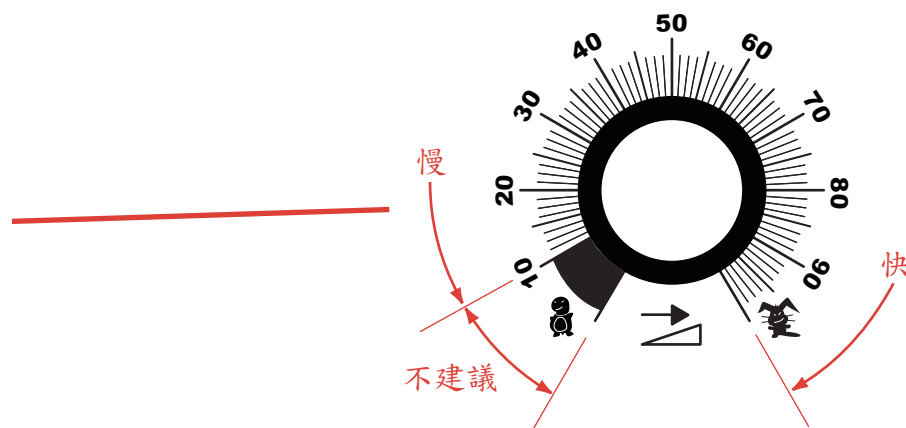
切換hold模式



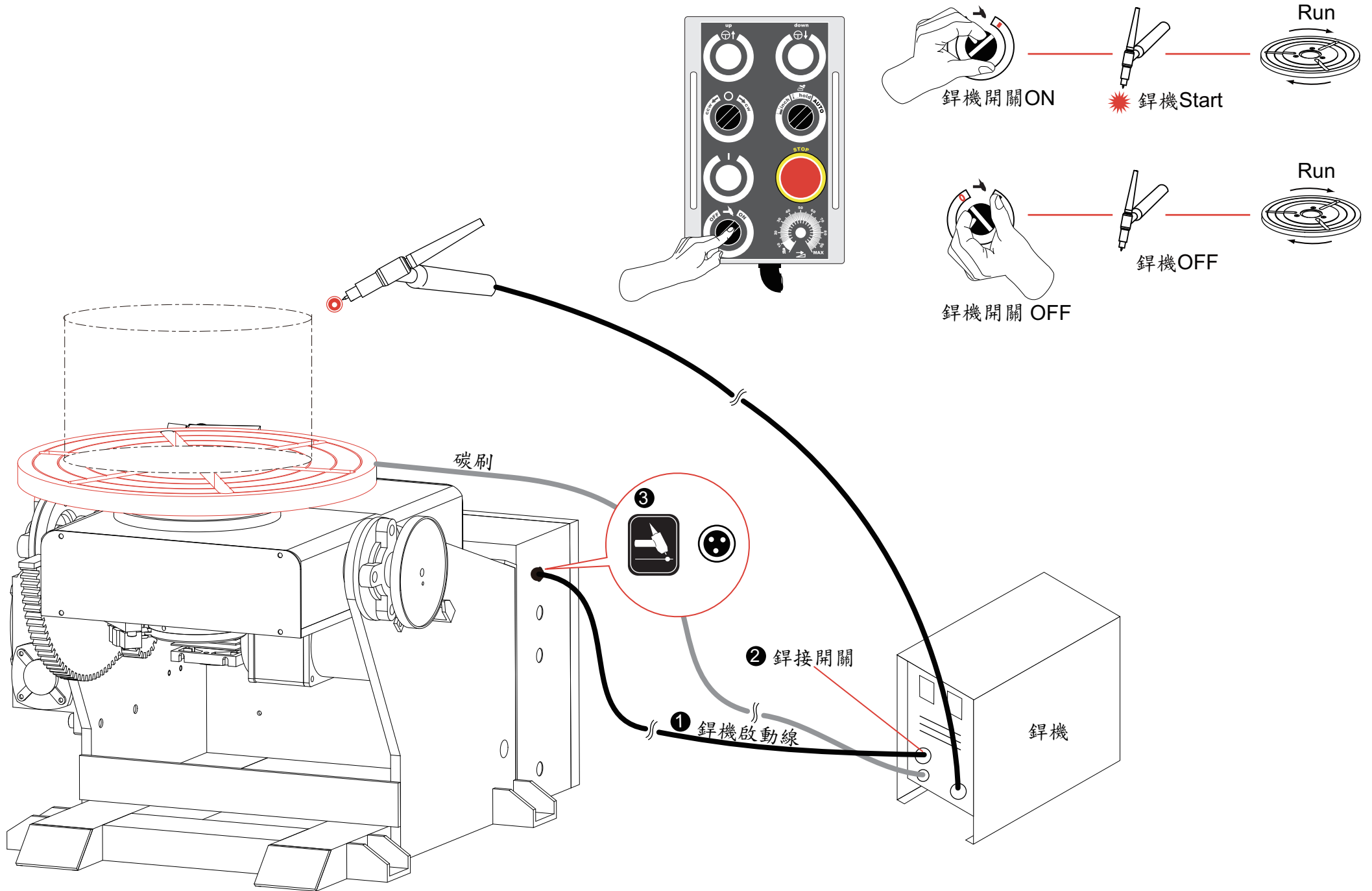
OR



4.11 轉盤旋轉速度



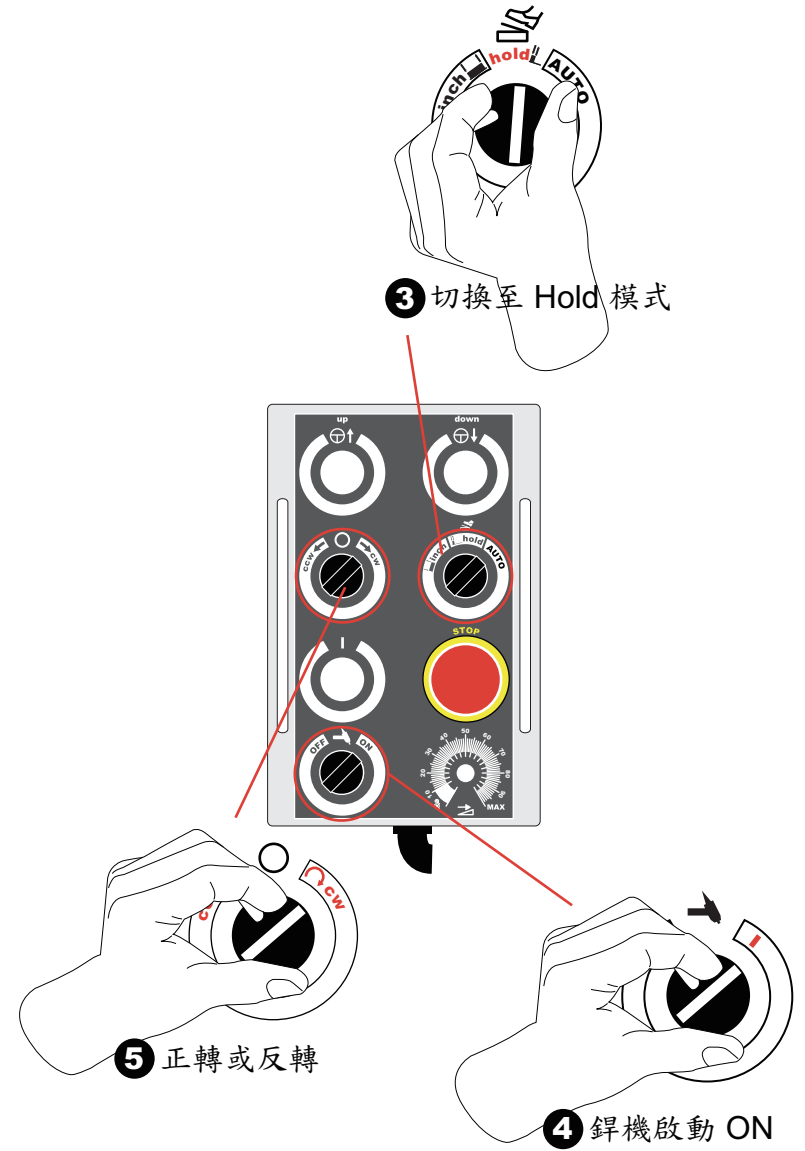
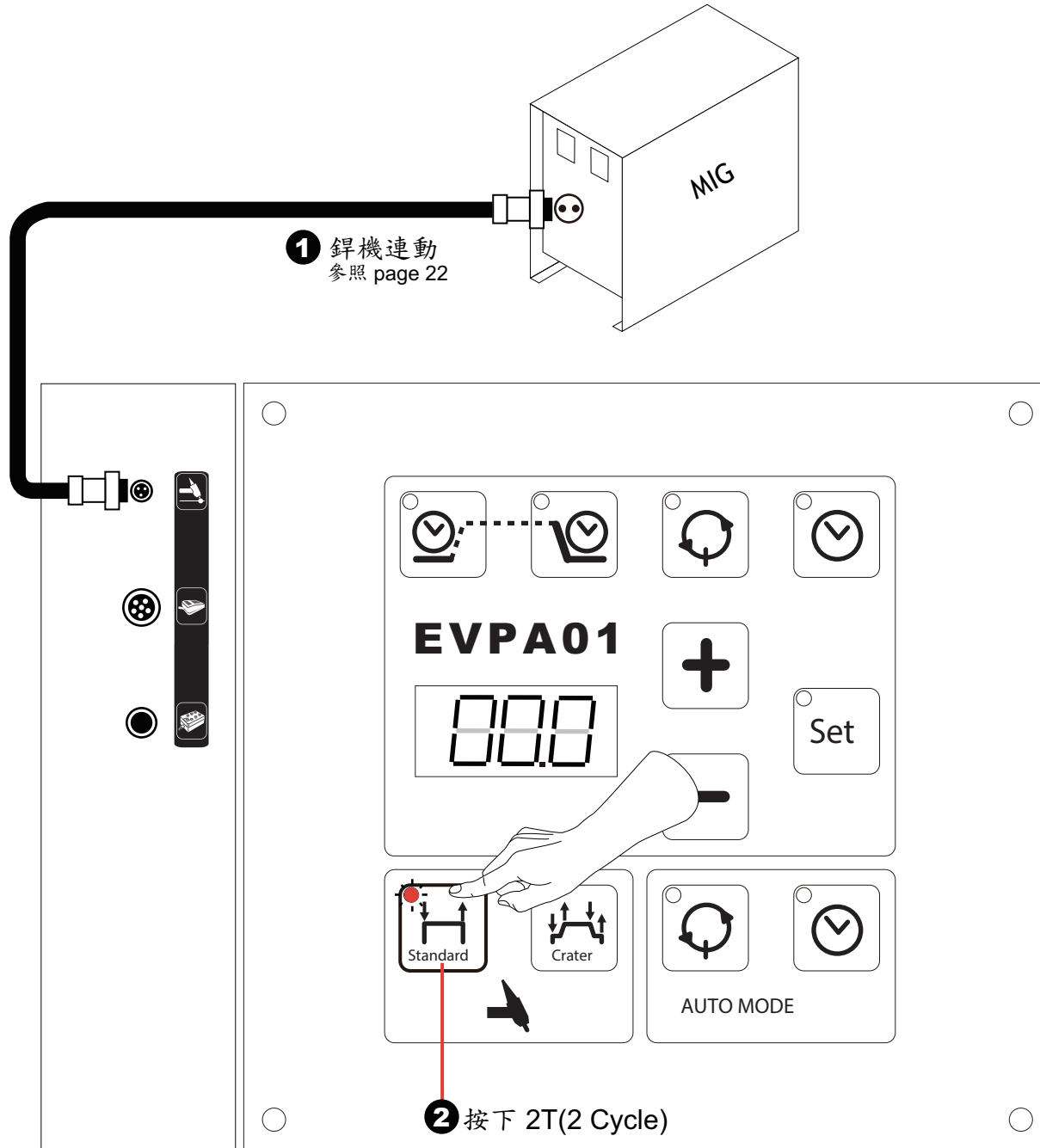
4.12 銲機啟動步驟



2T(2 cycle) 機器操作

4.13 2T(2 Cycle) / 自保持(HOLD)/ MIG

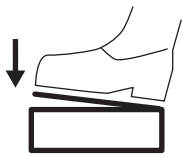
4.13.1 準備



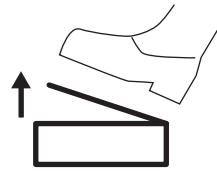
4.13 2T(2 Cycle) / 自保持(HOLD) / MIG

4.13.2 銲接啟動

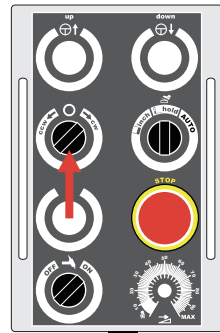
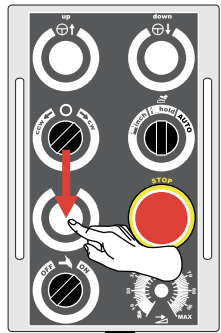
① 啟動



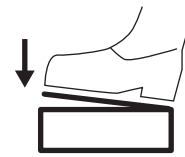
or



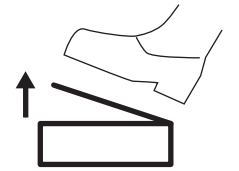
or



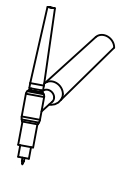
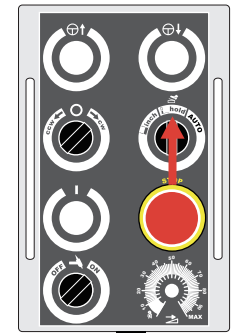
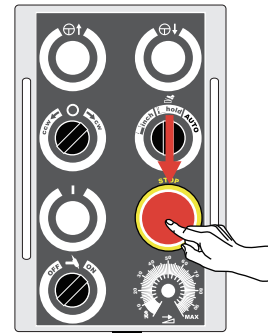
② 停止



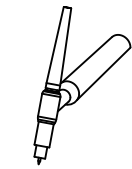
or



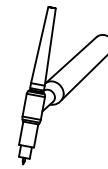
or



銲接電弧

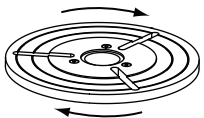


銲接電弧

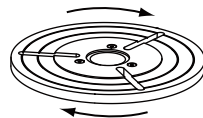


停止

Run



Run

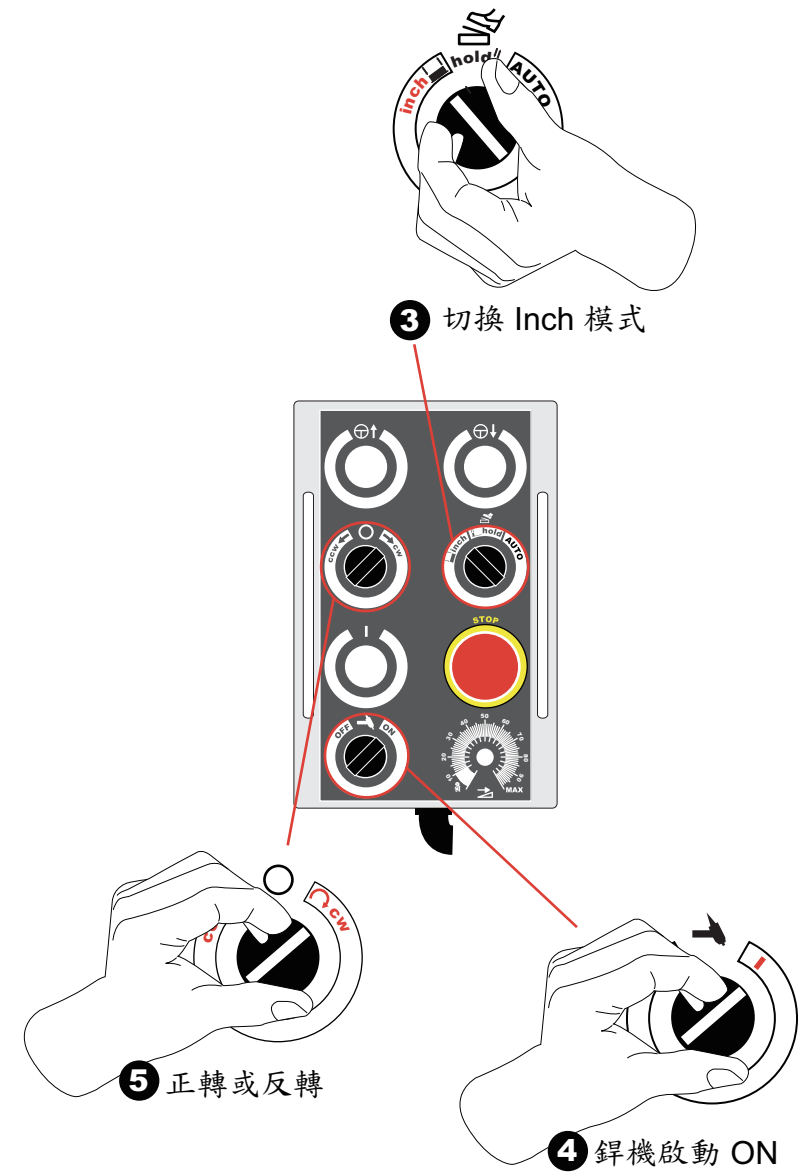
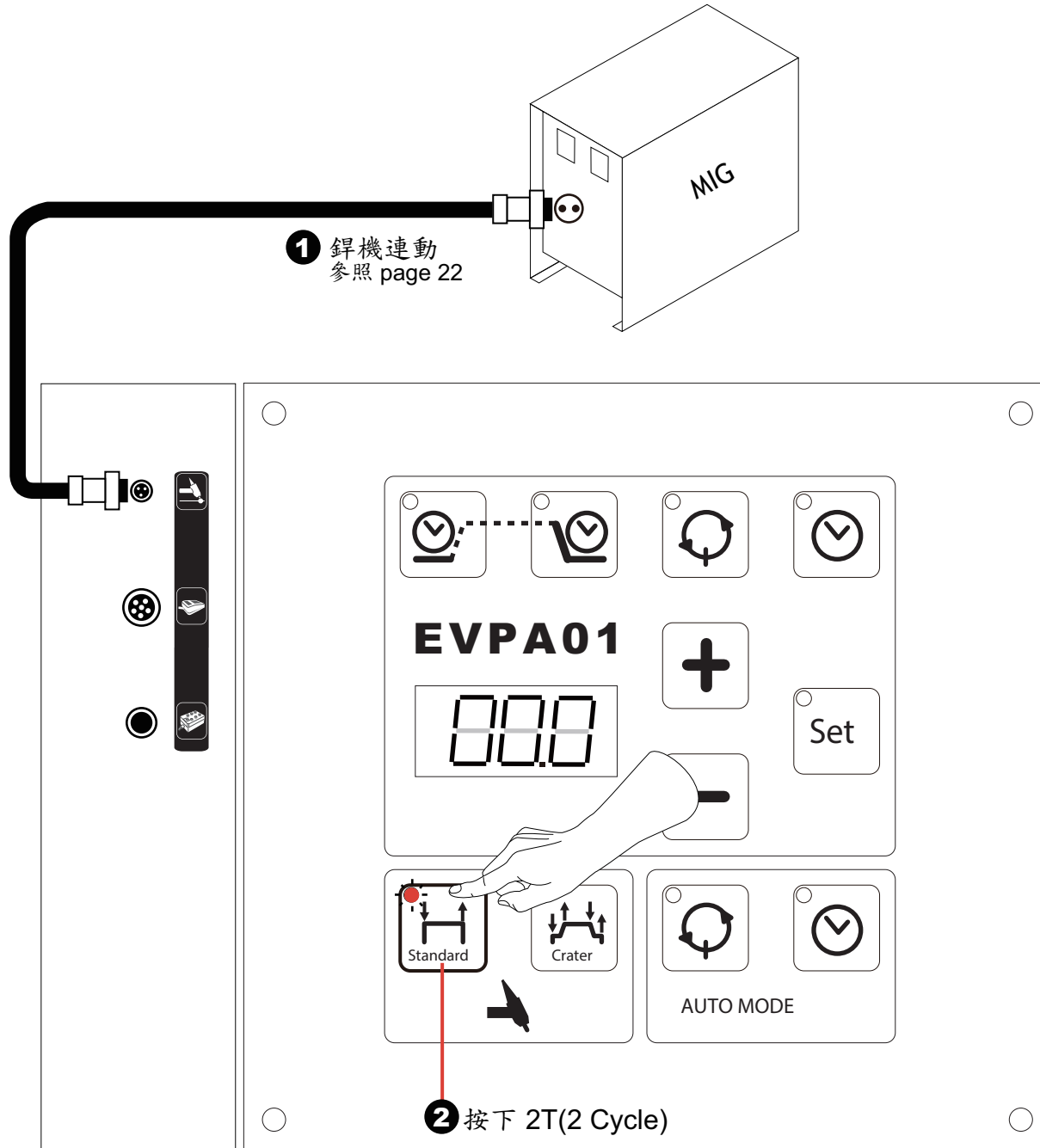


Stop



4.14 2T(2 Cycle) / 寸動(INCH) / MIG

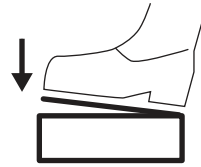
4.14.1 銲接啟動



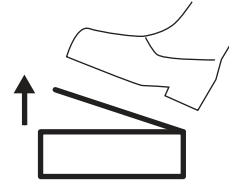
4.14 2T(2 Cycle) / 寸動(INCH) / MIG

4.14.2 銲接啟動

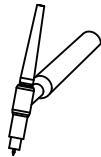
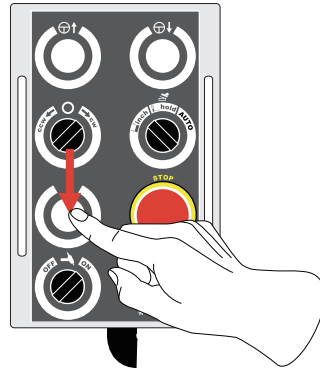
1 啟動



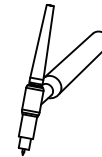
2 停止



or

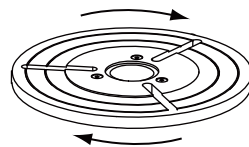


銲接電弧



停止

Run

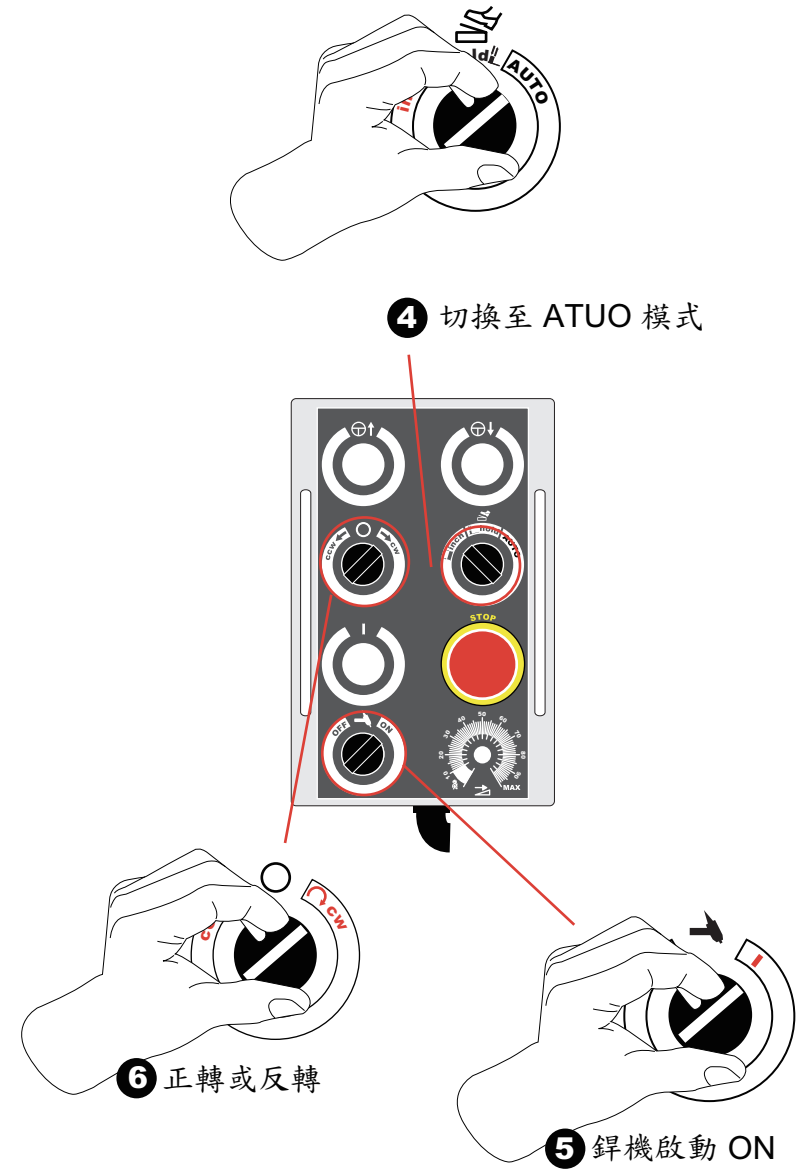
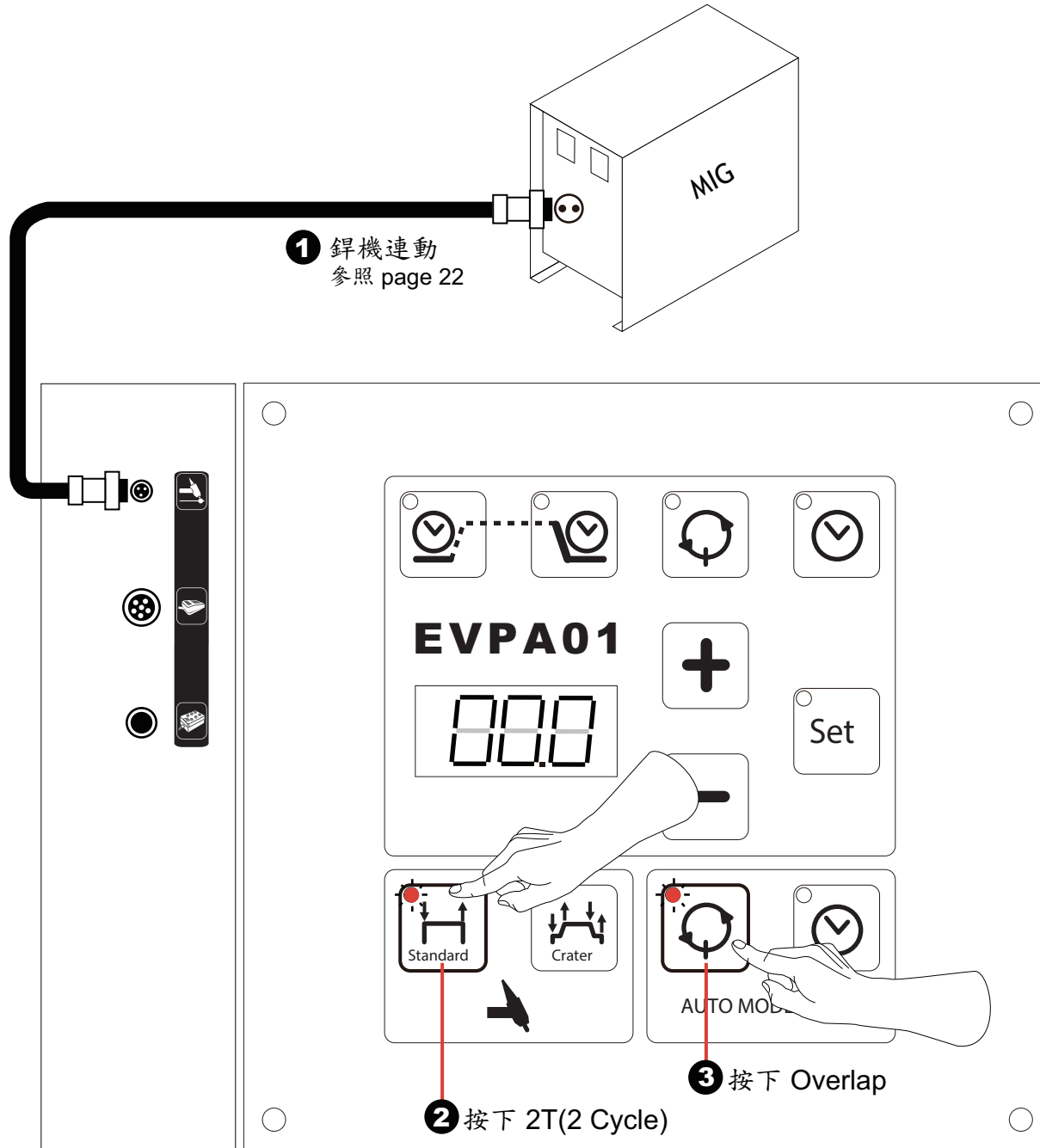


Stop



4.15 2T(2 Cycle) / 交疊(OVERLAP) / MIG

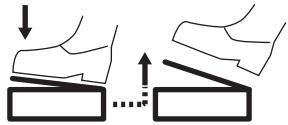
4.15.1 準備



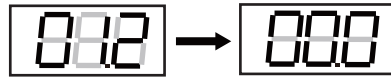
4.15 2T(2 Cycle) / 交疊(OVERLAP) / MIG

4.15.2 銲接啟動

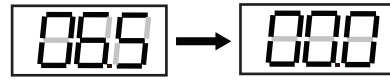
① 啟動



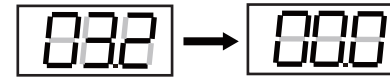
② 開始時間



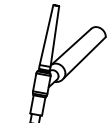
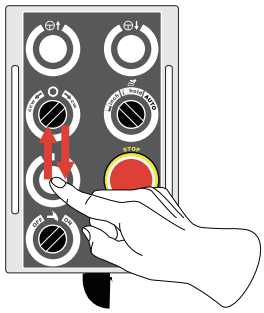
③ 交疊(Overlap)



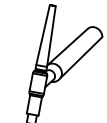
④ 起弧時間



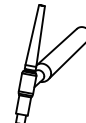
or



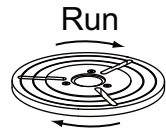
銲接電弧



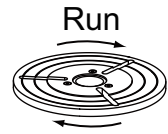
銲接電弧



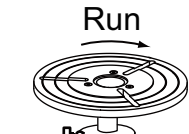
停止



Run

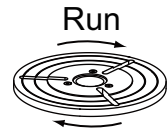


Run

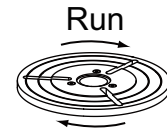


Run

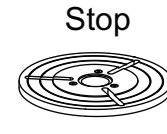
微動開關 ON



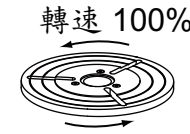
Run



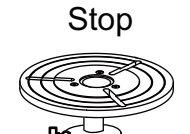
Run



Stop



轉速 100%

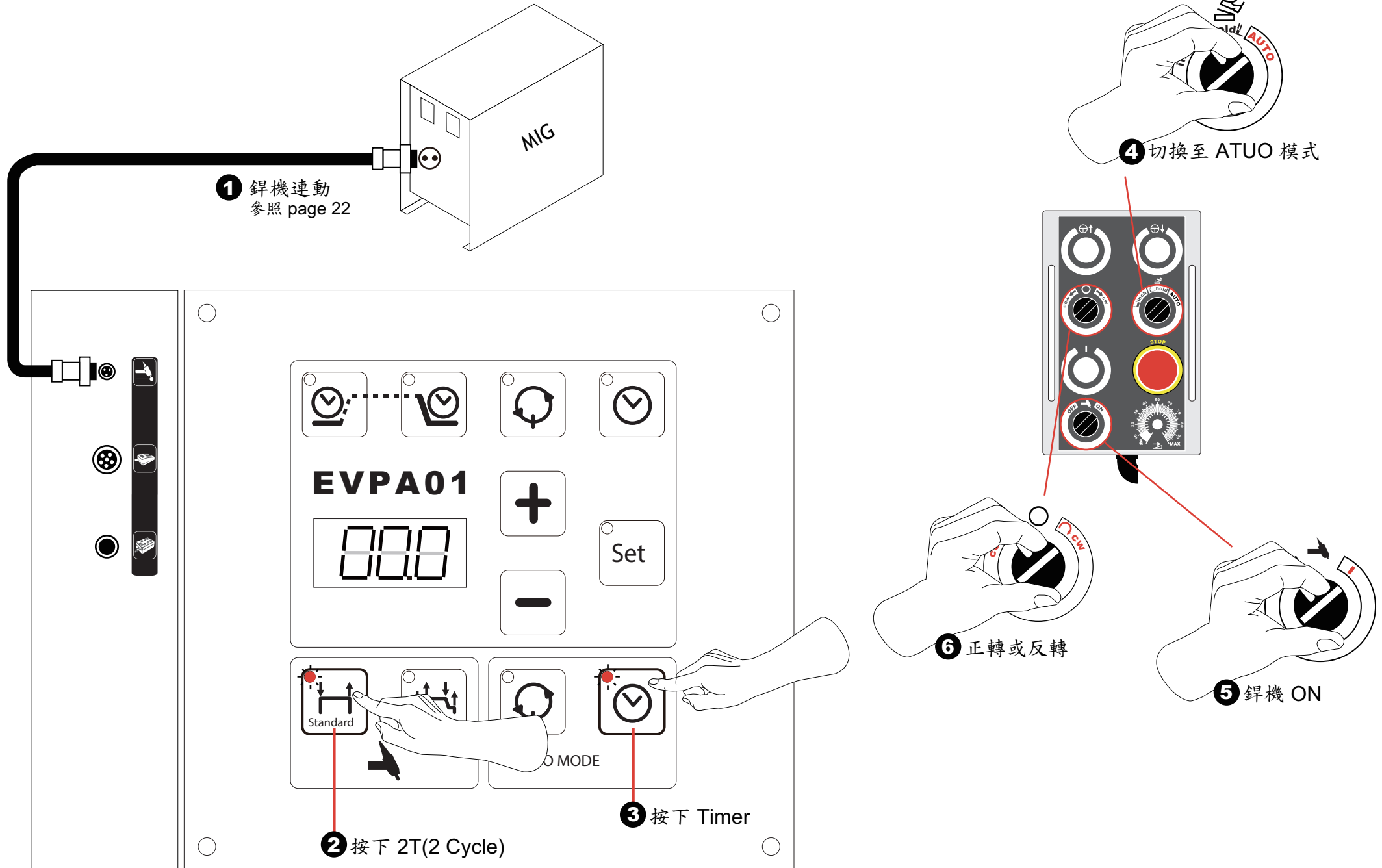


Stop

微動開關 ON

4.16 2T(2 Cycle) / 計時器(TIMER) / MIG

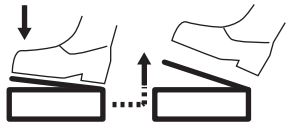
4.16.1 準備



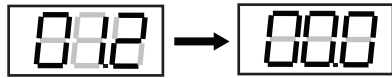
4.16 2T(2 Cycle) / 計時器(TIMER) / MIG

4.16.2 銲機啟動

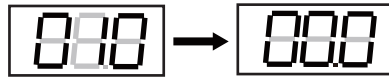
① 啟動



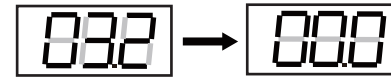
② 啟動時間



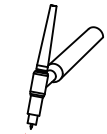
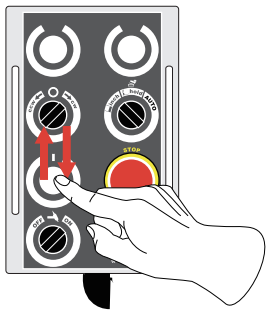
③ 計時器時間



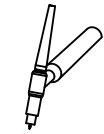
④ 起弧時間



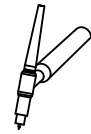
or



銲接電弧

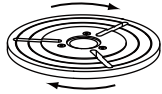


銲接電弧

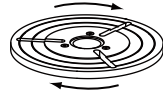


停止

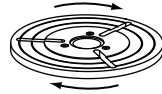
Run



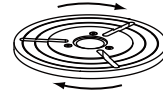
Run



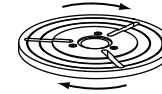
Run



Run



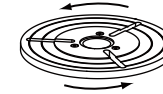
Run



Stop




轉速 100%




Stop

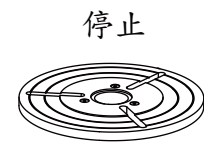
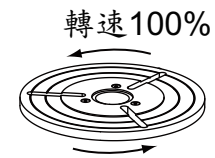
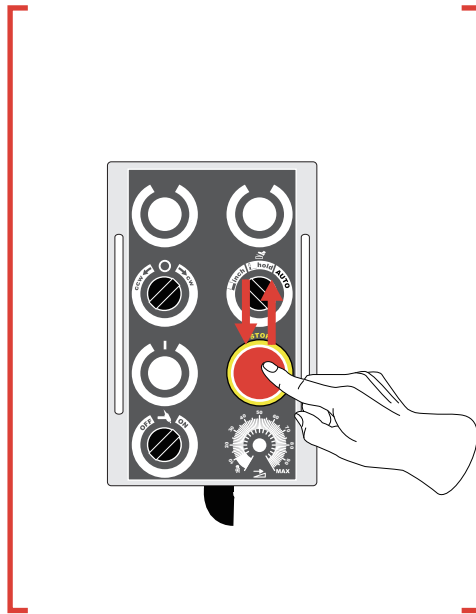
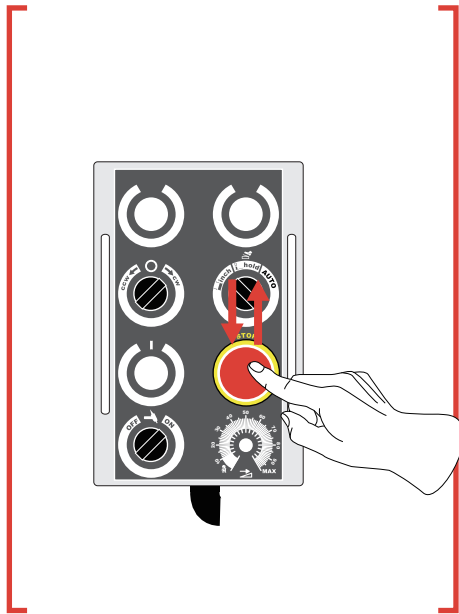


微動開關 ON

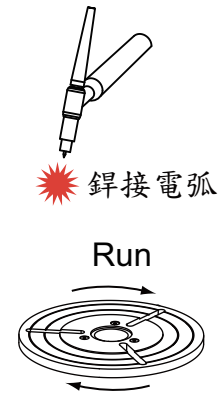
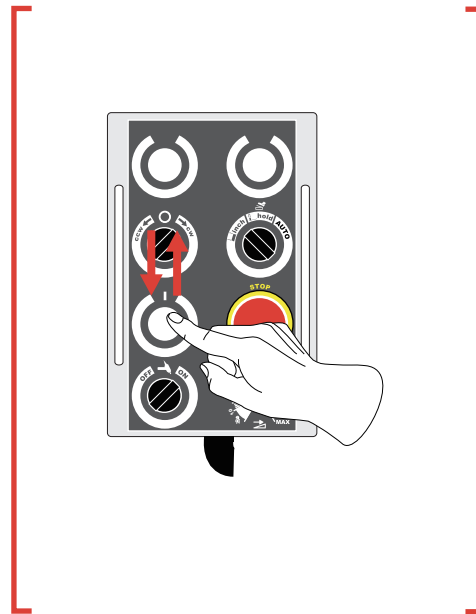
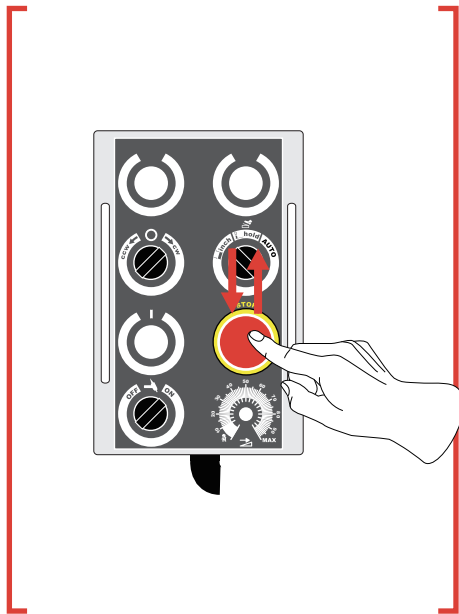
4.17  (2 Cycle)

 重疊而停止工作

4.17.1 禁止運行



4.17.2 重新啟動



銜接 page 28 動作

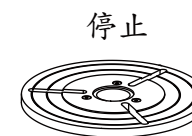
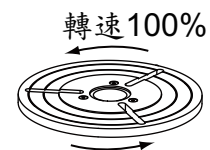
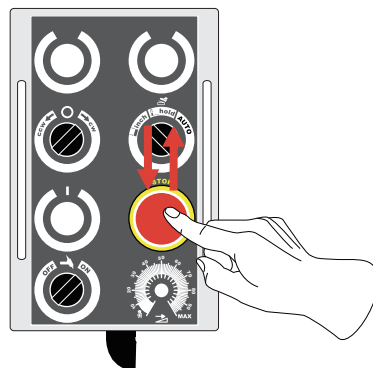
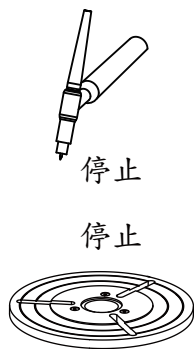
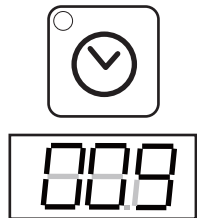
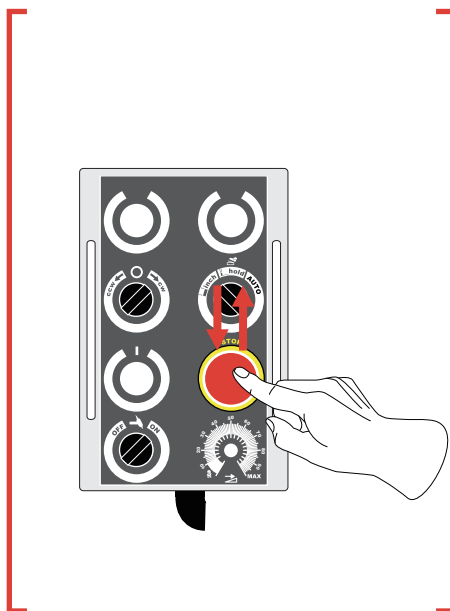


4.18 (2 Cycle)

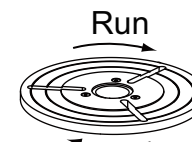
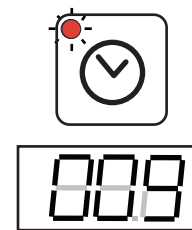
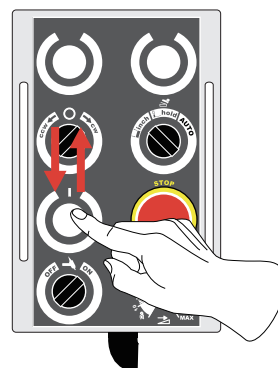
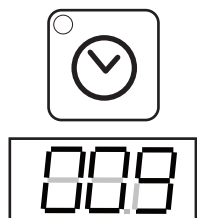
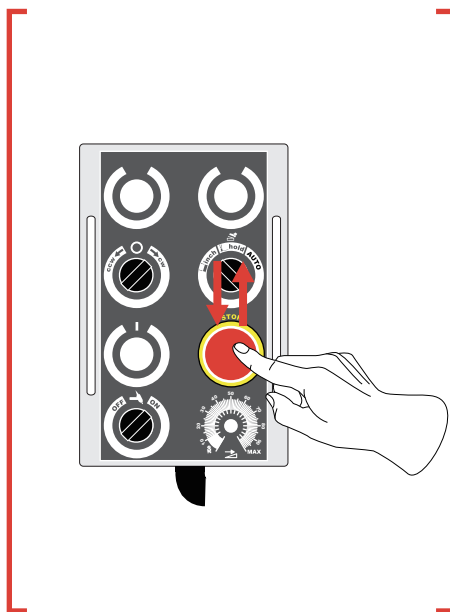


計時器停止操作時

4.18.1 禁止運行



4.18.2 重新啟動



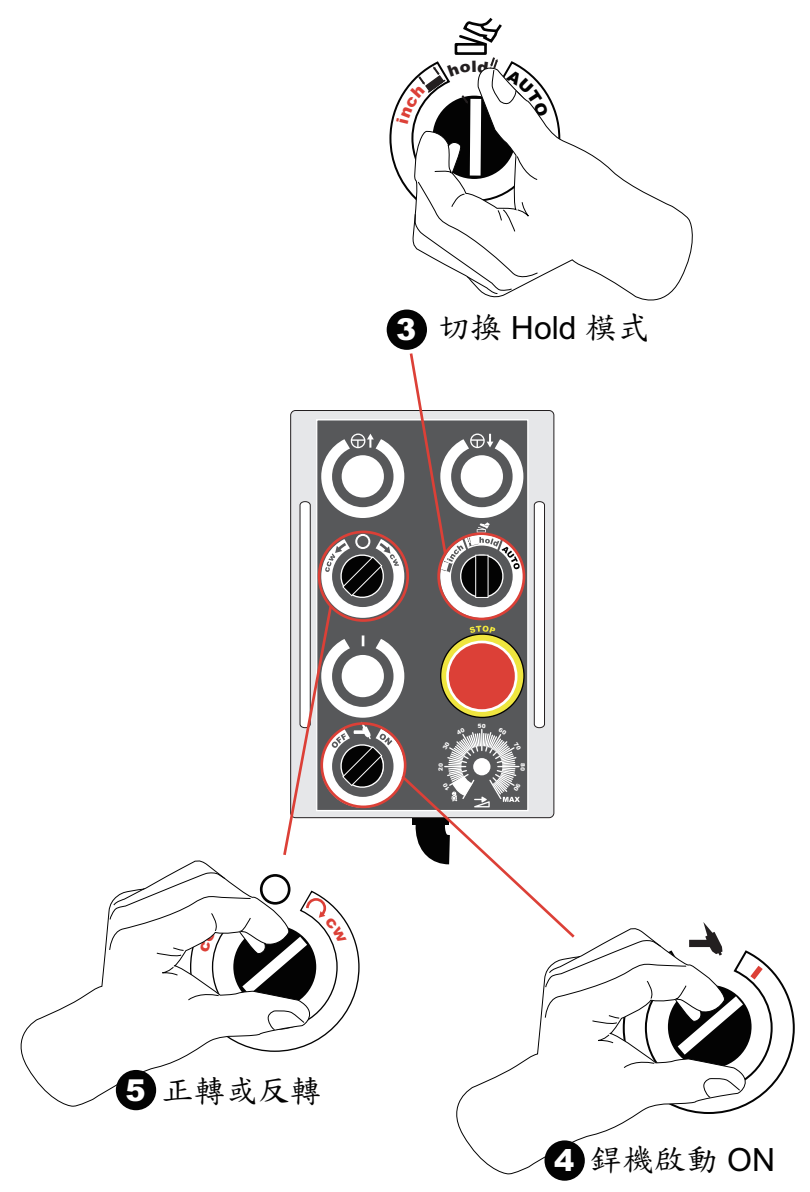
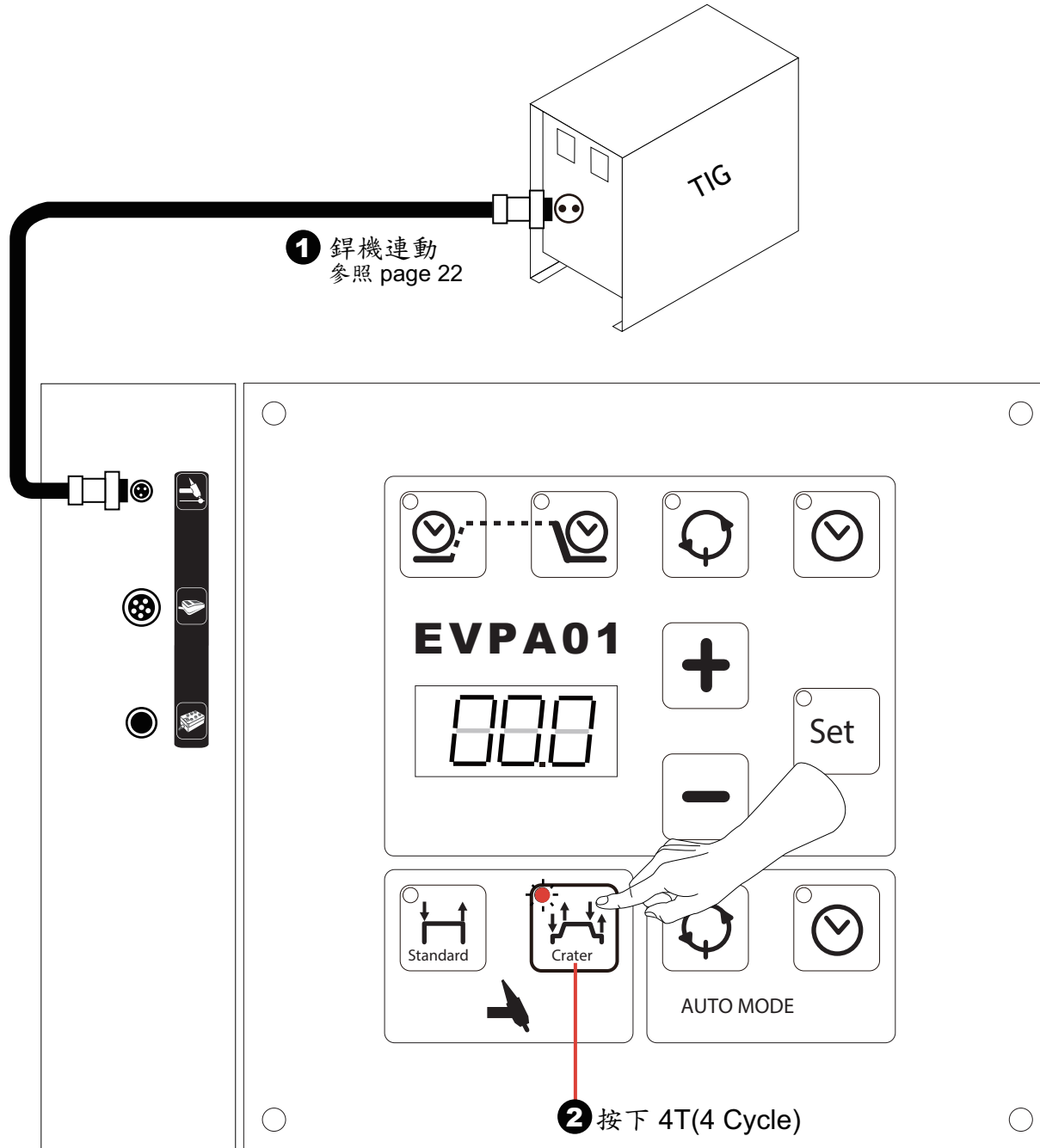
銜接 page 30 動作



4T(4 cycle) 機器操作

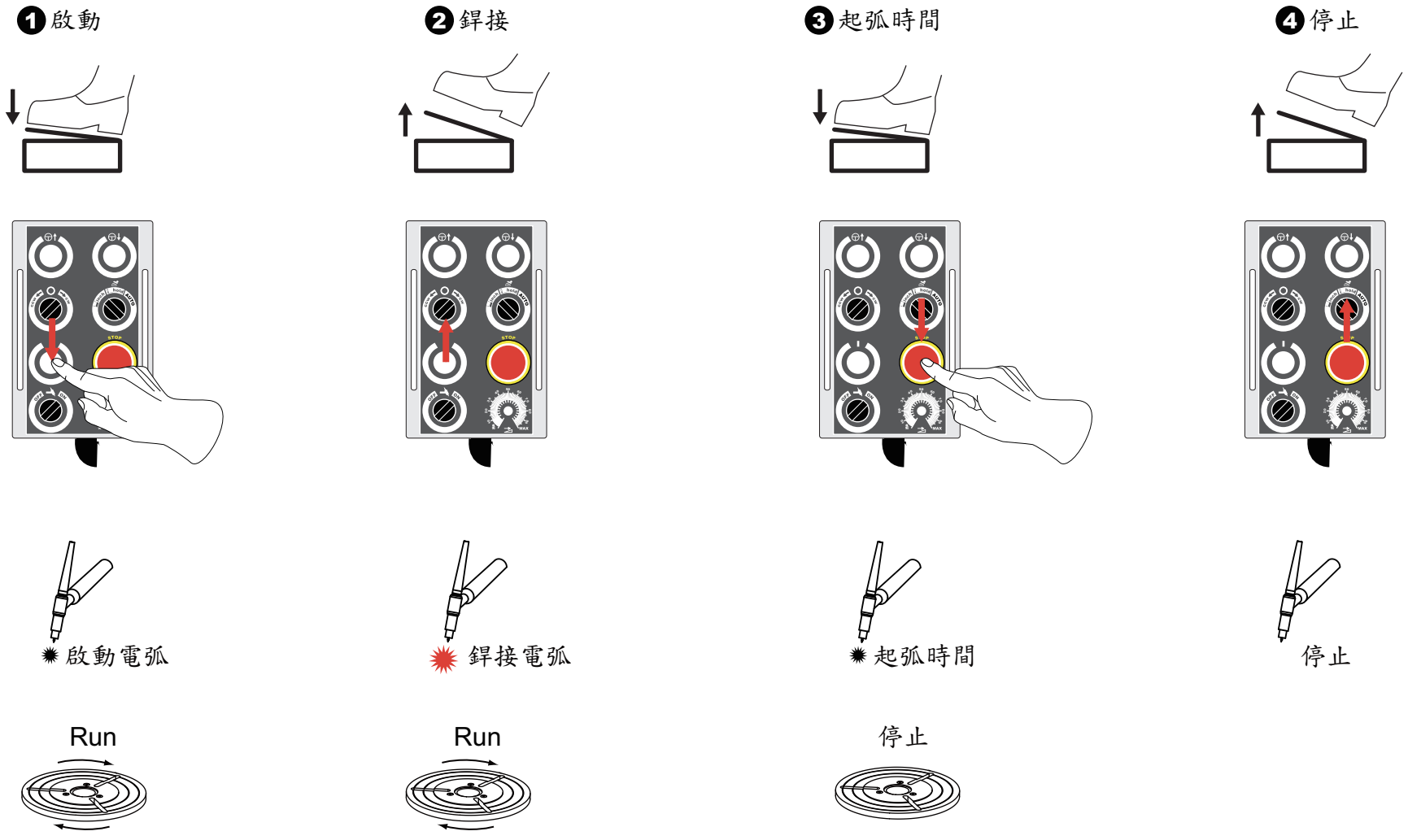
4.19 4T(4 Cycle) / (自保持)HOLD / TIG

4.19.1 準備



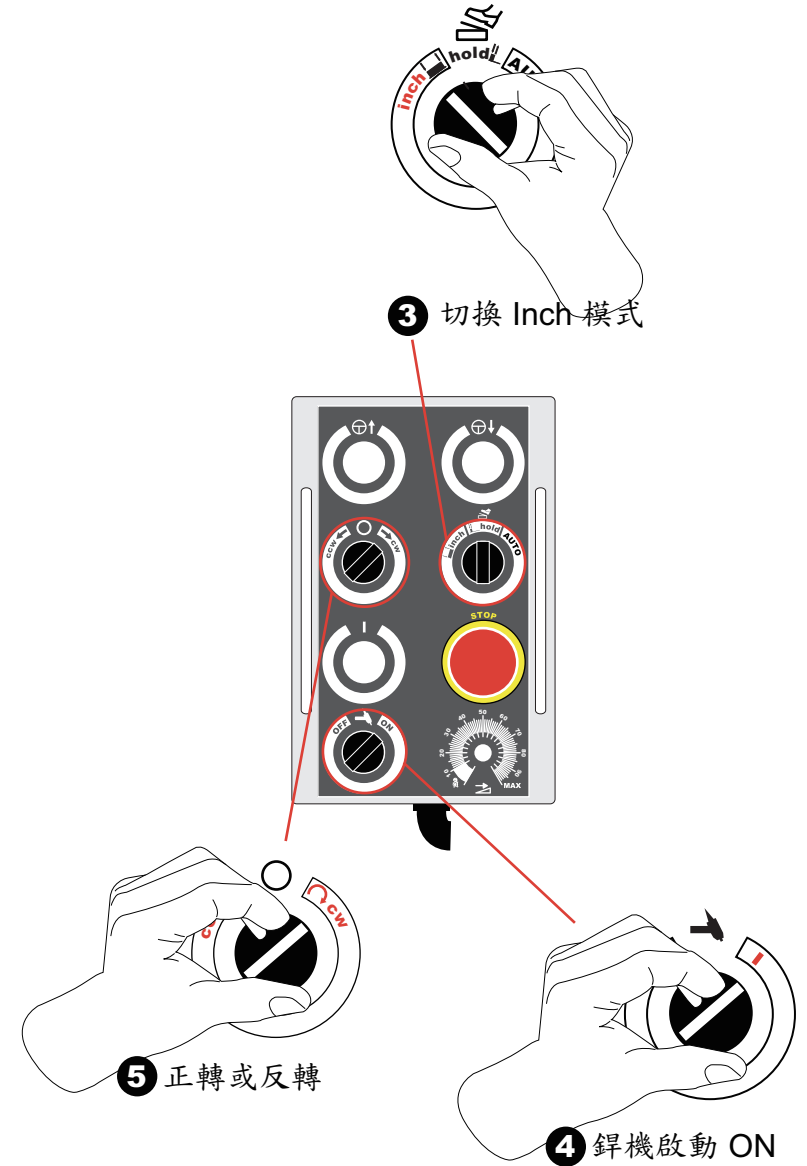
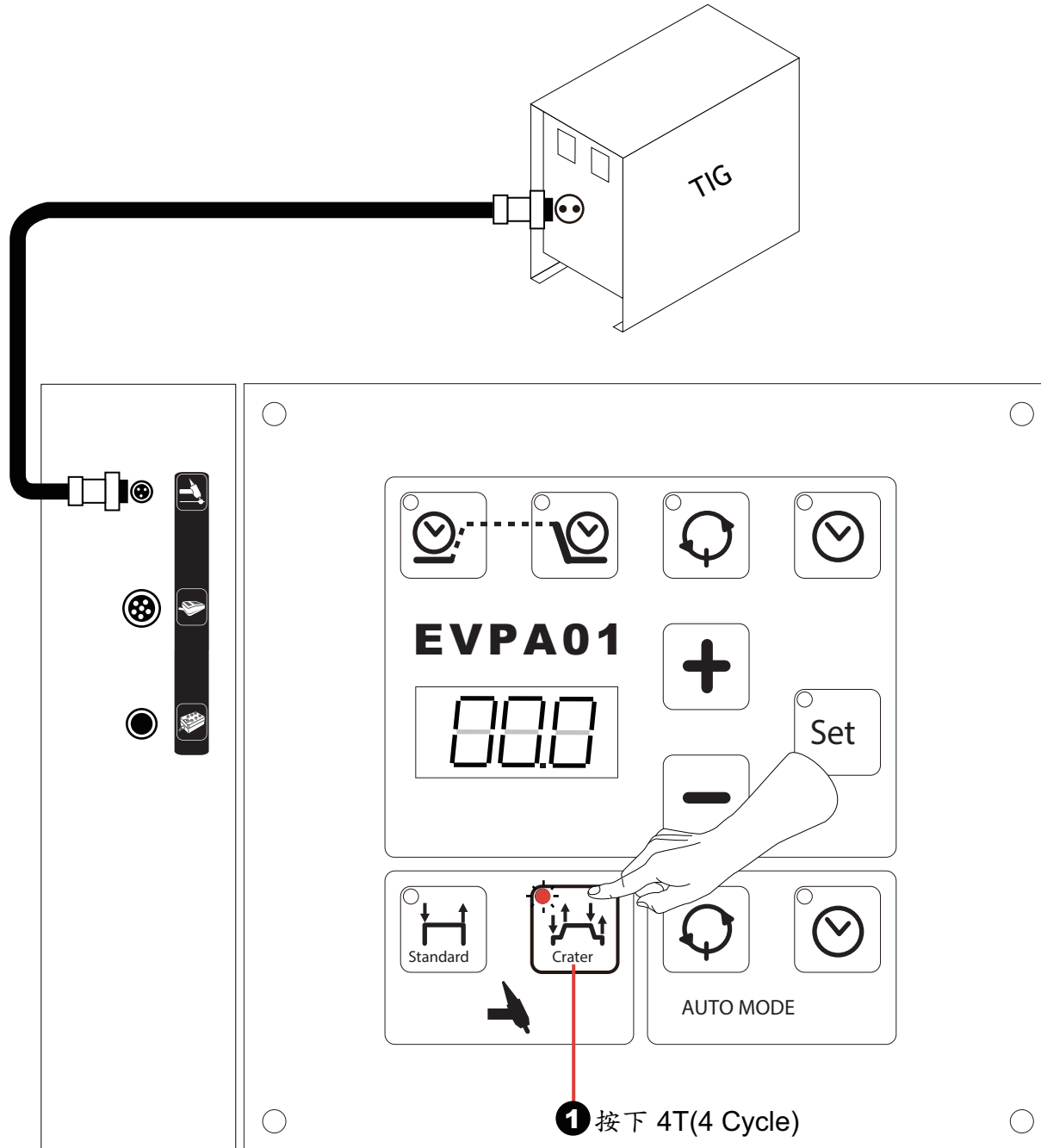
4.19 4T(4 Cycle) / 自保持(HOLD) / TIG

4.19.2 銲接啟動



4.20 4T(4 Cycle) / 寸動(INCH)

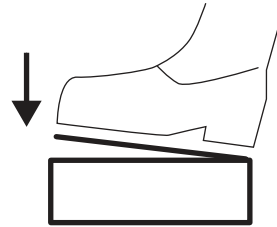
4.20.1 準備



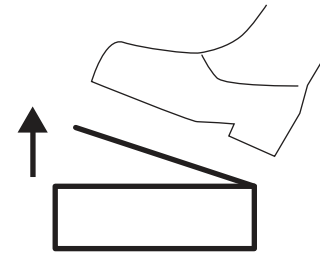
4.20 4T(4 Cycle) / 寸動(INCH)

4.20.2 啟動

1 啟動

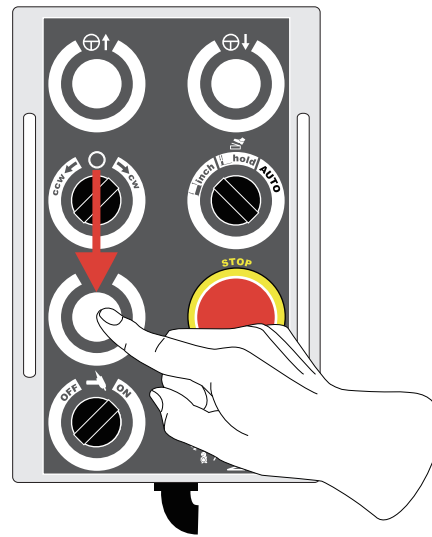


2 停止

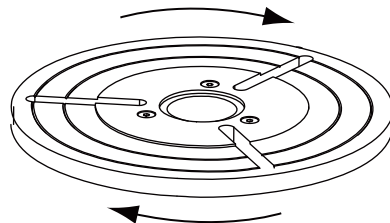


or

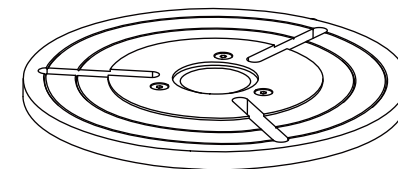
or



Run

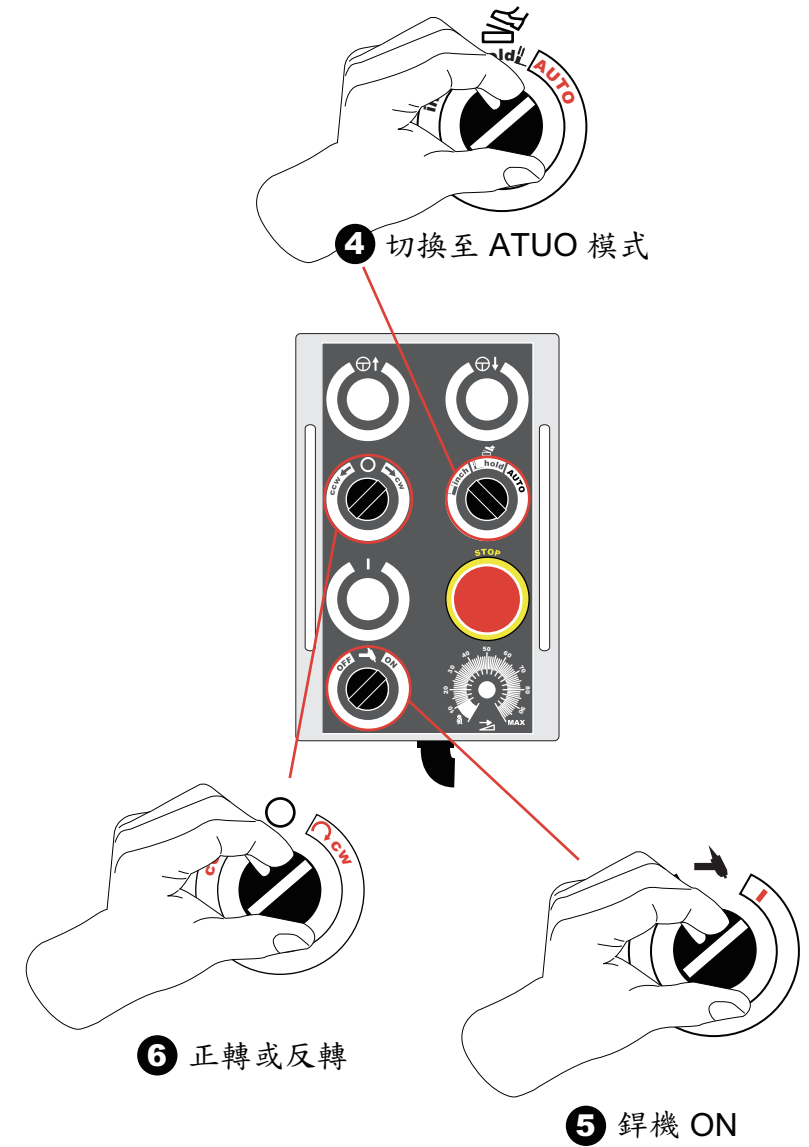
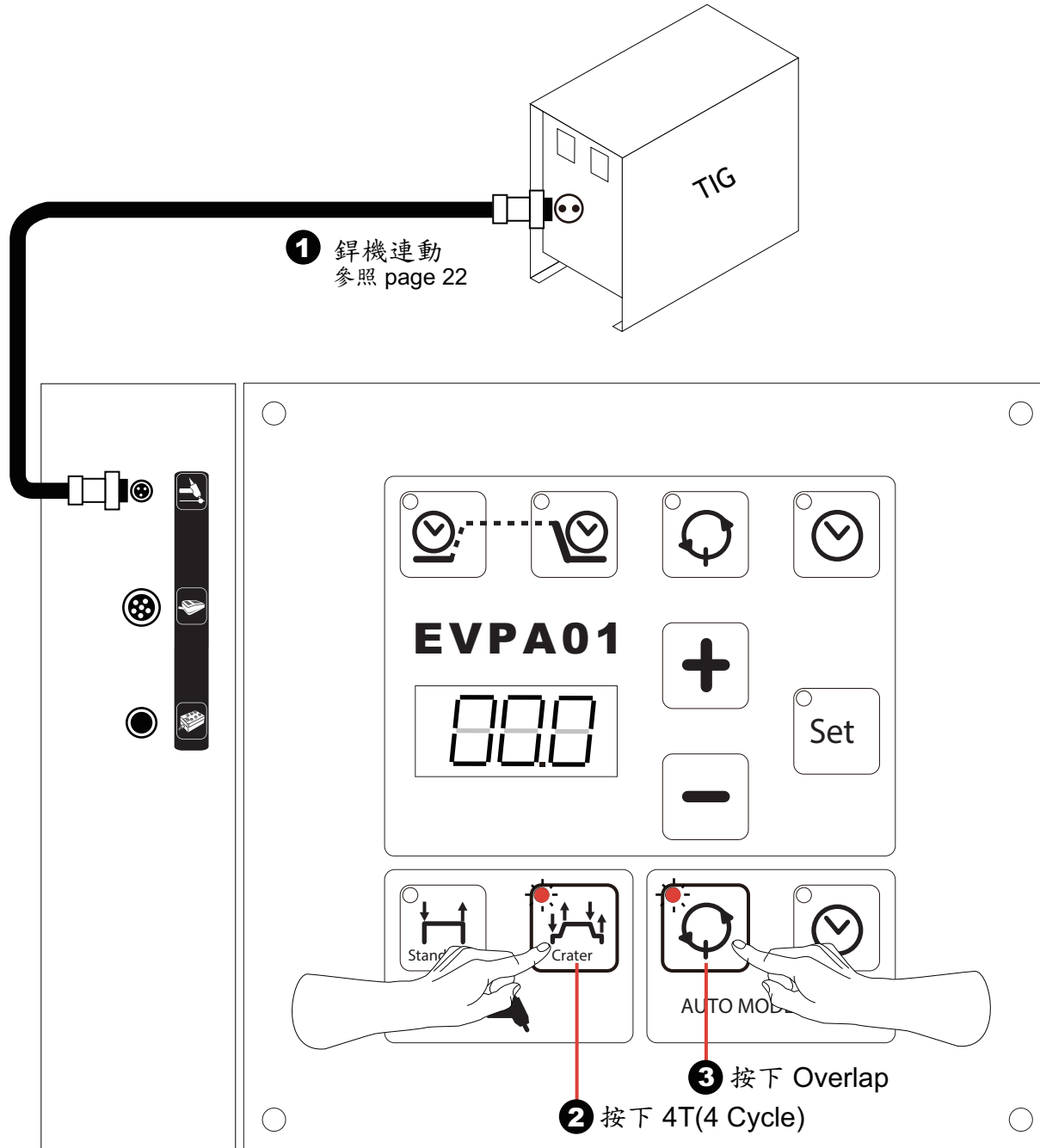


停止



4.21 4T(4 Cycle) / 交疊OVERLAP / TIG

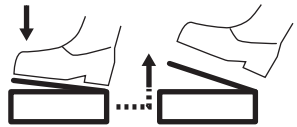
4.21.1 準備



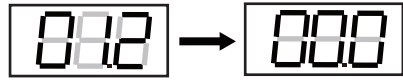
4.21 4T(4 Cycle) / 交疊(OVERLAP) / TIG

4.21.2 銲接啟動

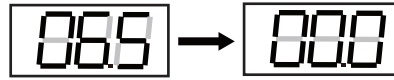
① 啟動



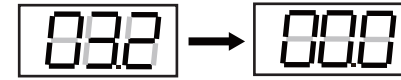
② 啟動時間



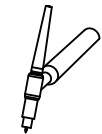
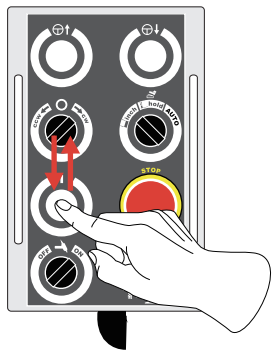
③ 交疊(Overlap)



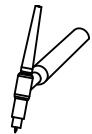
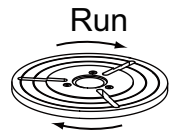
④ 起弧時間



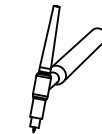
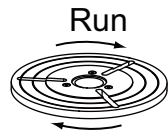
or



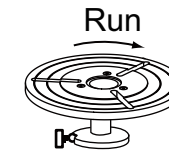
＊ 啟動電弧



＊ 銲接電弧



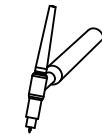
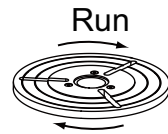
＊ 銲接電弧



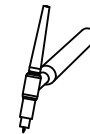
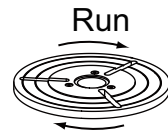
微動開關 ON



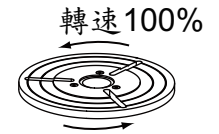
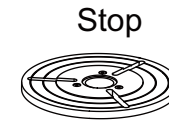
＊ 銲接電弧



＊ 起弧時間



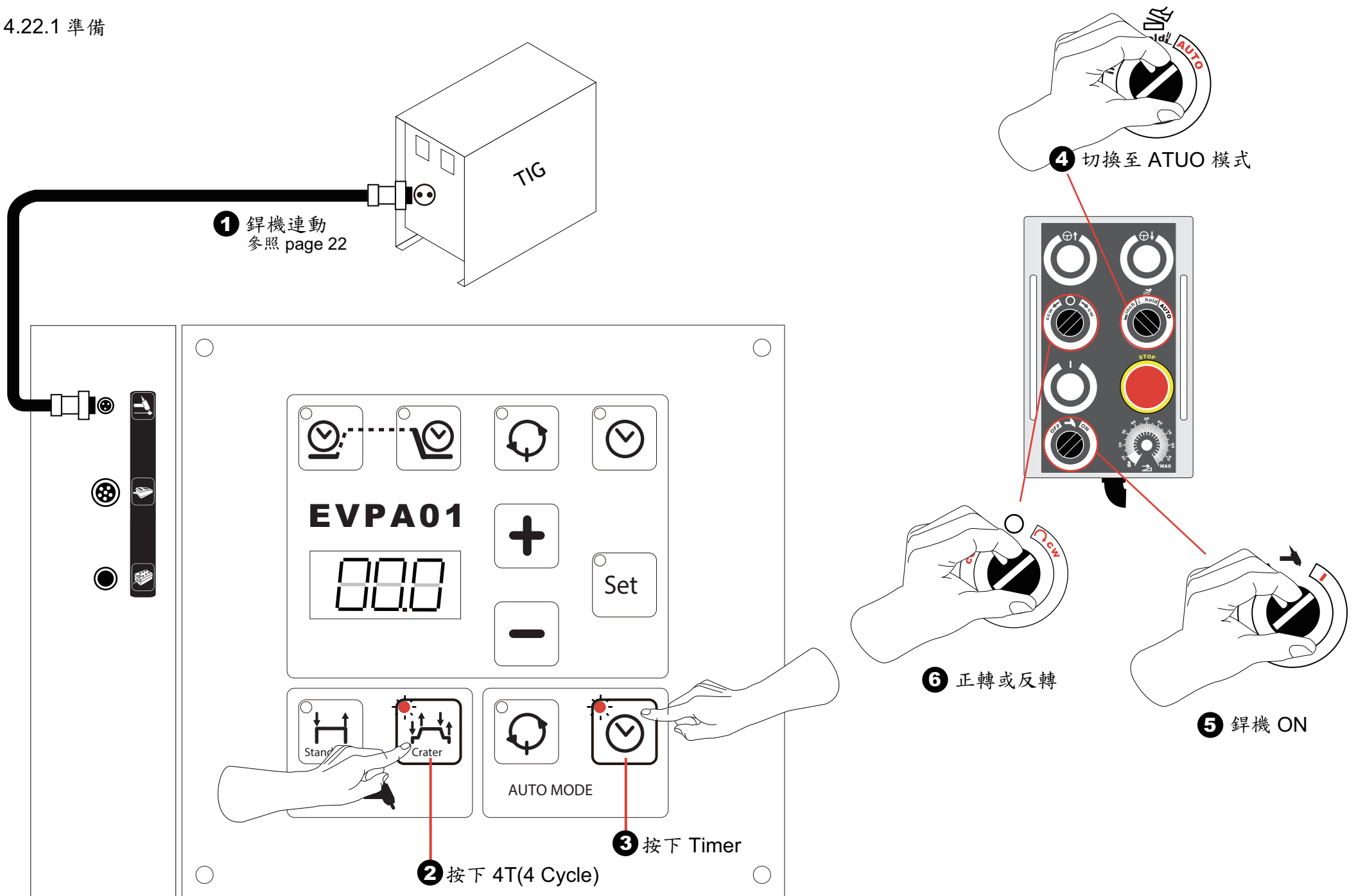
停止



微動開關 ON

4.22 4T(4 Cycle) / 計時器(TIMER) / TIG

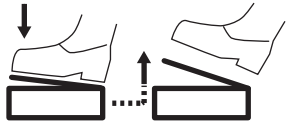
4.22.1 準備



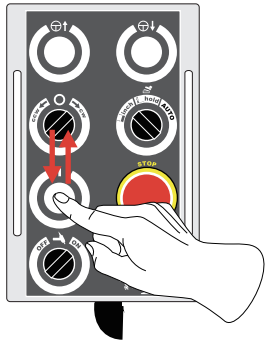
4.22 4T(4 Cycle) / 計時器(TIMER) / TIG

4.22.2 銲機啟動

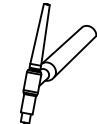
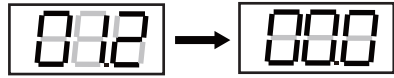
① 啟動



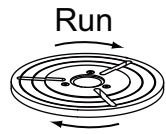
or



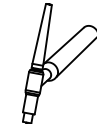
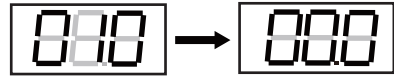
② 啟動時間



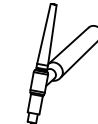
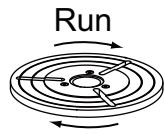
＊ 啟動電弧



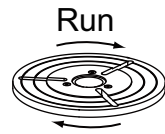
③ 計時器時間



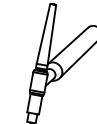
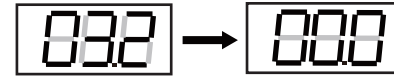
＊ 銲接電弧



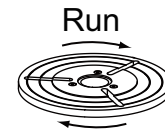
＊ 銲接電弧



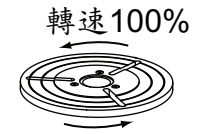
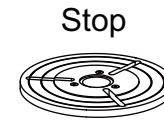
④ 起弧時間



＊ 收弧



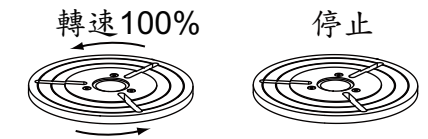
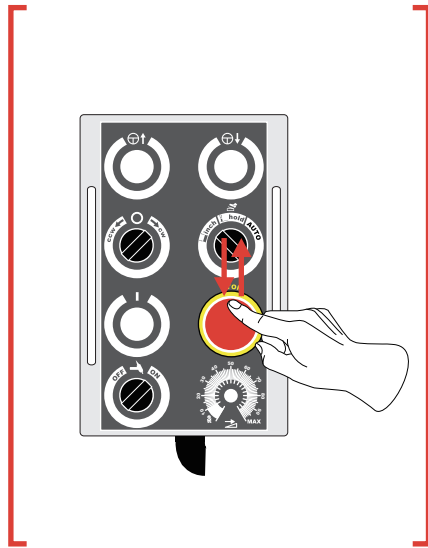
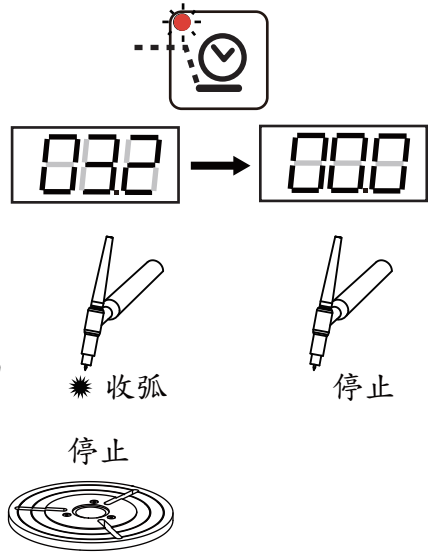
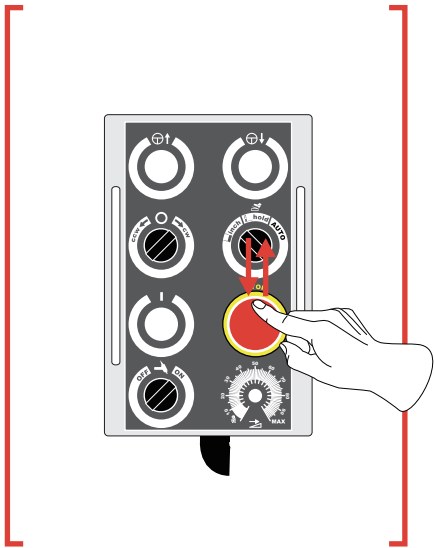
Stop



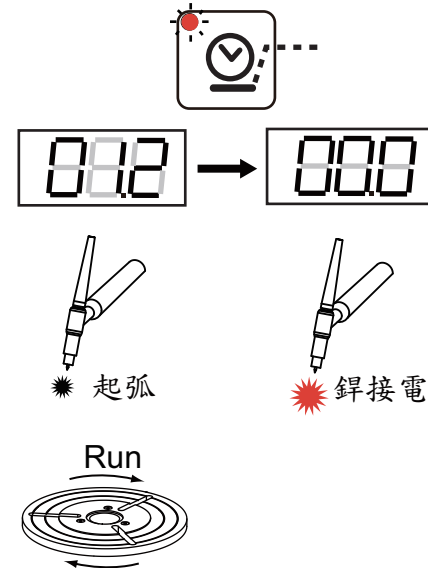
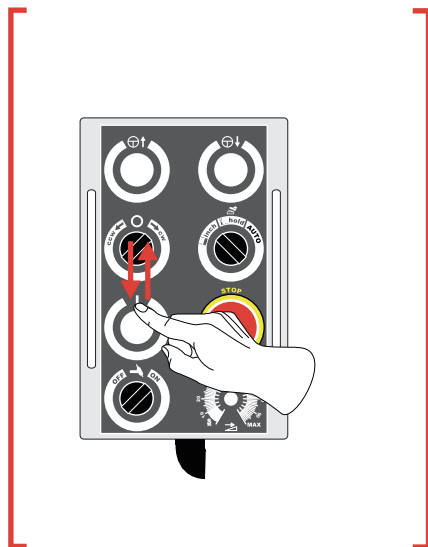
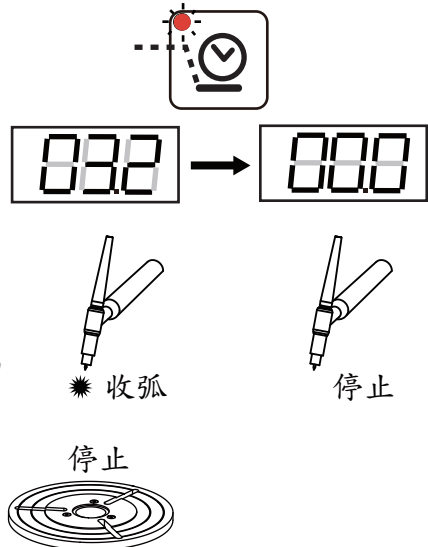
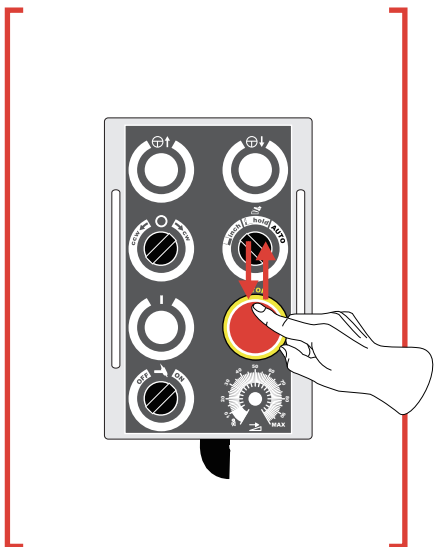
4.23 (4 Cycle)

重疊而停止工作

4.23.1 禁止運行



4.23.2 重新啟動



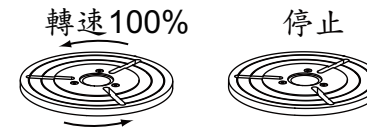
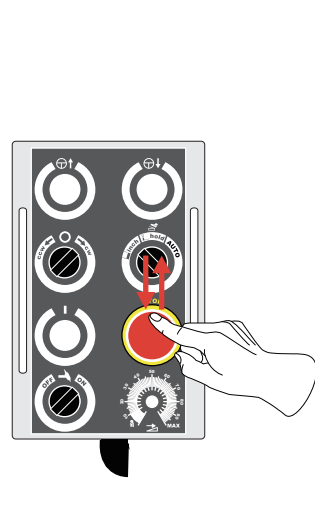
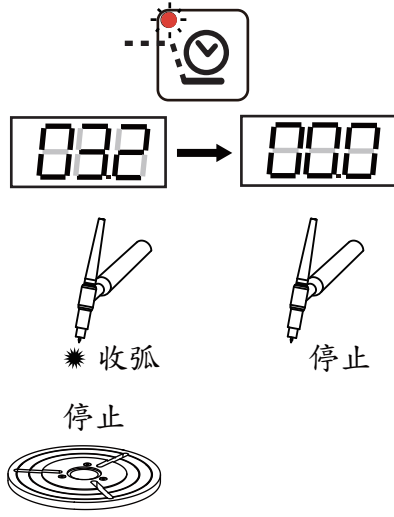
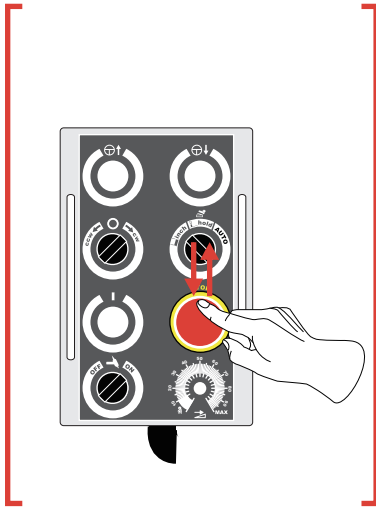
銲接 page 38 動作



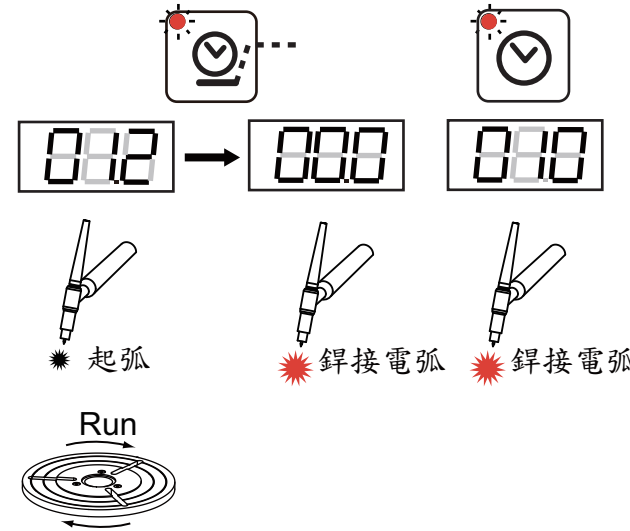
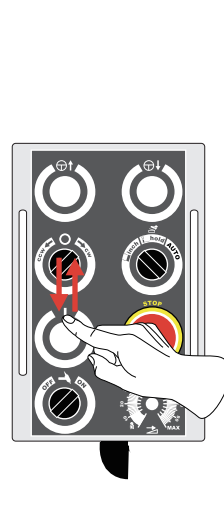
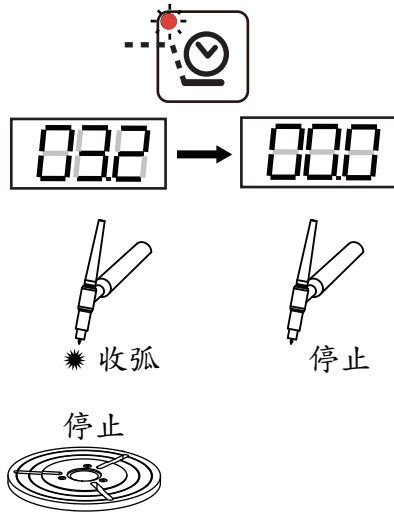
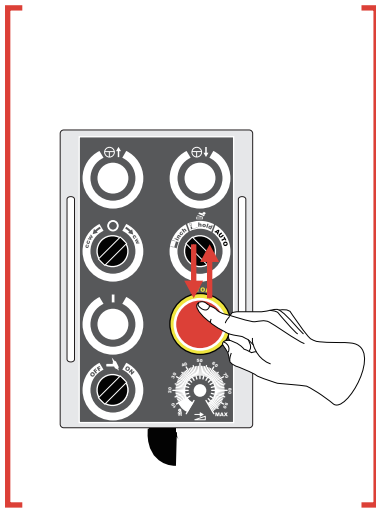
4.24 (4 Cycle)

計時器停止操作時

4.24.1 禁止運行



4.24.2 重新啟動

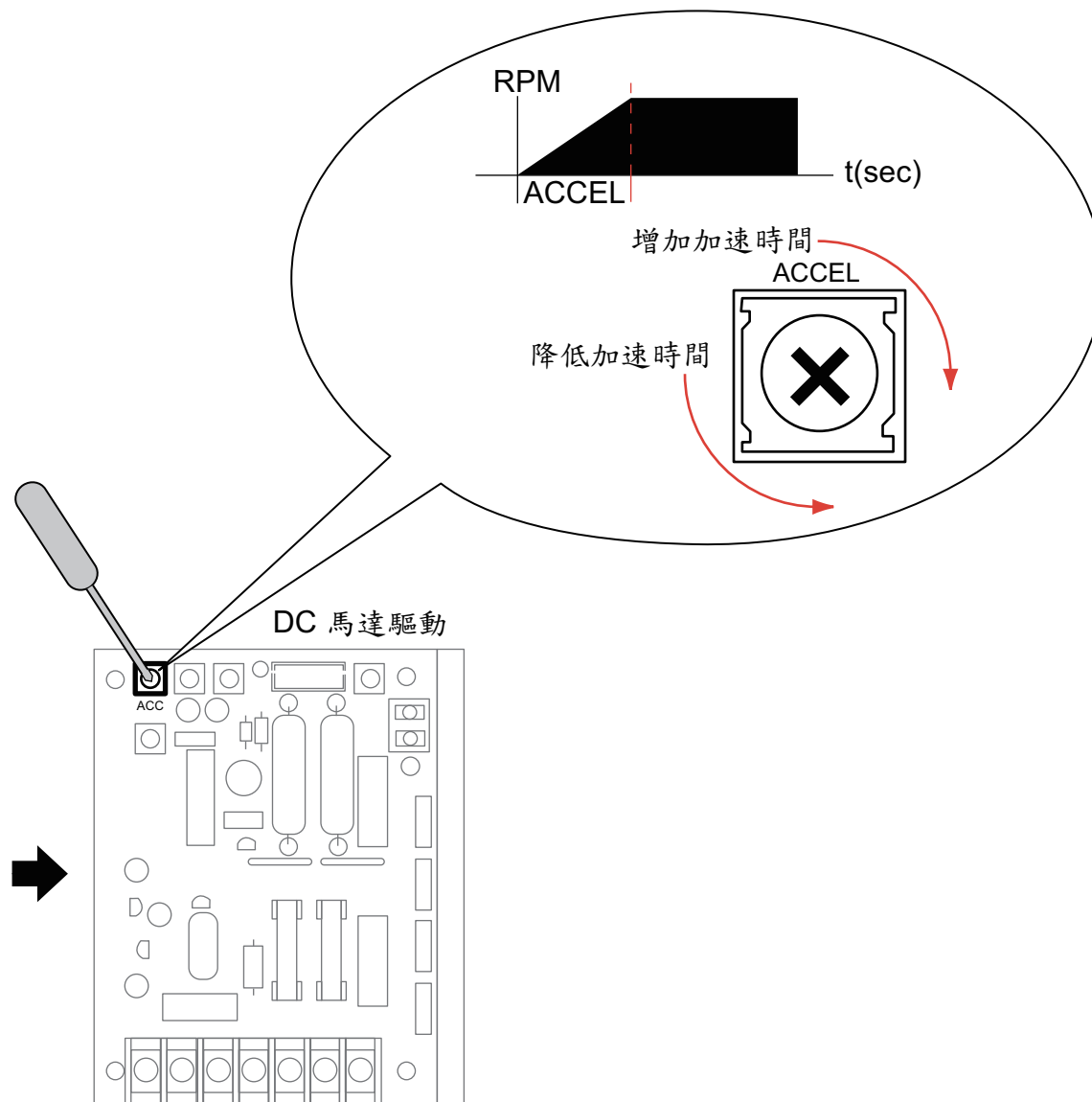
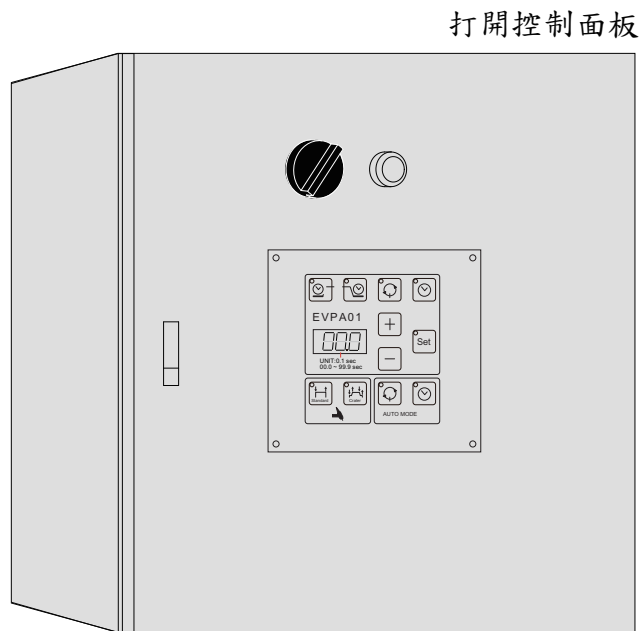


銜接 page 40 動作



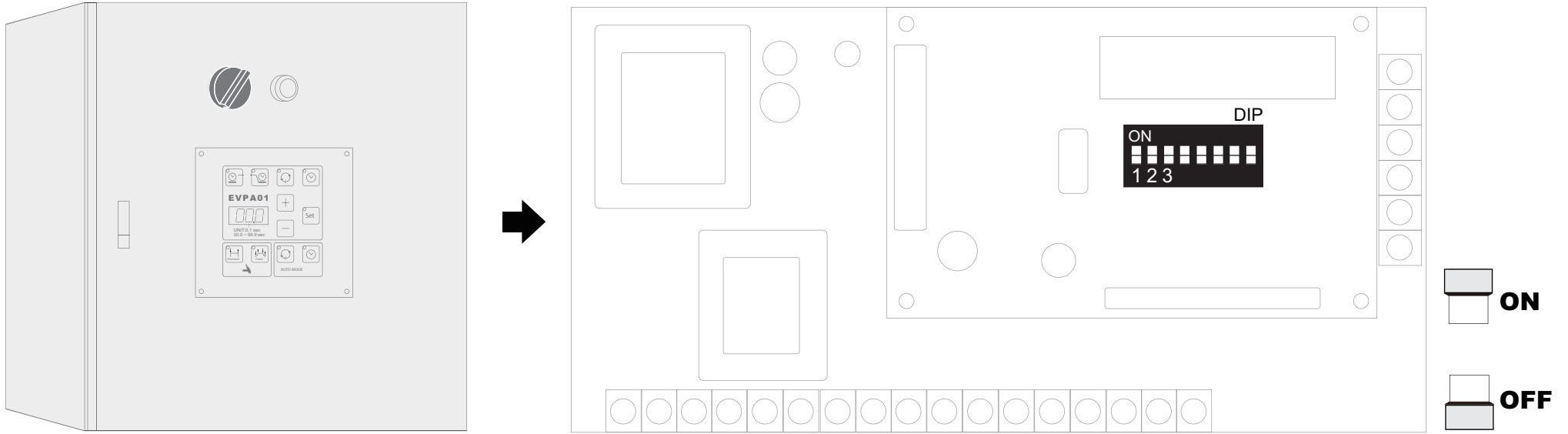
Chapter 5: 設置步驟

5.1 轉盤加速時間

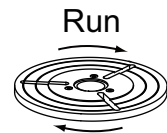
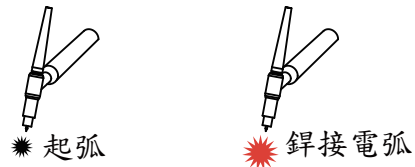
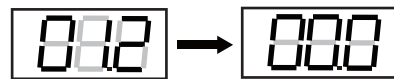
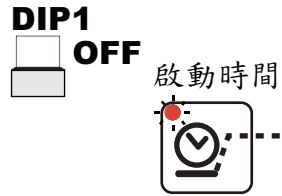
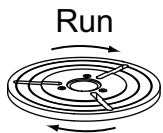
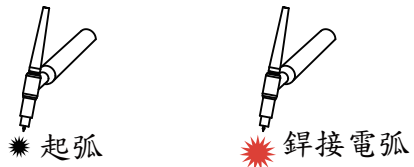
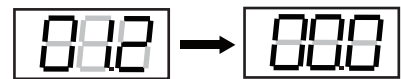
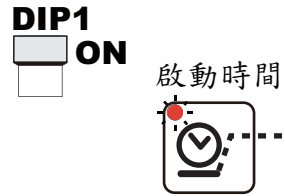


5.2 控制電路板的開關說明

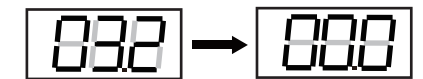
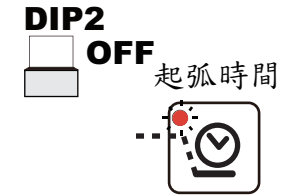
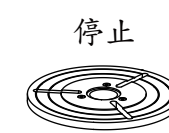
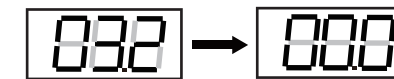
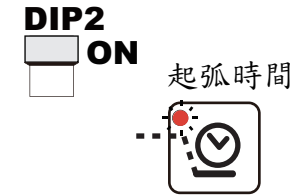
打開控制面板



5.2.1 DIP1 (4 Cycle) Mode

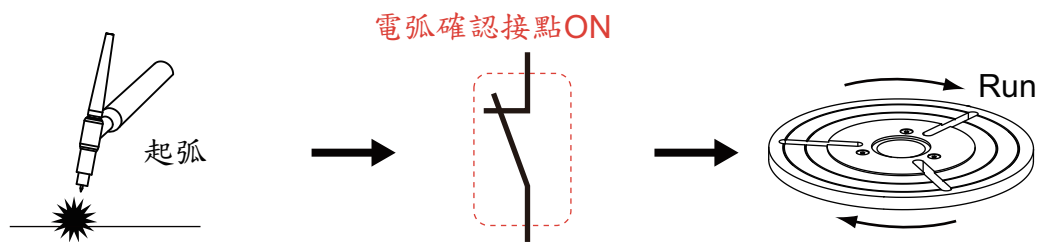
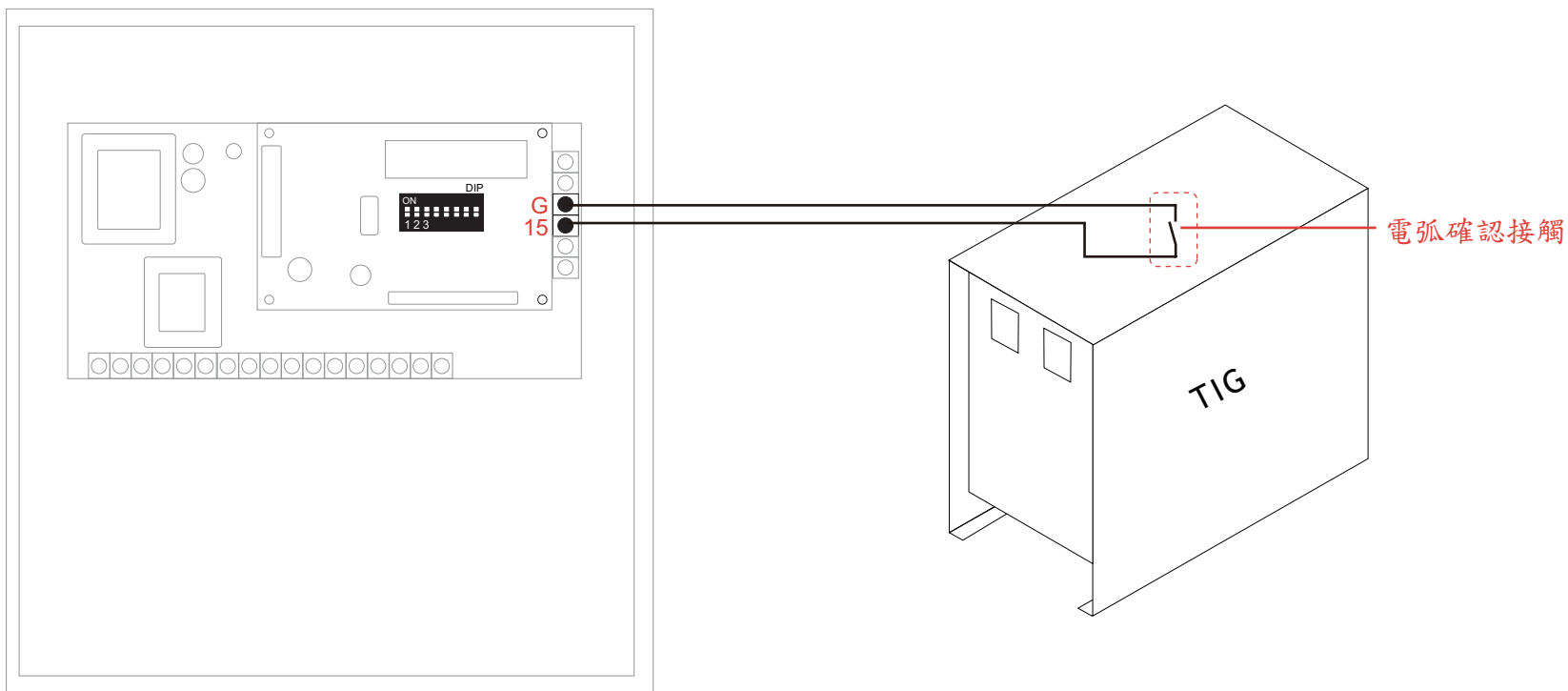


5.2.2 DIP2 (4 Cycle) Mode



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)



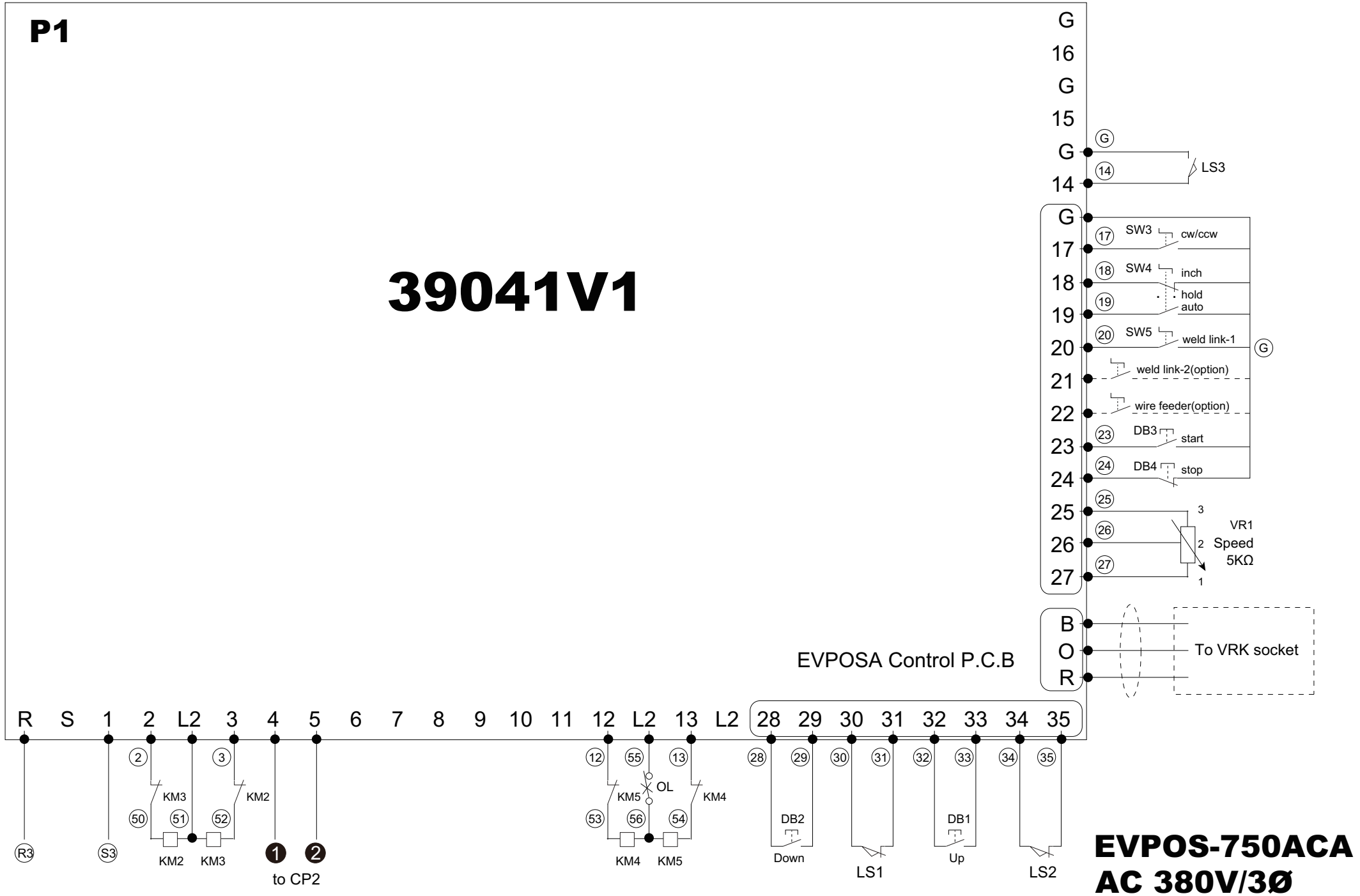
DIP3 OFF (不接觸)



附錄

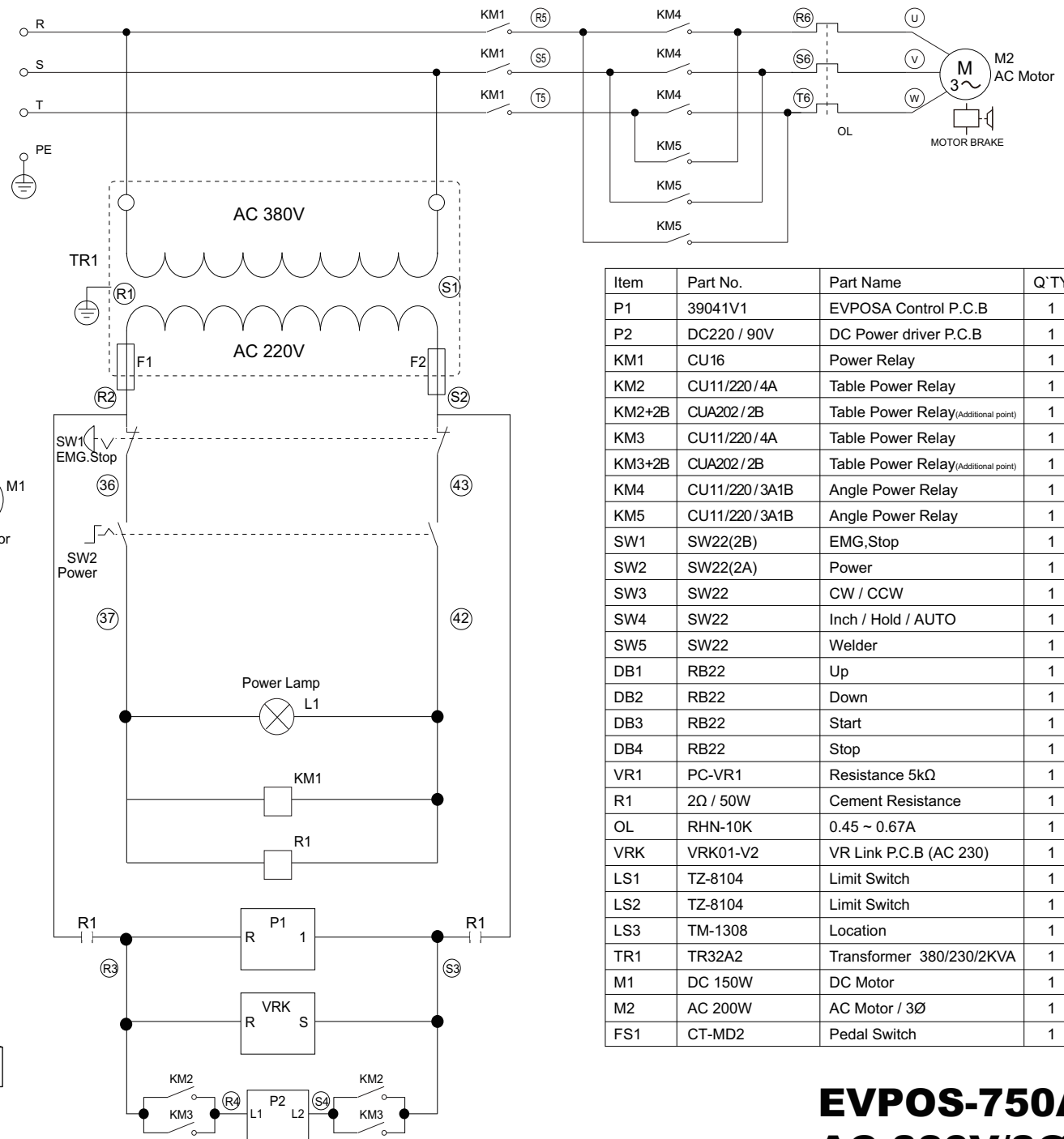
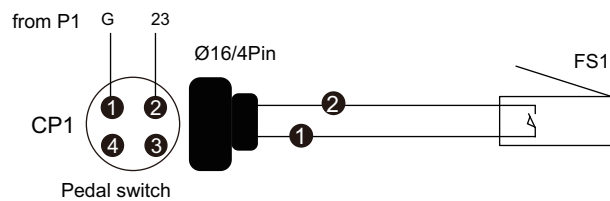
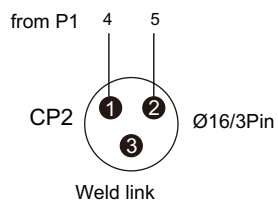
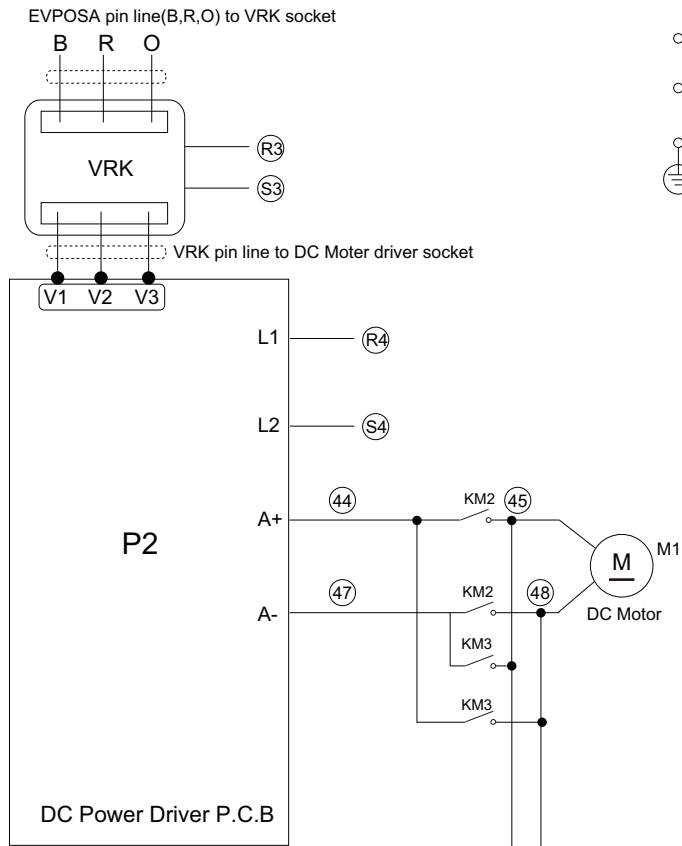
P1

39041V1



EVPOSA Control P.C.B

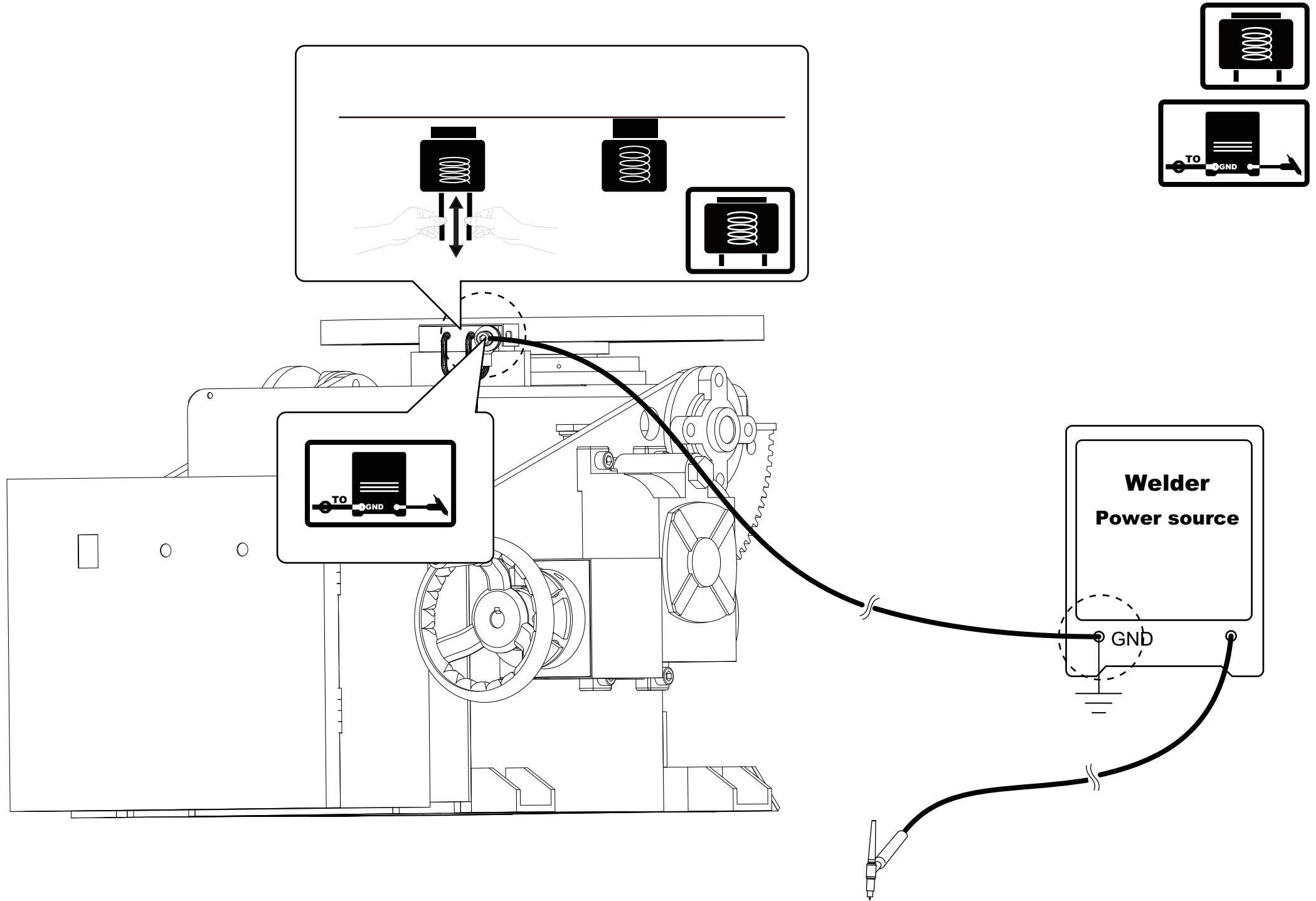
EVPOS-750ACA
AC 380V/3Ø



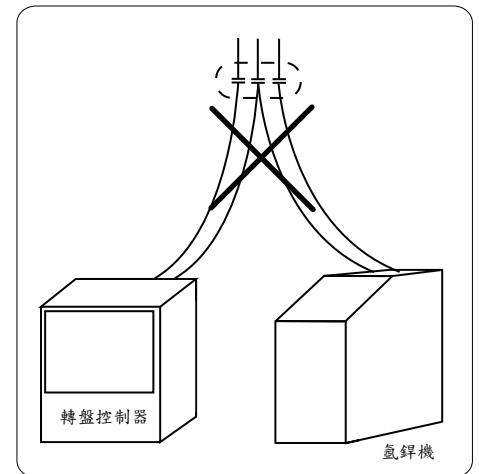
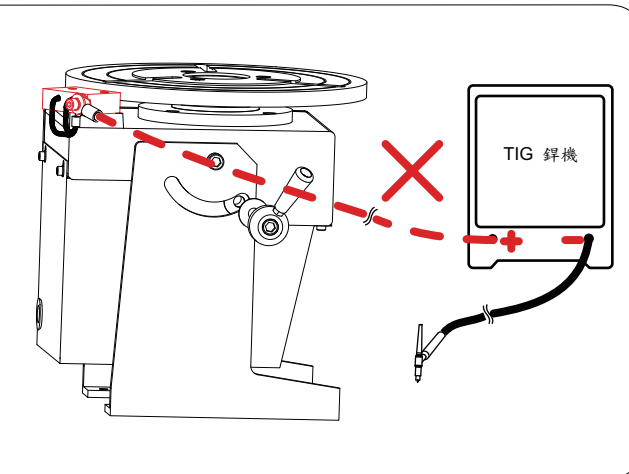
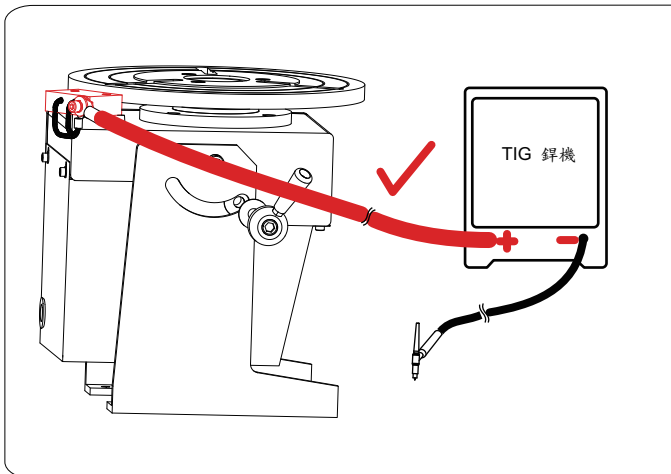
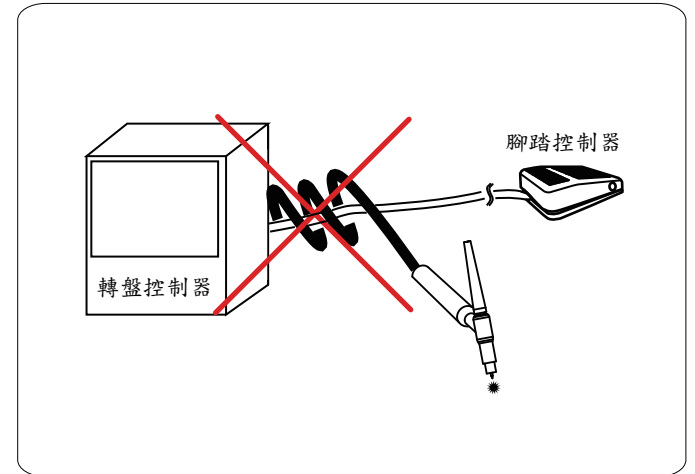
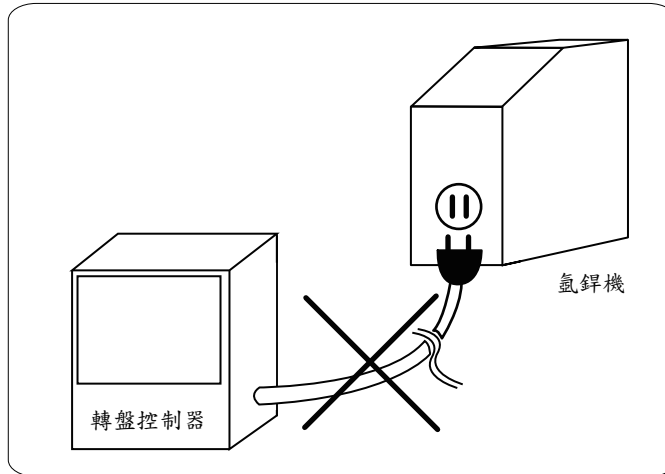
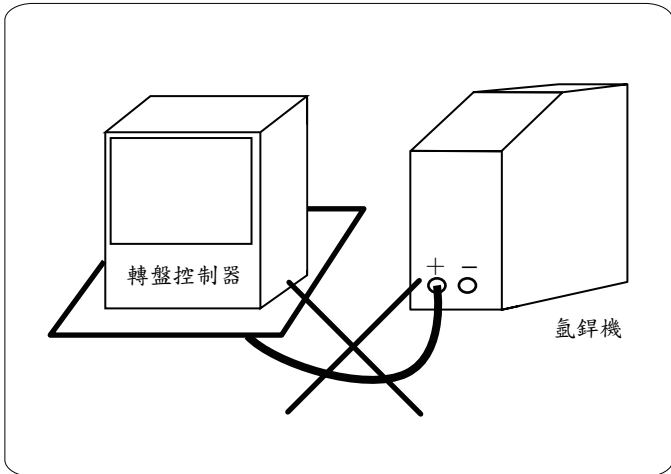
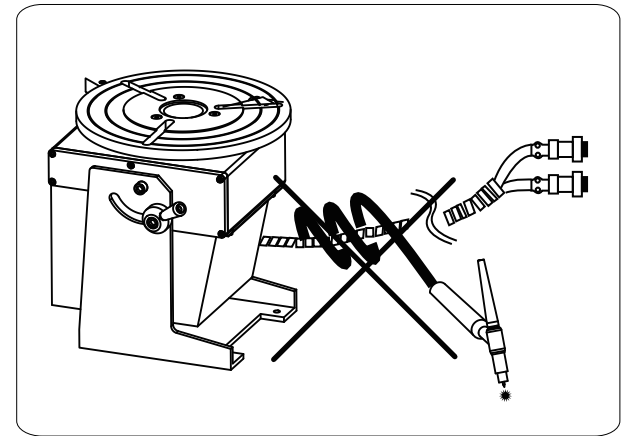
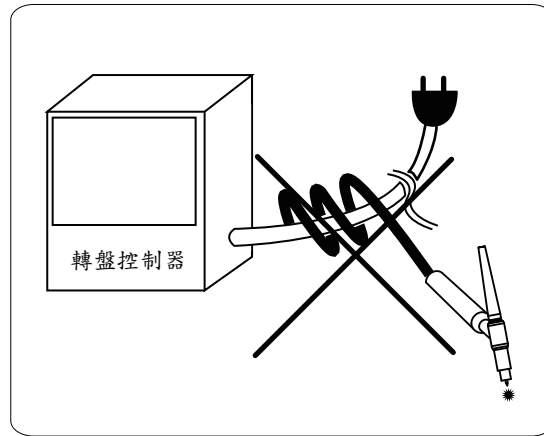
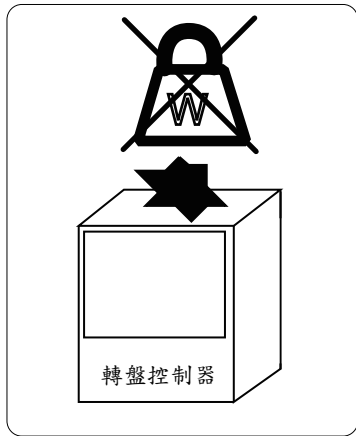
Item	Part No.	Part Name	Q'TY
P1	39041V1	EVPOSA Control P.C.B	1
P2	DC220 / 90V	DC Power driver P.C.B	1
KM1	CU16	Power Relay	1
KM2	CU11/220 / 4A	Table Power Relay	1
KM2+2B	CUA202 / 2B	Table Power Relay(Additional point)	1
KM3	CU11/220 / 4A	Table Power Relay	1
KM3+2B	CUA202 / 2B	Table Power Relay(Additional point)	1
KM4	CU11/220 / 3A1B	Angle Power Relay	1
KM5	CU11/220 / 3A1B	Angle Power Relay	1
SW1	SW22(2B)	EMG,Stop	1
SW2	SW22(2A)	Power	1
SW3	SW22	CW / CCW	1
SW4	SW22	Inch / Hold / AUTO	1
SW5	SW22	Welder	1
DB1	RB22	Up	1
DB2	RB22	Down	1
DB3	RB22	Start	1
DB4	RB22	Stop	1
VR1	PC-VR1	Resistance 5kΩ	1
R1	2Ω / 50W	Cement Resistance	1
OL	RHN-10K	0.45 ~ 0.67A	1
VRK	VRK01-V2	VR Link P.C.B (AC 230)	1
LS1	TZ-8104	Limit Switch	1
LS2	TZ-8104	Limit Switch	1
LS3	TM-1308	Location	1
TR1	TR32A2	Transformer 380/230/2KVA	1
M1	DC 150W	DC Motor	1
M2	AC 200W	AC Motor / 3Ø	1
FS1	CT-MD2	Pedal Switch	1

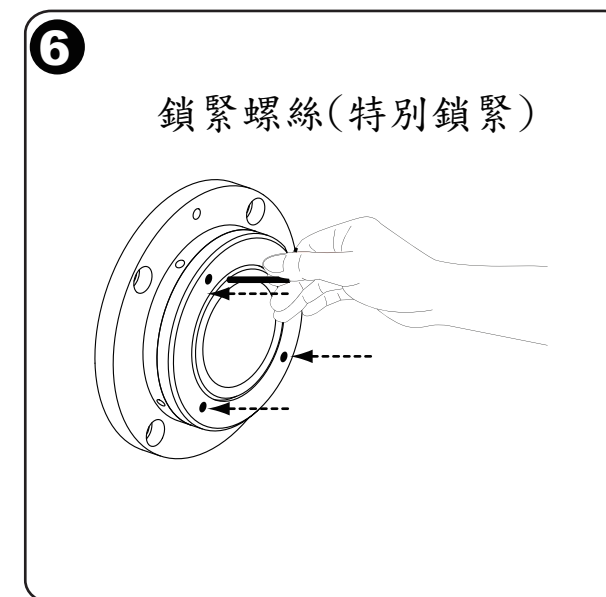
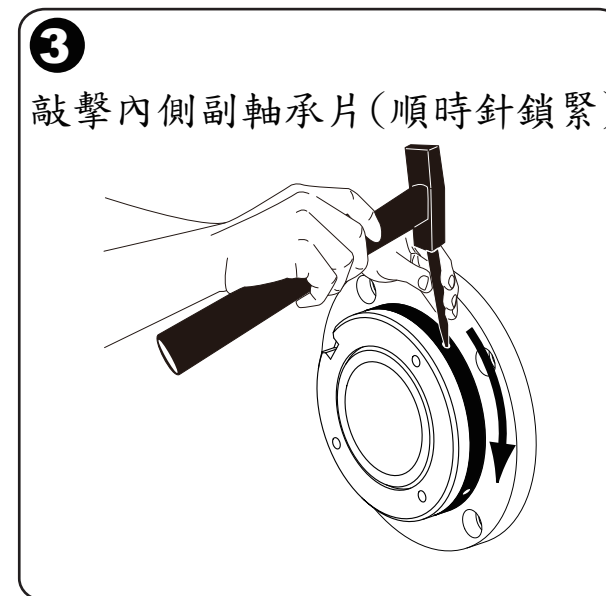
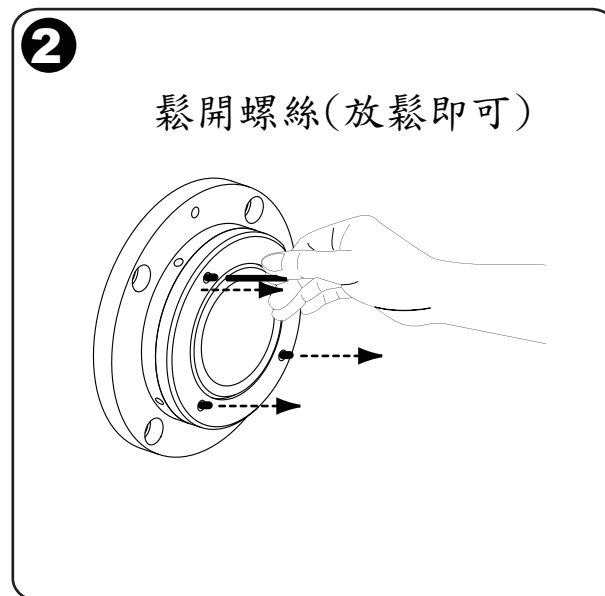
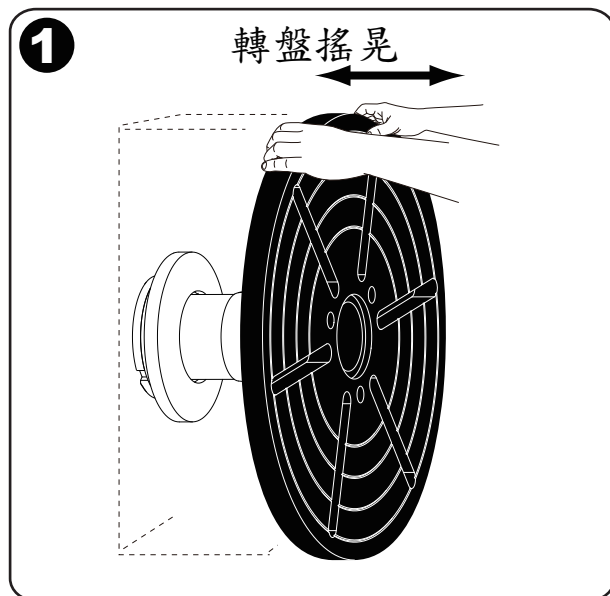
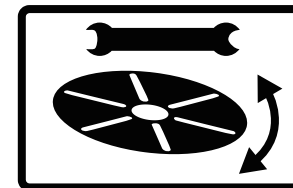
EVPOS-750ACA
AC 380V/3Ø

注意碳刷及接地



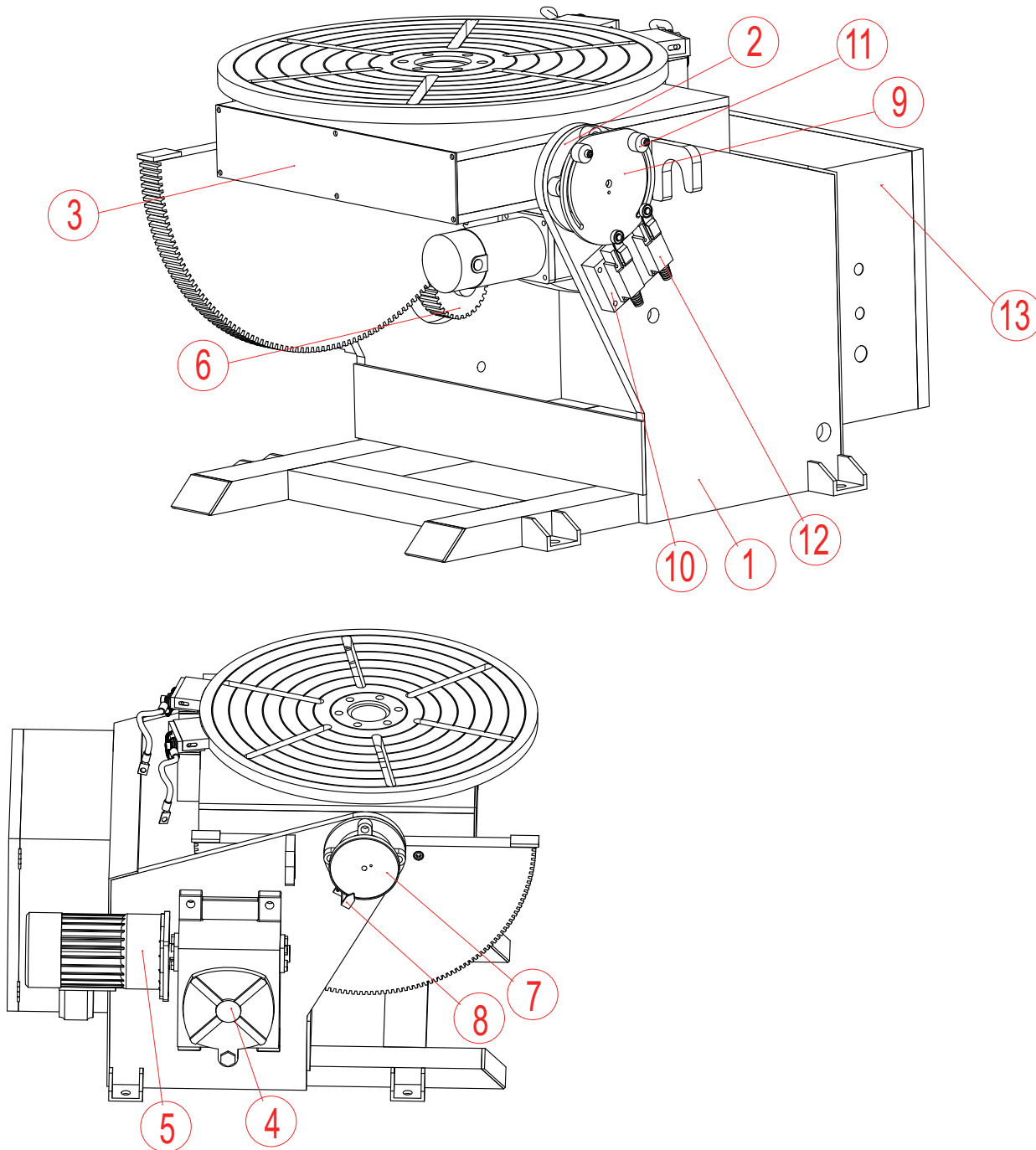
注意事項





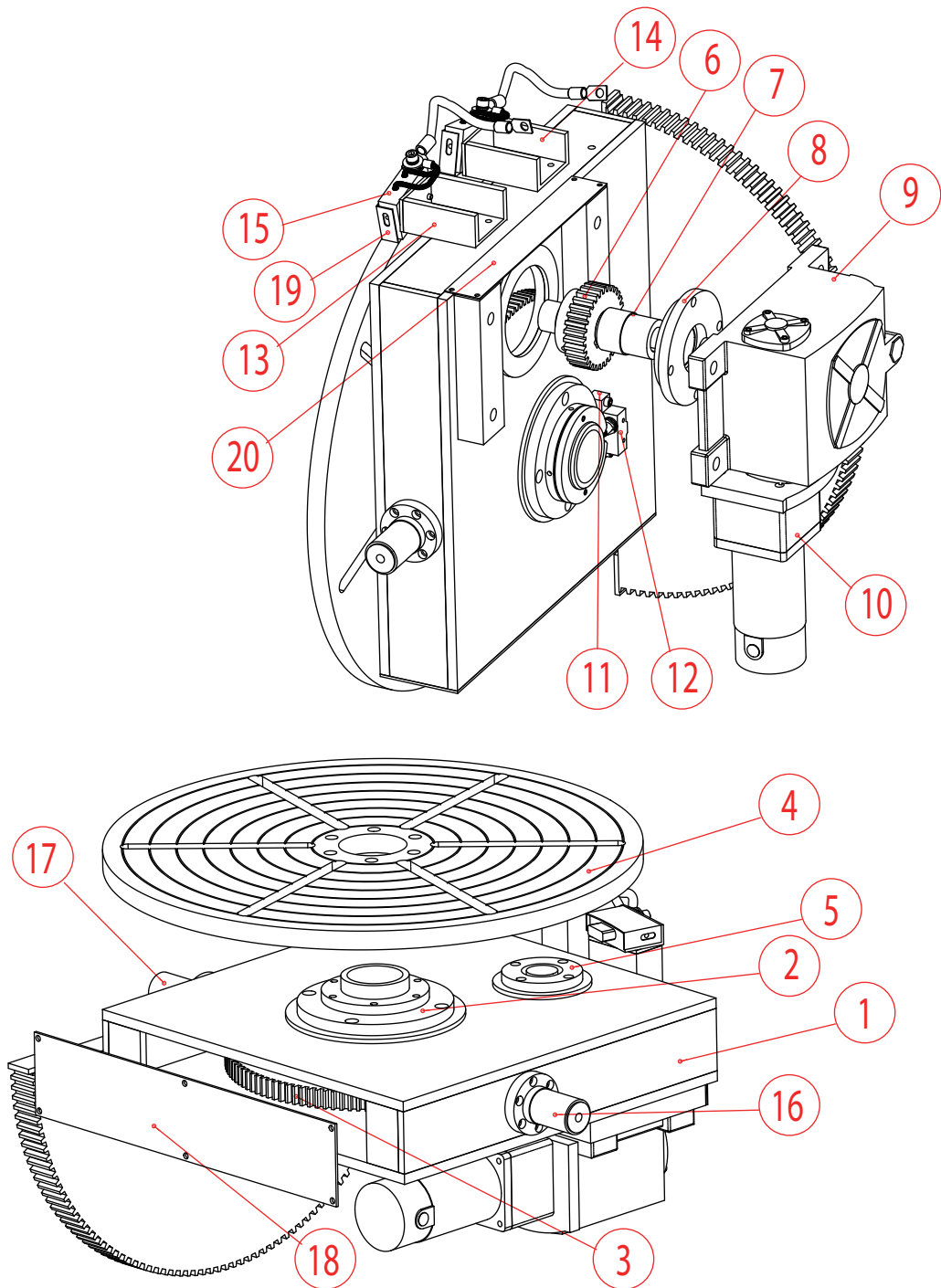
反覆 3-5 次

組合圖



件號	料號	名稱	數量
1	EV750-01	基座	1
2	UCP208	軸承座	2
3	EV750A-1	主體箱組合	1
4	EDGM-80-30B-R	蝸輪減速機	1
5	CV200-10SZB	馬達齒輪減速機	1
6	EV750-08	轉位驅動齒輪	1
7	EV750-16	角度板	1
8	EV750-17	68刻度指針	1
9	EV750A-01	微調板	1
10	EV1T-22	微動座	1
11	EV750A-02	觸碰塊	2
12	YJ-8104	微動開關	2
13	EV-02	400*450控制箱	1

組合圖



件號	料號	名稱	數量
1	EV750-02	主體齒輪組	1
2	P100A1-1	主軸總成	1
3	EV750-06	主齒輪	1
4	EV750-04	平盤	1
5	EV750-12	上軸承蓋	1
6	EV750-07	驅動齒輪	1
7	EV750-11	驅動軸心	1
8	EV750-13	下軸承蓋	1
9	KE70RD-30B-5GX	蝸輪減速機	1
10		5GX減速機	1
11	P1010	微動塊	1
12	TM1308	微動開關	1
13	EV750-15(A)	右接地固定座	1
14	EV750-15(B)	左接地固定座	1
15	P100A2	接地銅座組	2
16	EV75A-03	加長轉位軸心	1
17	EV750-09	齒輪轉位軸心	1
18	EV750-14	主體箱側板	1
19	EV500-13	302銅座護蓋	2
20	EV750-18	主體後護蓋	1