



OWNERS MANUAL

POS2CC10

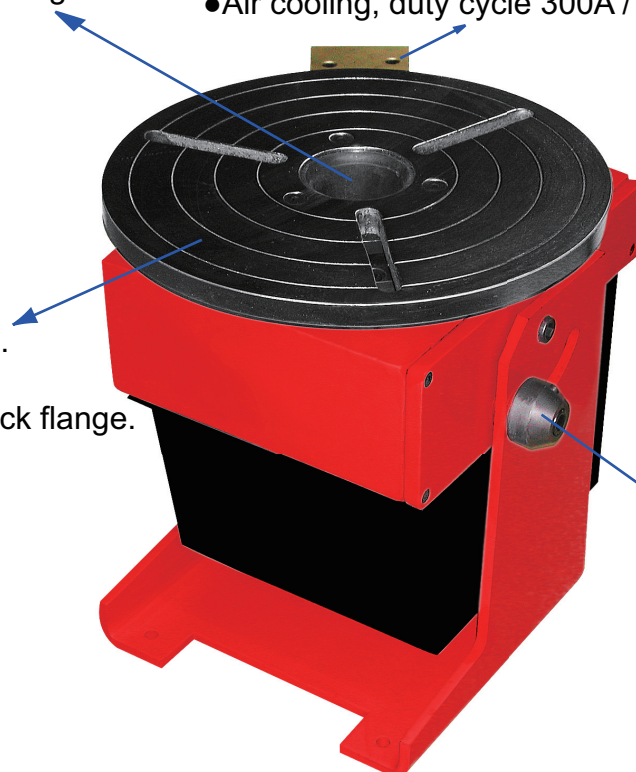


Chapter 1: Functon

1.1 POS2 Structure characteristic and Specification

- Internal diameter 60mm. Pass through holes
- Carbon brush electric conduction, the copper alloy outer cover dispels the heat.
- Air cooling, duty cycle 300A / 100%

- The table is electroplated, it is not apt to stick dregs.
- All right use of two sides of the table.
- Level nick and the standard lathe uses the 9" 3- chuck flange.



- The screw locks the regular angle
- Table angle range : -5° to 95°

○ Welding method that can be matched

- MIG/MAG
- TIG
- Wire-TIG
- Plasma weld
- SAW

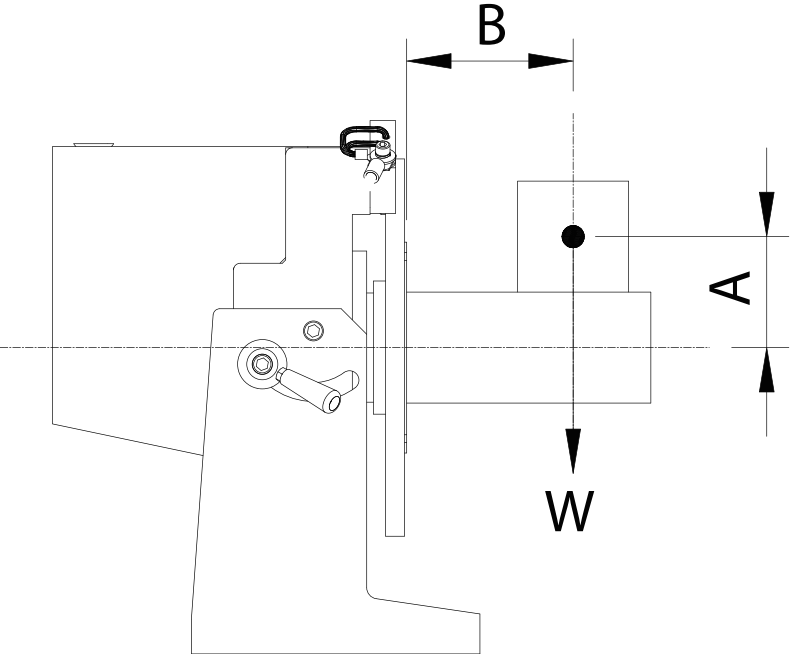
○ Dispose the place

- In the factory

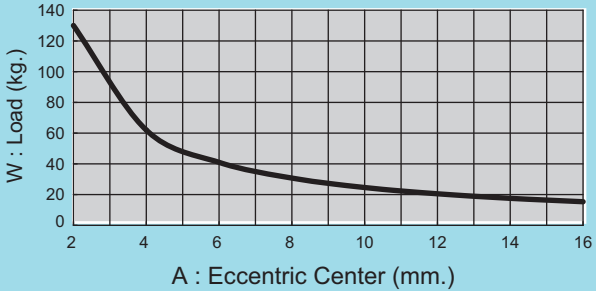
○ Duty cycle

- Can operate in succession 100%
- Weld electric current 300A

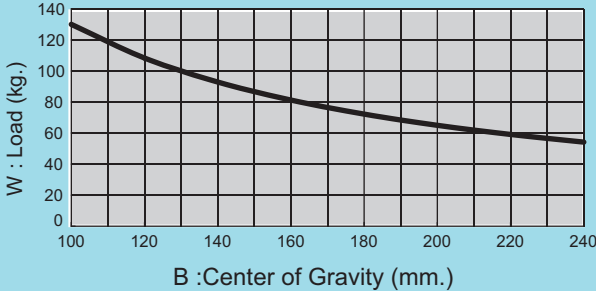
Oder No.	P2A	P2B	P2C	P2D
Specification/model	POS2A	POS2B	POS2C	POS2D
Motor	DC90V/100W	DC90V/100W	DC90V/100W	DC90V/100W
Table axis centre hole	I.D60mm	I.D60mm	I.D60mm	I.D60mm
Table Dia	O.D340mm	O.D340mm	O.D340mm	O.D340mm
Table angle	0° - 90°	0° - 90°	0° - 90°	0° - 90°
Welding current	300A/100%	300A/100%	300A/100%	300A/100%
Table speed	2.4 - 24rpm	1.2 - 12rpm	0.6 - 6rpm	0.2 - 2rpm
Rotate load	170 Kg	230 Kg	290 Kg	360 Kg
Rotate torque	40 Kg-cm.	80 Kg-cm.	120 Kg-cm.	120 Kg-cm.
Size	L:322mm W:403mm H:418mm	L:322mm W:403mm H:418mm	L:322mm W:403mm H:418mm	L:322mm W:403mm H:418mm
N.W/G.W	62Kg / 68Kg	62Kg / 68Kg	62Kg / 68Kg	62Kg / 68Kg



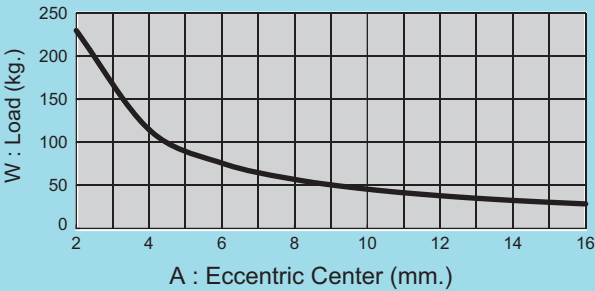
POS-2A Positioner Eccentric Load



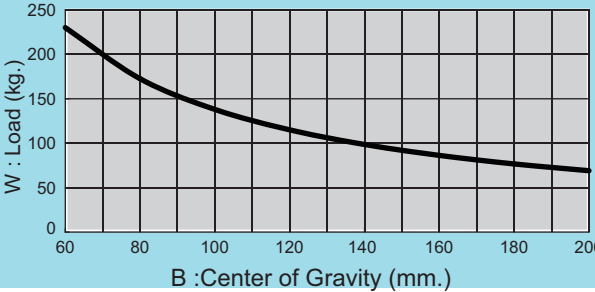
POS-2A Center of Gravity



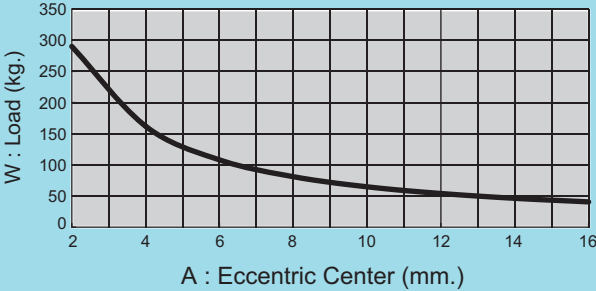
POS-2B Positioner Eccentric Load



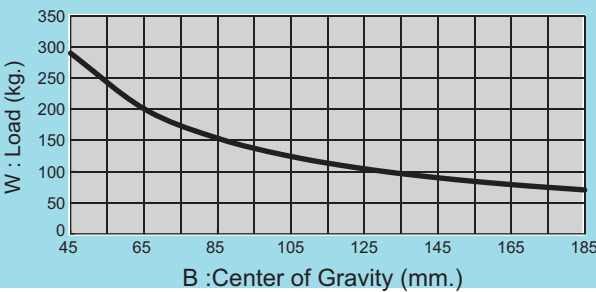
POS-2B Center of Gravity



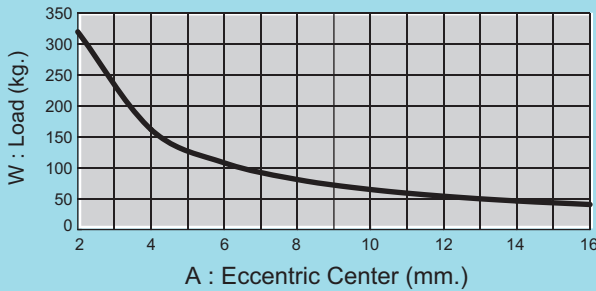
POS-2C Positioner Eccentric Load



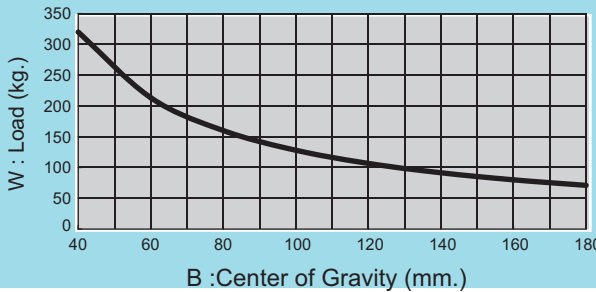
POS-2C Center of Gravity

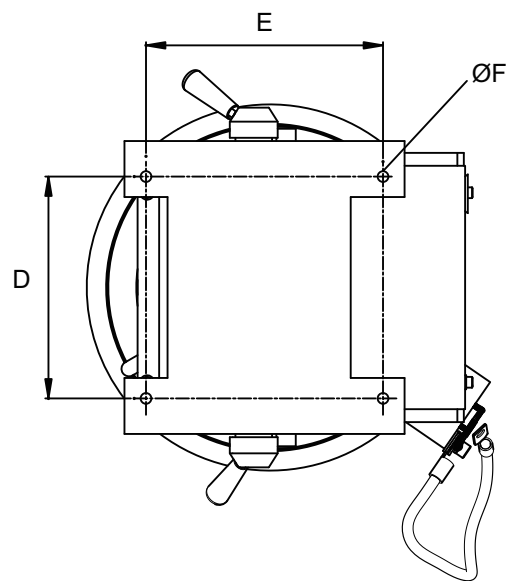
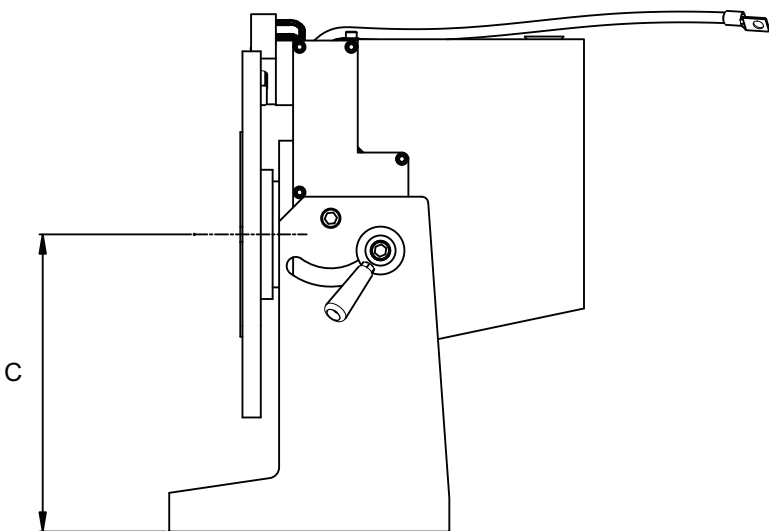
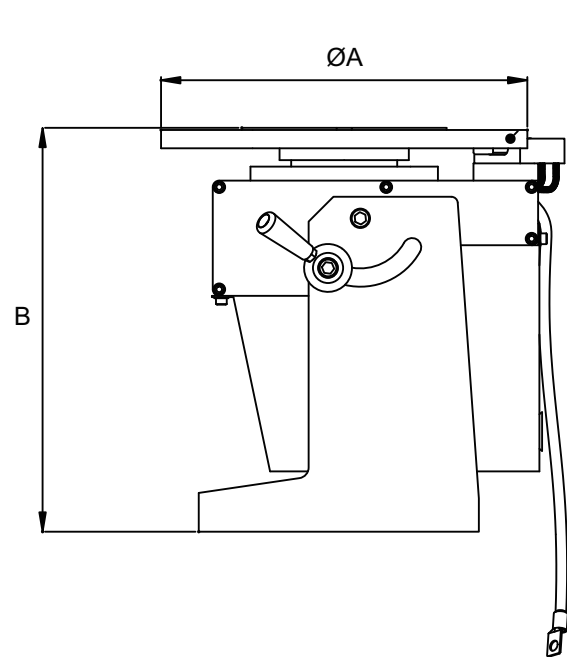


POS-2D Positioner Eccentric Load

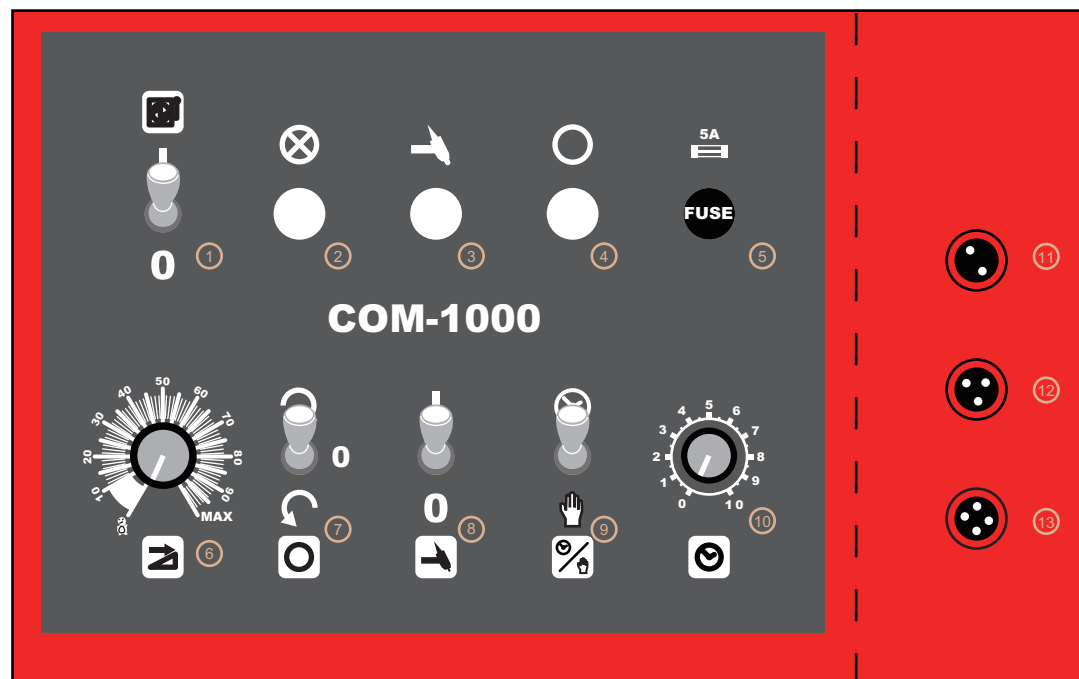


POS-2D Center of Gravity





	POS1	POS2
A	340mm	340mm
B	375mm	418mm
C	276mm	319mm
D	206mm	206mm
E	220mm	220mm
F	10mm	10mm

**Specification / No.****COM-1000**

Power

A1: AC110V/60Hz/4A

A2: AC220V/50Hz/3A

Power of the motor

DC90V/150W

Rotate the direction

cw/ccw

Timer

0-240sec

(Five kinds of adjustable time ranges)

Arc way of the welde

☐ Standard

Line welder

1st

Stop the brake

Magnetism brake

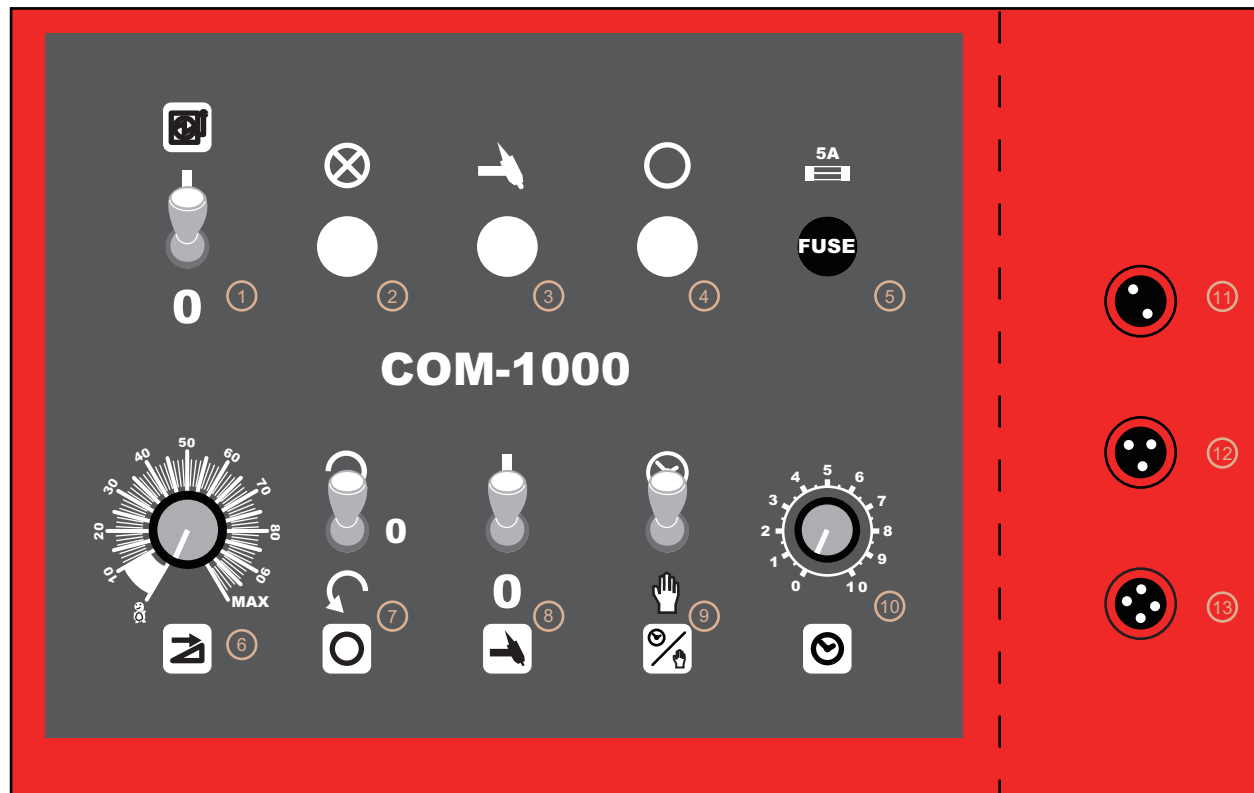
H.F. Protect

95%

Start the device

Foot switch (Line 2M)

1.5 Structure characteristic



○ **Welding method that can be matched**

- MIG/MAG
- TIG
- Wire-TIG
- Plasma weld
- SAW

○ **Dispose the place**

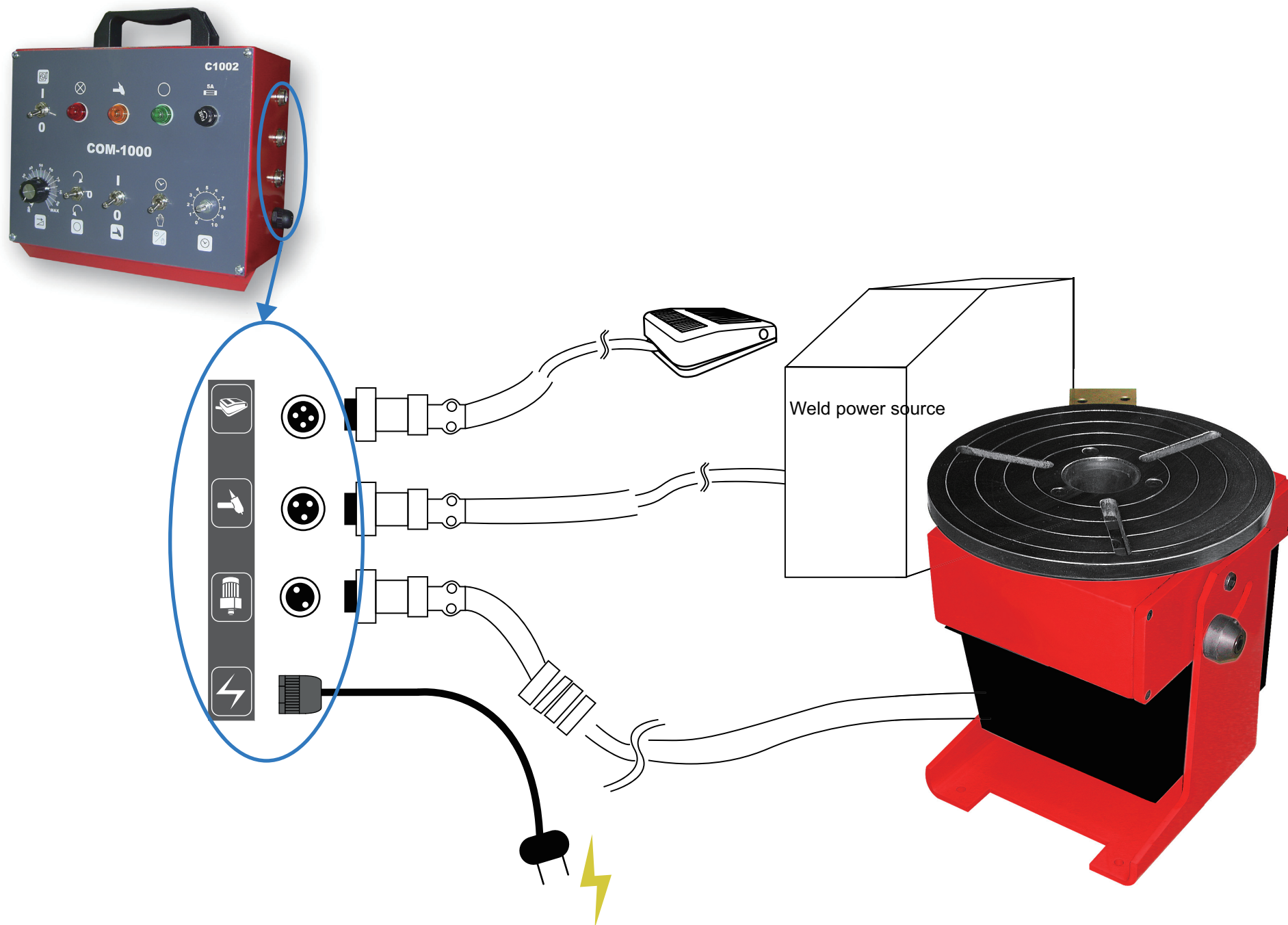
- In the factory

○ **Duty cycle**

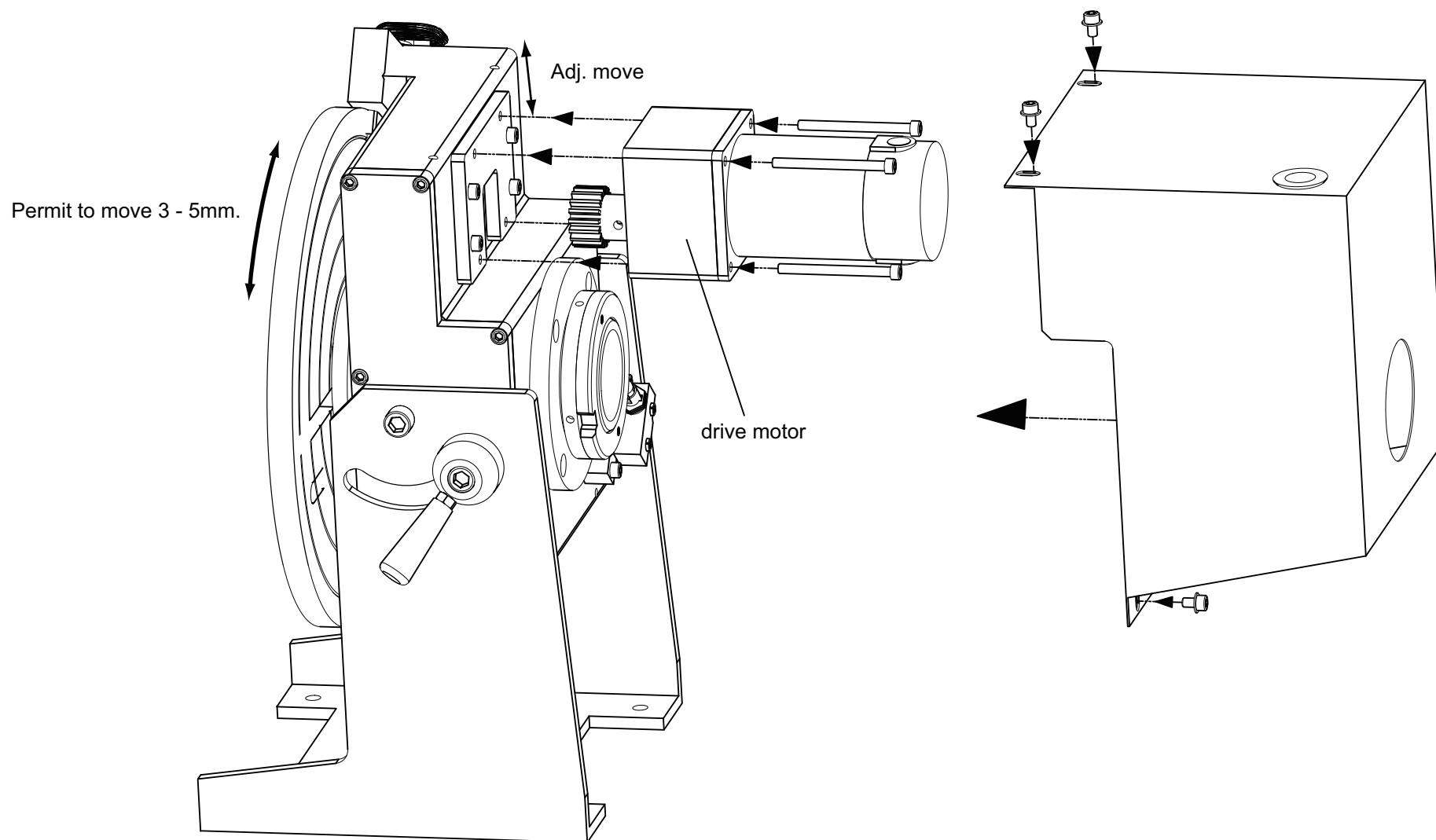
- Can operate in succession 100%
- Weld electric current 300A

Chapter 2: Installation

2.1 Installation



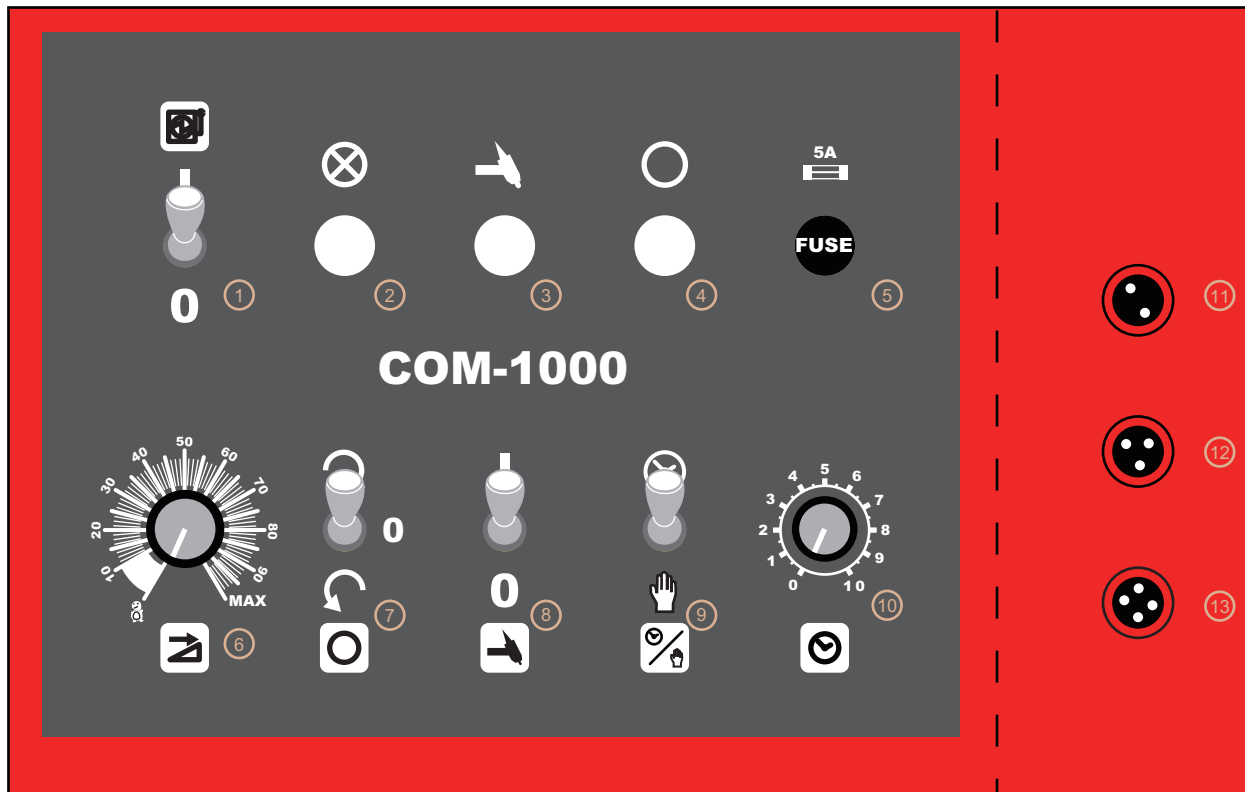
2.2 Install the method of the drive motor



Rotate the table and confirm moving the distance(3 - 5 mm) with hands, lock the drive motor

Chapter 3: Operating

3.1 Control Panel



1.Power switch

2.Power light

3.Table light

4.Welder light

5.FUSE

6.Table speed (RPM)

7.Table cw/ccw switch

8.Welder switch

9.Auto / Inch switch

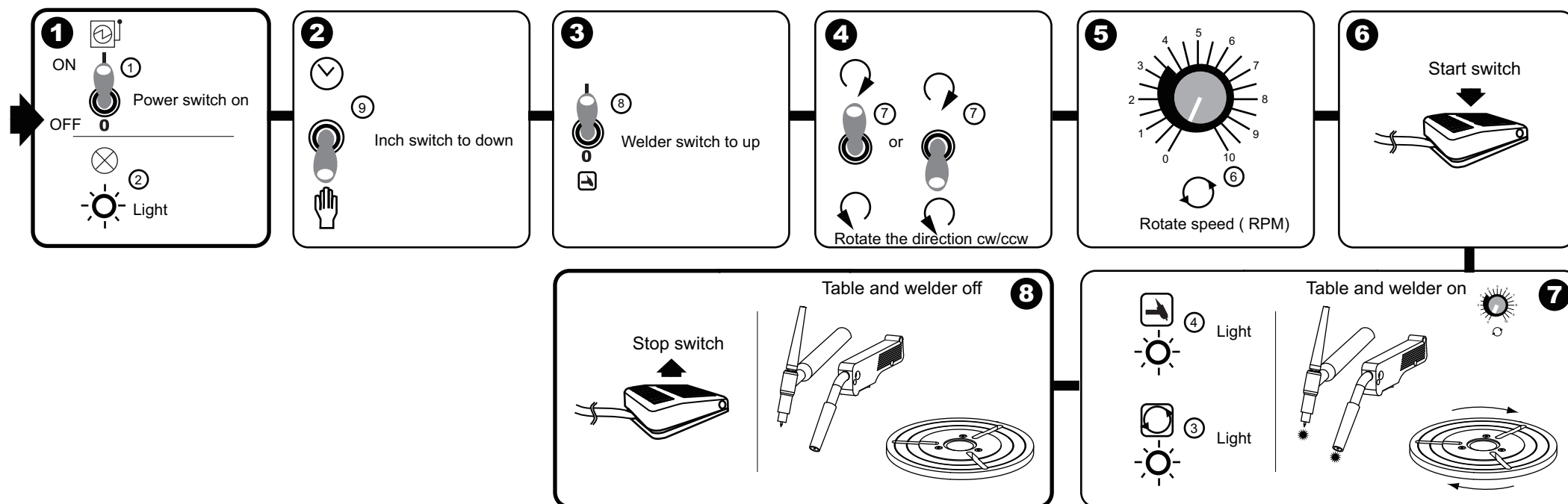
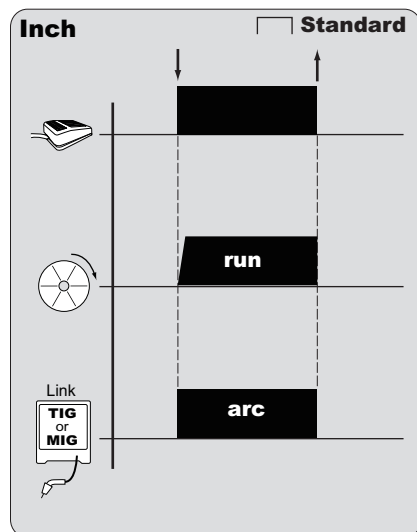
10.Timer

11.Start switch socket(4P)

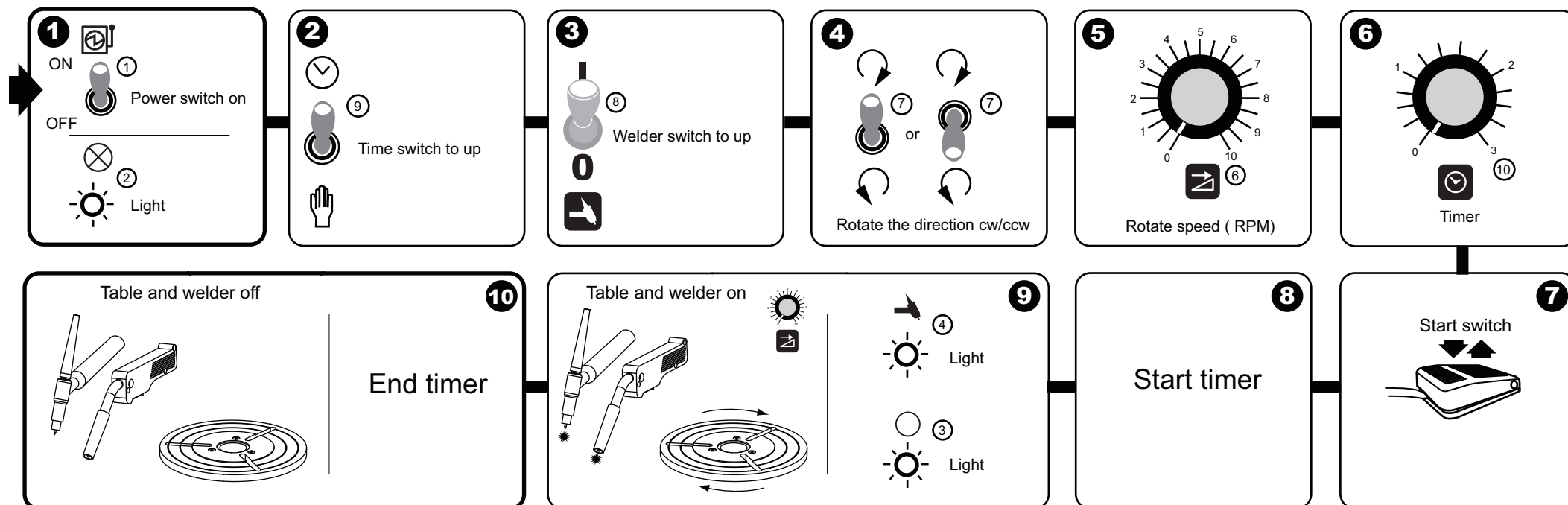
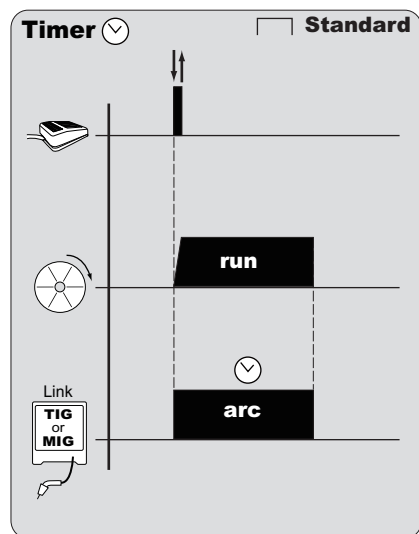
12.Welder switch socket(3P)

13.Table motor socket(2P)

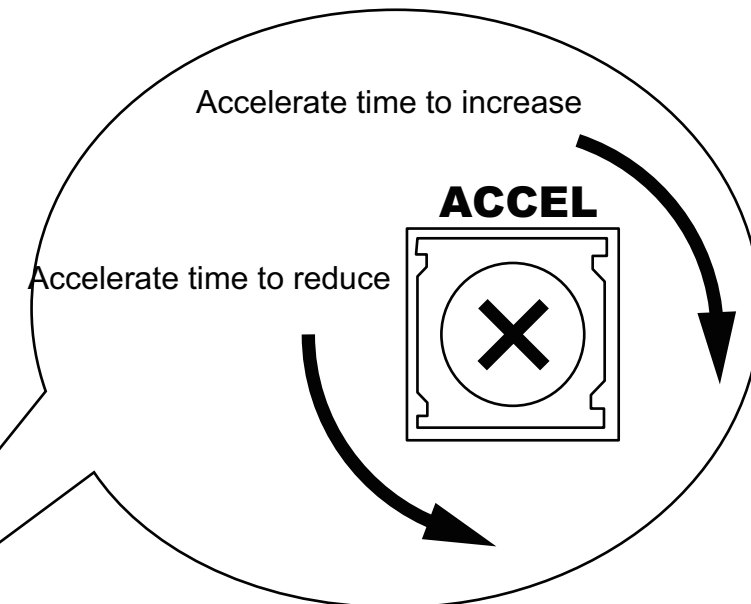
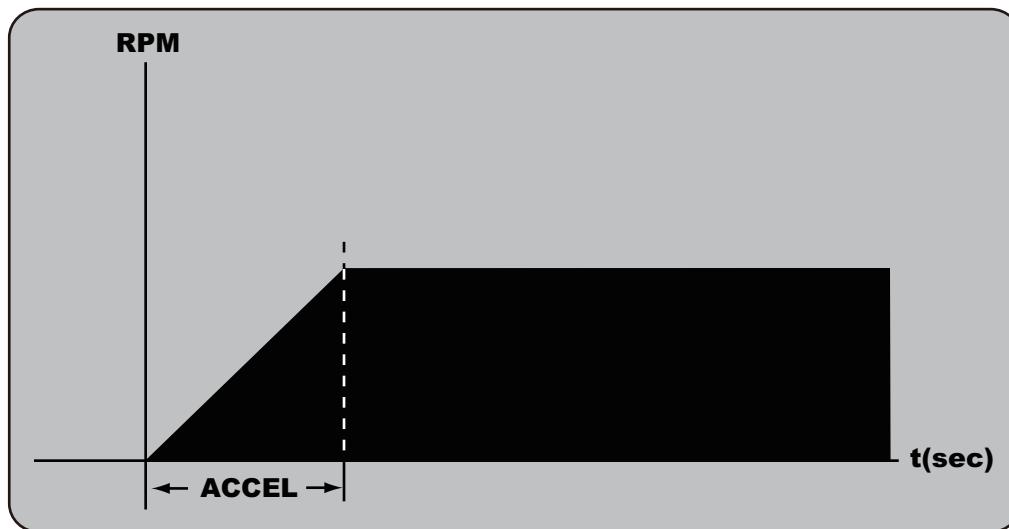
3.2 Inch operating



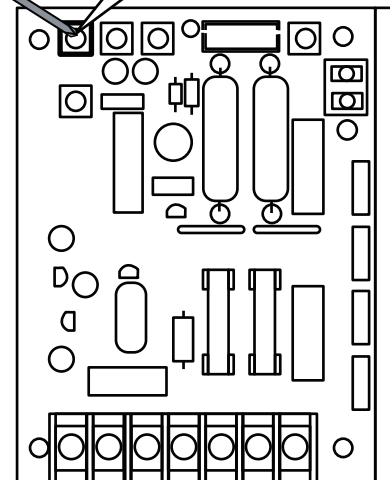
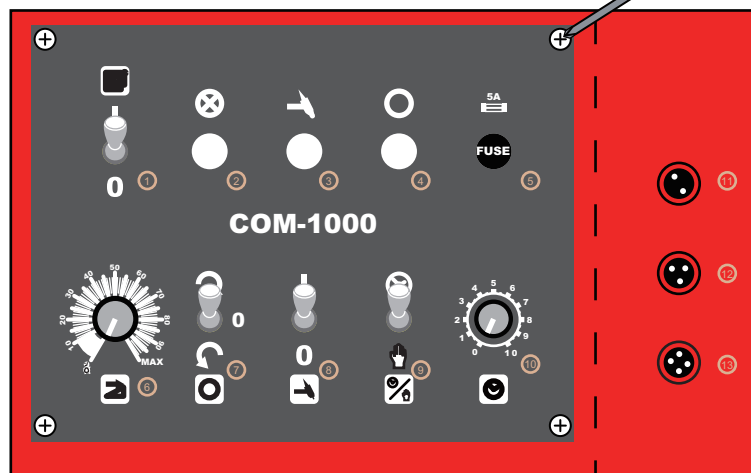
3.3 Timer operating



3.4 Table start and accelerate time to adjust



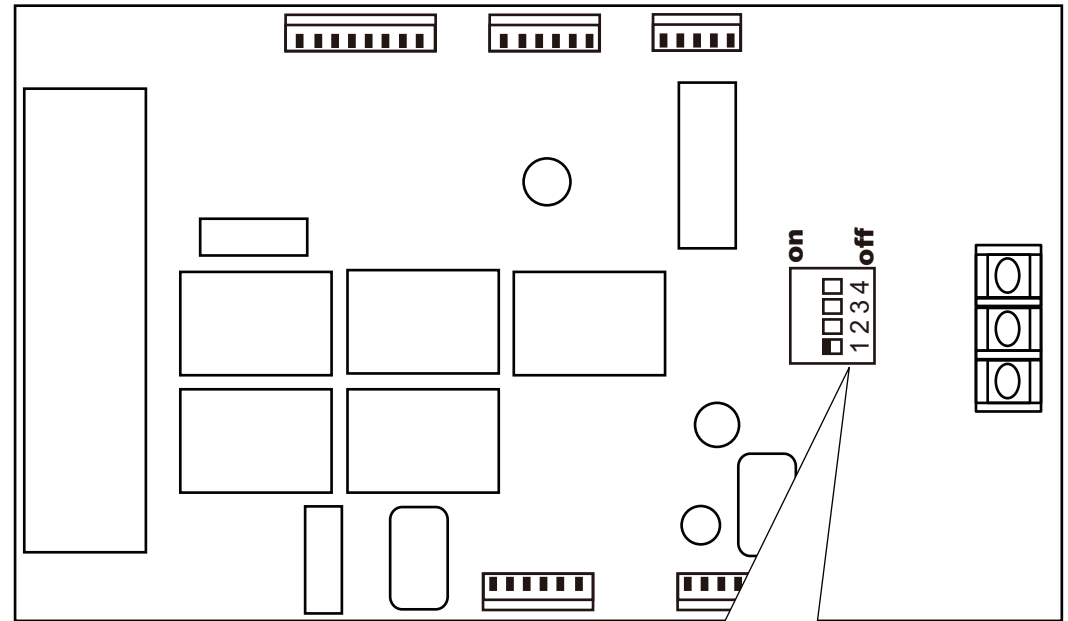
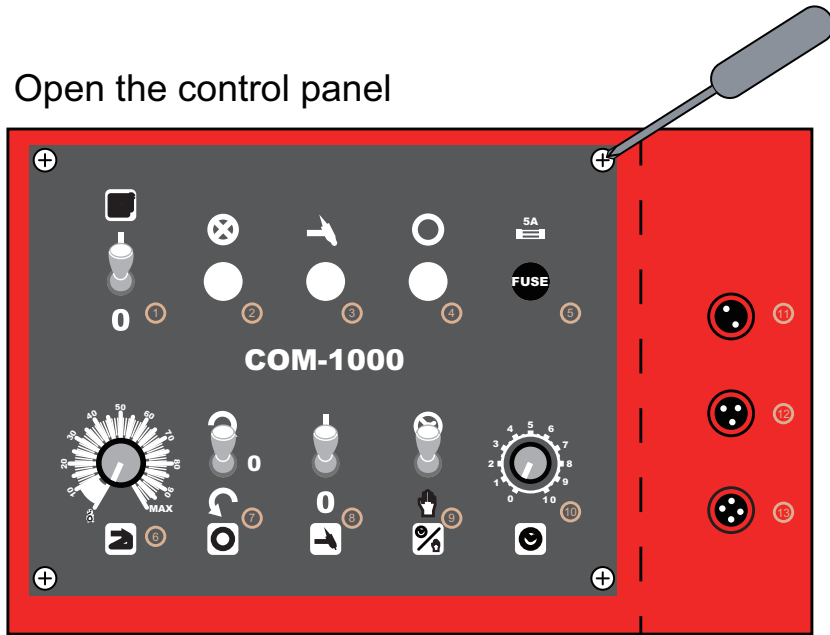
Open the control panel



DC motor driver

3.5 The time of the timer range adjusting

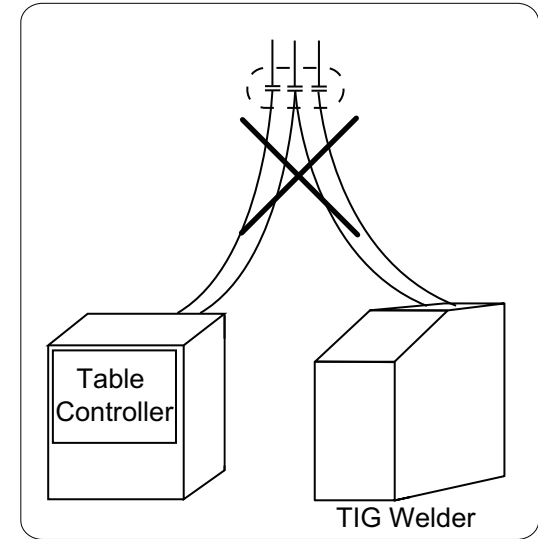
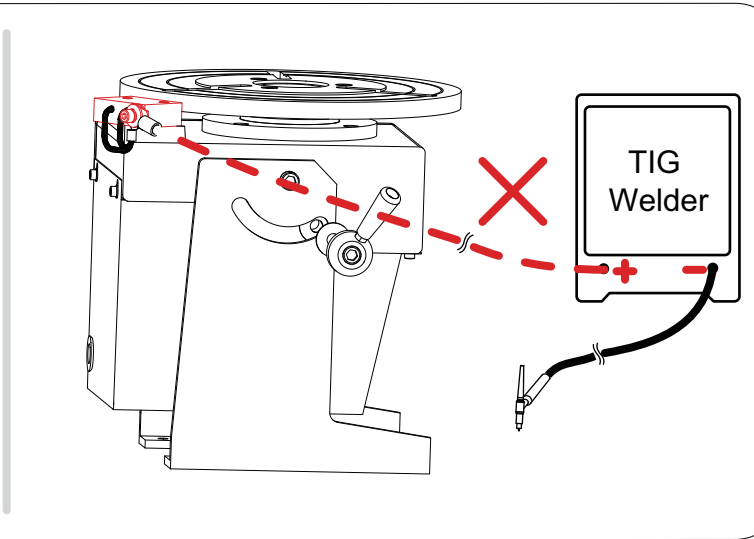
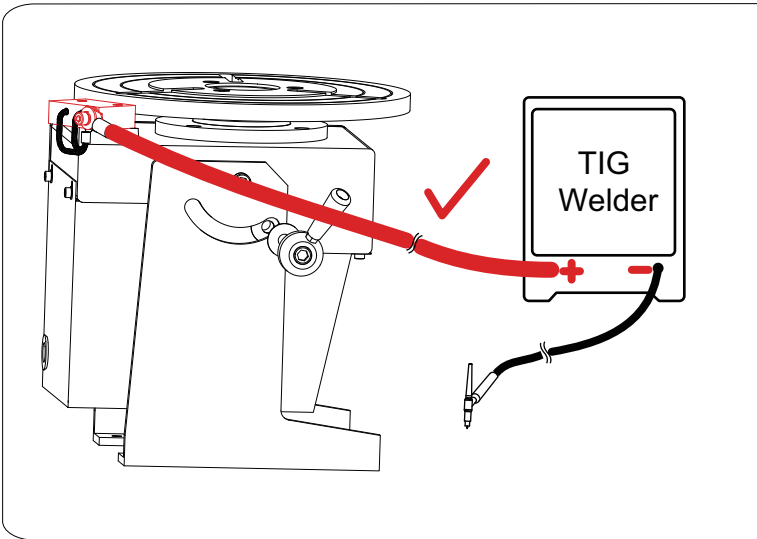
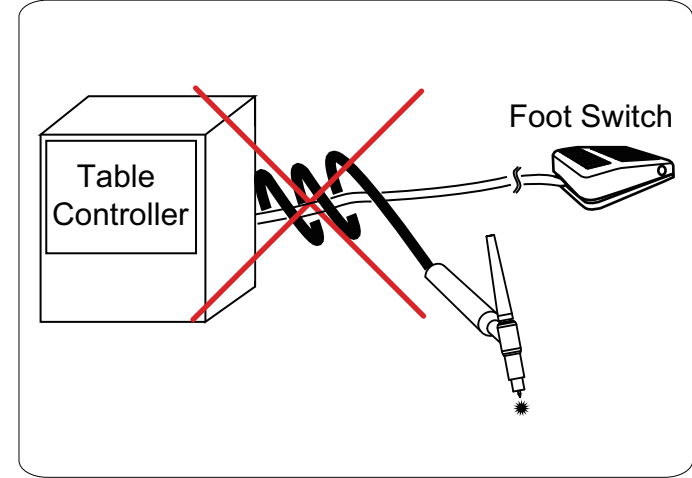
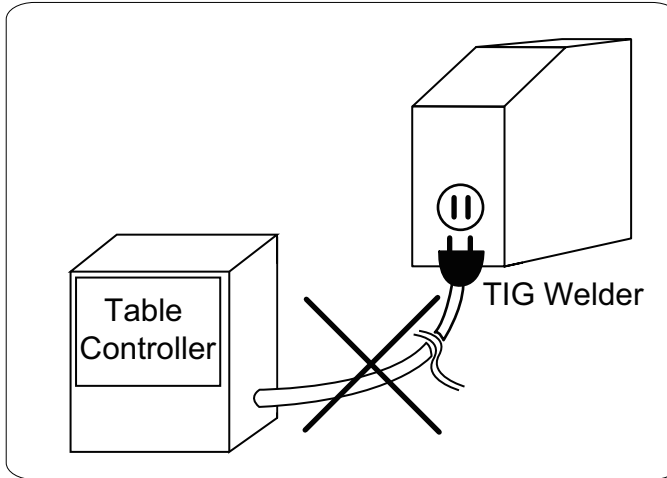
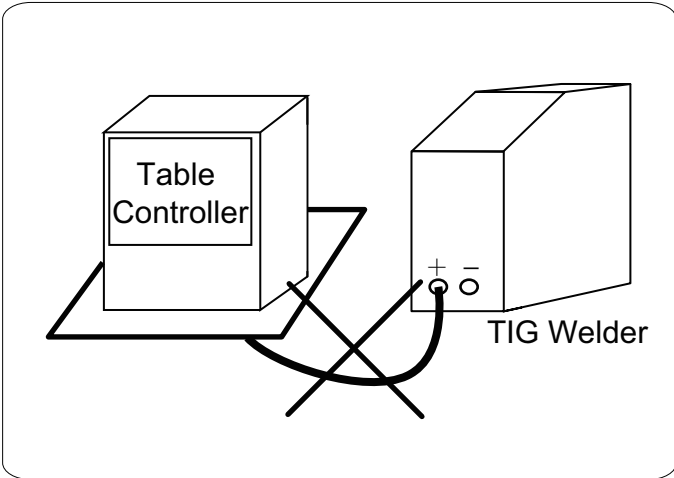
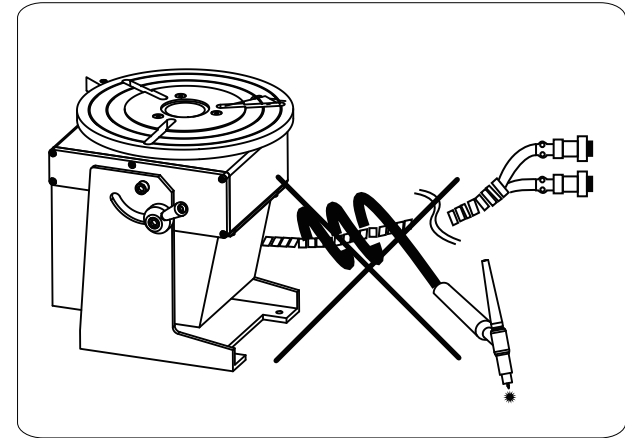
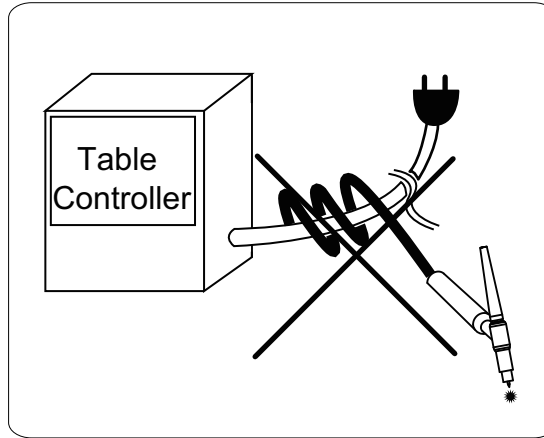
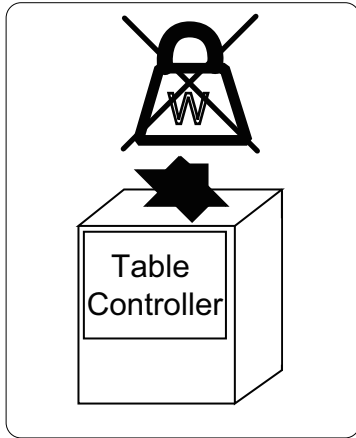
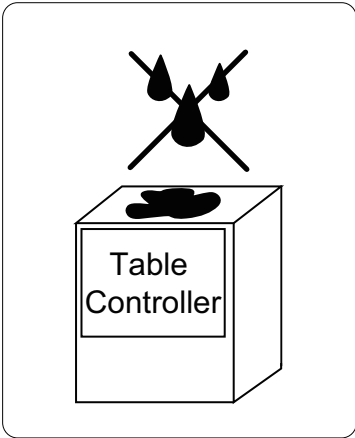
Open the control panel

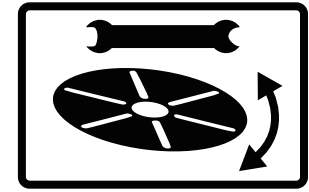
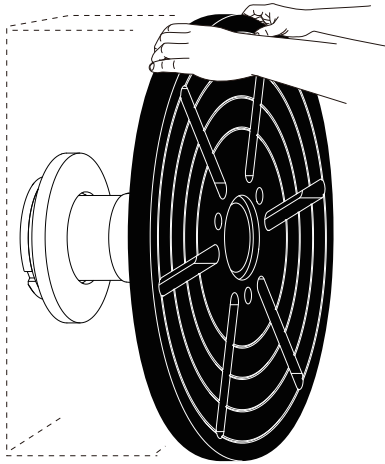
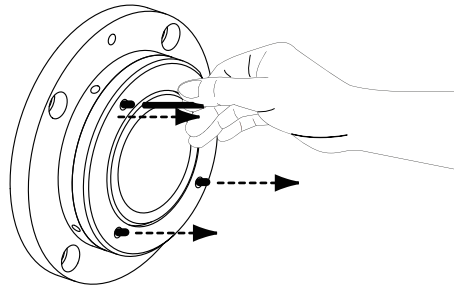
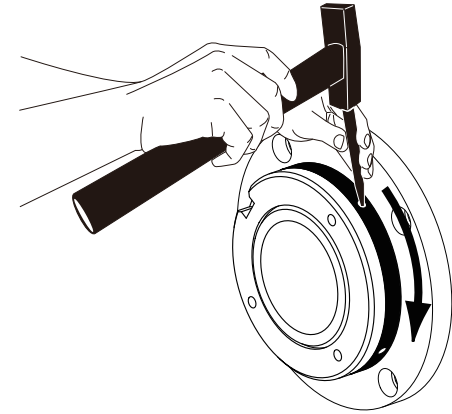
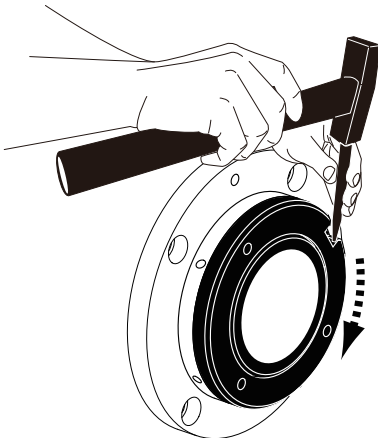
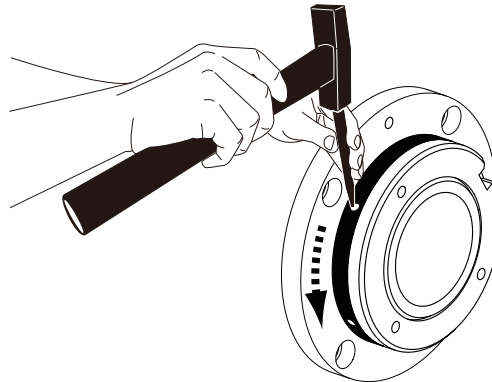


	SW1	SW2	SW3	SW4
8Sec	ON	OFF	ON	OFF
30Sec	OFF	ON	ON	OFF
60Sec	OFF	ON	ON	ON
180Sec	OFF	OFF	OFF	OFF
240Sec	ON	ON	ON	OFF

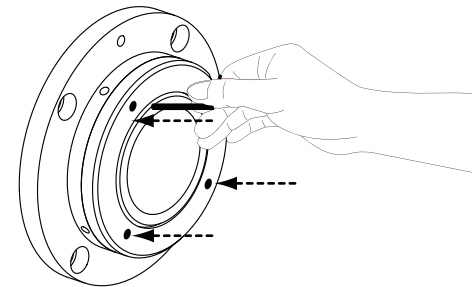
Appendix

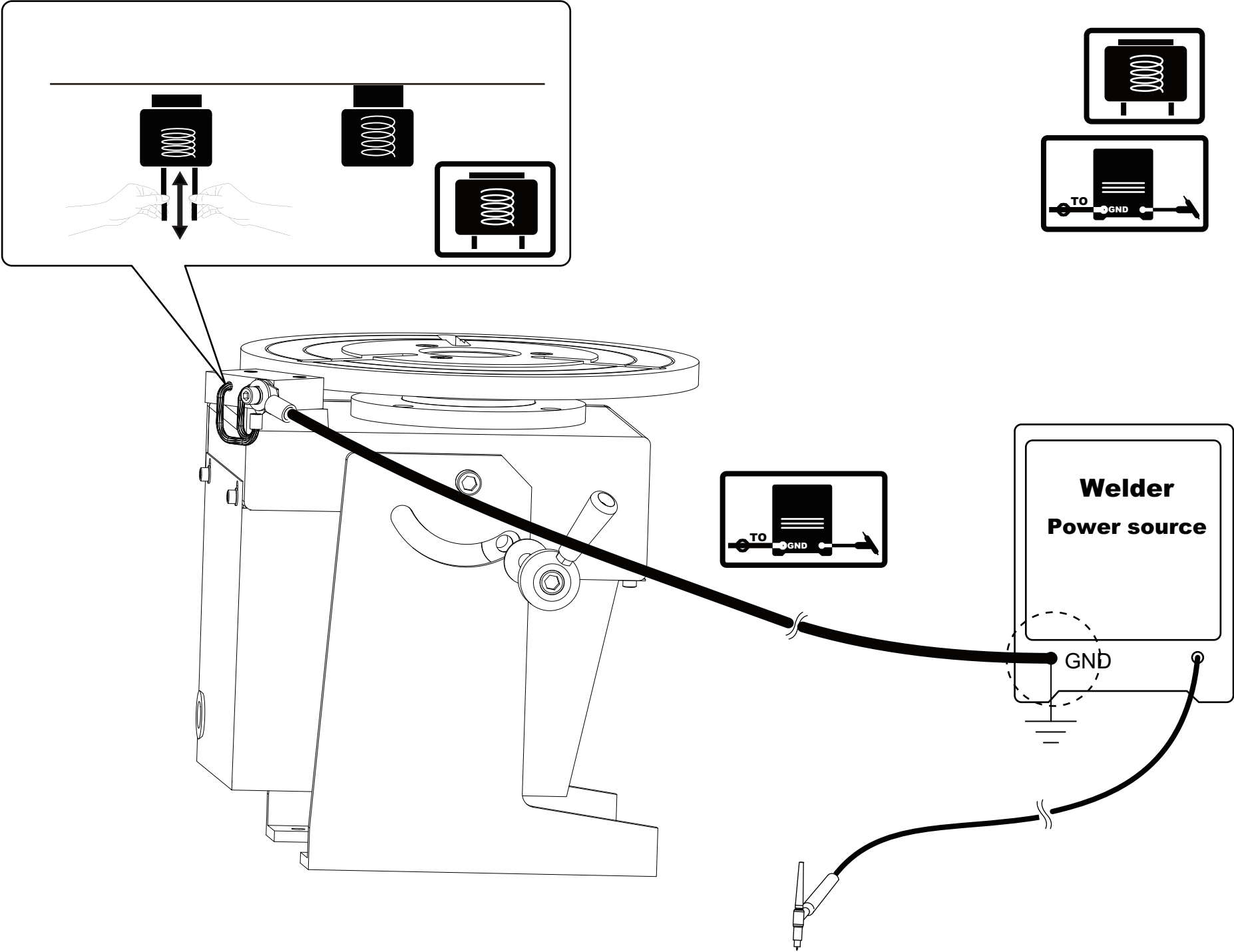
Warn the item

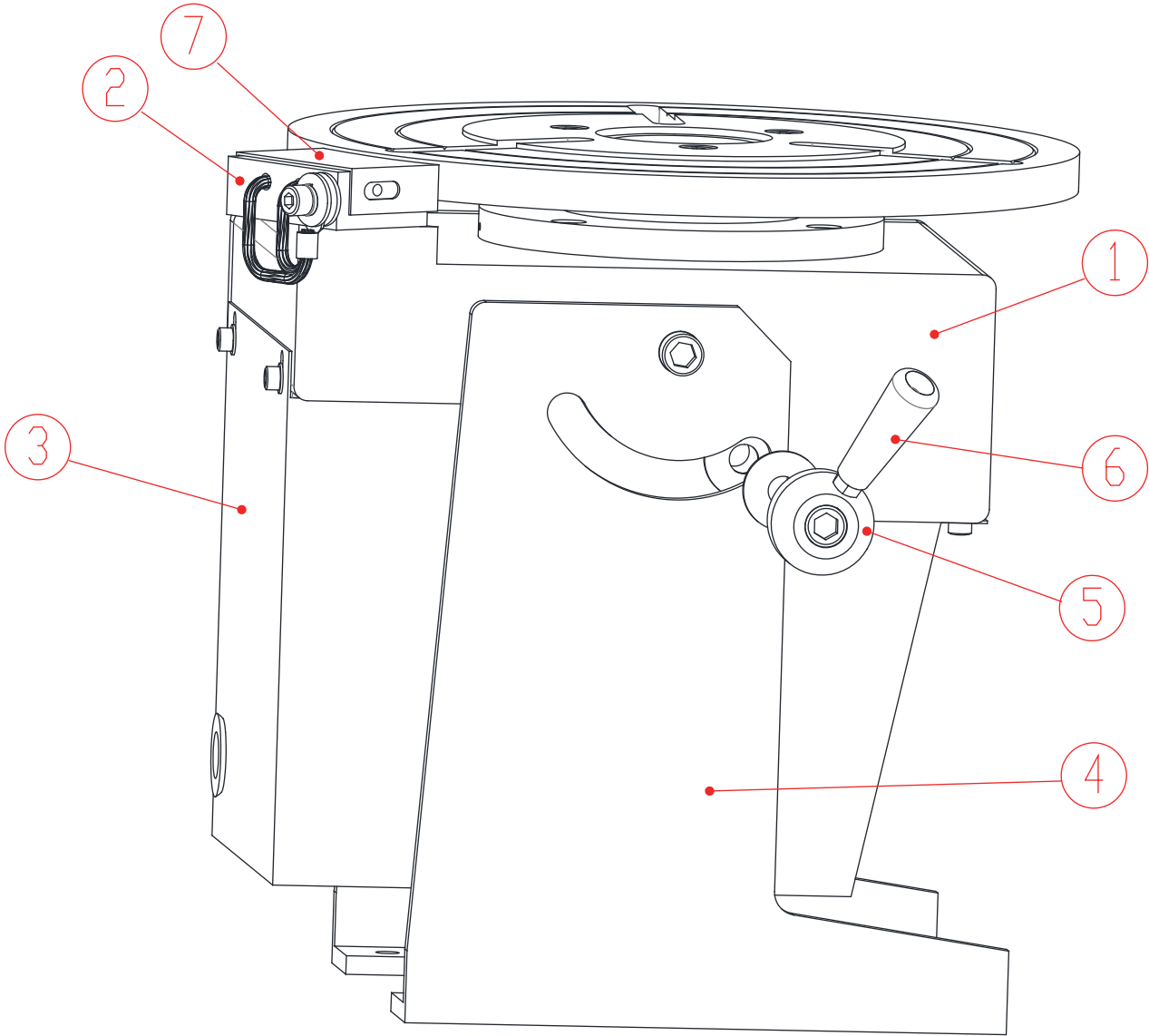


**1 Table is rocked****2 Unlock screw****3 Lock bearing cover****4 Lock ring****5 End bearing cover**

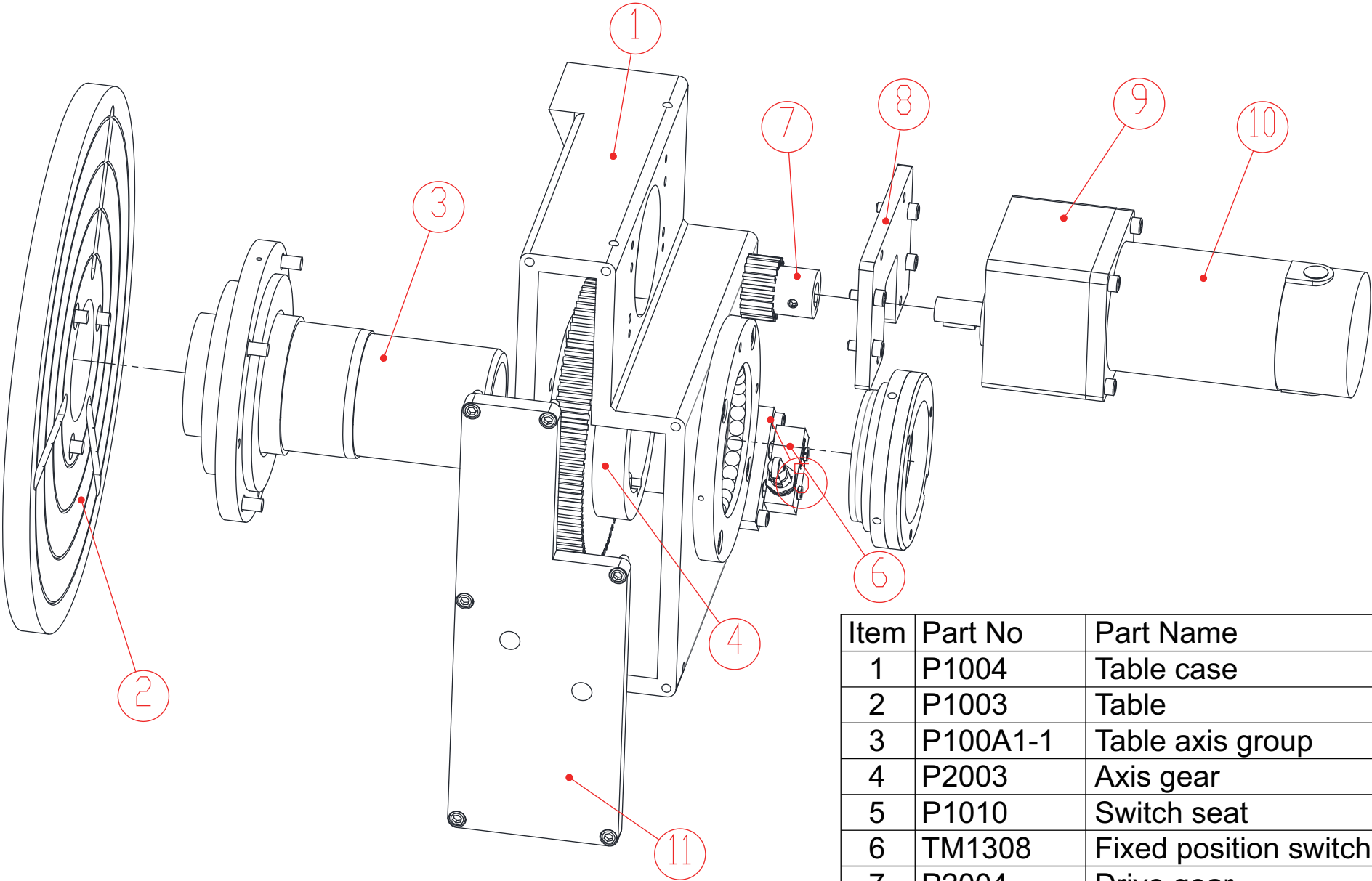
Repeat 3-5 times

6 lock screw

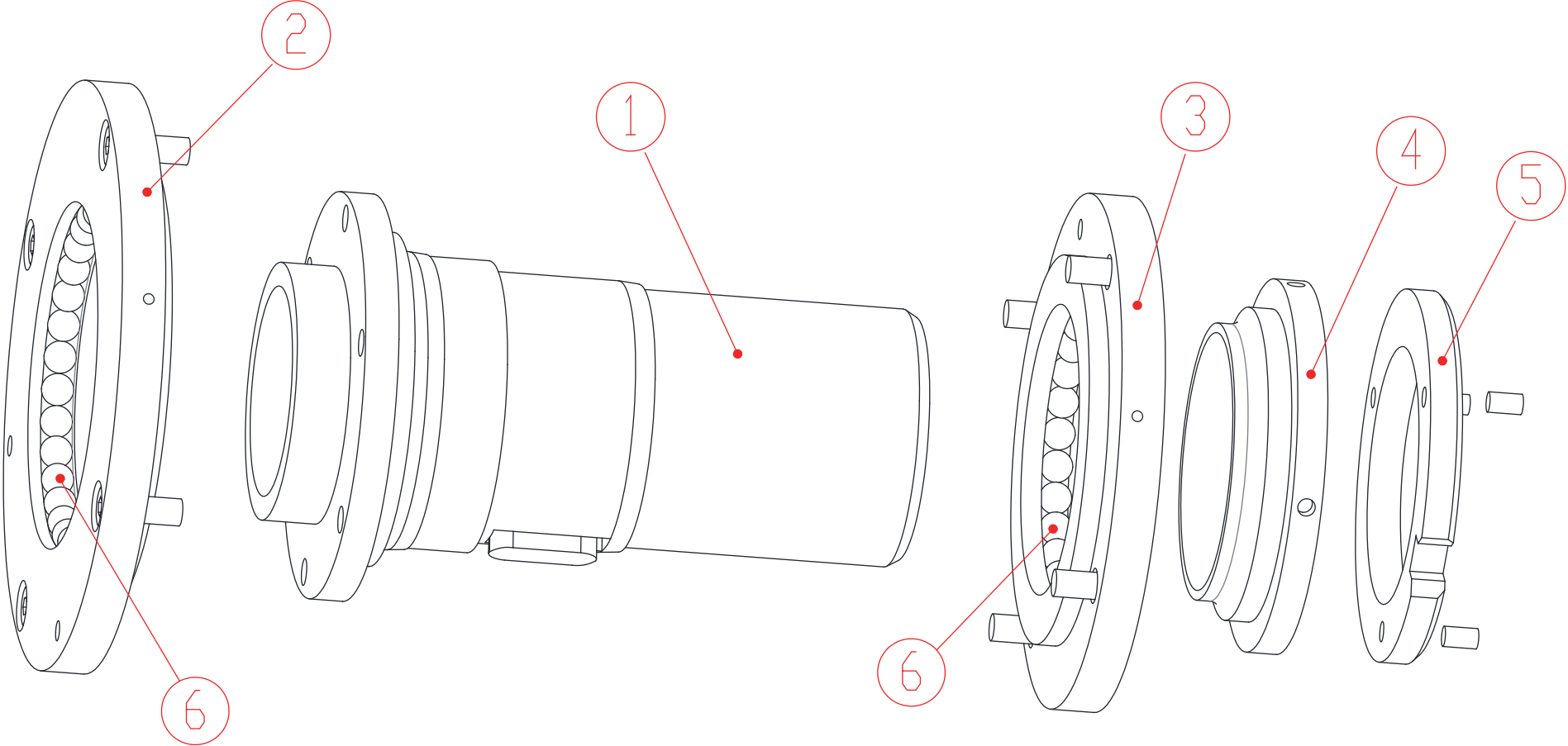




Item	Part No	Part Name	Q'TY
1	P200A1	Table case group	1
2	P200A2	Welding ground	1
3	P2002	Motor cover	1
4	P2001	Table shelf	1
5	P1006	Angle fixed screw	2
6		W5/16"handle	2
7	P1008-4	202Copper seat cover	1



Item	Part No	Part Name	Q'TY
1	P1004	Table case	1
2	P1003	Table	1
3	P100A1-1	Table axis group	1
4	P2003	Axis gear	1
5	P1010	Switch seat	1
6	TM1308	Fixed position switch	1
7	P2004	Drive gear	1
8	P1012	Motor flange	1
9	5GN	Reducing gear box	1
10		DC motor	1
11	P1004-1	Table case cover	1



Item	Part No	Part Name	Q'TY
1	P1001-1	Table axis	1
2	P1001-2	Front bearing case	1
3	P1001-3	Axial end bearing case	1
4	P1001-4	End cover	1
5	P1001-5	Lock ring	1
6	OD-3	Steel ball 3/8"	80

