

IMPORTANT: Read these instructions before installing,
operating, or servicing this product.

WELDING POSITIONER

OWNER'S MANUAL



INTRODUCTION



WARNING: A procedure, which, if not properly followed, may cause injury to the operator or others in the operating area.

Equipment Identification

The identification number specification or model, and serial number of this unit usually appears on a nameplate attached to the control panel, record these numbers for future reference.

Receipt of Equipment

When you receive the equipment, check it against the shipping documents, Make sure it is complete and inspect the equipment for possible damage during shipping, if there is any damage, notify the carrier immediately to file a claim.

Furnish complete information concerning damage claims or mistake(s) in shipment to our company Include the equipment identification number along with a description of the parts in question.

Move the equipment to the installation site before uncrating the unit. Use care to avoid damaging the equipment when using bars, hammers, etc. to uncrate the unit.



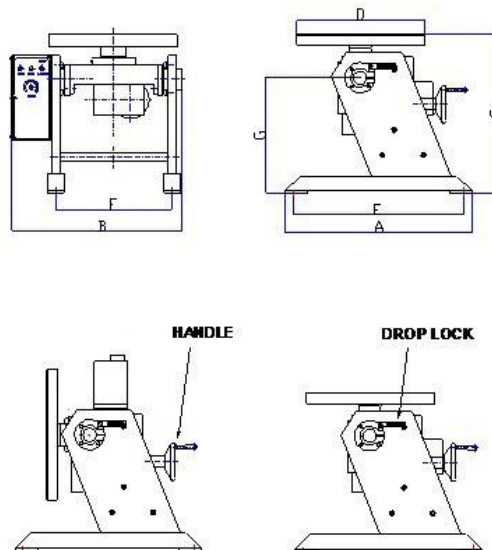
SPECIFICATION

No	MODEL	UNIT	HD-30	HD-50	HD-100	HD-200	HD-300
1	Power input	/	AC110V 50Hz	AC220V 50Hz	AC220V 50Hz	AC220V 50Hz	AC220V 50Hz
2	Horizontal loading capacity	Kg	30	50	100	100	300
3	Vertical loading capacity	Kg	15	25	50	50	150
4	Working table diameter	mm	310	310	400	400	500
5	Working table height	mm	380	380	520	520	650
6	Working table tilting angle	°	0-90	0-90	0-90	0-90	0-90
7	Working table rotation speed	r/min	1-15	0.5-7	0.5-7	0.5-7	0.2-2.5
8	Rotation motor	W	80	120	120	120	200
9	Overall length(A)	mm	380	380	490	490	680
10	Overall width(B)	mm	380	380	530	530	660
11	Overall height(C)	mm	380	380	520	520	650
12	Cable terminal	/	30-50mm ²	30-50mm ²	30-50mm ²	30-50mm ²	30-50mm ²
13	Table Centre Through Hole Dia	mm	25	25	45/75/140	45/75/140	90



14	Net weight	Kg	35	35	70	78	102
15	Applicable chuck	/	KD/80- 200	KD/80- 200	KD-200/3 00	KD-200/ 300	KD-300/4 00

DEMENSIONS

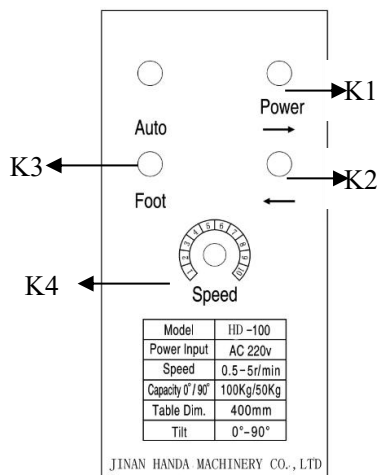


NOTE:

- 1 、 HD-50: E=340mm F=320 mm
- 2 、 HD-100: E=480mm F=400mm
- 3 、 HD-200: E=480mm F=400mm
- 4 、 HD-300: E=590mm F=475mm
- 5 、 LUBE HOLE: Pour lubricating oil per week.
- 6 、 DROP LOCK: Holding locking screw tightly when choose working table angle.



CONTROL PANEL



FRONT PANEL:

K1: POWER ON/OFF SWITCH

K2: FORWARD/REVERSE SWITCH

K3: POWER PILOT

K4: SPEED ADJUSTMENT

TROUBLE SHOOTING GUIDE

NO.	SYMPTOM	POSSIBLE CAUSE	REMEDY
1	Power pilot does not lit	1. Power fuse is burnt. 2. LED burnt. 3. Power switch is burnt. 4. No power input.	1. Replace a new fuse. 2. Replace LED. 3. Replace switch. 4. Check the switch or replace.
2	Speed Adjustment no Motion.	1. Damaged potentiometer. 2. Motor control PCB no output.	1. Check if potentiometer is 10KΩ, otherwise replace. 2. Replace a new motor control PCB.
3	Foot switch no motion	Foot switch is damaged.	Check the foot switch or replace.

4	Forward/Reverse no output	Forward/Reverse switch is damaged.	Check the switch or replace.
5	Motor no motion	1. Motor has power input but no motion. 2. Motor control PCB has no power input 3. Motor control PCB is damaged.	1. Replace a new motor. 2. Check the transformer or replace. 3. Replace control PCB.

ILLUSTRATION OF THE CONTROL PCB ADJUSTMENT

1、 Attention when choose the switches of input and output voltage (115V/230V) , disconnect the power timely when doing the switch.

2 、 ACCEL is time accelerateing adjustable potentiometer

When the output voltage is 0-90VDC, from 0.5 seconds to 11 seconds can be adjustable;

When the output voltage is 0-180VDC, from 0.5 seconds to 22 seconds can be adjustable.

3、 DECEL is decelerating adjustable potentiometer.

When the output voltage is 0-90 VDC, the longest time is 13 seconds; When the output voltage is 0-180VDC, the longest time is 25 seconds.

4、 MAX SPD is maximal speed adjustable potentionmeter;

Twist it to the end clockwise to set the maximum speed.

5、 MIN SPD is minimum speed adjustable potentionmeter;

Twist it to the end clockwise to set the zero speed anticlockwise.

6、 INHIBIT is external enable control side,

When this function works,the speed of motor is set by MIN SPD.

7、 TORQUE、 IRCOMP are torque and laden adjustable potentiometer.



CONTROL SCHEMATIC DIGRAM

