

POSITIONERS

# POSIMATIC PS03

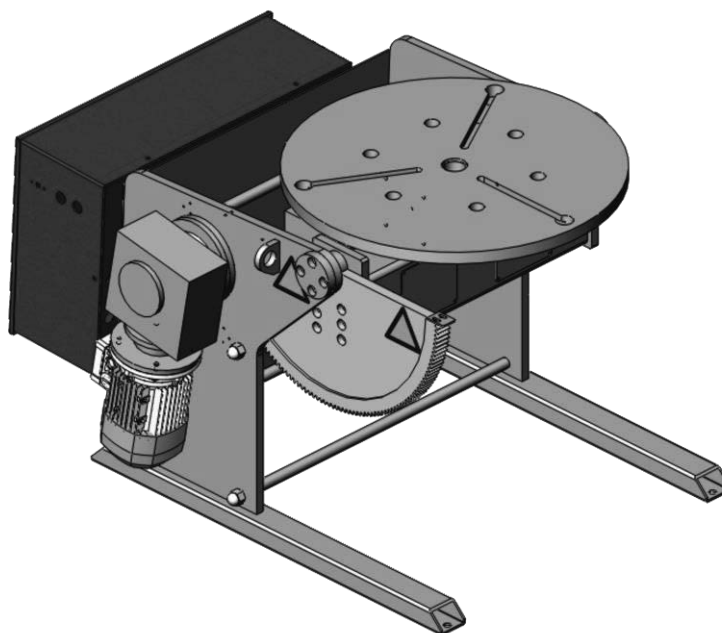
SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE

POSIMATIC PS03

POSIMATIC PS03 PLASMA

W000385391

95032101NG



EDITION : EN  
REVISION : C  
DATE : 11-2018

Instructions for use

REF : **8695 6642**

*Original instructions*

**LINCOLN**<sup>®</sup>  
**ELECTRIC**

**Thank for the trust you have expressed by purchasing this equipment, which will give you full satisfaction if you follow its instructions for use and maintenance.**

**Its design, component specifications and workmanship comply with applicable European directives.**

**Please refer to the enclosed CE declaration to identify the directives applicable to it.**

**The manufacturer will not be held responsible where items not recommended by themselves are associated with this product.**

**For your safety,there follows a non-restrictive list of recommendations or requirements, many of which appear in the employment code.**

**Finally we would ask you kindly to inform your supplier of any error which you may find in this instruction manual.**

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# INFORMATIONS

## DISPLAYS AND PRESSURE GAUGES

The measuring devices or displays for voltage, current, speed, pressure, etc., whether analog or digital, should be considered as indicators

For operating instructions, adjustments, troubleshooting and spare parts see safety instructions for use and maintenance.

## REVISIONS

### REVISION B

11/17

DESIGNATION	PAGE
Update	E-18 ; D-17

### REVISION C

11/18

DESIGNATION	PAGE
To change logos	

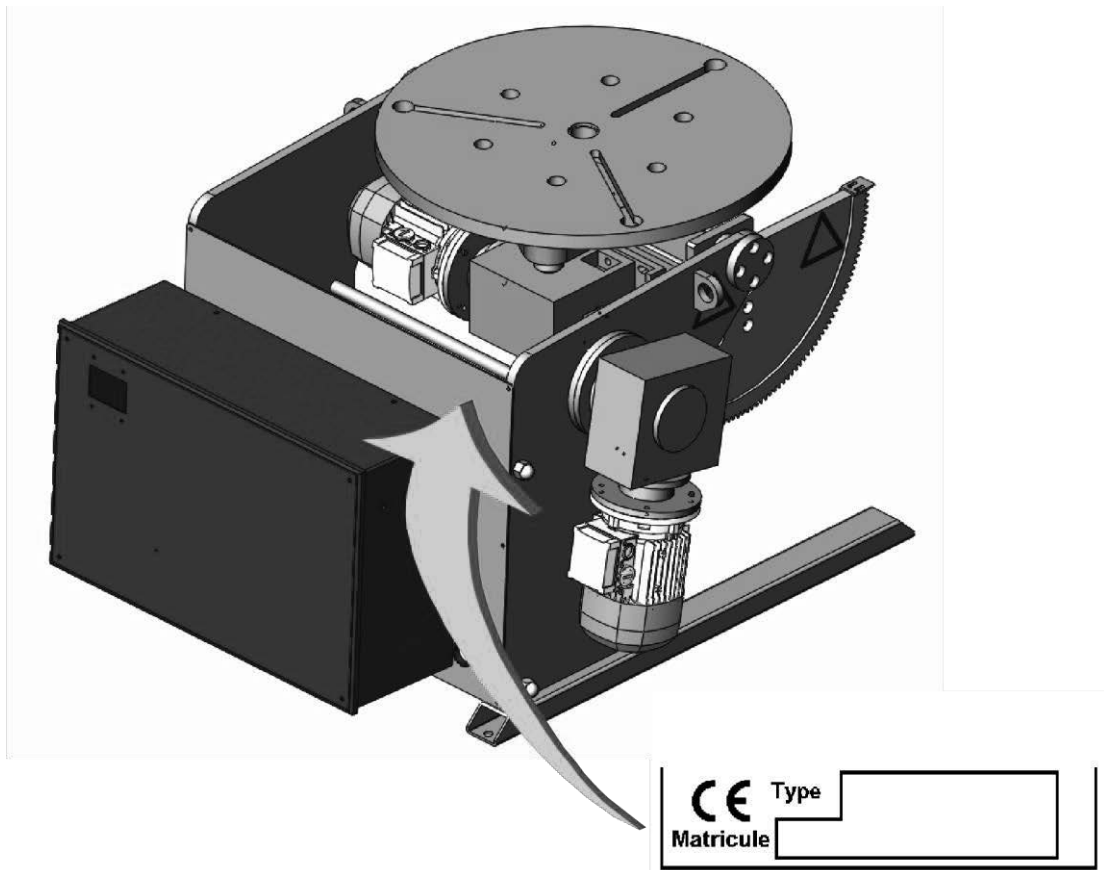
# A - IDENTIFICATION

Please enter the number of your machine in the following box.

Quote this information in all correspondence.

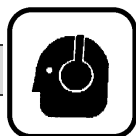
			0000	← 4
<b>CE</b> Type		000000000000 ← 5		
Matricule		0036X000000		
		1	2	3

1	Manufacturing factory code	4	Year manufactured
2	Manufacturing year code	5	Product type
3	Product serial no.		



# B - SAFETY INSTRUCTIONS

For general safety instructions, please refer to the specific manual supplied with the equipment.



## 1 - AIRBORNE NOISE

Please refer to the specific manual « 8695 7051 » supplied with the equipment.

## 2 - SPECIFIC SAFETY INSTRUCTIONS



We recommend a concrete floor for the machine to be satisfactorily stable.  
If necessary level the machine and it should be anchored to the floor through the holes provided for that purpose in the frames.



Before using the machine, make sure that all the guards are in place. All guard covers must be screwed in.  
Only authorised personnel may access electrical cabinets, which must have locking systems.



Check the state of the electrical cables (supply and controls).



Try the movements without load and check the good functioning of safety equipment and devices, particularly limit-switches.



Do not exceed the tilting and rotating torques which determine the maximum admissible load (see diagrams on the equipment).



Do not let loads fall hard on the equipment.



Fully tighten the workpiece(s) on the positioner table.



Ensure that the equipment's working cannot be jammed by tools and/or objects left near moving parts, or by rotating pieces which could hit fixed parts (ground, stands, posts, workshop frames, etc.).  
*Imperative:* an operator corridor must be clear over a minimum width of 800 mm according to safety standard NF EN 547-1 -3.



**Never use the positioner table as a sheet metal working table or heat the workpiece without taking basic precautions.**



**If the equipment is used for welding, make sure that the ground of the power source is connected to the piece before you start welding.**



**Never modify the machine.** The positioner **is not** designed for anchoring or lifting equipment



The use of Personal Protective Equipment (PPE) is **mandatory**.



Clean the working area from time to time.



Machine **maintenance** must be carried out **with all the energy supplies switched off**. The disconnection and padlocking of all energy sources is **mandatory**.

### 3 - IMPORTANT RECOMMENDATIONS



When starting-up or when changing a connection, there is one chance in two that the connection of phases will be inverted, in which case the tilt limit switches become totally ineffective and there are great risks of damage (refer to chapter page D17).

# C - DESCRIPTION

## 1 - DESCRIPTION

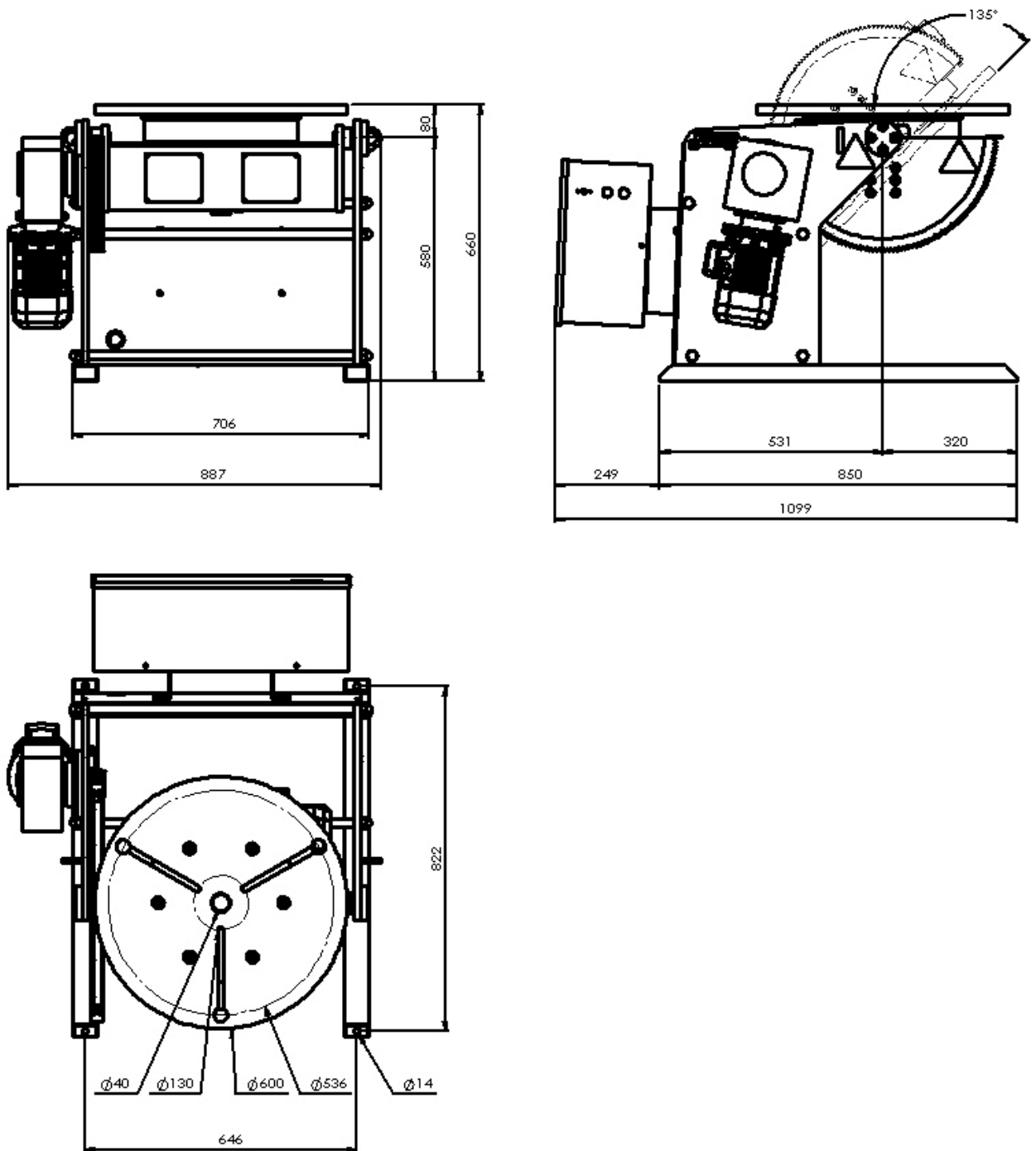
- **POSIMATIC** is a device which enables parts with varied shapes to be positioned in order to optimize operations such as welding, oxycutting, resurfacing, metallization, etc. by presenting the working line in the best position.

### a) Main characteristics

	POSIMATIC PS03	POSIMATIC PS03 PLASMA
All positions load (Kg)	300	300
Maximum tilt torque (m.kg)	100	100
Time for 135° (s)	31	31
Table tilt angle (°)	135	135
Tilt axis/plate distance (mm)	80	80
Minimum rotation speed (in rpm)	0.2	0.1
Maximum rotation speed (in rpm)	3.0	3.0
Accuracy (%)	5	1
Plate diameter (mm)	600	600
total weight of the machine (Kg)	350	350
Power (KVA)	1.5	1.5
Maximum absorbed current (A)	2.2	2.2
Welding ground connection (A at 100%)	500	500



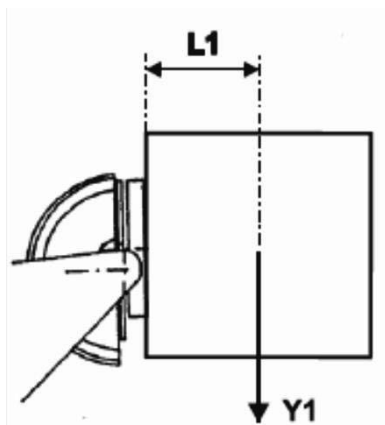
## b) Dimensions and space requirements



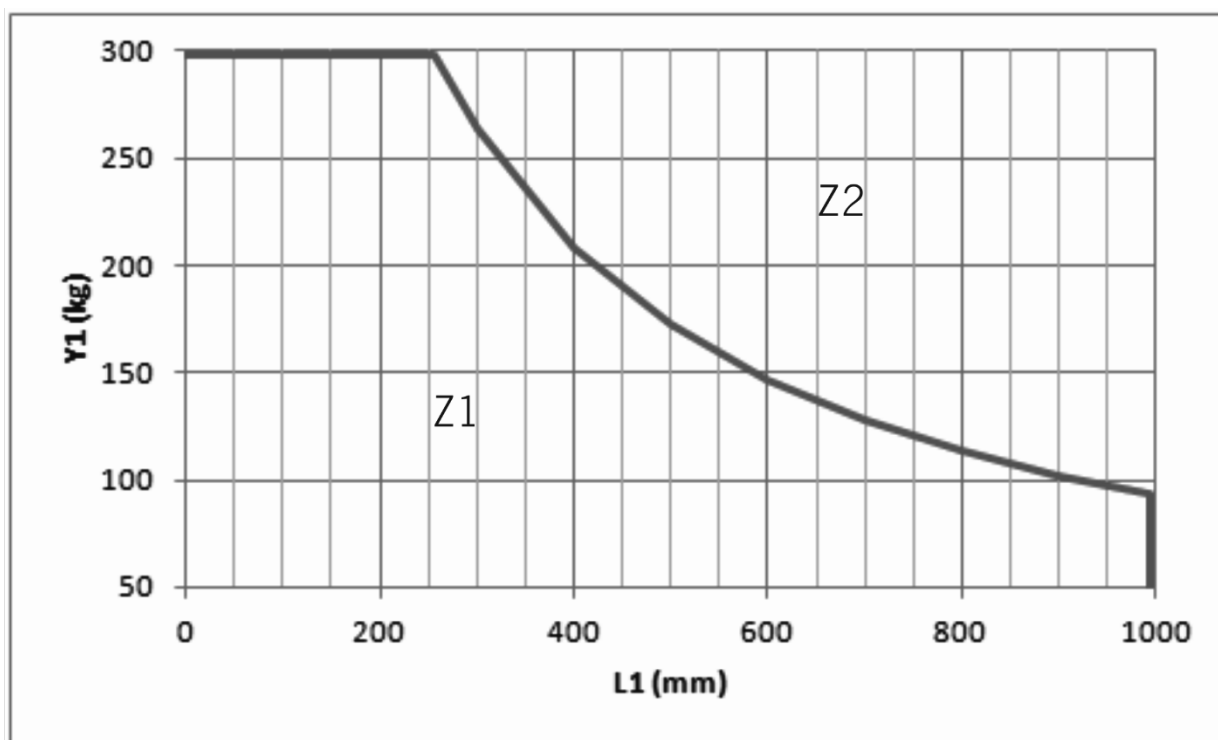
**POSIMATIC PS03**

**c) Diagram of the tilting torque**

Admissible load in daN (**Y1**) in relation to the distance in mm (**L1**) of the part centre of gravity in relation to the surface of the plate.



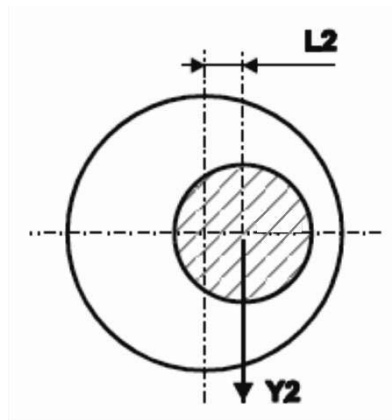
$$Y1 = \frac{100000}{L1 + 80}$$



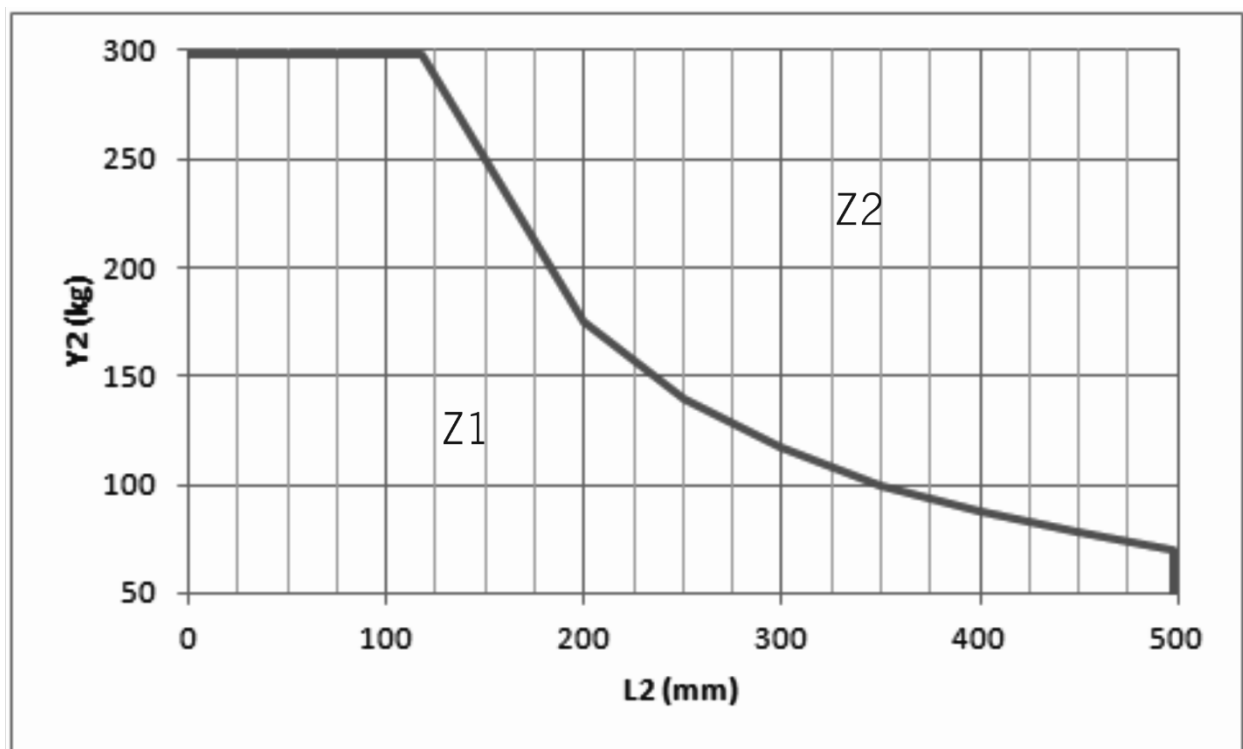
- Z1** Authorized area
- Z2** Prohibited area (vertical plate)
- Y1** Load in daN
- L1** Distance / plate in mm

#### d) Diagram of the rotating torque

Admissible load in daN (**Y2**) in relation to the distance in mm (**L2**) between the centre of gravity and the rotation axis.



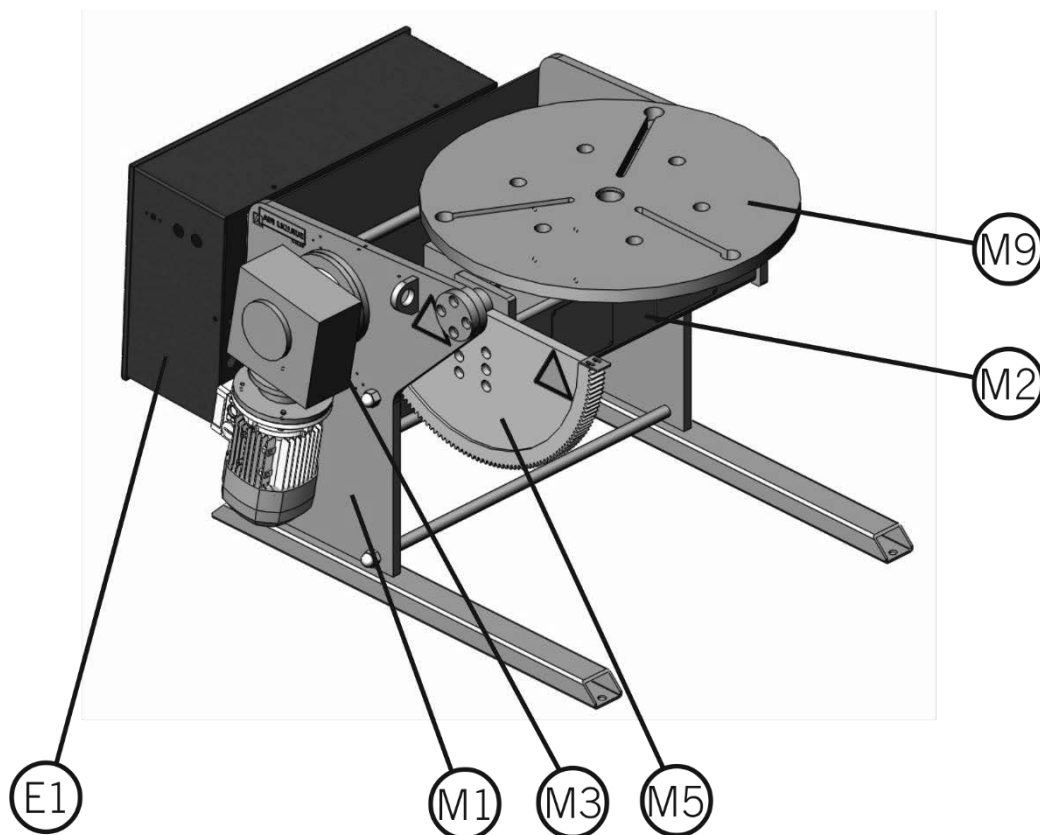
$$Y2 = \frac{35000}{L2}$$



- Z1** Authorized area
- Z2** Prohibited area (vertical plate)
- Y2** Load in daN
- L2** Distance / plate in mm

## 2 - DETAILED DESCRIPTION

### a) General appearance



<b>M1</b>	Frame	<b>M5</b>	Cogged quadrant
<b>M2</b>	Tilting frame	<b>M9</b>	Plate
<b>M3</b>	Gearbox	<b>E1</b>	Electrical cabinet

The **POSIMATIC** mainly comprises a frame (**M1**) in which the tilting mechanical (**M2**) components are mounted. It supports the rotating plate (**M9**).

The frame (**M1**) supports also :

- The tilting gearbox (**M3**).
- The electrical cabinet (**E1**).

The tilting frame (**M2**) supports :

- The cogged quadrant (**M5**).
- The rotating plate (**M9**) the cogged ring (**M8**).
- The rotating gearbox (**M6**).

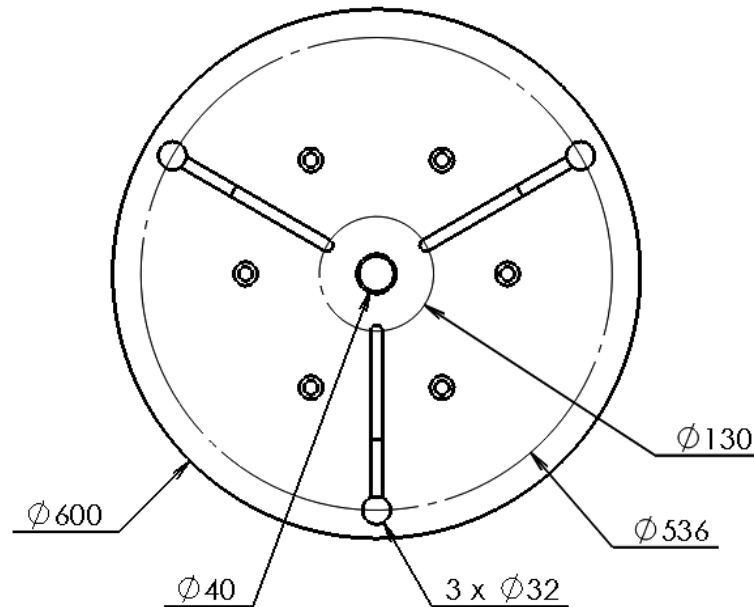
A control box (**E2**) connected by means of a multi conductor cable is used for tilting and rotation movement remote control.

### **b) The plate (M9)**

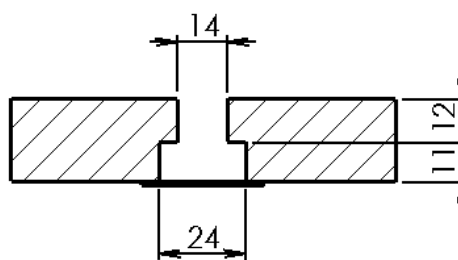
The work table or plate (**M9**) made of heavy plate provides easy attachment of parts to be welded.

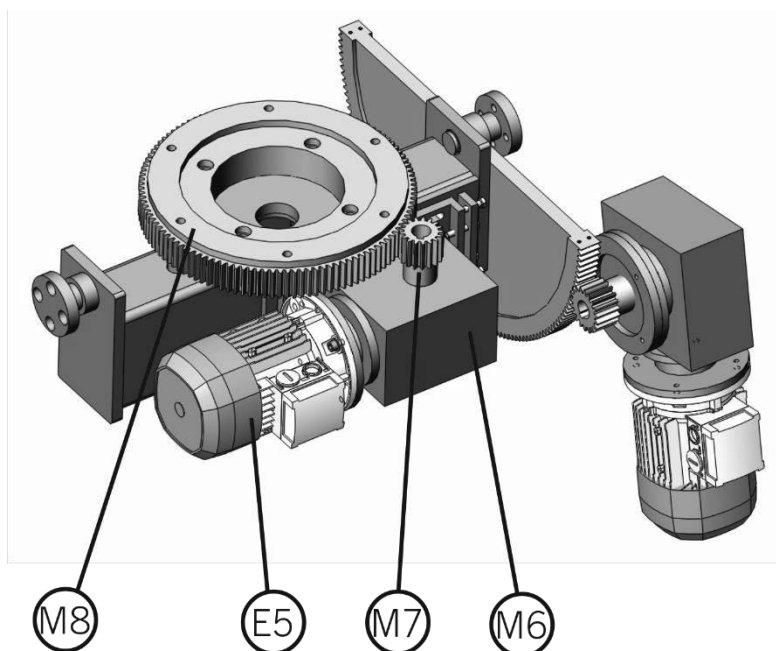
Grooves are provided to accommodate bolts in such a manner that bolts cannot be accidentally removed from the slots.

The central hole  $\varnothing 40$  is extended by a tube that runs through the tilting frame (**M2**). It allows the gas supply for welding applications for example.



Dimensions of grooves

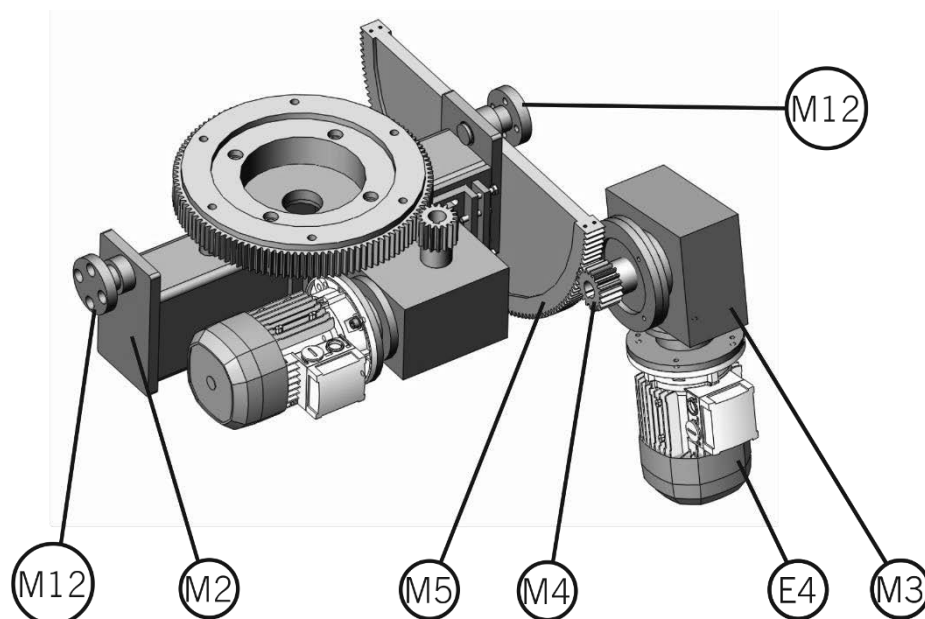


**c) Rotation components**

- E5** Motor
- M6** Gearbox
- M7** Drive gear
- M8** Cogged ring

A wheel and worm reduction gear (**E5-M6**) transmits the rotation movement to the cogged ring (**M8**) through the drive gear (**M7**).

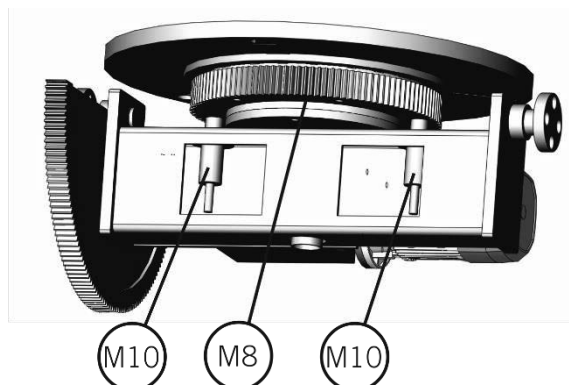
Speed control is made via a potentiometer fixed on the pushbutton box. A graduated dial shows speed setting.

**d) Tilting components**

- E4** Motor
- M2** Tilting frame
- M3** Gearbox
- M4** Drive gear
- M5** Cogged quadrant
- M12** Trunnions

A wheel and worm reduction gear (**E4-M3**) transmits the rotation movement to the cogged quadrant (**M5**) through the drive gear (**M4**).

The box (**M2**) is hinged on two horizontal trunnions (**M12**) mounted in bushes housed in the frame (**M1**) and accommodates the fixed part of the positioning ring (**M8**).

**e) Welding ground connection**

**M8** Cogged ring

**M10** Welding ground connection

**POSIMATIC PS03** is fitted with two ground connectors (**M10**). They are made up of an assembly with two brushes pushed by springs that rub against the cogged ring (**M8**).

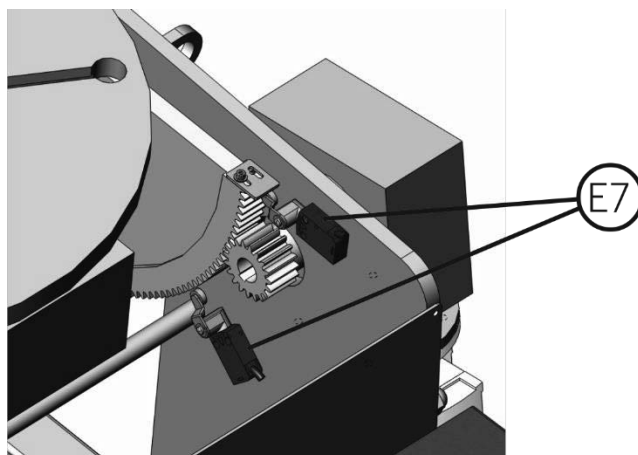
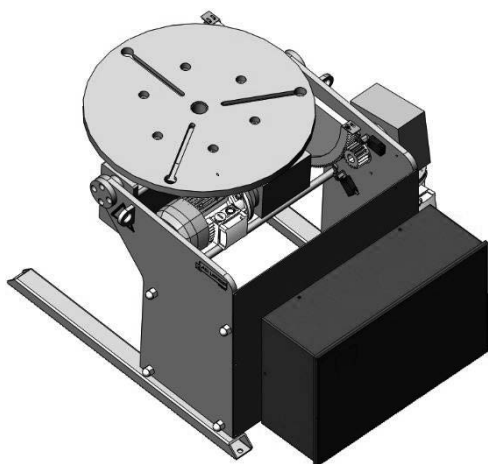
The capacity of this welding ground connection (500A for a 100% duty factor) is such that it enables nearly all welding processes to be used, except that under conducting flux which requires higher current.

In order to avoid overheating of the ground connection, it is advised that welding cables be connected with a section compatible of course with the current conveyed and the duty factor.

**This ground connection must be made to avoid deteriorating the ball bearings of the positioner.**

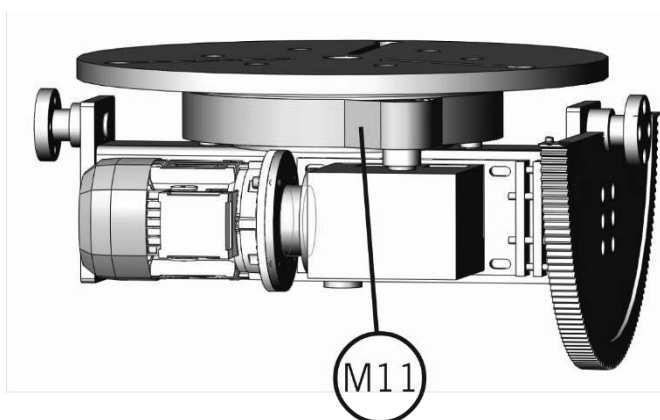


### **f) Safety systems**



**E7** Tilting limit switch

Two limit switches (**E7**) switch off motor power supply when the mobile sub-assembly reaches the extreme position (0° and 135°).



**M11** Tothing protective

A tothing protective (**M11**) keeps the operator safe by eliminating the risks from the rotating mechanism (**M8** and **M7**) .

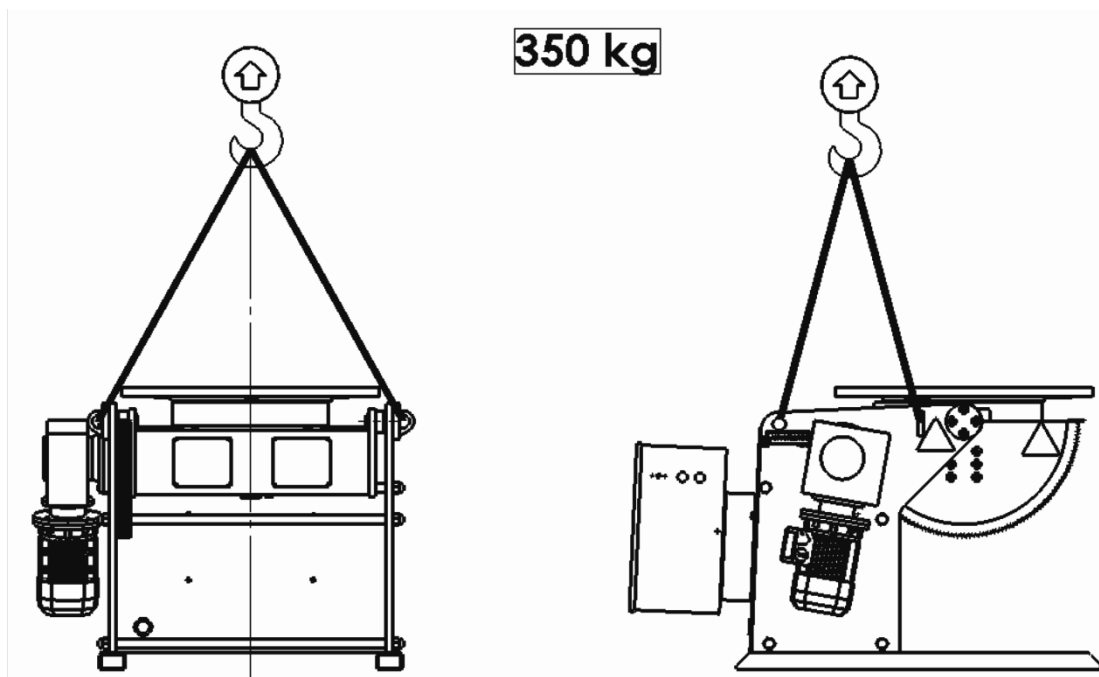
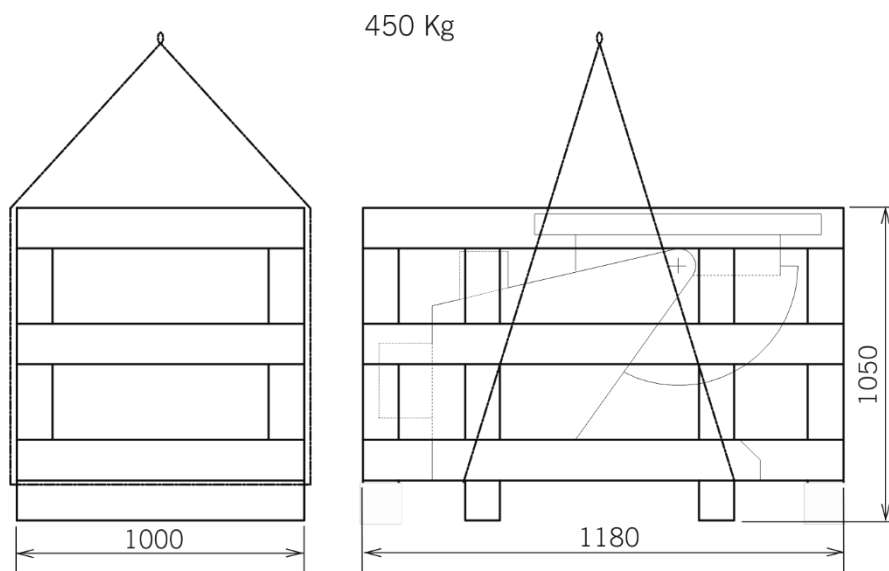
# D - ASSEMBLY - INSTALLATION

## 1 - HANDLING THE POSIMATIC

- Sling the **POSIMATIC** in its wooden packaging as indicated in the drawing.
- Unpack the **POSIMATIC** from its delivery packaging.
- Sling the **POSIMATIC**, always using the slinging eyes which are provided for moving.



**Operator protection :**  
**Helmet - Gloves -**  
**Safety shoes**



## 2 - PUTTING IN PLACE

The positioner must be placed on a plane floor and strong enough.

Wedge the feet if necessary.

Ensure that the equipment's working cannot be jammed by tools and/or objects left near moving parts, or by rotating pieces which could hit fixed parts (ground, stands, posts, workshop frames, etc.).

Imperative: an operator corridor must be clear over a minimum width of 800 mm according to safety standard NF EN 547-1 -3.

## 3 - FIXING THE POSIMATIC

This machine must imperatively be anchored to the floor with four anchoring points in a 20 Mpa (350 kg/m<sup>3</sup>) single continuous concrete screed with metal reinforcement, completed since at least 21 days (standard BAEL 91).

### EQUIPMENT RECOMMENDED FOR FASTENING POSIMATIC:

Brand	Type chevilles	Référence	Ø de perçage (mm)	Charge admissible (daN)
SPIT	Metal	050590 FIX 10/25	Ø 10	345 à/to/bis 560
	Chemical	051510 CAPSULE MAXIMA M10 050960 TIGES MAXIMA M10X130	Ø 12	700

## 4 - ELECTRICAL CONNECTIONS

The **POSIMATIC** is connected electrically to the network by means of the five-metre cable located at the rear of the supply cabinet.

The cable, which has four conductors, is to be connected to a standardised 3 x 400 V / 50-60Hz system with equipotential bonding.



### **VERY IMPORTANT**

For compliance with European safety standards, the connection to the electricity supply is to be made via a wall-mounted cabinet with an individual protective sectioning switch with rating appropriate for the mains voltage and the consumption by the equipment

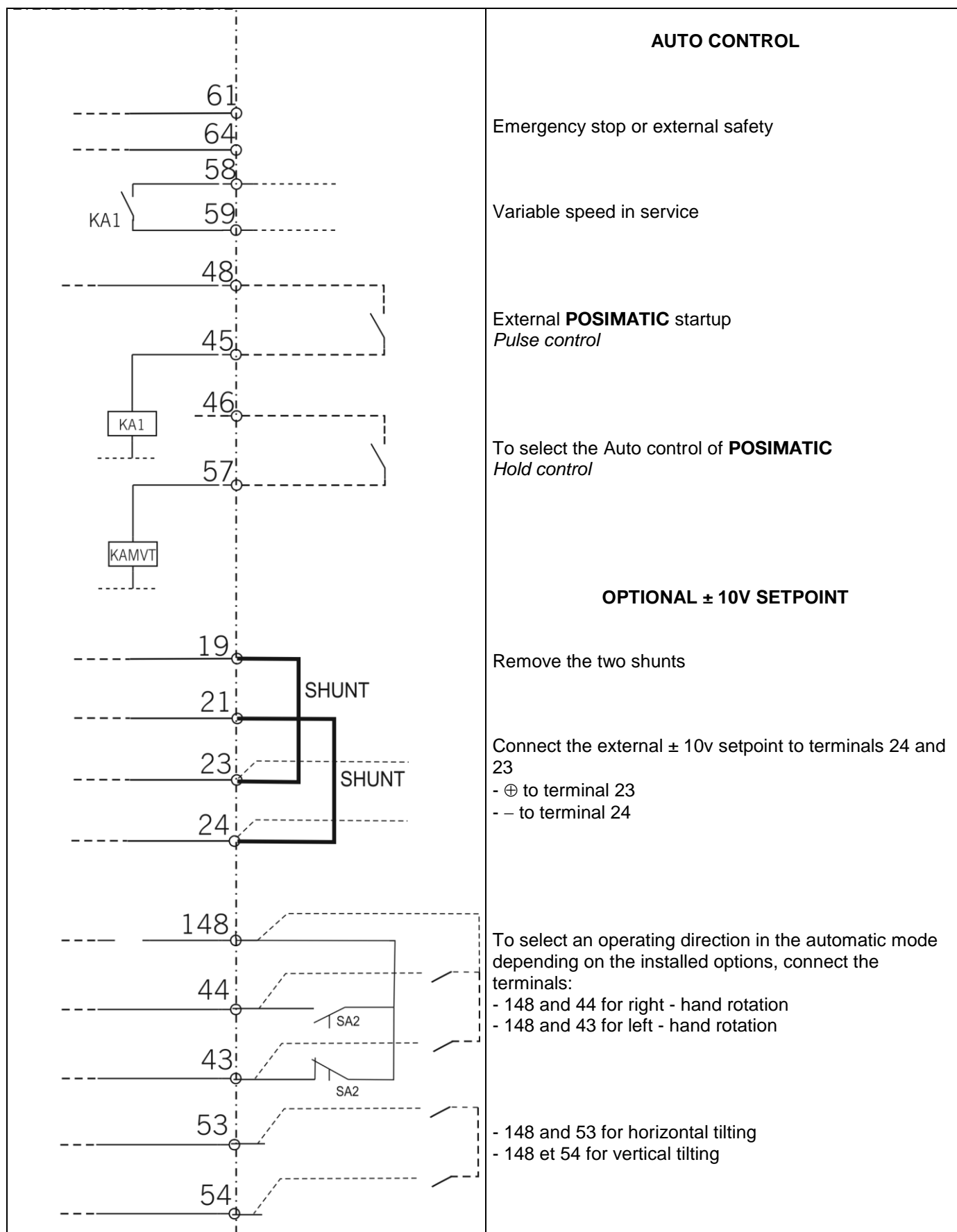
The protective sectioning switch must offer breaking capacity of 100KA.

We market cabinets that meet the criteria set out.

### ARRANGEMENT OF CABLES AND FLEXIBLE HOSES

The customer must provide a means to support and protect cables and flexible hoses from mechanical, chemical or thermal damage, right from their point of origin.

## EXTERNAL CONNECTION FOR THE DIFFERENT OPTIONS



## 5 - INSTALLATION

### a) Checking after transport

The positioner is delivered ready for operation.

However, certain preliminary steps should be taken before starting-up:

- make sure that no visible element has been damaged during transport,
- check that the main elements are properly tightened; transport may have loosened them, especially tilt limit switches,
- check that electrical connections are correct.

### b) Checking phase direction

- check that the electrical connections are correct,
- press the plate lowering button « **C5** »

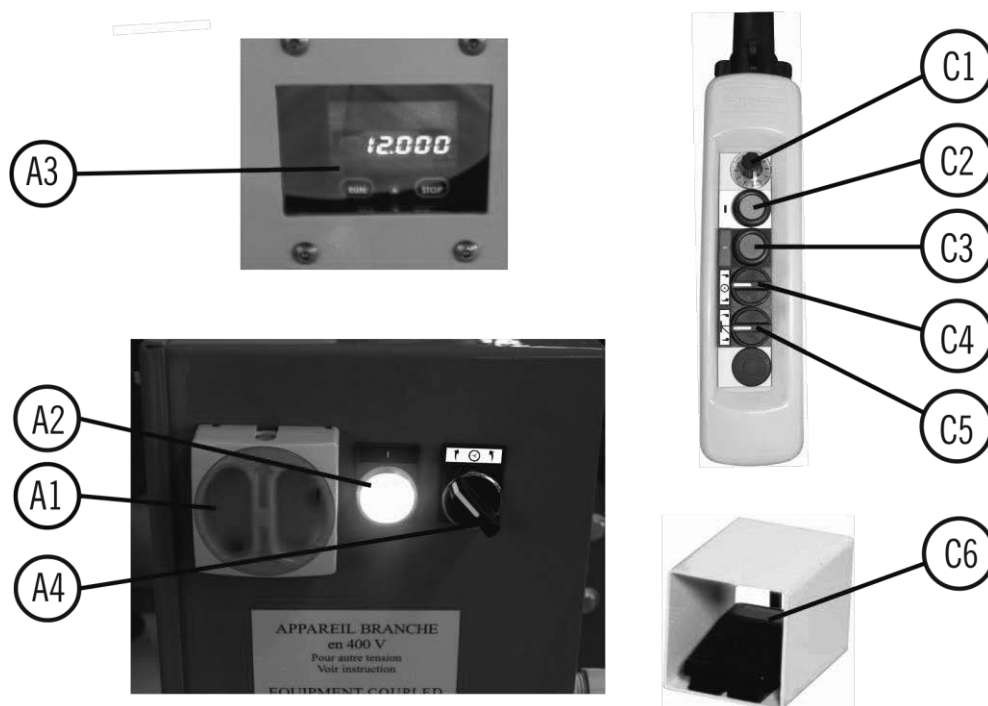


- the plate lowers: the phases are connected properly
- the plate rises: invert two phases at the connection of the mains supply

When these tests are conclusive, the positioner is ready for starting-up. Repeat these checks each time the positioner is moved.

# E - OPERATOR MANUAL

## 1 - CONTROL BUTTONS ON CABINET



Rep		Description
	A1	Main power button.
	A2	Power on indicator
	A3	Power on indicator
	A4	Rotation direction with automatic starting up
	C1	Rotation speed adjustment potentiometer
	C2	Power <b>on</b> pushbutton (variable drive)
	C3	Power <b>off</b> pushbutton (variable drive)
	C4	Switch with three fixed positions for rotation direction. The central position is the idle position.
	C5	Switch with three fixed positions for tiling direction. The central position is the idle position.
	C6	Pedal to allow the rotation movement of the plate.



# F - MAINTENANCE

## 1 - SERVICING

- For the machine to continue to provide good service for as long as possible, a certain minimum of care and maintenance is necessary.



Before working on the machine, it is **MANDATORY** to lock out all the supplies of utilities to the machine (electricity, air, gas etc.).  
Locking an emergency stop button is not sufficient.

### LUBRICATION

The reducing gear of **POSIMATIC** are lubricated with oil. They are provided with level control windows, filling plugs and drain plugs.

This reduction gears can operate at an ambient temperature from 0°C to +40°C.

The bearing of the positioning ring is lubricated with grease.

External cogging is lubricated with grease.

### CONTROL AND SAFETY




All the instructions in this manual must be followed closely, particularly those relating to the limits of use.

Further, the main parts of the equipment, particularly the coggings, the screws and nuts, power cables of motors and remote control, motor ventilation etc., must be inspected periodically.




After a long time of unusing the positioner, all the periodical controls should be done before restarting.




**First servicing****80h or 1 month**

Parts	Operations		Lubrication
<b>Positioning ring (cogging)</b>		1) Unmount the plate. 2) Clean the cogging, especially the bottom of the teeth. 3) Grease the cogging with a brush.	<b>Grease HPG 400</b>
<b>Positioning ring (bearing)</b>		Grease the bearing with the help of greasers accessible when plate is unmounted.	<b>Esso beacon 2</b>
<b>Gearboxes</b>		Drain the gearboxes and fill them with new oil	<b>Oil HAFA SYNTEC 220</b>

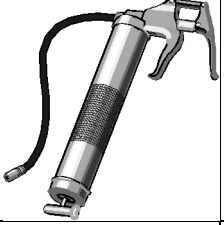
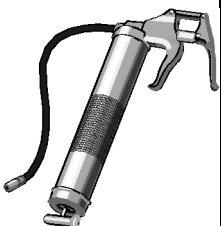
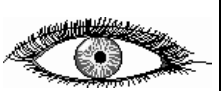


**Periodical servicing and controls****WEEKLY**

Parts	Operations		Lubrication
<b>PLATE</b>		<p>Check the tightening of the plate fixation screws.</p>  <p>If an abnormality is detected (loose screw), it is advised to unmount completely the plate and also check the tightening of the screws that hold the positioning ring on the box.</p>	
<b>WELDING GROUND CONNECTION</b>		Check the condition of the contact surfaces	

**EVERY 2 WEEKS**

Parts	Operations		Lubrication
<b>GEARS</b>		<ol style="list-style-type: none"> <li>1) Check the condition of the teeth of the cogged sector of the tilting mechanism</li> <li>2) Grease the cogging of the positioning ring</li> </ol>	<b>Grease HPG 400</b>

## EVERY 6 MONTHS

Parts	Operations		Lubrication
<b>GEARBOXES</b>		Drain the gearboxes and fill them with new oil	<b>Oil HAFA SYNTEC 220</b>
<b>Positioning ring (bearing)</b>		Grease the bearing with the help of greasers accessible when plate is unmounted.	<b>Esso beacon 2</b>
<b>Positioning ring (cogging)</b>		Check the condition of the teeth of the ring and his pinion gear.	
<b>Tilting cogged sector</b>		Check the condition of the teeth of the cogged sector of the tilting mechanism and his pinion gear .	
<b>Tilting bushes</b>		Check the wear state.	

## 2 - TROUBLESHOOTING

Possible symptoms	Probables causes	Possible remedies
The positioner indicator goes off after the power is switched on with the switch QS1.	Indicator lamp has blown	Replace the lamp
	Fuses FU1 or FU3 have blown	Replace the fuses on the basis of the fuse rating table.
The plate will not rotate after it is started up.	No rotation direction has been selected.	Select a rotation direction using the switch $\uparrow\downarrow$ .
		With automatic control, the connection is not made between terminals 148 and 44 (right-hand rotation) or 148 and 43 (left-hand rotation) to control the operating direction. Make the connection with a shunt or external contact; see electrical connections.
		When using an external $\pm 10V$ setpoint, check the presence of voltage between terminals 23 and 24 (0V $\rightarrow$ no rotation).
	The motor is not powered	Check and replace the fuses FU2 if needed.
The plate turns for a short time and then stops.	Over-intensity leading to:  - a variable drive fault F0102 or F0103	Check that you have followed the table with the admissible load and unbalance values for your positioner.
		Check that the load has not increased suddenly.
		Check that the terminals U, V and W of the variable drive are not shorted.
		Check that the motor cable is not shorted and that the motor is correctly coupled.

Possible symptoms	Probables causes	Possible remedies									
Tilting will not work.	No tilting direction has been selected.	Select a tilting direction using the switch ↑↓.									
		Check that no limit switch is actuated									
		With automatic control, the connection is not made between terminals 148 and 54 (tilting up) or 148 and 53 (tilting down) to control the operating direction. Make the connection with a shunt or external contact; see electrical connections.									
	The motor is not powered	Check that the thermal relay Q3 has not tripped. Then check that the thermal relay is correctly adjusted according to the table below:									
		<table><tr><td>type:</td><td>03</td><td>08</td><td>15</td><td>30</td></tr><tr><td>Value(A)</td><td>1.05</td><td>1.85</td><td>2.66</td><td>5.20</td></tr></table>	type:	03	08	15	30	Value(A)	1.05	1.85	2.66
type:		03	08	15	30						
Value(A)	1.05	1.85	2.66	5.20							
Tilting runs for a short time then stops.	Over-intensity leading to: - a thermal relay fault	Check the state and adjustment of the thermal relay according to the table above.									
		Check that you have followed the table with the admissible load and unbalance values for your positioner									
		Check that the load has not increased suddenly.									
		Check that the motor cable is not shorted and that the motor is correctly coupled.									

## DEFINITIONS OF ERRORS DISPLAYED ON THE VARIABLE DRIVE

NUMERO NUMBER/NUMMER	DESCRIPTION
<b>F0102,F0103</b>	Variable drive overload. Check the load behaviour. Check the motor parameter adjustments.
<b>F0200...F0300</b>	Temperature too high. Check cooling, flap, sensor and ambient temperature. Temperature low. Check the ambient temperature and the heating of the electrical cabinet.
<b>F0400, F0403</b>	Motor temperature too high or sensor faulty. Check the connection to X12.4. Phase fault. Check the motor and the wiring
<b>F0500...F0507</b>	Overload, short circuit or dispersion in the ground, motor current or phase fault. Check the load behaviour and the gradients (P420...P423). Check the motor and the wiring.
<b>F0700...F0706</b>	DC bus voltage too high or too low. Check the deceleration gradients (P421, P423) and the connected braking resistor. Check the network voltage. Check the network voltage, the fuses and the network circuit.
<b>F0801,F0804</b>	Electrical voltage (24V) too high or too low. Check the wiring of the control terminals
<b>F1100...F1110</b>	Maximum frequency reached. Check the control signals and adjustments. Inspect the deceleration gradients (P421, P423) and the connected braking resistor
<b>F1310</b>	Minimum output current. Check the motor and the wiring.
<b>F1401</b>	Signal of the reference value on the input X12.3 faulty, check the signal.
<b>F1407</b>	Over-intensity at input X12.3, check the signal.
<b>F1408</b>	Over-intensity at input X12.4, check the signal.
<b>A0001...A0004</b>	Variable drive overload. Check the load behaviour. Check the motor and application parameters.
<b>A0008,A0010</b>	Temperature too high. Check cooling, flap and ambient temperature.
<b>A0080</b>	Once the maximum motor temperature is reached, check the motor and sensor.
<b>A0100</b>	Network phase failure, check the main fuses and the power cable
<b>A0400</b>	Once the frequency limit is reached; output frequency limited.
<b>A0800</b>	Input signal at X12.3 too low. Increase the value
<b>A1000</b>	Input signal at X12.4 too low. Increase the value
<b>A4000</b>	The voltage of the DC bus has reached the minimum value

## POSITIONER FUSES RATINGS

	STANDARD POSITIONERS		
	FU1 (5x20)	FU2 (10x38)	FU3 (5x20)
<b>POSIMATIC PS03</b>	1 A FsT	6 A aM	6 A FsF

### 3 - SPARE PARTS

#### How to order

The photos or sketches identify nearly every part in a machine or an installation

The descriptive tables include 3 kinds of items:

- those normally held in stock: ✓
- articles not held in stock: ✕
- those available on request: no marks

(For these, we recommend that you send us a copy of the page with the list of parts duly completed. Please specify in the Order column the number of parts desired and indicate the type and the serial number of your equipment.)

For items noted on the photos or sketches but not in the tables, send a copy of the page concerned, highlighting the particular mark.


For example:

		✓	normally in stock
		✕	not in stock
			on request

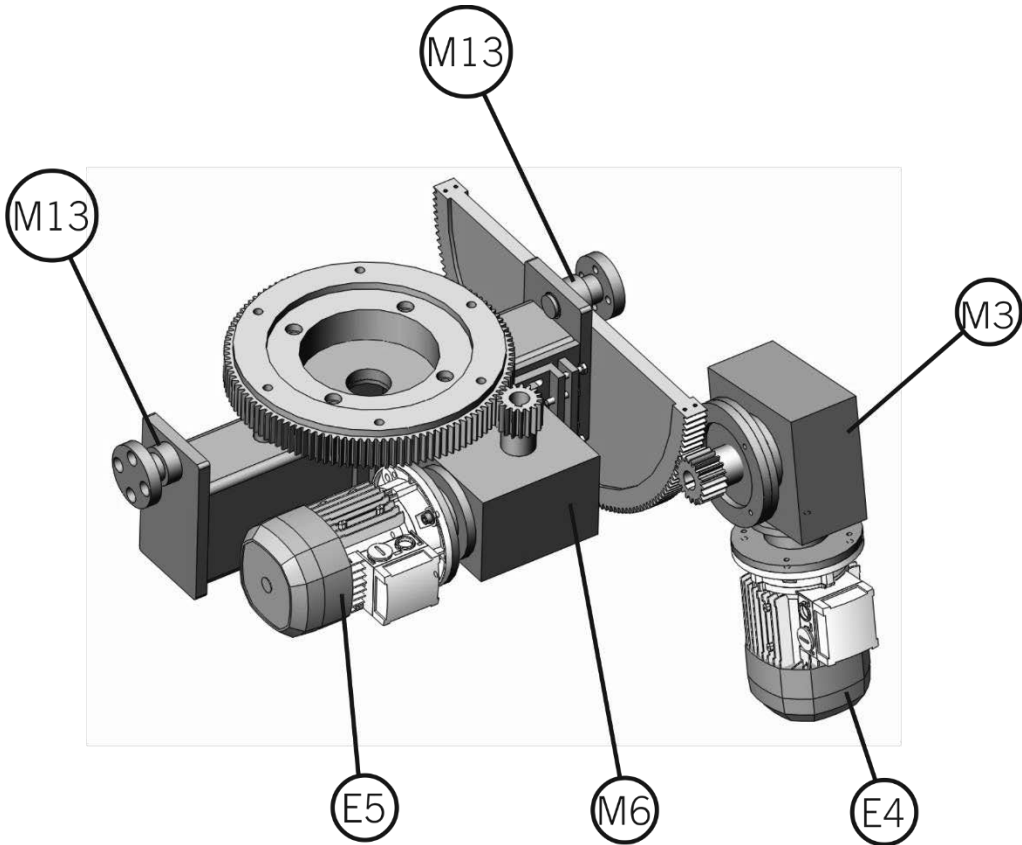
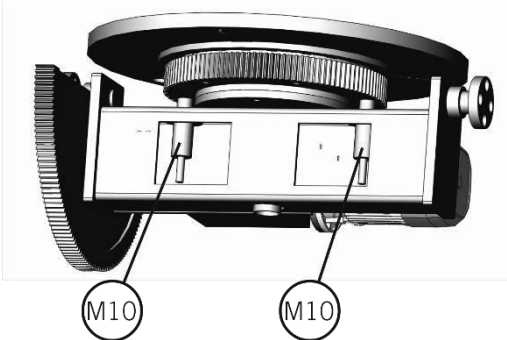
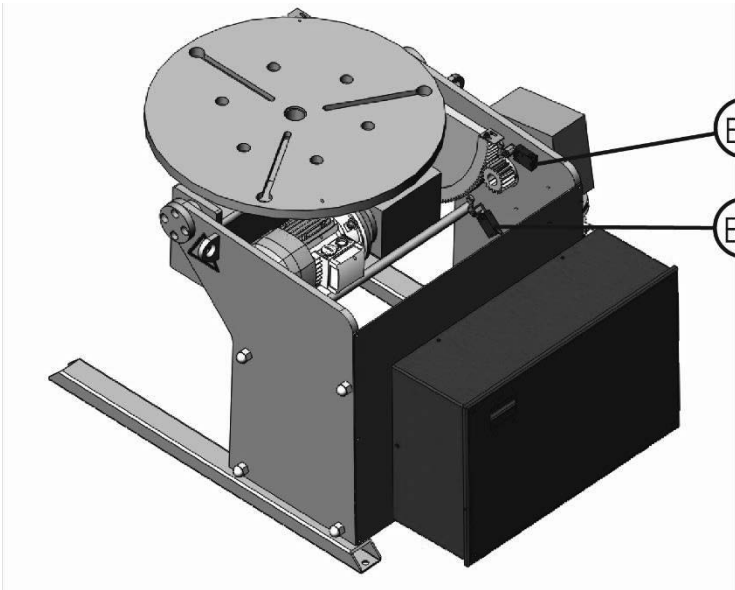
  

Item	Ref.	Stock	Order	Designation
1	W000XXXXXX	✓		Machine interface board
2	W000XXXXXX	✕		Flowmeter
3	9357 XXXX			Silk-screen printed front panel

- For parts order, give the quantity required and put the number of your machine in the box below.

	TYPE :
	Number :

**MECHANICAL PART**





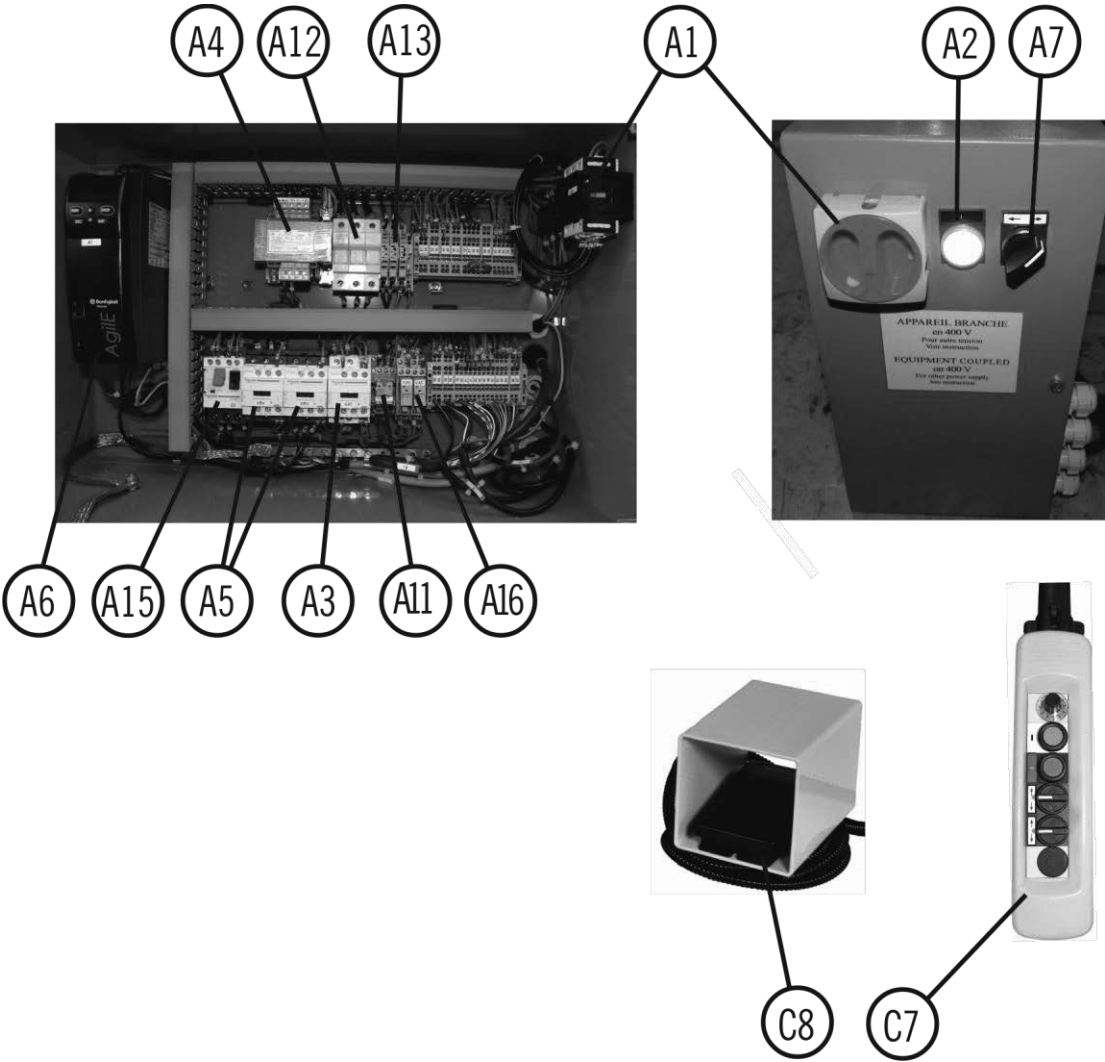
✓	normally in stock
✗	not in stock
	on request

Item	Ref. PS03	Ref. PS03 Plasma	Stock	Order	Designation
E5	W000386978		✓		Motor
E5		.5700274			Motor
		.5700277			Adapter flange
M6	W000386952	W000386952	✓		Gearbox
M10	W000386963	W000386963	✓		Ground connection
E4	W000386978	W000386978	✓		Motor
M3	W000386953	W000386953	✓		Gearbox
M13	W000386970	W000386970	✓		Bush
E7	W000386987	W000386987	✓		Sensor

➤ For parts order, give the quantity required and put the number of your machine in the box below.

CE Type <input type="text"/> Matricule <input type="text"/>	TYPE :
	Number :

**ELECTRICAL PART**



✓	normally in stock
✗	not in stock
	on request

Item	Ref. PS03	Ref. PS03 Plasma	Stock	Order	Designation
A1	W000140748	W000140748	✓		Main switch
A2	W000137799	W000137799	✓		24V BA9S bulb
A2	.570 4057	.570 4057			Indicator body
A2	.570 4054	.570 4054			Power on indicator head
A3	.570 1064	.570 1064			Auxiliary contactor KA1
A4	.570 6078	.570 6078			63VA 220-380/2x24V transformer
A5	.570 1025	.570 1025			Reversing contactor
A6	W000386983		✓		0.55KW AGILE drive for <b>PS03</b>
A6		.570 0209			0.55KW ACU drive for <b>PS03</b> Plasma
		.570 0269			RES02 addon for <b>PS03</b> Plasma
A7	W000366020	W000366020	✗		Two fixed pitch selector head
A7	W000366042	W000366042	✗		Body
A7	W000366044	W000366044	✗		Contact
A11	9109 3173	9109 3173			4 contacts relay
A12	.570 5167	.570 5167			10x38 three-poles cut-off (FU2)
A13	.551 3716	.551 3716			5x20 fuse holder (FU1-FU3)
A13	.551 3727	.551 3727			Accessory - fuse holder 5x20 (FU1-FU3)
A13	.551 3728	.551 3728			Accessory - fuse holder 5x20 (FU1-FU3)
A15	.570 5277 + .570 5342	.570 5277 + .570 5342			Thermal relay
A16	.5606743	.5606743			2 contact relay
C7	9503 2002	9503 2002			Control box with cable
C8	W000273453	W000273453	✓		Pedal

➤ For parts order, give the quantity required and put the number of your machine in the box below

CE Type <input type="text"/> Matricule <input type="text"/>	TYPE :
	Number :

[illegible]