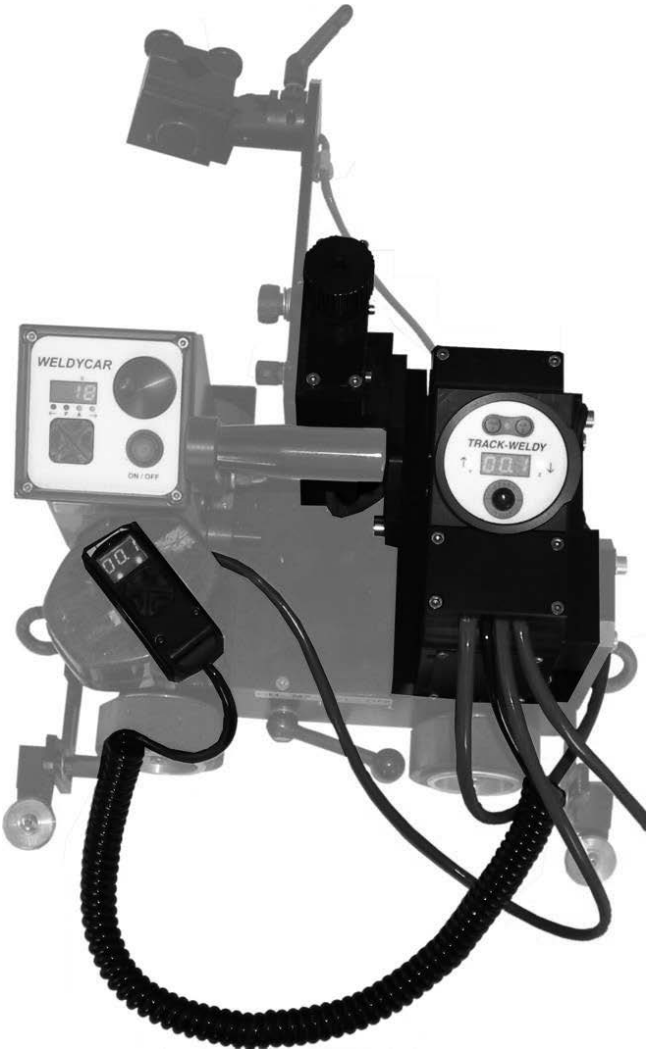
MOTORIZED CROSSED SLIDES FOR WELYCAR

TRACK-WELDY

SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE



EDITION: EN
REVISION: B
DATE: 10-2020

Instructions for use

REF: **8695 5873**

Original instructions

LINCOLN® 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.

CONTENTS

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

REVISIONS

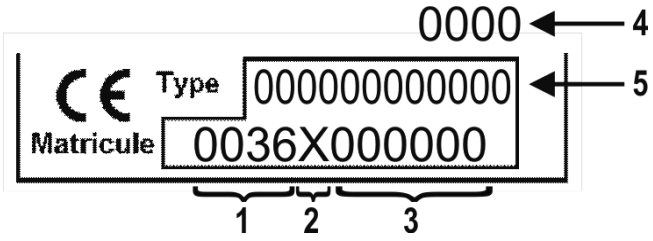
REVISION B **10/20**

DESIGNATION	PAGE
To change logos	

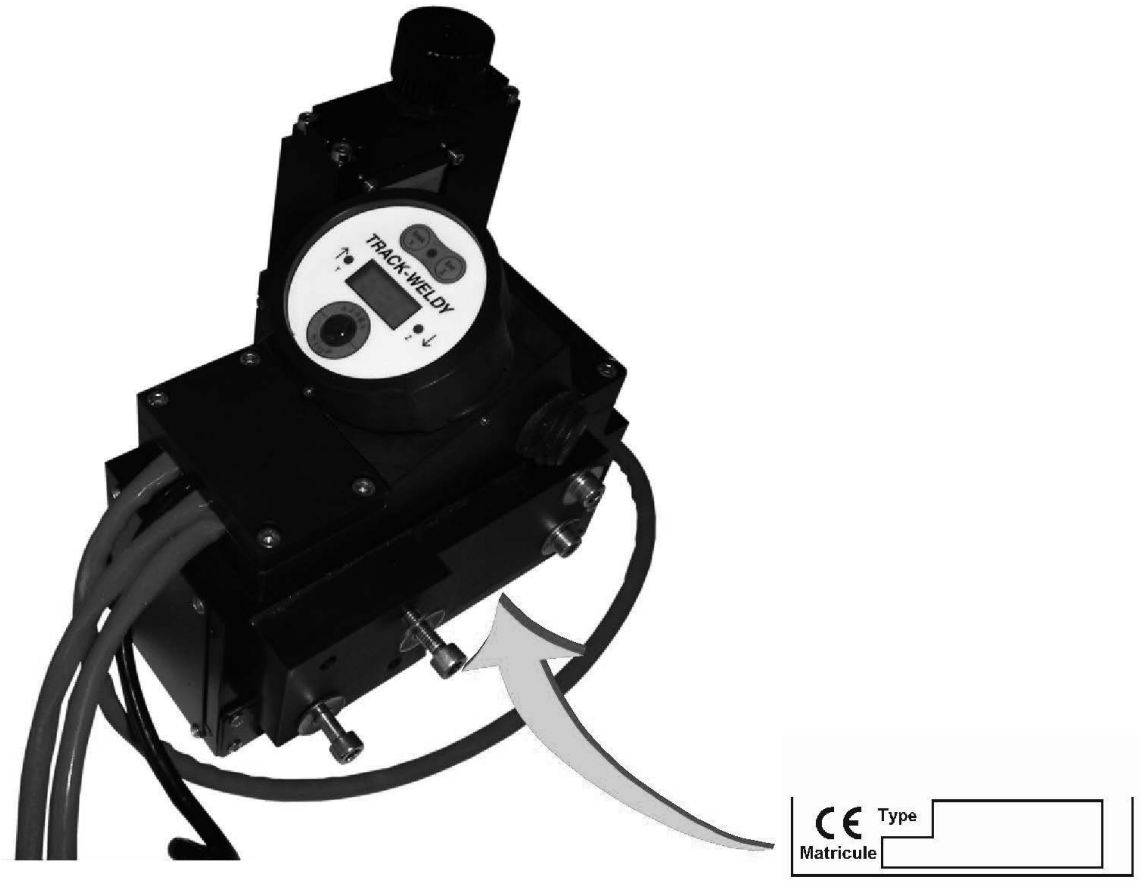
A - IDENTIFICATION

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

Quote this information in all correspondence.



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



B - SAFETY INSTRUCTIONS

ELECTROMECHANICAL EQUIPMENT USED AS THE SUBASSEMBLY OF AN INSTALLATION.

- This equipment can be associated with a welding installation, in which case it is covered by safety instructions described in the instructions for the welding installation

- If this equipment is used in other cases, a minimum of instructions must be respected, in particular :

1 - SERVICING

- Check often that the insulation and connections of the electrical equipment and accessories are in good condition: plugs, cables, flexible cables, sheaths, connectors, extension cables, workpiece clamps, electrode holders or torches...
- Maintenance and repair work on insulating sheaths and covers should never be carried out in a makeshift manner.
- Have defective accessories repaired by a specialist or, better still, replace them.
- Periodically check that electrical connections are properly tightened and do not overheat.

2 - PERSONAL PROTECTION

RISK OF EXTERNAL INJURY.

- The operator must be properly dressed and protected for the work he is carrying out.
- Ensure that no part of the operator's body or of his assistant's body can come in contact with metal parts and workpieces which are energized or which could accidentally become energized and/or which are moving.
- Do not wrap electrical cables around your body.

Make sure that no spray or water enters into the electrical box of the oscillator.
➔ IP235 PROTECTION

C - DESCRIPTION

1 - DEFINITION

These autonomous crossed slides **TRACK-WELDY**, can be mounted on **WELDYCAR** which is able to support one MIG/MAG torch.

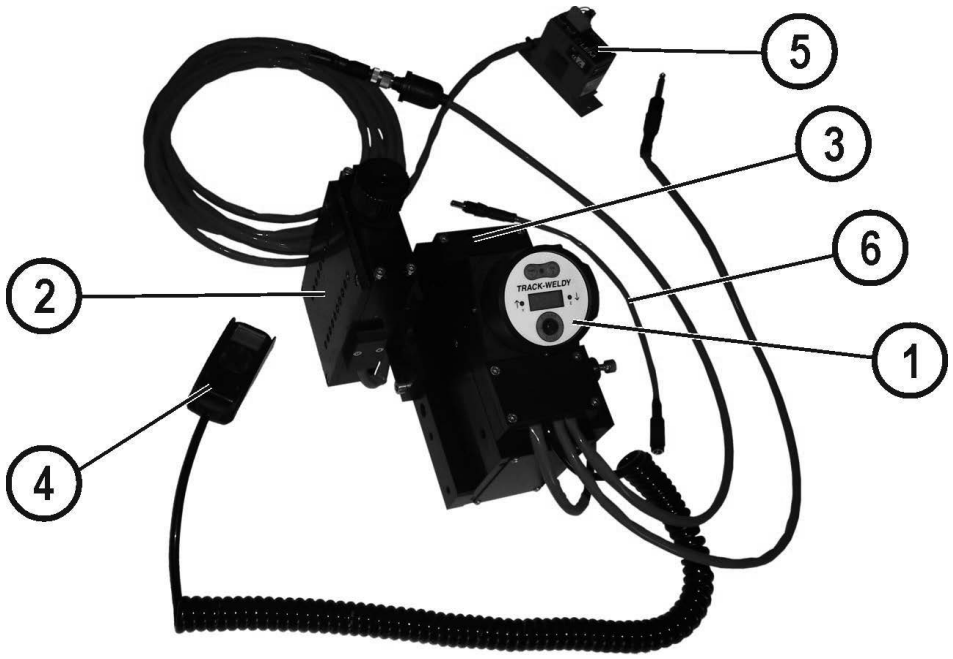
A first lateral slide allows the right/left movement of the torch, the second slide allows the control of the distance torch/piece during the welding.

The **WELDYCAR**, equipped with the crossed slides, keeps the same technical characteristics. The electrical supply of the **TRACK-WELDY** is done by the 14V plug on the **WELDYCAR**.

These crossed slides can be controlled by 2 ways :

- The 56mm stroke lateral slide with a joystick or with a linear oscillation function (idem **OSCI-WELDY**)
- The 56mm stroke vertical slide with a joystick or with vertical control tracking through the arc.

The **TRACK-WELDY** can be used as a simple crossed electrical slide or as oscillator and/or arc control tracking.



1	Control Panel
2	Vertical slide 56 mm stroke controlled by arc control device or the joystick
3	Lateral slide 56 mm stroke controlled by the joystick with or without linear oscillation (**OSCI-WELDY**)
4	Remote control
5	Current measure device and harness
6	Arc detection additional harnesse

2 - POWER SUPPLY

The **TRACK-WELDY** is powered by connecting a jack plug onto the **WELDYCAR**, itself powered by a 14.4 VDC battery.

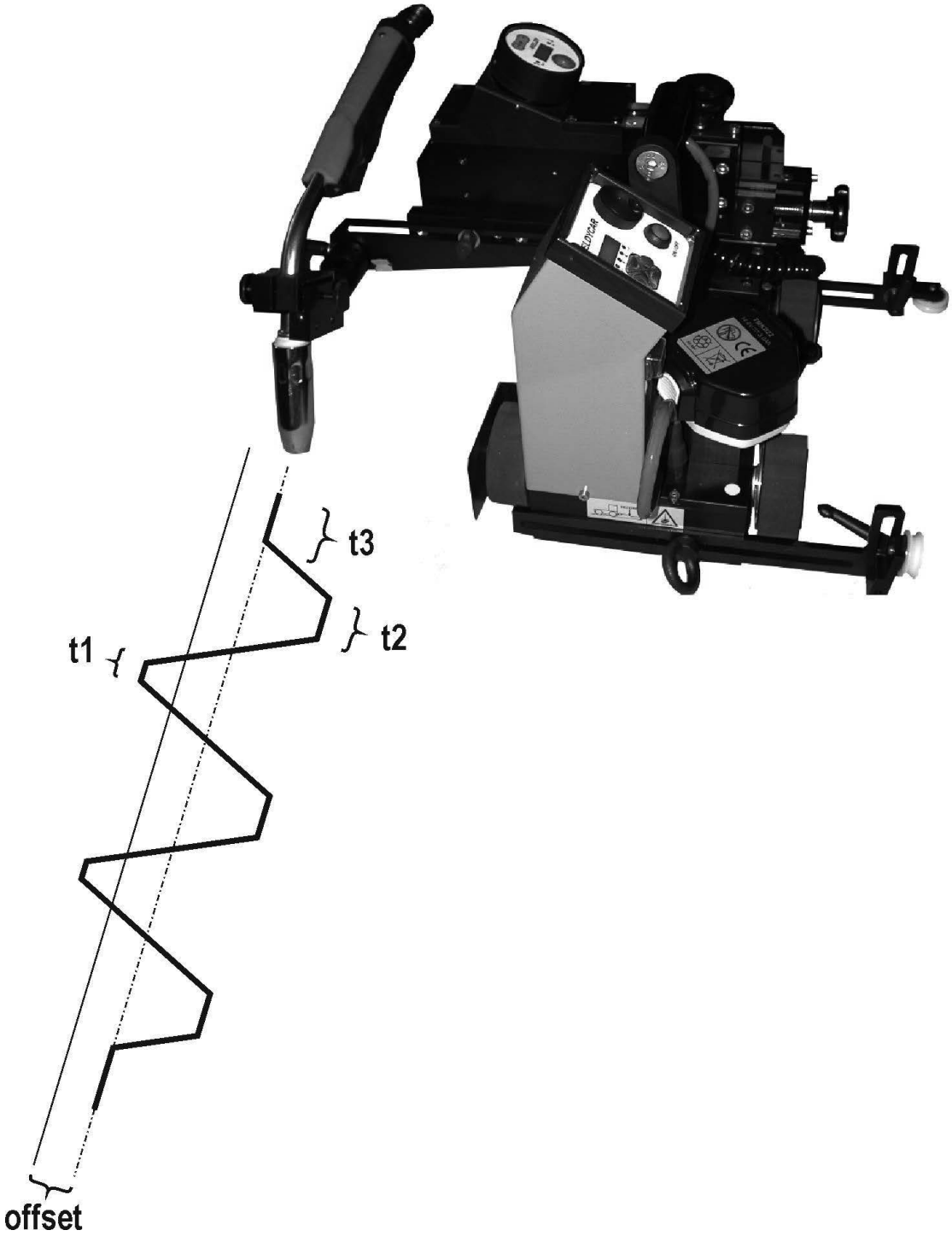
The **WELDYCAR** carriage and its associated **TRACK-WELDY** are completely autonomous. The **WELDYCAR** battery provides continuous operation of 2 hours.

3 - CHARACTERISTIC

		TRACK-WELDY
Stroke left/right slide	mm	56 mm
Stroke up/down slide	mm	56 mm
Autonomy of work with Weldycar	-	2 h in continuous work
Protection indice	-	IP 23
Weight	Kg	4
Supply	-	14V by connection to the Weldycar
Functionning temperature	-	-5°C to +45°C
Storage temperature	-	-10°C to +60°C
Relative humidity	-	< 90%

4 - MODE OSCILLATEUR LINEAIRE

The **TRACK-WELDY** is designed to receive the **WELDYCAR** torch holder. The lateral slide allows the function of linear oscillator (Idem **OSCI-WELDY**).



Characteristics of the lateral slide in linear oscillation mode.

		Lateral slide
Oscillation travel(range) :	mm	2 to 56mm
Offset (O)*:	mm	0 to 27mm (Depending on the range)
Oscillation speed :	cm/min	De 20 to 200cm/min
Carriage + linear oscillator autonomy :	-	2h continuous use
External delay time (t1) :	sec	0 to 10 sec
External delay time (t2) :	sec	0 to 10 sec
Delay time before starting (t3) :	sec	0 to 10 sec

*: The offset can vary according to the programmed range.

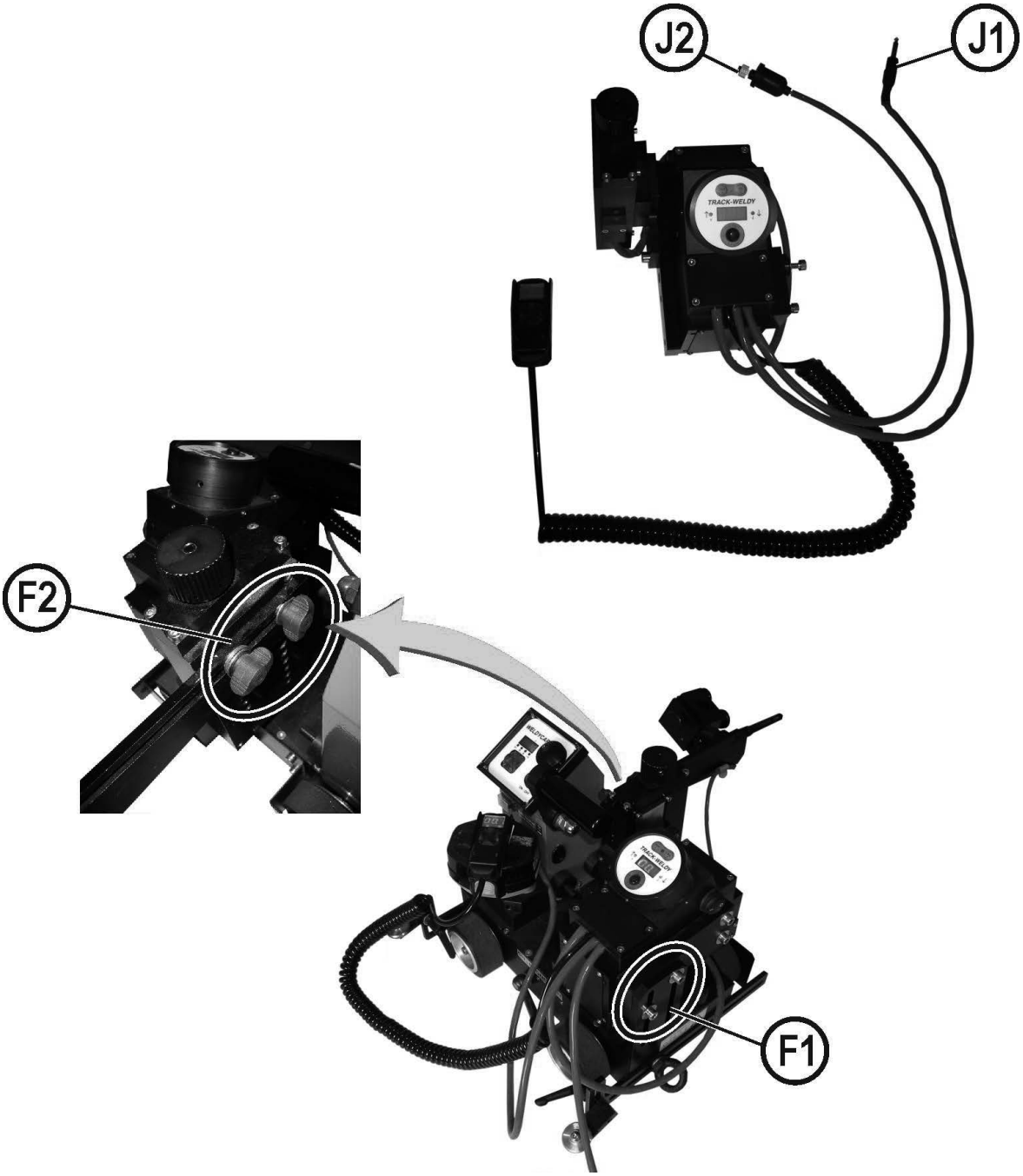
The formula is : $\frac{56 - range}{2}$ = permitted offset

Example :
Range = 2 mm => possible offset = +/- 27 mm
Range = 20 mm => possible offset = +/- 18 mm

If the user wants a greater offset, a “NO” message is displayed on the screen + buzzer.

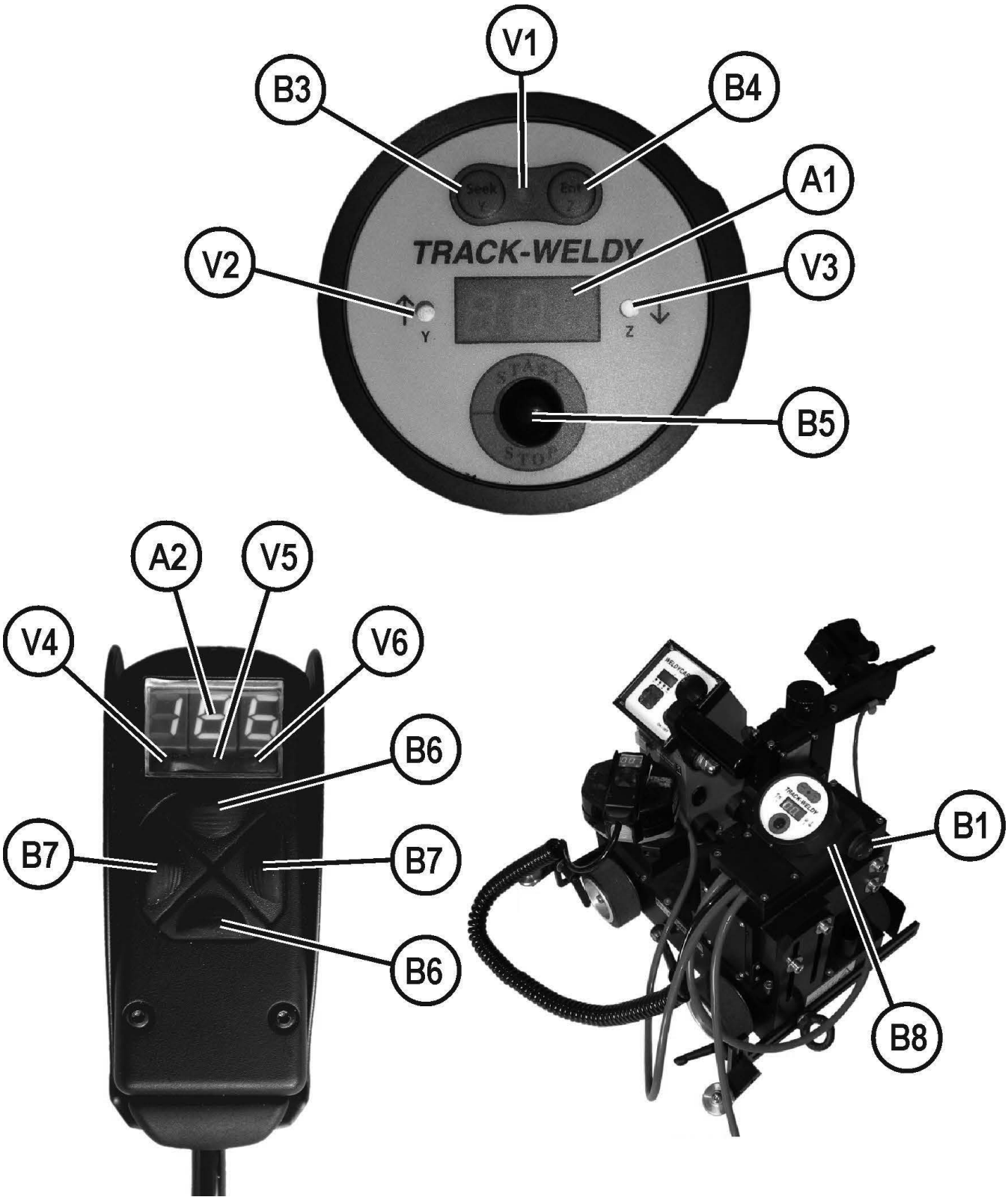
D - MONTAGE INSTALLATION

1. Remove the torch holder from the **WELDYCAR**
2. Remove the manual crossed slides from the **WELDYCAR**
3. Fix the **TRACK-WELDY** on the **WELDYCAR** with the screws F1
4. Fix the torch holder on the **TRACK-WELDY** with the handle F2
5. Connect the jack plug J1 on the power supply
6. Connect the current measure device on the connector J2
7. Put the current measure device on the ground cable of the power source
8. Connect the arc detection additional harness



E - OPERATOR MANUAL

1 - COMMANDE



A1	Display on the **TRACK-WELDY**
A2	Display on remote control
B1	Switch on / off button
B3	Button to select the mode Oscillation on Y axis
B4	Button to select the mode Oscillation on Z axis
B5	Start / stop slides movement
B6	Button to adjust the Z axis position
B7	Button to adjust the Y axis position
B8	Thumbwheel to change the oscillation amplitude
V1	Automatic mode light
V2	Setting light for Y axis
V3	Setting light for Z axis
V4	Setting light for Y axis
V5	Setting light for automatic mode
V6	Setting light for Z axis

2 - SETTING PROCEDURE

2.1 Manual mode

- Push the button **B1** to switch on the **TRACK-WELDY**
- At the start, the machine is in manual mode
- The light **V2**, **V3**, **V4** and **V5** are on continuous lighting
- The **V1** and **V5** are off

In the manual mode, it's possible to move the slides manually with the remote control :

- Push buttons **B6** : to move the Z axis up/down
- Push buttons **B7** : to move the Y axis left/right

2.2 Automatic mode

- After adjustment in manual mode of the slides (preferably in medium position), it's possible to put the machine in automatic mode.
- When pushing button **B3** (for Y axis) or **B4** (for Z axis), the automatic mode is pre-selected in according the selected axis.
- The light **V2** (for Y axis) or **V3** (for Z axis) are flashing when the automatic mode is selected.
- Push on the **B5** start button to start the automatic mode (oscillation and/or arc control tracking).

In automatic mode, it's always possible to come back to manual mode by pushing the **B5** button. Push only 1 button **B3** or **B4** to come back to manual mode on the correspondent axis.

2.3 Setting of SETUP parameters

SP	Oscillation speed
t_1	Stopping time in outer position
t_2	Stopping time in inner position
t_3	Time before starting oscillation (if synchronized with Weldycar)

1. Switch on with **B1** by pushing simultaneously **B4**
2. The parameter "SP" is then changeable
3. Push **B4** to visualize the value of the parameter
4. Change the value by turning the thumbwheel **B8**
5. Press **B4** to accept
6. Press **B3** again to go to "t_1", "t_2" then "t_3" then exit from the settings menu
7. Accept each time with **B4**

* For the oscillation function, it’s possible to adjust, during the welding :
  - The amplitude with thumbwheel **B8**
  - The offset with the buttons « ← », « → » and **B7**

The oscillation speed is programmed in the SETUP.

* For the function are control tracking, once the are measurer device is connected and positioned on the earth cable of the power source, it’s possible to modify the current consign with the thumbwheel **B8**.

Possibility of programming oscillator start

It is possible to start the oscillator via an external contact. The **J2** socket can be used to close the contact and start the oscillator.
The delay time "t_3" then becomes useful and the oscillator only starts after the delay time.

3 - TRACK-WELDY USE

		V2	V3	V1	B3	B4	B8	B5	B6	B7
Lateral Slide	Manual	ON	ON	OFF	Switch on the Oscillation	Switch on the arc tracking			Up / Down	Offset Y
Vertical Slide	Manual									
Lateral Slide	Oscillator	Flashing	ON	Flashing in cycle	Switch off the Oscillation	Switch on the arc tracking	Amplitude Oscillation	Start cycle	Up / Down	Offset Y
Vertical Slide	Manual									
Lateral Slide	Manual	ON	Flashing	Flashing in cycle	Switch on the Oscillation	Switch off the arc tracking		Start cycle	Current adjustment	Offset Y
Vertical Slide	Ar control									
Lateral Slide	Oscillator	Flashing	Flashing	Flashing in cycle	Switch off the Oscillation	Switch off the arc tracking	Amplitude Oscillation	Start cycle	Current adjustment	Offset Y
Vertical Slide	Ar control									

F - MAINTENANCE

1 - SERVICING

- So that the machine continues to provide good service for as long as possible, a certain minimum of care and maintenance is necessary
- The frequency of this maintenance work is given on the basis of the production of one work station per day. Maintenance should be more frequent if production is greater.

Your maintenance department may photocopy these pages so that it can follow up maintenance dates and operations (tick as appropriate)

Daily

		Remove regularly welding projection on protection lenses of the photo cell, protection casing and support roller. Regularly clean the outside of the carriage and the welding torch support adjusting elements.

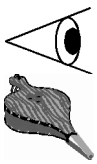
Every 100 hours

Date of maintenance: / /

		- Grease manœuvre screw
		- Dismount and clean the support rollers

Annually or after every 500 hours

Date of maintenance: / /

		- check up the transmission system - adjust the clearance of guiding shims on the slides - adjust the clearance of the geared motor on the large sprocket wheel.
		- wash and grease the wheels - blow very carefully the electronic card, speed regulator, electric rack.

2 - 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.)

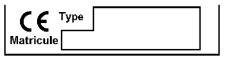
For items noted on the photos or sketches but not in the tables, send a copy of the page concerned, highlighting the particular mark.

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.



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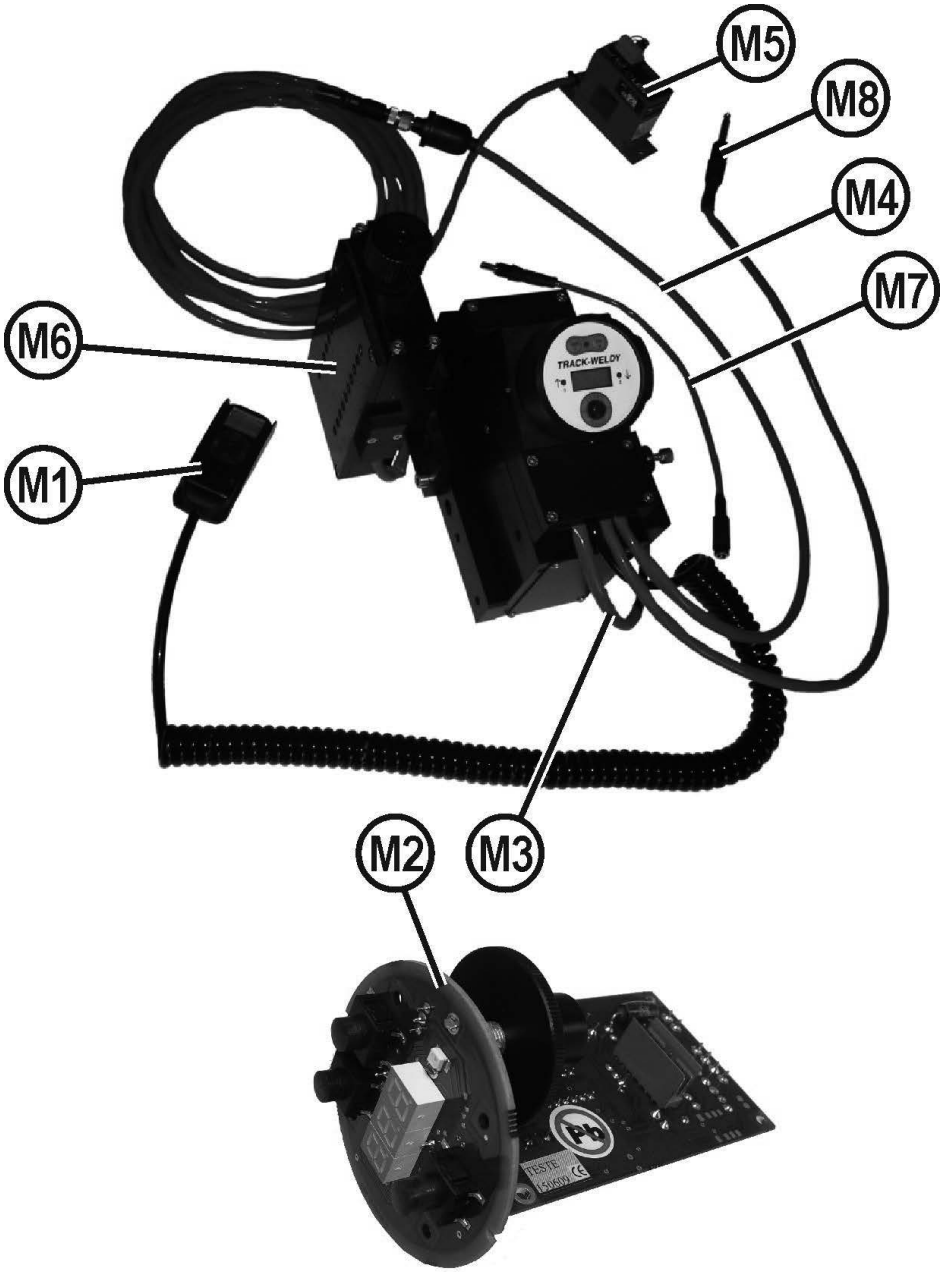
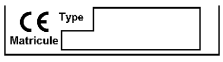

M5
M8
M4
M7
M6
M1
M2
M3
TRACK-WELDY

✔	normally in stock
✘	not in stock
	on request

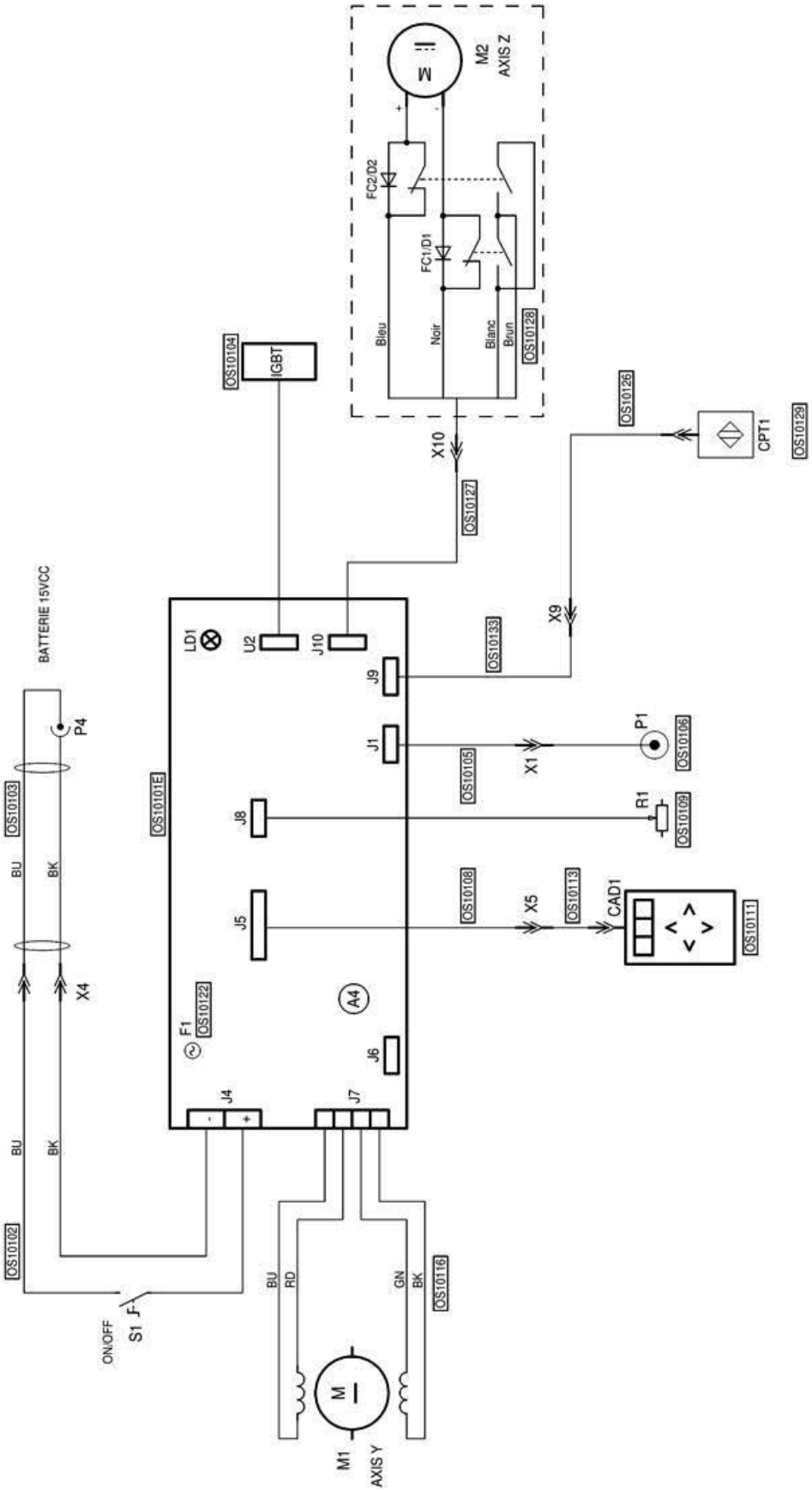
Item	Ref.	Stock	Order	Designation
M1				Remote control with cable
M2				Control circuit
M3				Harness of Vertical slide Z
M4				Harness for current measure device
M5				Current measure device with 5m harness
M6				Z - electrical slide with harness
M7				Arc detector additional harness
M8	W000276824			Battery power harness

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



TYPE:
Number:

3 - WIRING DIAGRAM



PERSONAL NOTES

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