

**WORK INSTRUCTION****C.N.C. Welding Machine**

REVISION: 01

PROCEDURE NO.: WI-8.2.4.39

DATE EFFECTIVE: 05/25/17

Procedure:

1. Turn power on (on back of machine)
2. Press reset
3. Press F1 to home the machine
4. Press **Cycle Start**
5. Press **F3** to set center of setup
6. Place **fixture** on first station (from the left)

To make the movements for the following setups use the dial control to achieve desired position.

7. Press **F1** to setup X parameters (left to right movement)
8. Press **F2** to setup Y parameters (back and forth movement)



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9. Press **F3** to setup Z parameters (up and down movement)

9.1 Once the center is located press **F1+F8** to save and lock the X parameters

9.2 Press **F2+ F8** to save and lock Y parameters.

9.3 Press F3 then use the dial control to bring the electrode up, remove the fixture and place a flange heater to be welded, using the dial control lower the electrode down setting it to a 1/16 high from the flange surface then press **F7** to save and lock parameter.

10. Using the numerical key pad press #1& 9 and press “Enter”

11. Press **ESC** (escape)

12. Press **F4** (Run)

At this point of the set up the program number can be changed if needed by pressing **F2** (old) a message will appear asking to enter the program number, using the key pad enter the program # to be used then press enter. (the program # should appear on the right top corner).

If no program has to be changed this procedure will not be needed and step 12 and 13 should be followed.

13. Press **F1**(Start)

14. Press **F1**(O:K)

15. Press **Cycle Start**. To start welding.

16. Set speed to **110** to **120**

If the machine needs to be stopped during operations press “**Feed Hold**”. Make sure to do this when a circle of weld cycle is done (single weld)

To continue welding press depress the **Feed Hold** then press **Cycle Start**.

For square flanges use program # **1812**

For round flanges use program # **4506**

For square flanges with T/weld #**1804**



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REVISION HISTORY

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	05/25/11	All	Initial release
01	05/25/17	1 thru 9.2	Removed Spanish Translation

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
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