



Series 3 Welding Lathe

Comprising of....

Solid headstock supplied with a 400mm diameter Chuck
Integral Weld current return brushgear rated at 400 amps
Speed Range : 0.20 to 3.5 rpm (this can be altered)
Capacity: Maximum Component Length: 3000mm
Maximum Component Weight: 600 Kgs

Main Frame

Floor standing main frame fabricated from steel RHS.
Provided with adjustable feet for levelling to factory floor.
Provided with lifting eyes.



Picture as a guideline only.

Tailstock

Sliding tailstock mounted on linear guide rail carriages
running on continuously supported hardened and ground linear
guide rails Lockable in any position along length of bed.
Fitted with sliding tooling faceplate arrangement controlled
by pneumatic cylinder.
Cylinder to exert a two stage pressure thrust force



Picture as a guideline only.

Adjustable Idlers

Two Adjustable Idlers supplied Manual linear movement available
between the headstock and tailstock Each Idler can be adjusted
in height to support material diameters 100mm to 150mm.
Each Idler can be locked in place along the length of the lathe

VBC Automatic Weld Controller

Easy to use intuitive control structure
Multilevel control (15 Stages)
Set-up function to check weld parameters prior to welding
Safety lockout switch to prevent operators modifying weld parameters
Supplied with, PWM drive (rotation)
Cold wire feeder controls
AVC controls
Rotation controls
Weld current and pulsing controls
and separate outlet for the linear drive of torch position.
Motorised Linear slide to attach to the torch included to control weld
height during your weld procedure
Torch height adjustment programmed via the multilevel control program
Memory upgrade to 128 programs
Fitted to remote 350A weld set and water cooler
Remote pendant



Typical pendant control
(Only machine specific functions will be
included which may differ to that shown)



VBCIE Arc Length Controller

Automatically maintains constant weld penetration, bead width & height above component. Sets the weld torch at the optimum height for striking the arc by means of the touch retract system.
Integral arc starting noise filter.
Torch clamp to fit the supplied welding torch

Arc Length Control Parameters

Park' or 'no park' at end of sequence.
Weld Pool Delay Time - to allow arc to stabilise before controlling arc length.
Touch Retract Distance – set distance of electrode to component, in millimetres.
Set Arc Volts – tracking voltage, dependant on value for set weld current.
Automatically maintains constant weld penetration, bead width & height above component. Sets the weld torch at the optimum height for striking the arc by means of the touch retract system.
Integral arc starting noise filter.

Torch Positioning and controls

Mounted on the pneumatic slide to assist with loading and unloading the parts
Torch Positioner with 3 axis torch adjustment
Height adjustment post to give range of torch height from centre height to 300mm above TDC
AVC with 75mm movement with touch and retract functions
Wire feeder spool and wire feed guide with 3 axis adjustment

Wire Feed Parameters

Pulsed or continuous feed modes.
Feed Speed - range 50-2500mm/min.
Manual and automatic purge facility
Pre and post purge function.
Pool delay, upslope and downslope timers.
Final current facility with final time function. This assists in preventing cracks at the end of the weld.
Weld Pool Delay Time - to allow arc to stabilise before feeding wire.
Pulse Synchronisation. Pulses the wire at a rate that matches the main and background current values of the Weldset. (Dabber TIG technique)
Using 4 Roller Wire feed motor / roller setup
VBCIE X-Y-Z wire exit guide adjustment

