

DC20 Welding Travel Carriage

Mechanized Welding
In All Positions!



Bug-O Systems

Automated Cutting and
Welding Systems

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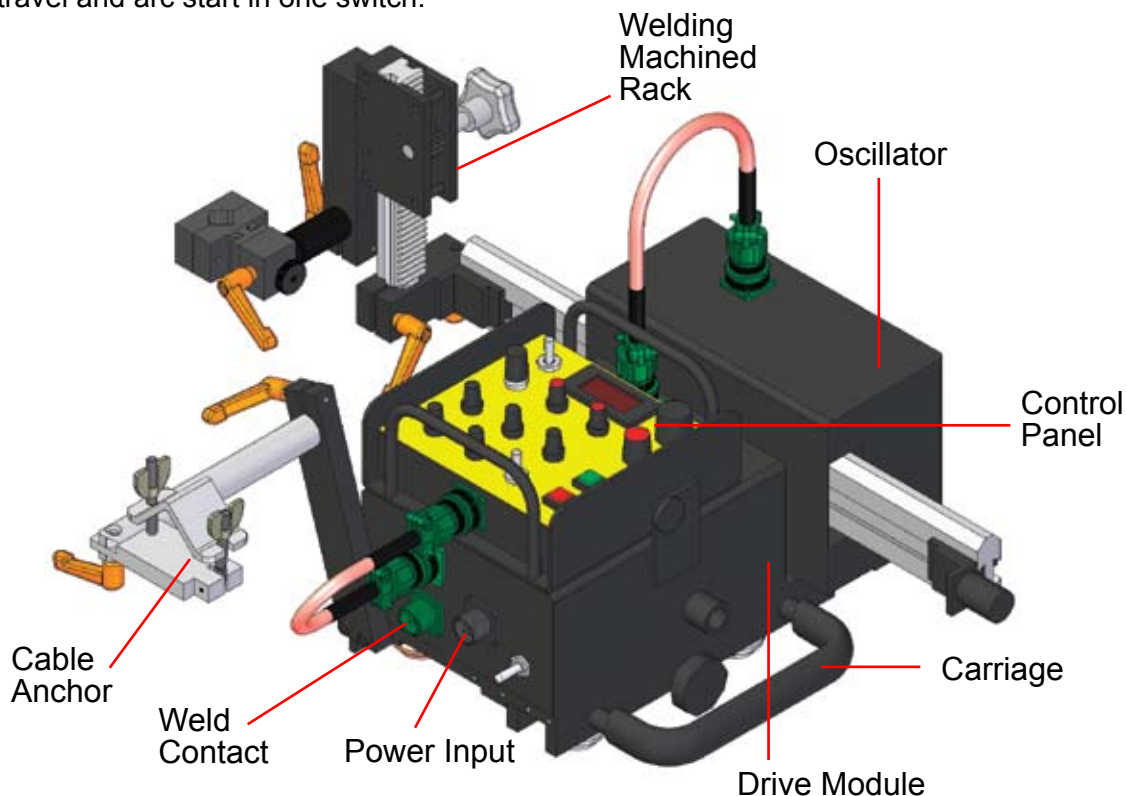
DC20 ALL POSITION WELDING SYSTEM

The DC20 is a compact portable welding travel carriage with integrated linear type oscillator for all position welding. It will perform continuous welding at a constant travel speed producing high quality uniform welds in a fraction of the time required for manual hand welding. Regulated travel speed without starting or stopping the welding process will eliminate excessive weld deposition and help reduce defects. Precise weld weaving with programmable dwells will improve weld penetration and control undercut.

Features:

The Welding Carriage DC-20 with Oscillation incorporates the following features:

- High torque, low inertia motor for precise stops and starts.
- Worm gear Drive Unit motor prevents the carriage from moving when the unit is turned off.
- Worm gear Oscillator motor prevents the crossarm from moving when the unit is turned off.
- High speed linear oscillator for weaving with independent control of right, center and left dwell times.
- Drive unit motor overload protection.
- Oscillator motor overload protection which turns off the motor when too much load is applied on the crossarm.
- Closed loop speed control for adjustable and repeatable control.
- Closed loop speed control to prevent drift from the center weld position.
- Storage setting welding parameters after power turn off.
- Welding machined rack with adjustable racking to ensure the accurate positioning of the torch.
- Crater fill in the beginning and end of the welding.
- Welding contactor ON/OFF switch.
- Carriage travel and arc start in one switch.





DC20 CONTROLS AND TECHNICAL DATA

Controls:



- C. **START**
- D. **STOP**
- E. **WELD CONTACT**
- F. **CRATER FILL** - in the end (0-5s)
- G. **CRATER FILL** - in the beginning (0-5s)
- H. **DWELL RIGHT** - (0-3s)
- I. **DWELL CENTER** - (0-3s)
- J. **DWELL LEFT** - (0-3s)
- K. **WEAVE SPEED** - 0-120 in/min; (0-3050mm/min)
- L. **MODE SELECTOR** - (four welding modes)
- M. **AMPLITUDE** - 0,12-2"; (3-50mm)
- N. **FORWARD/REVERSE** - travel direction

- A. **SPEED CONTROL** 2-50 in/min. (50-1270 mm/min.) Shown on LED display, in/min. or cm/min
- B. **STEERING TORCH** 5,9" (0-150mm)-accuracy \pm 0,2mm

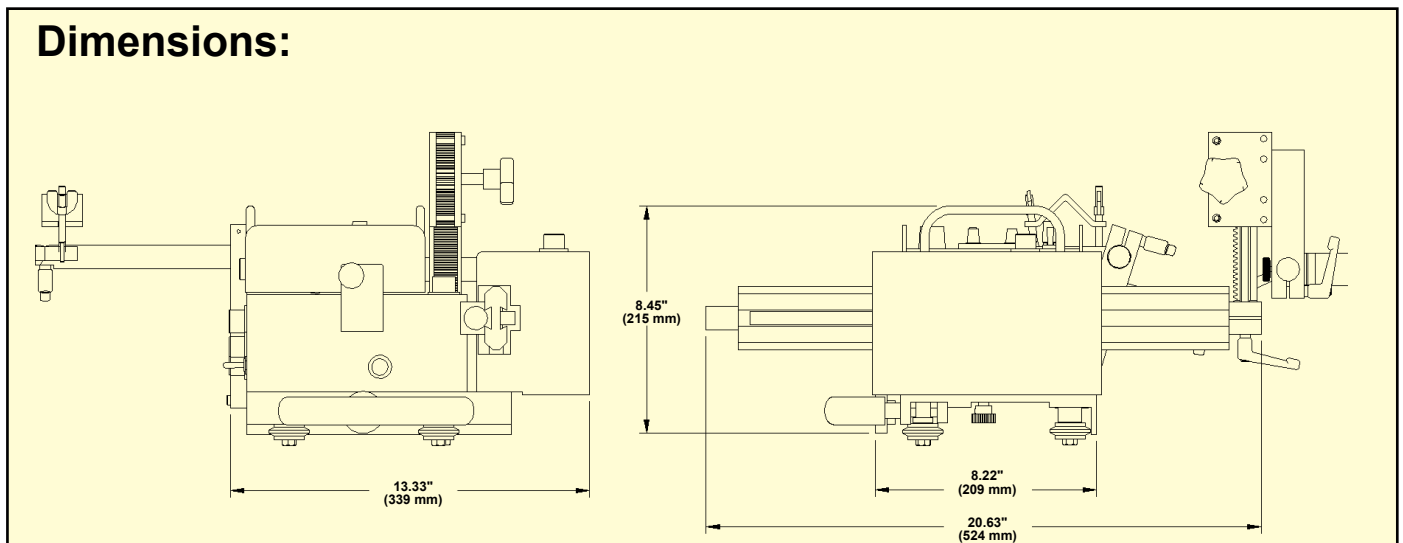
TECHNICAL DATA:

- Part Numbers:** PRO-1000 115Volt (50,60Hz)
PRO-1002 230Volt (50,60Hz)
- Power:** 115V; 230V (50,60Hz)
- Net Weight:** 32.63 lbs. (14.8kg)
- Shipping Weight:** 64 lbs. (29kg)
- Dimensions:** 24" x 16" x 13" (610 x 400 x 340mm)
- Welding Position:** All position (in accordance with tracking rail.)
- Pulling Power:** 67.0 lb. (300N/horizontal); 33lb. (150N/vertical)
- Torch Holder:** For the straight and goose-neck torch.



DC20 shown with Remote Pendant.

Dimensions:

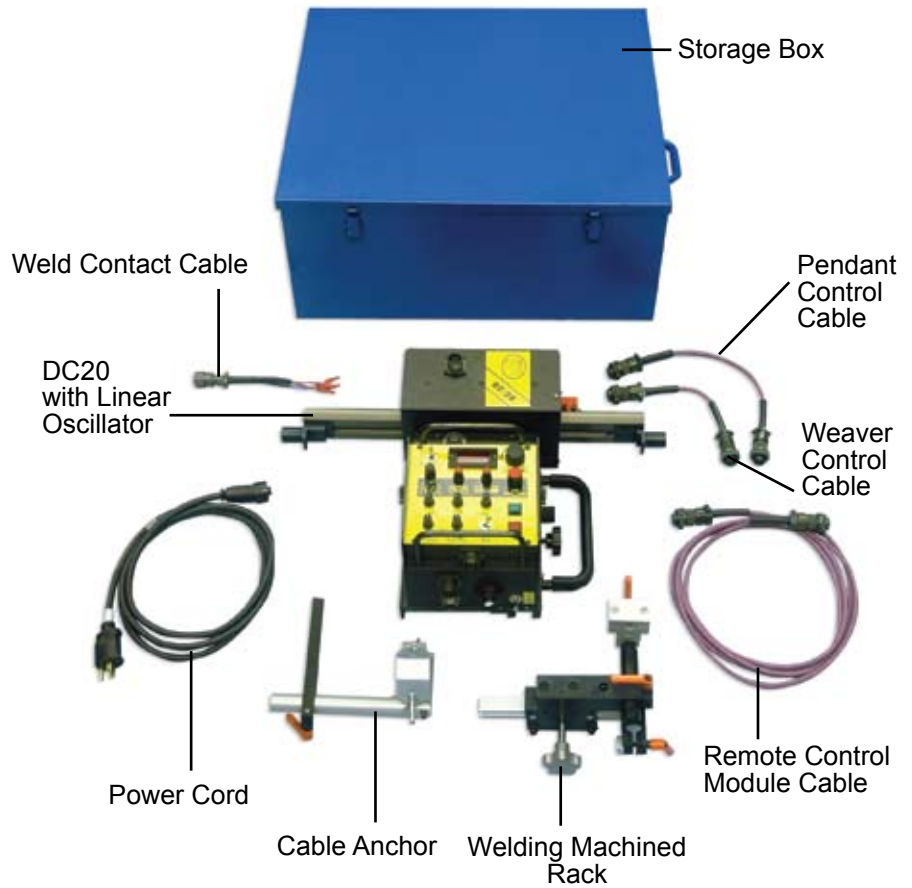




DC20 KITS

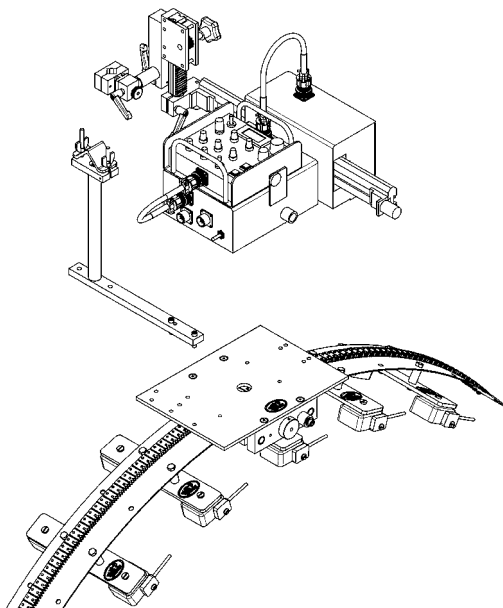
PRO-1000 and PRO-1002 Kits include a storage box and all items shown. The carriage contained with the kit is suitable for use with our standard rigid and semi-flex rail. Rail and magnets not included with PRO-1000 or PRO-1002.

For use with bent or high-flex rail please see below for optional carriages.



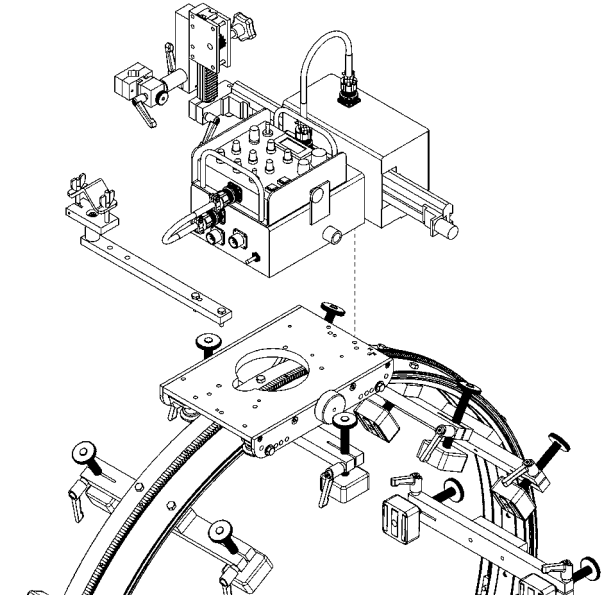
Hi-Flex Rail:

PRO-1105 Hi-Flex Carriage



Bent Rail:

PRO-5910 Tube Carriage



For more information please see our "Rails & Attachments" brochure.