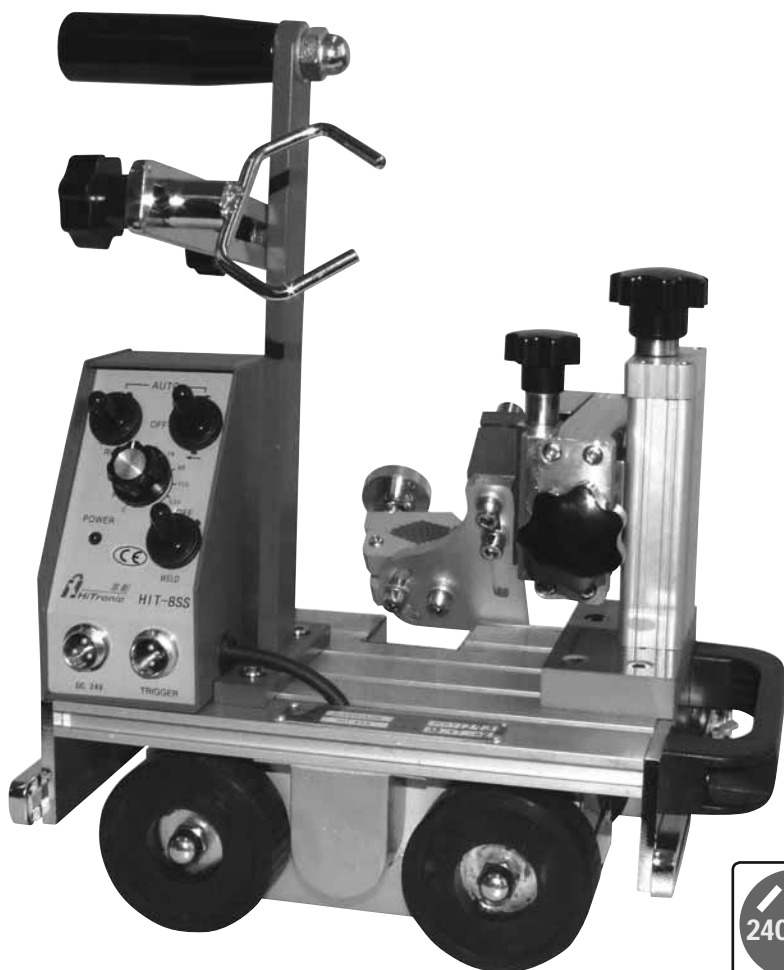


UNI-MIG
WELDING



HIT8SS

Automatic Carraige Manual





1 YEARS Warranty*

Machine Model

Description	Part Number
HIT8SS Automatic Carraige	UMAWT

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SAFETY

Welding and cutting equipment can be dangerous to both the operator and people in or near the surrounding working area, if the equipment is not correctly operated. Equipment must only be used under the strict and comprehensive observance of all relevant safety regulations. Please read and understand this instruction manual carefully before the installation and use/operation of this equipment.

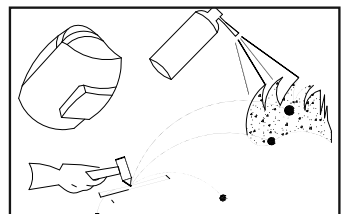
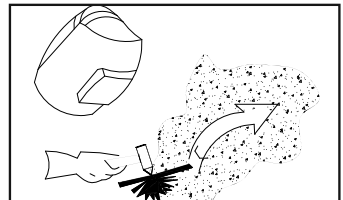
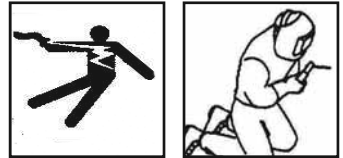
- Do not switch the function modes while the machine is operating.
Switching of the function modes during welding can damage the machine.
Damage caused in this manner will not be covered under warranty.
- Disconnect the electrode-holder cable from the machine before switching on the machine, to avoid arcing should the electrode be in contact with the work piece.
- A safety switch is necessary to prevent the equipment from electric leakage.
- Welding tools and accessories should be of high quality and in good working order.
- Operators should be trained and or qualified. Electric shock: It can kill.
- Connect the primary input cable according to Australian standard regulation.
- Avoid all contact with live electrical parts of the welding circuit, electrodes and wires with bare hands. The operator must wear dry welding gloves while he/she performs the welding task.
- The operator should keep the work piece insulated from himself/herself. Smoke and gas generated whilst welding or cutting can be harmful to people's health.
- Avoid breathing the smoke and gas generated whilst welding or cutting. Keep the working area well ventilated.
- Arc rays are harmful to people's eyes and skin. Always wear a welding helmet and suitable protective clothing including welding gloves whilst the welding operation is performed.
- Measures should be taken to protect people in or near the surrounding working area, from all hazards associated with welding.

Fire hazard

- The welding sparks may cause fire, therefore remove flammable material away from the working area.
 - Have a fire extinguisher nearby, and have a trained person ready to use it.
- Noise:** possibly harmful to people's hearing.
- Noise is generated while welding/cutting, wear approved hearing protection when noise levels are high.

Machine fault:

- Consult this instruction manual.
- Contact your local dealer or supplier for further advice.



*** CAUTION ***

Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapours from substance inside. These can cause an explosion even though the vessel has been "cleaned". Vent hollow castings or containers before heating, cutting or welding. They may explode.

GENERAL DESCRIPTION & SAFEGUARDS

Rotating Motions

Rotating motion can be dangerous -- even smooth, slowly rotating shafts can grip clothing, and force an arm or hand into a dangerous position. Collars, gears, clutches, flywheels, shaft ends, and horizontal or vertical shafting are some examples of common mechanisms that may be hazardous. The danger increases when projections such as set screws, bolts, nicks, abrasions, and projecting keys are exposed on rotating parts.



OUTLINE

1-1 ADVANTAGE OF HIT-8SS CARRIAGE

- 1) Simple operation, easy setup, light weight and small size combine to make the HIT8SS a must have for the productivity conscious operator.
- 2) Precise carriage movement with four wheel drive, ensures constant weld quality and appearance. Carriage can be operated in both directions (forward and reverse.)
- 3) Automatic operation, Welding machine and carriage operation can be wired for simultaneous operation, i.e. press down the start button, welding starts automatically, and carriage starts automatically
- 4) Carriage movement (Forward or Reverse) can be operated without operation of the welding machine.
- 5) Increased productivity, One operator can operate numerous sets of carriages at the same time, minimizing operator fatigue and injury.
- 6) Can be used in multiple welding applications, See Page 6
- 7) Use for welding large diameter pipe, the minimum diameter that can be welded is 800 mm.
- 8) Machine supplied with quality aluminium case for protection and easy transportation.

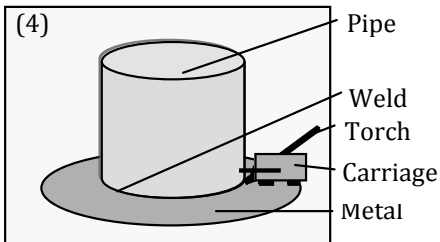
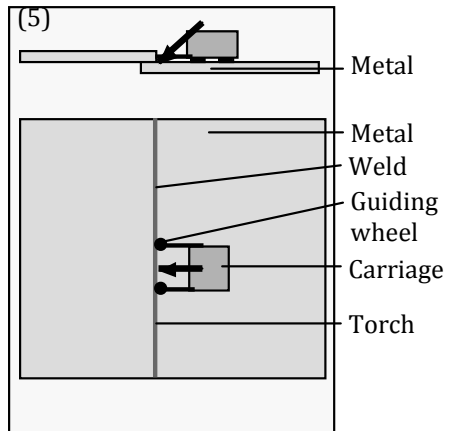
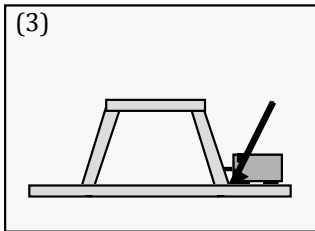
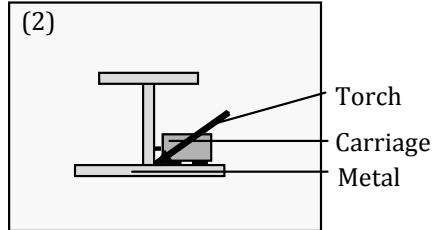
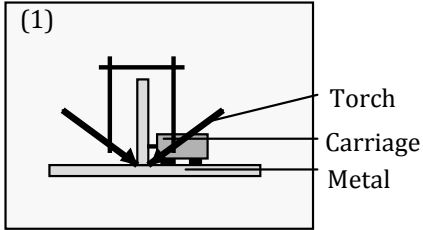
SPECIFICATION

Model	HIT-8SS
Input Voltage()	AC 220-DC 24
Speed (mm/min)	0-900
Net Weight (kg)	8
Power (W)	22
Attraction force (kg)	25
Torch adjustment range	up/down, left/right 50 mm
Torch angle adjustment	360
Dimension (mm)	215x275x250

STANDARD PACKAGE

Item No.	Description	Quan.
1.	HIT-8SS carriage (with control box)	1set
2.	Safe DC 24V Power source (AC220V to DC24V)	1pc
3.	Input cord x 3m	1pc
4.	Inter-connection cord x 20m	1pc
5.	Triggering cable x 5m	1pc
6.	Manual	1pc
7.	2862 Guiding wheel	2 pcs/set
8.	Torch position adjuster 0520 left	1pc
9.	Torch holder 1056	1pc

APPLICATION EXAMPLE CHARTS



- (1) Carriage runs in vertical position, allowing both sides to be welded.
- (2) H beam welding, carriage runs in vertical position, single torch.
- (3) U structure welding, carriage runs in vertical position, single sided welding.
- (4) Round seam welding vertical running, Min radius 800mm.
- (5) Flat lap joint for thick plate.

SETUP CONNECTION AND WELDING OPERATION

1. PREPARATION FOR WELDING

- A. Power supply for welder and carriage.
- B. MIG Welder / Wire feeder - Wired for automatic operation with HIT8SS.
- C. Control power supply AC 220V.
- D. HIT-8SS Auto-carriage.
- E. Gas.

2. CONNECTION PROCEDURE

- A. Supply AC 220V power to the main power box.
- B. Connect the DC 24V from the power box to HIT-8SS carriage (ref. Chart 2).
- C. Connect the welder's torch switch line to the HIT-8SS carriage.
- D. Adjust the parameters of the MIG welder, including the welding voltage / current, and fit the MIG welding torch and adjust the angle of torch.
- E. Ensure that path of carriage is clear of dirt and debris.

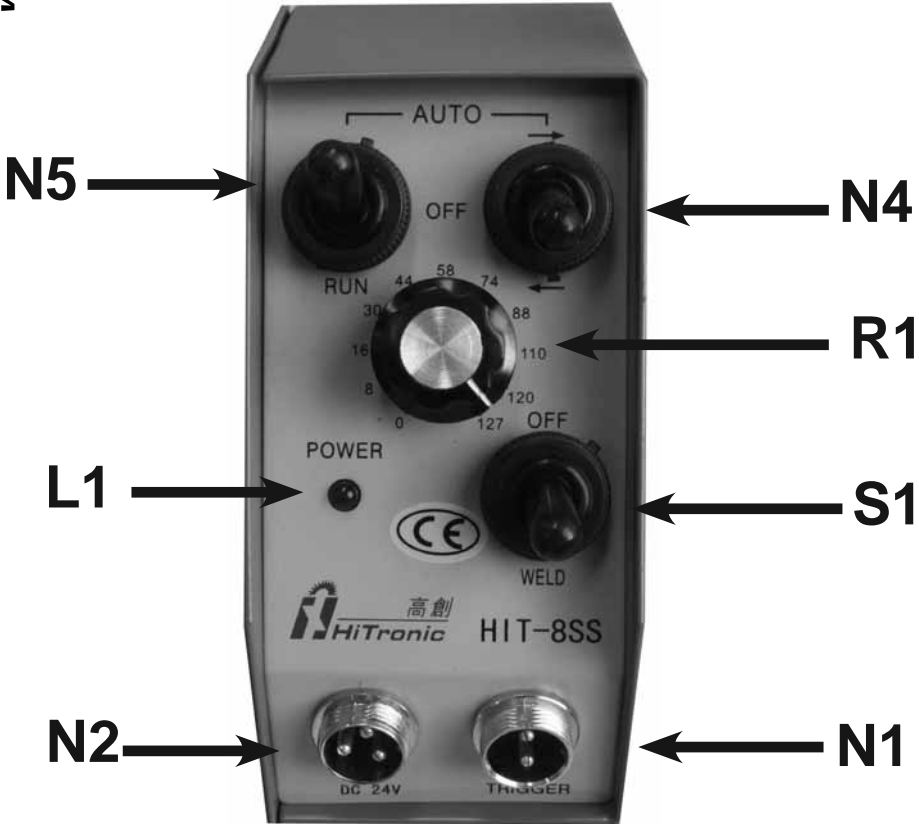
3. WELDING OPERATION AUTOMATIC

- A. Ensure power source of HIT-8SS has been correctly connected and that trigger connection to MIG Welder is connected for automatic operation
- B. Select the carriage running direction switch, N4: FORWARD / REV.
- C. Select the carriage operation method, N5: RUN
- D. Adjust HIT-8SS carriage running speed, Adjusting knob R1: SPEED.
- E. Select the carriage operation method, N5: to AUTO
- F. Push the switch selector to the "WELD" position S1, welding and carriage operation will automatically occur : Push the switch selector to the "OFF" position S1, the welding arc ceases and the carriage stops movement.

4. WELDING OPERATION MANUAL

- A. Ensure power source of HIT-8SS has been correctly connected for manual welding operation, by selecting four tack trigger or trigger latch operation on the power source.
- B. Select the carriage running direction switch, N4: FORWARD / REV.
- C. Select the carriage operation method, N5: RUN
- D. Adjust HIT-8SS carriage running speed, Adjusting knob R1: SPEED.
- E. Push the trigger switch on the torch, and welding will commence.
- F. Push the trigger switch once, the welding arc ceases.
- G. Push the switch selector S1 to the "OFF" position, the welding carriage stops movement.

CARRIAGE PANEL OF OPERATION



- R1: Carriage running speed adjustment knob
- S1: Weld / OFF selection switch
- N4: Carriage forward / reverse running direction selection switch
- N5: Carriage RUN/ OFF/ AUTO selection switch
- L1: Power lamp
- N1: 2 pins male socket, use for torch trigger
- N2: 3 pins male socket, use for DC 24V input power



CHART 2

MAINTENANCE

WARNING:

Exposure to extremely dusty, damp, or corrosive air is damaging to the welding machine. In order to prevent any possible failure or fault of this welding equipment, clean the dust at regular intervals with clean and dry compressed air of required pressure.

Please note that: lack of maintenance can result in the cancellation of the guarantee; the guarantee of this welding equipment will be void if the machine has been modified, attempt to take apart the machine or open the factory-made sealing of the machine without the consent of an authorized representative of the manufacturer.

TROUBLESHOOTING

Caution:

Only qualified technicians are authorized to undertake the repair of this welding equipment. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed in this manual.

WARRANTY

- 1 Years from date of purchase.

• Welding Guns of Australia Pty Ltd warranties all goods as specified by the manufacturer of those goods. This Warranty does not cover freight or goods that have been interfered with. All goods in question must be repaired by an authorised repair agent as appointed by this company. Warranty does not cover abuse, mis-use, accident, theft, general wear and tear. New product will not be supplied until

Welding Guns of Australia Pty Ltd has inspected product returned for warranty and agree's to replace product. Product will only be replaced if repair is impossible.
If in doubt please ring.



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Disclaimer:

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For further information please call Welding Guns of Australia Pty Ltd.

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