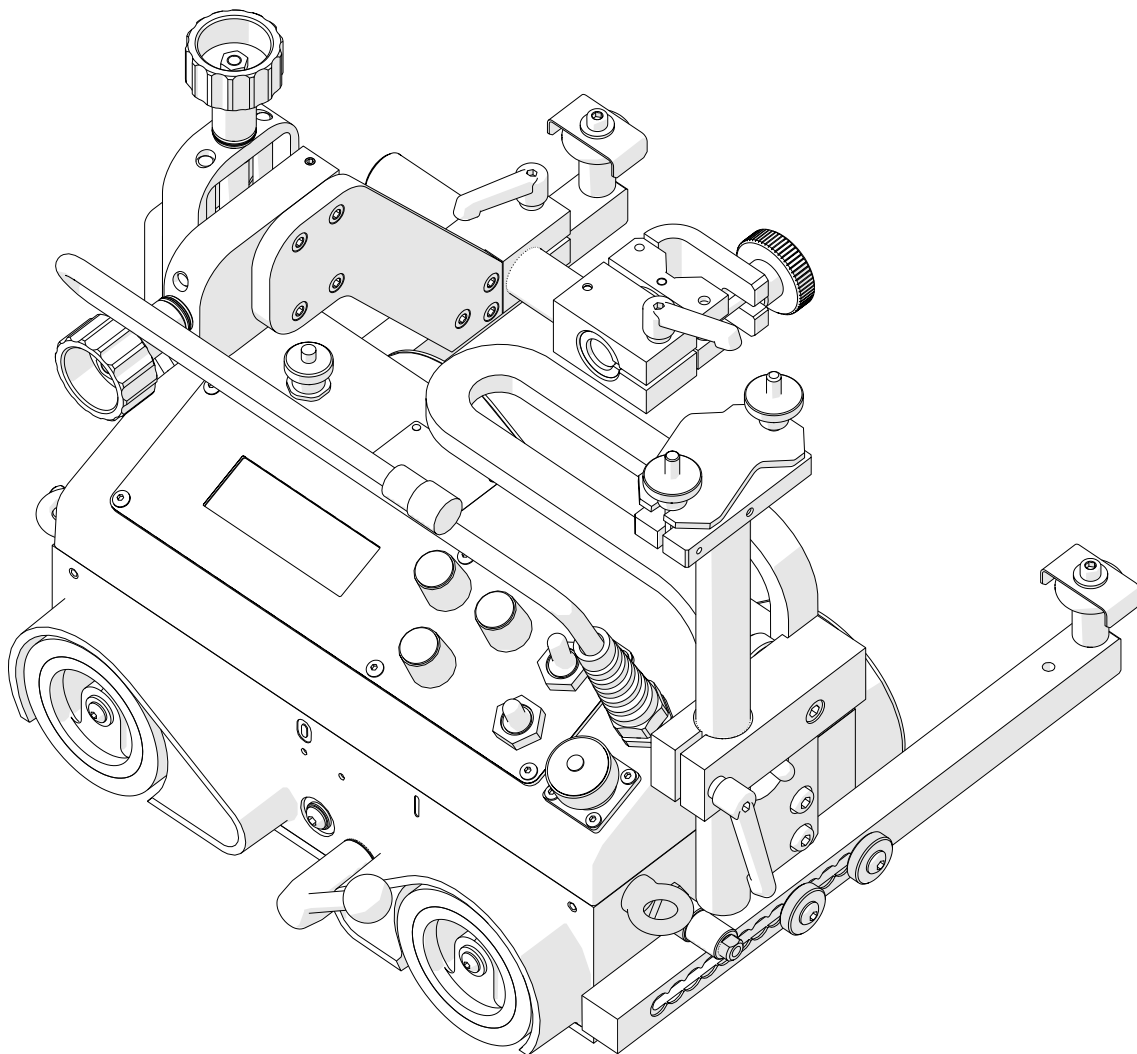


OPERATOR'S MANUAL

LIZARD WELDING CARRIAGE



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Contents

1. GENERAL INFORMATION	3
1.1. Application	3
1.2. Technical data.....	3
1.3. Design	5
1.4. Equipment included	6
2. SAFETY PRECAUTIONS.....	7
3. STARTUP AND OPERATION	9
3.1. Preparing	9
3.2. Connecting to welding circuits.....	10
3.3. Positioning at the worksite	11
3.4. Starting	12
3.5. Programming	12
3.6. Welding procedure.....	14
3.7. Operating.....	15
3.8. Using oscillator (accessory)	16
3.8.1. Installing.....	16
3.8.2. Welding with oscillation	17
3.8.3. Operating.....	18
3.9. Troubleshooting	19
4. MAINTENANCE	20
5. ACCESSORIES	21
5.1. Oscillator.....	21
5.2. 16–22 mm torch clamp.....	23
5.3. 16–22 mm torch clip.....	23
5.4. 22–35 mm torch clamp.....	23
5.5. Short rod.....	24
5.6. Long rod.....	24
5.7. Short rod torch holder with clamp.....	24
5.8. Short rod torch holder with clip.....	25
5.9. Short rod low torch holder with clip.....	25
5.10. Long rod torch holder with clamp	25
5.11. Long rod torch holder with clip.....	26
5.12. Torch extension arm	26
5.13. Edge following guide arms	27
5.14. Adjustable guide arms.....	28
5.15. Magnet guide arms	29
5.16. Dual torch mount.....	32
5.17. Guiding set.....	33
5.18. Guide adjustment tool	35
5.19. 76 mm cross slide	36
6. WIRING DIAGRAM	37
7. DECLARATION OF CONFORMITY	38
8. QUALITY CERTIFICATE.....	39
9. WARRANTY CARD.....	40

1. GENERAL INFORMATION

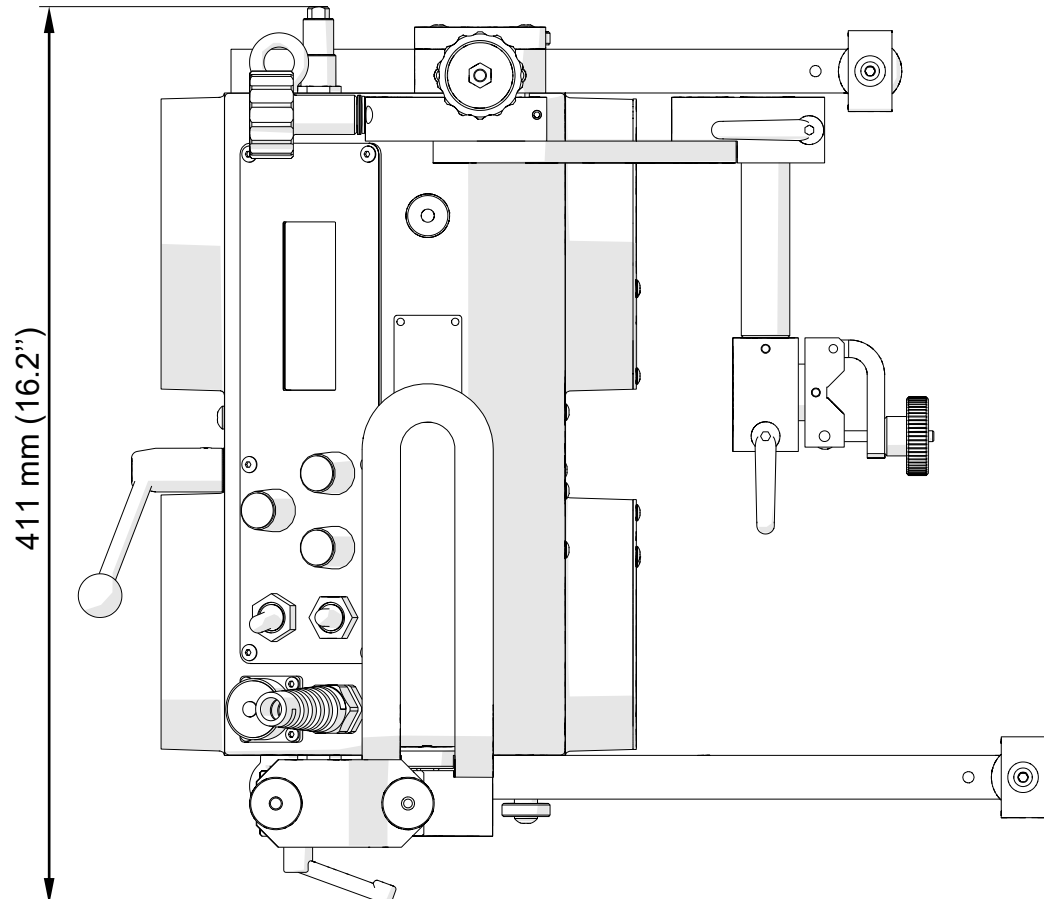
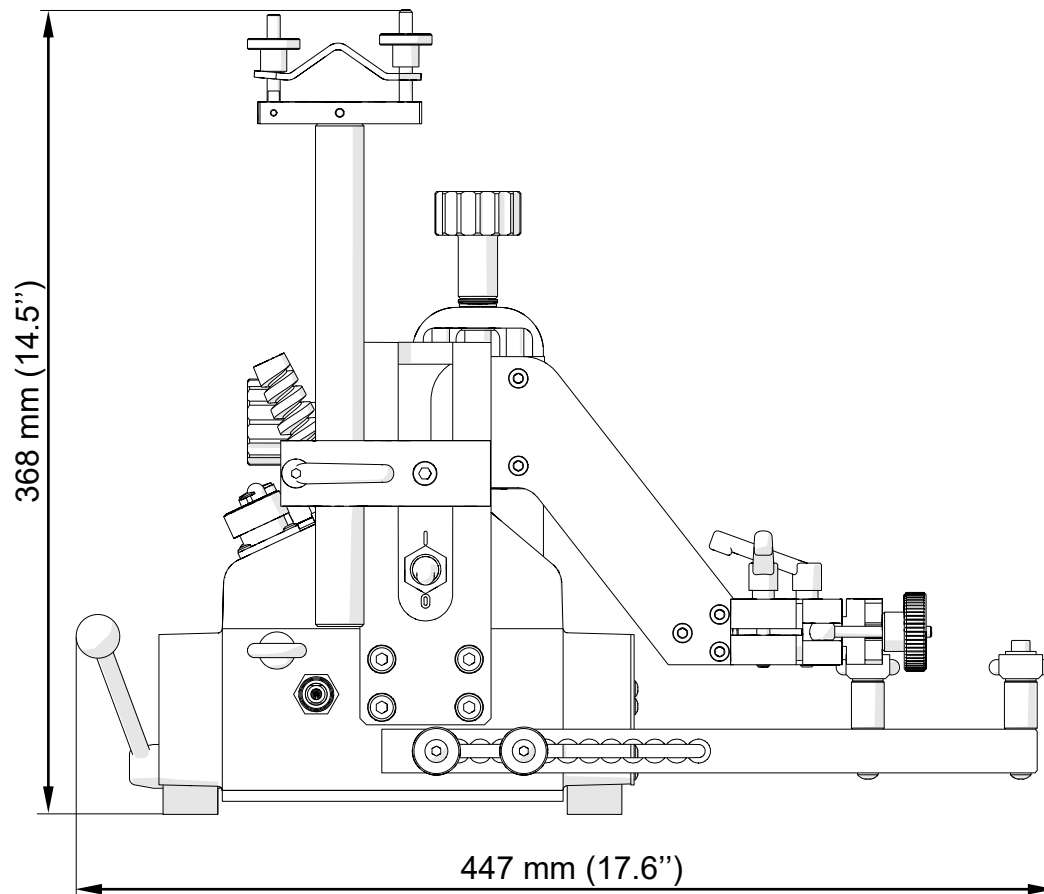
1.1. Application

The LIZARD is a welding carriage designed to produce continuous or intermittent butt and fillet welds using MIG/MAG torches with the handle diameter of 16–22 mm (0.63–0.87"). The carriage is fixed by permanent magnets and can work in the following welding positions: PA/1F/1G, PB/2F, PC/2G, PD/4F, and PE/4G.

Accessories allow, for instance, welding with oscillation, using torches with the handle diameter larger than 22 mm, two torches simultaneously, guiding the carriage along outside edges, lap joints and templates, walls low or with holes, and on ceilings, pipes, and tanks.

1.2. Technical data

Voltage		1~ 115–230 V, 50–60 Hz
Power		25 W
Welding position (according to EN ISO 6947 and AWS/ASME)	horizontal	PA / 1F / 1G PB / 2F PC / 2G PD / 4F PE / 4G
	vertical	PF / 3F / 3G (with optional oscillator) PG / 3F / 3G (with optional oscillator)
Minimum path curvature radius		1500 mm (5 ft)
Torch type		MIG/MAG
Torch diameter		16–22 mm (0.63–0.87")
Maximum torch reach		80 mm (3.15")
Maximum permitted cable weight	horizontal work	12 kg (27 lbs)
	vertical work	8 kg (18 lbs)
Minimum workpiece thickness		5 mm (0.20")
Ground clearance		5 mm (0.20")
Horizontal pulling force		220 N
Vertical pulling force		150 N
Cross slide adjustment range		0–35 mm (0–1.38", up-down, left-right)
Guide arm adjustment range		0–75 mm (2.95")
Horizontal speed		0–120 cm/min (0–47.2 in/min)
Vertical speed		0–110 cm/min (0–43.3 in/min)
Noise level		Less than 70 dB
Weight		14 kg (31 lbs)



1.3. Design

The LIZARD welding carriage consists of a chassis, a drive system, a controller, a cross slide, two guide arms, a cable anchor, and a torch holder. The drive system contains a gear-motor that drives four rubber wheels.

Permanent magnets fitted at the carriage bottom ensure proper clamping to ferromagnetic surfaces. The cross slide allows for precise control of the torch holder position in both the horizontal and vertical axis, and connecting the arc ignition cable will enable the carriage to ignite an arc when selecting a travel direction.

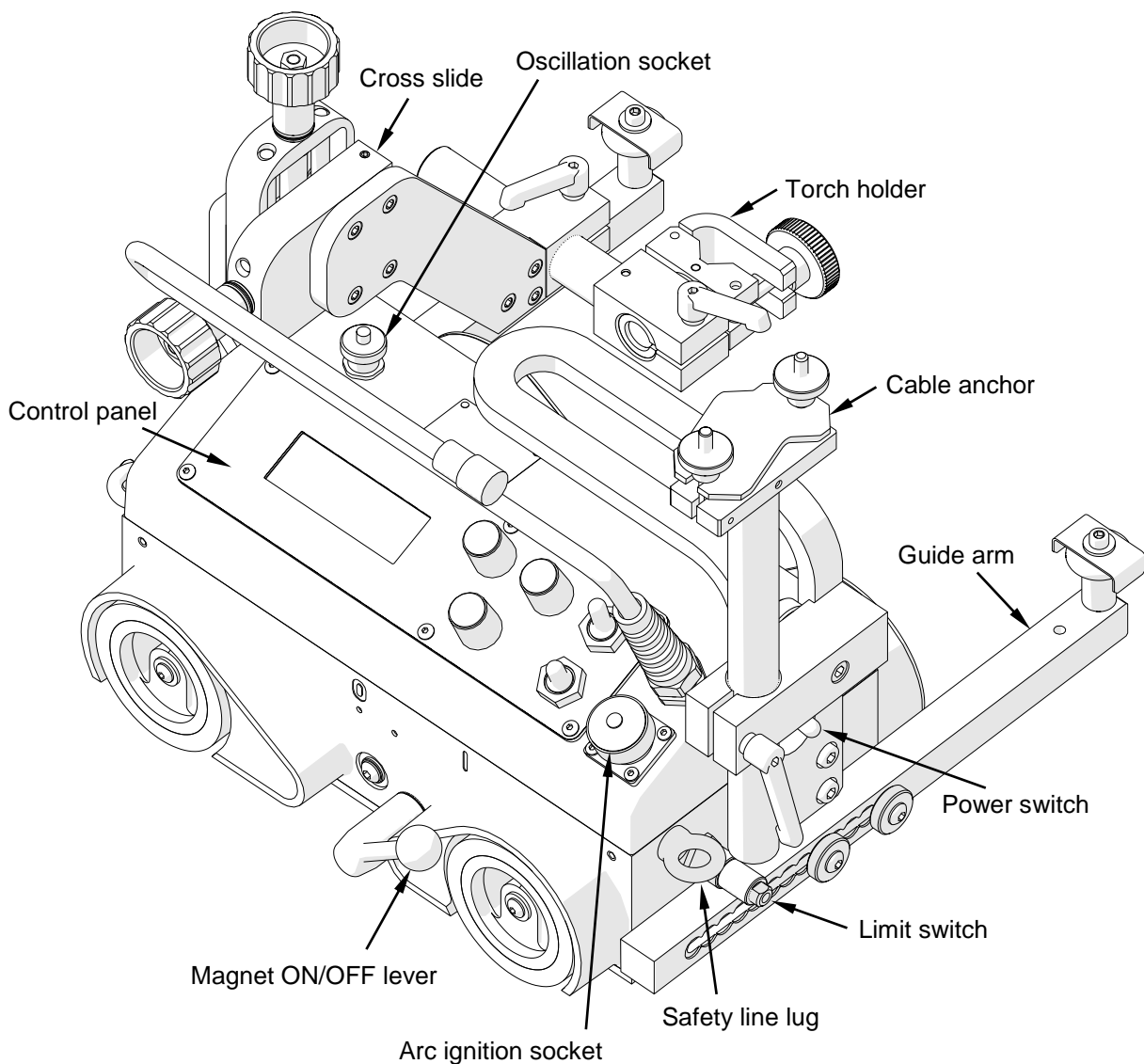


Fig. 1. View of the LIZARD

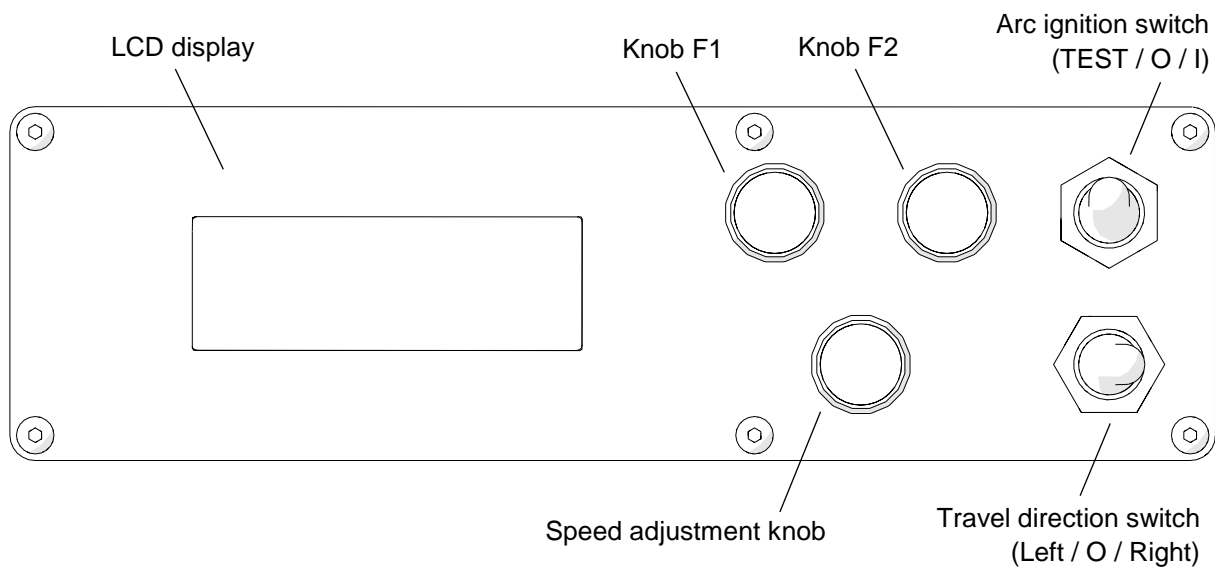


Fig. 2. View of the control panel

1.4. Equipment included

The LIZARD is supplied including the following elements.

Carriage	1 unit
Foam filled cardboard box	1 unit
Cable anchor	1 unit
Short rod torch holder with clamp	1 unit
3 m (10 ft) power cord	1 unit
6.5 m (21 ft) arc ignition cable	1 unit
4 mm hex wrench	1 unit
Operator's Manual	1 unit

2. SAFETY PRECAUTIONS

1. Before beginning, read this Operator's Manual and complete proper occupational safety and health training.
2. Use the carriage only in applications specified in this Operator's Manual.
3. The carriage must be complete and all parts must be genuine and fully operational.
4. The specifications of the power source must conform to those specified on the rating plate.
5. Plug the carriage into a properly grounded power source.
6. Never carry the carriage by the cords or the arc ignition cable and never pull them as this may damage them and result in electric shock.
7. Untrained bystanders must not be present near the carriage.
8. Before beginning, make sure that the correct is the condition of the carriage, power source, cords, arc ignition cable, plugs, control panel, and wheels.
9. Keep the carriage dry. Exposure to rain, snow, or frost is prohibited.
10. Keep the work area well lit, clean, and free of obstacles.
11. Never use near flammable liquids or gases, or in explosive environments.
12. Make sure that the rubber of the wheels is clean and not damaged.
13. Never disassemble the cover of the wheels.
14. Remove objects attracted to the chassis by the magnet.
15. Transport and position the carriage using the carrying handle and only when the magnet ON/OFF lever is set to the position 'O'.
16. Position the carriage on the ferromagnetic workpiece in such a way that the wheels are in contact with the surface and there is no contact between the surface and the chassis.
17. Do not stay below the carriage placed at heights.
18. Plug the cords and the arc ignition cable only when the power switch is set to the position 'O'.
19. Keep the sockets clean. Do not use compressed air for cleaning.
20. Install only MIG/MAG torches with the handle diameter corresponding to the torch holder in use.
21. Position the torch not more than 80 mm (3.15") outward from the left or right side of the carriage.

22. Keep the torch cables from coming in contact with the surface. They must be suspended to reduce the load of the carriage. Use only cables whose weight is not more than 12 kg (27 lbs) for horizontal work and 8 kg (18 lbs) for vertical work.
23. Operating on curvatures with a convex or concave radius less than 1500 mm (5 ft) is prohibited.
24. When operating at heights, use a safety line to protect the carriage from dropping.
25. Always use eye protection (helmet, shield, and screen), hearing protection, gloves, and protective clothing during operation. Do not wear loose clothing.
26. Before every use, inspect the carriage to ensure it is not damaged. Check whether any part is cracked or improperly fitted. Make sure to maintain proper conditions that may affect the operation of the carriage.
27. Never try to manually stop the motion of the carriage. To stop, set the travel direction switch to the position 'O'.
28. Maintain only when the carriage is unplugged from the power source.
29. Repair only in a service center appointed by the seller.
30. If the carriage falls from any height, is wet, or has any other damage that could affect the technical state of the carriage, stop the operation and immediately send the carriage to the service center for inspection and repair.
31. Never leave the carriage unattended during operation.
32. Remove from the worksite and store in a secure and dry location when not in use.

3. STARTUP AND OPERATION

3.1. Preparing

Use the carrying handle to transport the carriage to the worksite. Then, set to the position 'O' all the switches (power, travel direction, and arc ignition switch) and the magnet lever.

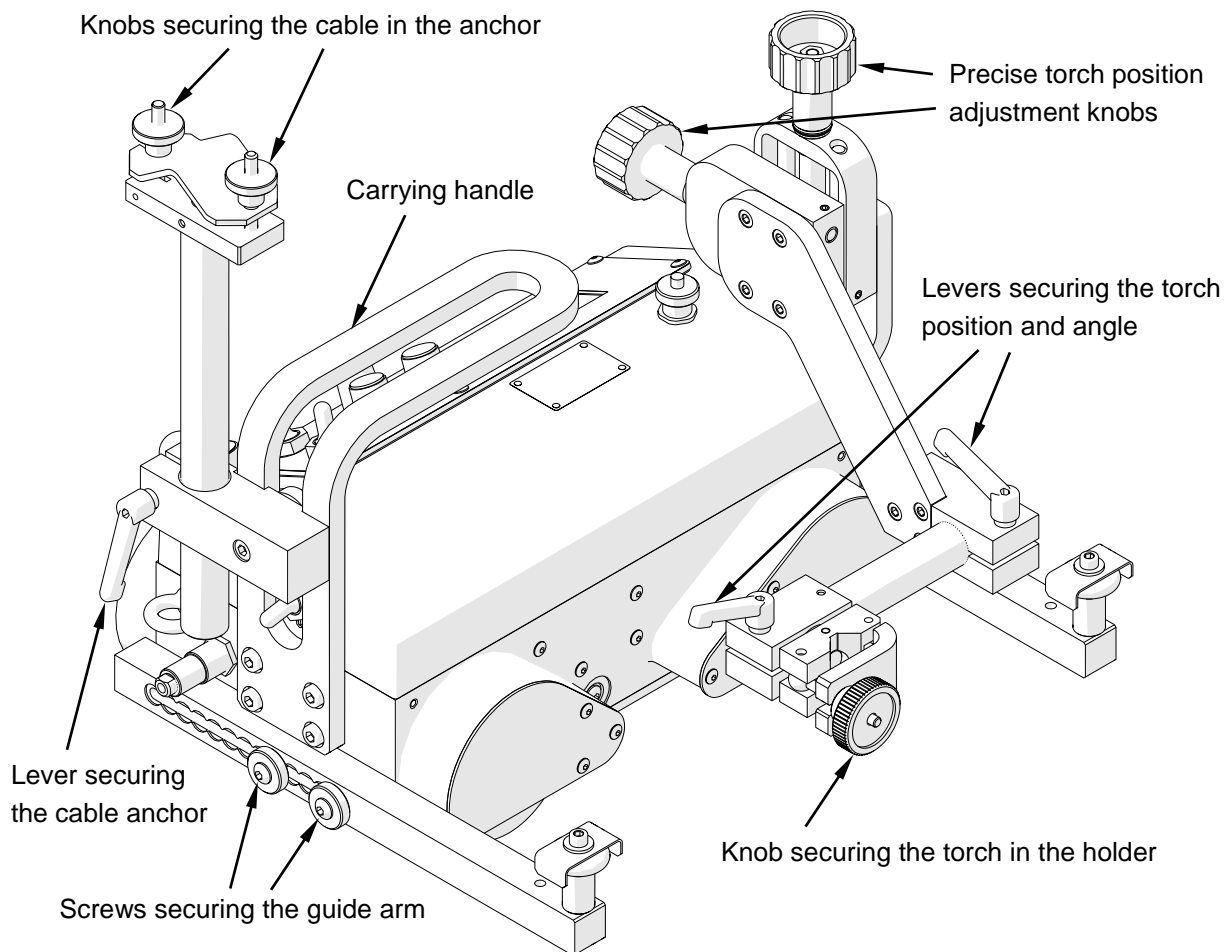


Fig. 3. View from the back side

Connect the carriage to the power source, insert the torch into the torch holder, and then secure it with the knob. Next, insert the torch cable into the cable anchor, secure it with the knobs, and then fix the anchor in the required position using the lever.

3.2. Connecting to welding circuits

The carriage can control two torches using the arc ignition cable plugged into the arc ignition socket. To do this, connect any blue-jacketed wire to any terminal of the welding circuit, and then connect the second blue-jacketed wire to the second terminal of the same circuit, according to the diagram shown in Fig. 4. To control the second torch, connect the green-jacketed wires to the terminals of the second welding circuit.

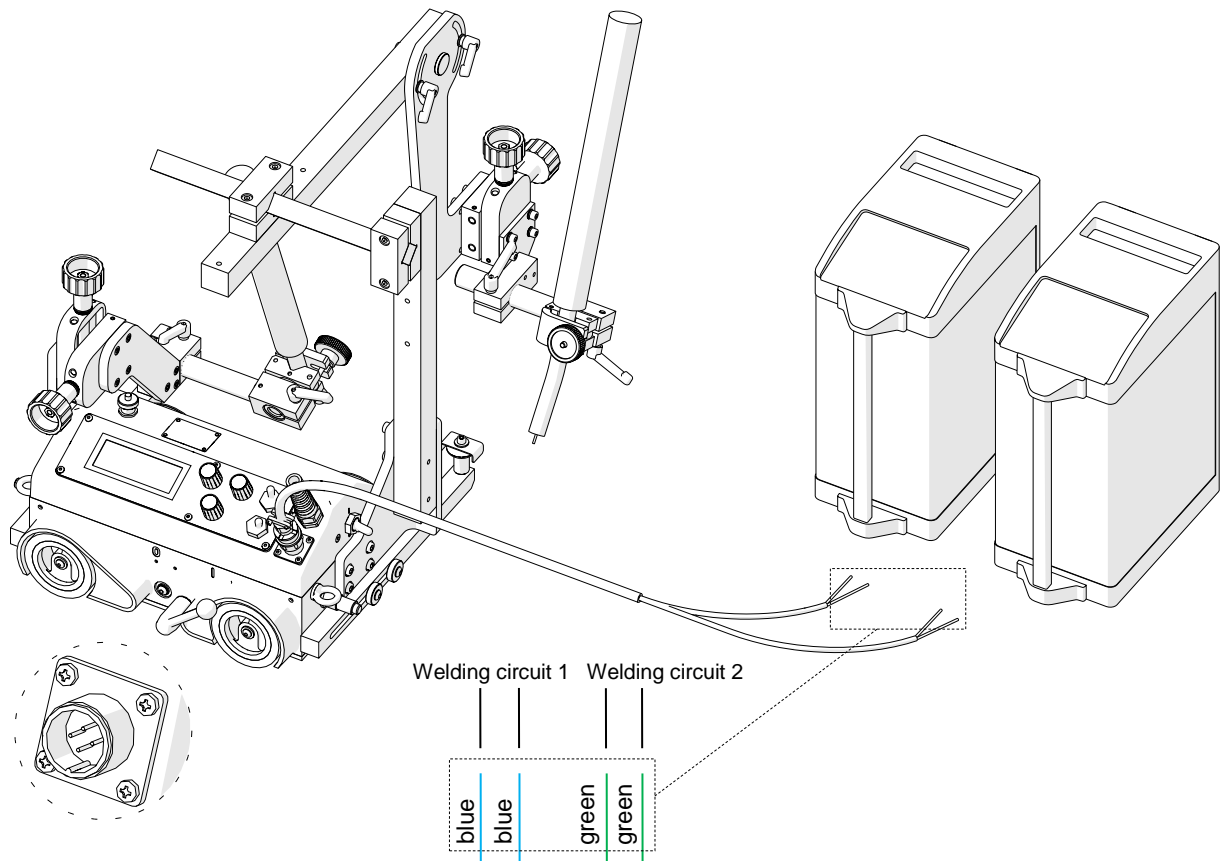


Fig. 4. Connecting the arc ignition cable to welding circuits

To check whether the arc ignition cable is connected correctly, power the carriage by setting the power switch to the position 'I', and set the arc ignition switch to the position TEST, which should enable the arc for a while.

3.3. Positioning at the worksite

The guide arms must be positioned so that the carriage is in constant contact with the workpiece. They can be set by a constant step (interval adjustment), or continuously after they are swapped (continuous adjustment). To set them properly when the carriage travels to the left, use the 4 mm hex wrench to loosen the screws securing the right guide arm, move out the right arm about 10 mm (0.4") or one groove more than the left arm (Fig. 5), and then retighten the screws.

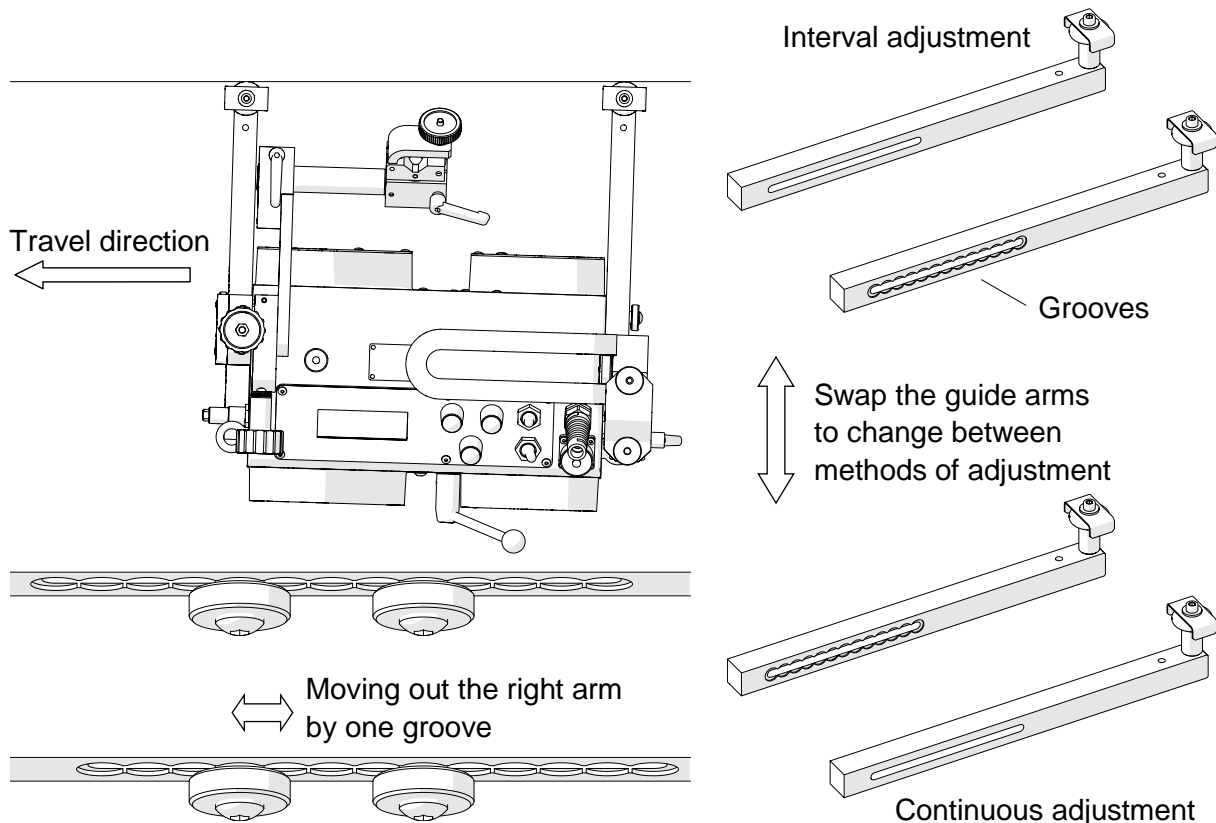


Fig. 5. Proper positioning of the guide arms

Switch the magnet ON/OFF lever from left ('O') to right ('I'), which will change the clamping force from minimum to maximum. Loosen the levers to adjust the position and angle of the torch, and set the torch position precisely using two knobs located at the cross slide. When operating at heights, attach a safety line to the lug to prevent possible injury if the carriage loses the clamping. The safety line is not included in standard equipment.

3.4. Starting

Plug the power cord into the power source and turn on the power by setting the power switch to the position 'I'. The initial screen with the version number of the current firmware will show on the display, and the carriage will automatically check for an oscillator connected to the oscillation socket. If the oscillator is connected, `Oscillator found` confirmation message will show. After the initialization of the control system, the main menu from Fig. 6 will show on the display.

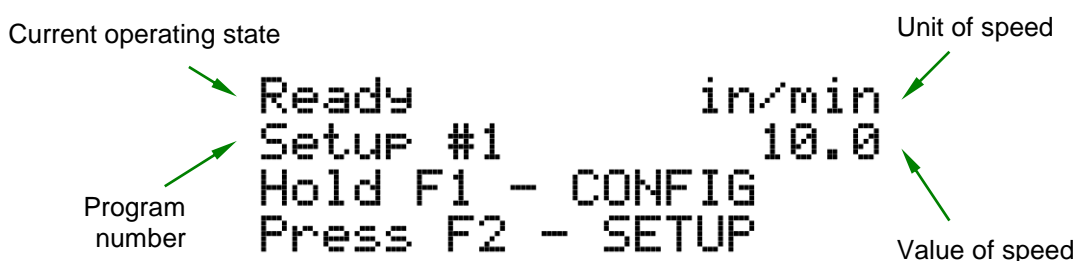


Fig. 6. Example of the main menu

Press and hold the knob F1 for about 3 seconds to enter into the configuration menu to set welding parameters.

3.5. Programming

The LIZARD welding carriage allows defining up to 40 welding programs. After entering into the configuration menu, proceed as described in Fig. 7 to move among the parameters from Tab. 1.

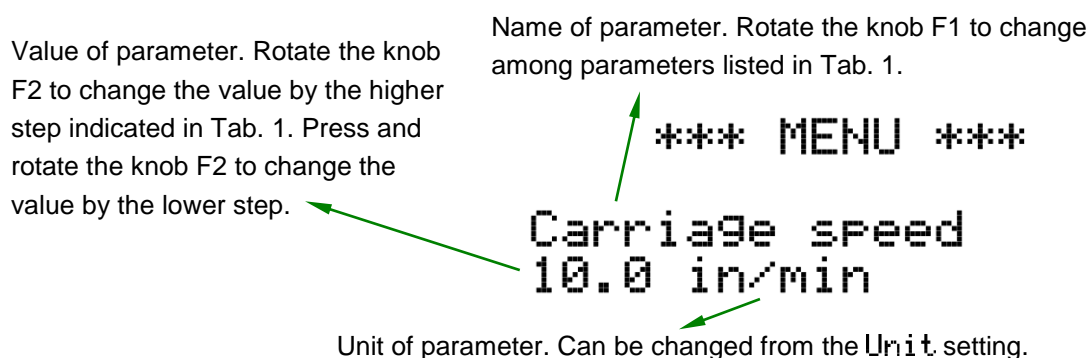


Fig. 7. Configuration menu

Parameter	Value	Description
Carriage speed	0–130 cm/min 0–52 in/min [step: 1 or 0.1]	Speed of the carriage.
Weld length	1–250 cm 1–100 in [step: 1 or 0.1]	Length of the single weld.
Skip	0–100 cm 0–40 in [step: 1 or 0.1]	Space between welds. If set to zero, 'crater fill' and 'backweld' are reset and the carriage works in the continuous welding mode.
Crater fill	0–3 s [step: 0.1]	Time of filling the crater. Inactive if 'skip' set to zero, which is indicated by the (!) sign.
Current lowering	YES NO	Function of the welding source to lower the current of the arc while filling the crater. Time of filling the crater must be set higher or equal to the time of the current lowering that is set at the welding source.
Backweld	0–2 cm 0–2 in [step: 0.1]	Length of the backweld. Shorter or equal to 'weld length'. Inactive if 'skip' set to zero, which is indicated by the (!) sign.
Total length	0–1000 cm 0–400 in infinity [step: 10 or 1]	Longer or equal to the sum of 'weld length' and 'skip'. If set to infinity, the program executes until the carriage is stopped manually.
Unit	cm in	Unit used in the menu.
Save setup	1–40	Pressing knob F2 saves the current configuration under the indicated program number.
Load setup	1–40	Pressing knob F2 loads the configuration saved under the indicated program number.
Language	ENGLISH POLISH SPANISH FRENCH PORTUGUESE TURKISH GERMAN RUSSIAN	Language of the menu.

Tab. 1. Settings available in basic version of LIZARD

To change the language of the menu, go to `Language` setting by rotating the knob F1 to the right, and then rotate the knob F2 to choose among the available languages. After the rest of the parameters from Tab. 1 is set, go to `Save setup`, choose a program number by rotating the knob F2, and press the knob to save the current values under this number. The action is confirmed by showing `Done` message for a short period. To load a previously saved program, proceed as described, but from `Load setup` setting. Then, to go back to the main menu (Fig. 6), press the knob F1 and hold it for 3 seconds. If the chosen parameters are not saved, they will be active only until the current program number is changed in the main menu.

3.6. Welding procedure

Fig. 8 shows a graphic description of the welding procedure that starts with the speed value shown in the main menu when selecting a travel direction. The first stage involves producing the weld, after which the carriage fills the crater (stage 2) for the chosen time. Next, the carriage performs the backweld (stage 3) and then moves to the starting point of the next weld (stage 4). This process is repeated until the carriage reaches the value of the total length.

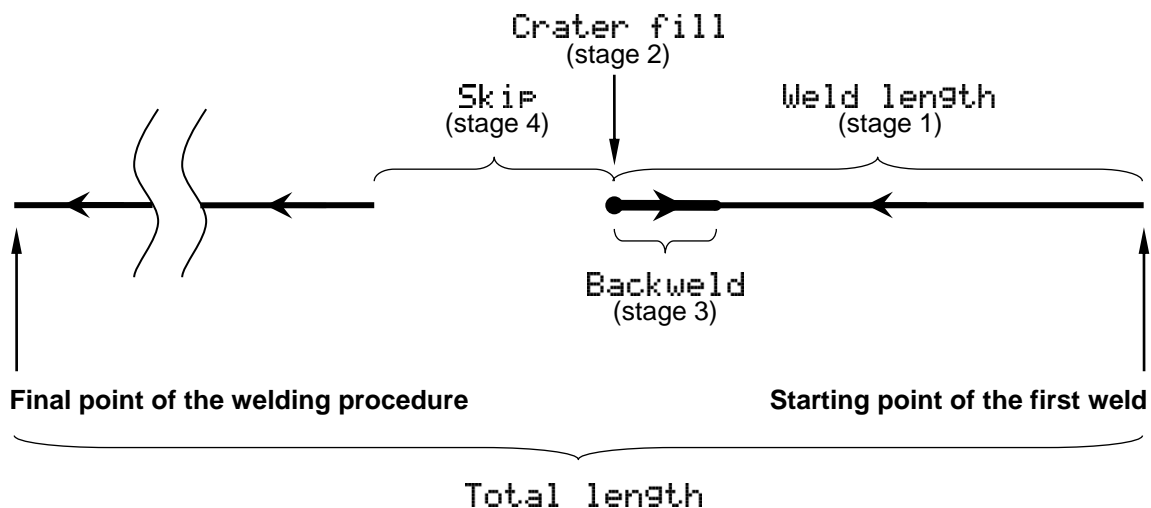


Fig. 8. Visualization of the welding procedure according to parameters from Tab. 1

3.7. Operating

After setting the power switch to the position 'I', the carriage will turn on. If the carriage is to control the torch, set the arc ignition switch to the position 'I'.



CAUTION! If the arc ignition switch is set to position 'I', the torch will start welding immediately after selecting a travel direction.

With Ready state shown on the main menu (Fig. 6) the current program Setup #1 can be changed by simultaneously pressing and rotating the knob F2. Use the speed adjustment knob to change the current welding speed. Right rotation increases the speed by the step of 0.1, and left rotation decreases the speed by the same step.

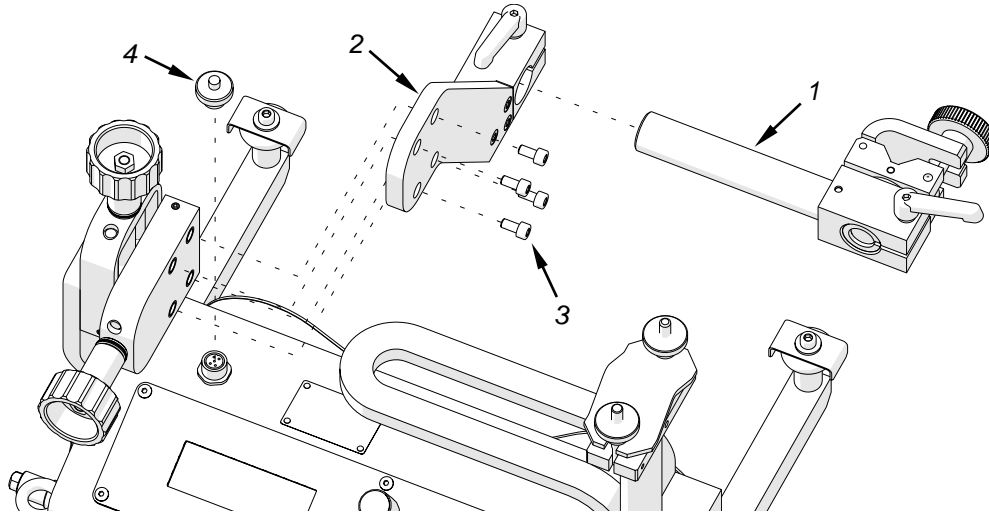
Use the travel direction switch to select a direction of motion. The carriage will start moving according to the chosen program parameters. The indication of the current operating mode will show on the display during program execution. The carriage speed can be adjusted during operation using the speed adjustment knob; however, the new speed will not be saved if the current program changes in the meantime.

The carriage stops after reaching the total length and Job's done confirmation message shows on the display. Then, set the travel direction switch to the position 'O' to go into the main menu. After the work is finished, turn off the power using the power switch and unplug the carriage from the power source.

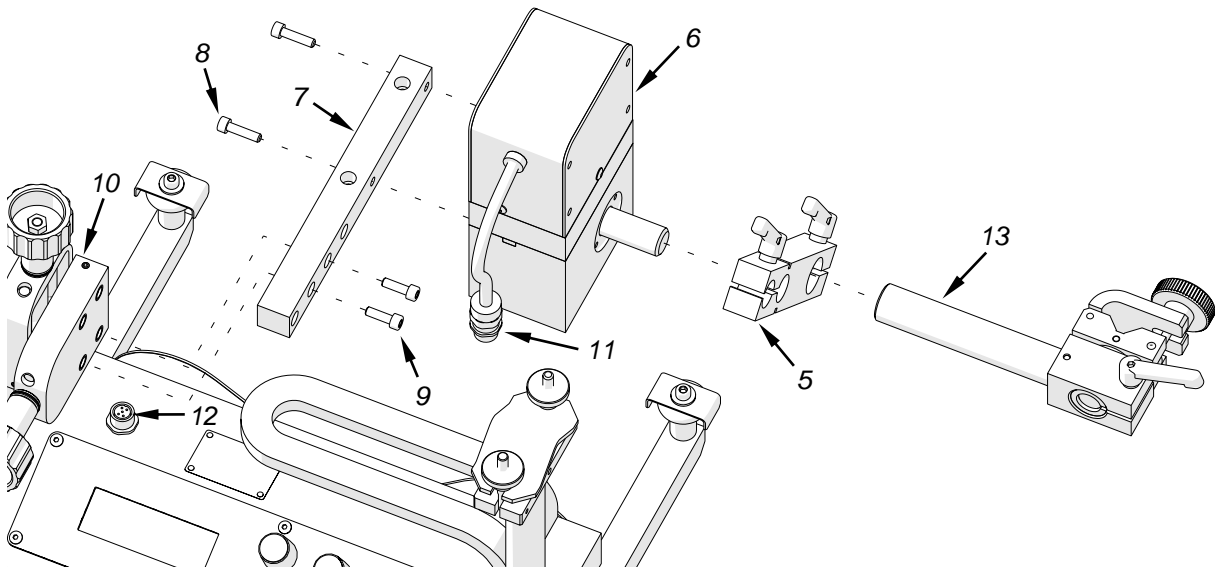
3.8. Using oscillator (accessory)

3.8.1. Installing

Install the oscillator according to the following instructions.



- Remove the torch holder 1.
- Remove the torch holder plate 2 by unscrewing screws 3 using 4 mm hex wrench.
- Unscrew the cap 4.



- Fix the arm 5 to the oscillator 6.
- Fix the oscillator 6 to the bracket 7 using two M5x20 screws 8.
- Fix the bracket 7 to the cross slide 10 using two M5x16 screws 9.
- Fix the oscillator plug 11 to the oscillation socket 12.
- Fix the low torch holder 13 to the oscillator arm 5.

3.8.2. Welding with oscillation

If the oscillator is connected to the LIZARD welding carriage, several new settings will appear in the menu (Tab. 2). Welding with oscillation is performed in the standard manner, however, produced welds form a shape similar to the shape shown in Fig. 9 instead of the straight line from Fig. 8.

Parameter	Value	Description
Osc. amplitude	0–100% [step: 10% or 1%]	Relative amplitude of the oscillation.
Osc. speed	0–100% [step: 10% or 1%]	Relative speed of the oscillation. The higher the speed, the shorter the oscillation period.
Osc. delay 1	0–5 s [step: 1 or 0.1]	Delay in the top position of the oscillation.
Osc. delay 2	0–5 s [step: 1 or 0.1]	Delay in the bottom position of the oscillation.
Dwell times lock	YES NO	Choosing YES locks the capability of changing delay times during welding.

Tab. 2. Additional settings available with connected oscillator

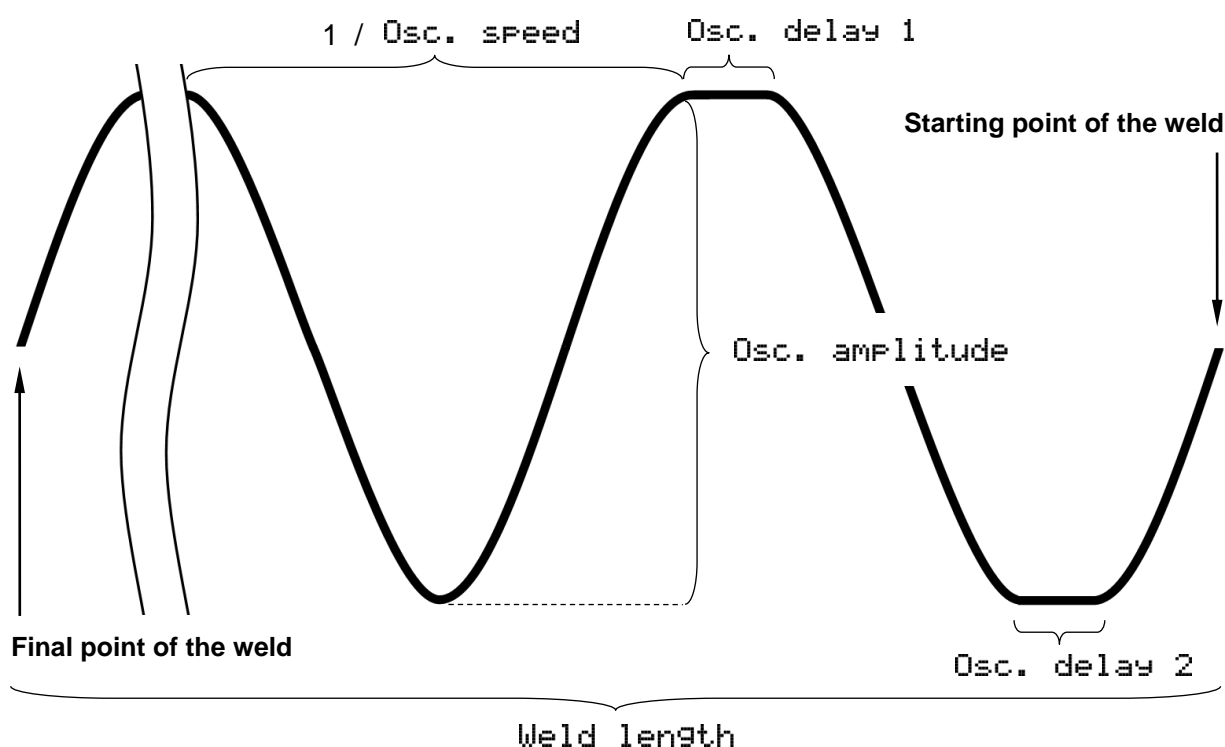


Fig. 9. Graphic description of the oscillation parameters from Tab. 2

3.8.3. Operating

The LIZARD welding carriage with connected oscillator is operated similarly to operating without the oscillator. During welding with the oscillator, the menu indicated in Fig. 10 is shown on the display.

Welding	in/min	
Setup #1	10.0	
F1 - amplitude:	100%	Rotation of the knob F1 changes the oscillation amplitude by 1%.
F2 - speed:	100%	Rotation of the knob F2 changes the oscillation speed by 1%.

Fig. 10. Menu shown during welding with the oscillator

If Dwell times lock parameter is set to YES, pressing the knob F1 or F2 during operation will not trigger any action. Otherwise, the delay parameters will show on the display and can be adjusted online (Fig. 11).

Welding	in/min	
Setup #1	10.0	
F1 - delay 1:	5.0 s	Rotation of the knob F1 changes the delay 1 by 0.1 s. Pressing the F1 switches from showing delay 1 to oscillation amplitude.
F2 - delay 2:	5.0 s	Rotation of the knob F2 changes the delay 2 by 0.1 s. Pressing the F2 switches from showing delay 2 to oscillation speed.

Fig. 11. Menu for changing the oscillator dwell times

3.9. Troubleshooting

Problem	Cause	Solution
Dark LCD display after powering.	Malfunction of the power cord, power switch, power supply unit, or controller.	Contact service center for inspection and repair.
Anomalies on the LCD display. Impossible to read the values.	Malfunction of the display or power supply unit.	Contact service center for inspection and repair.
*** FATAL ERROR *** FRONT limit switch activated	Carriage reached the obstacle at the front.	Remove the obstacle blocking the movement of the carriage or choose the opposite travel direction.
*** FATAL ERROR *** REAR limit switch activated	Carriage reached the obstacle at the rear.	Remove the obstacle blocking the movement of the carriage or choose the opposite travel direction.
*** FATAL ERROR *** Travel switch incorrect signal	Too fast switching between left and right travel direction.	Set the travel direction switch to the position 'O'.
Set travel switch to zero	1. Travel direction switch not in position 'O' when powering. 2. Displayed during motion indicates a malfunction of the travel direction switch or travel direction identification circuit of the controller.	1. Set the travel direction switch to the position 'O'. 2. Contact service center for inspection and repair.

4. MAINTENANCE

Daily:

1. Clean the chassis and the wheels.
2. Clean the rollers of the guide arms and make sure that the rollers rotate freely.
3. Clean the torch nozzle. Replace if damaged.

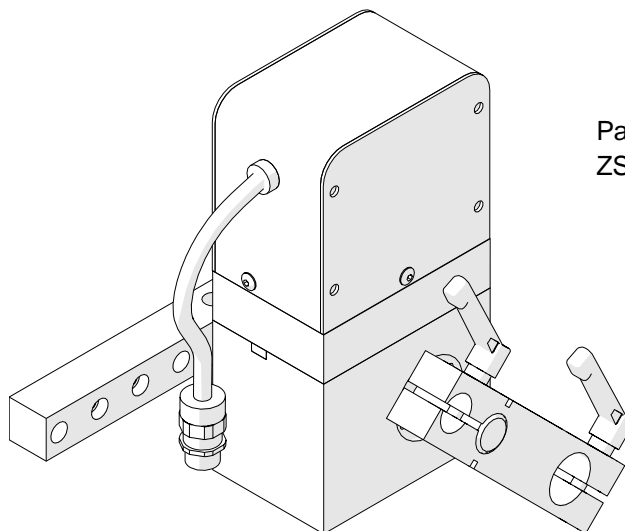
Monthly:

1. Check whether the knobs and the switches operate as intended. Replace if loose or damaged.
2. Inspect cables, cords, and hoses. Replace if damaged.
3. Tighten screws if loose.

5. ACCESSORIES

5.1. Oscillator

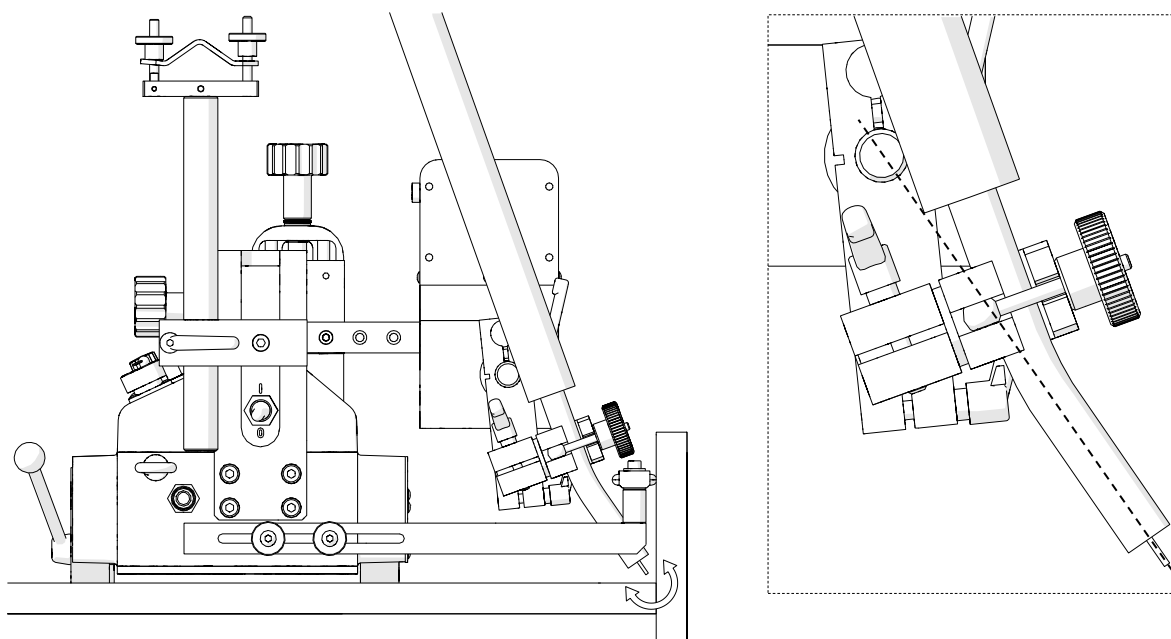
Allows welding with oscillation. Can be installed vertically or horizontally.



Part number:
ZSP-0477-10-00-00-0

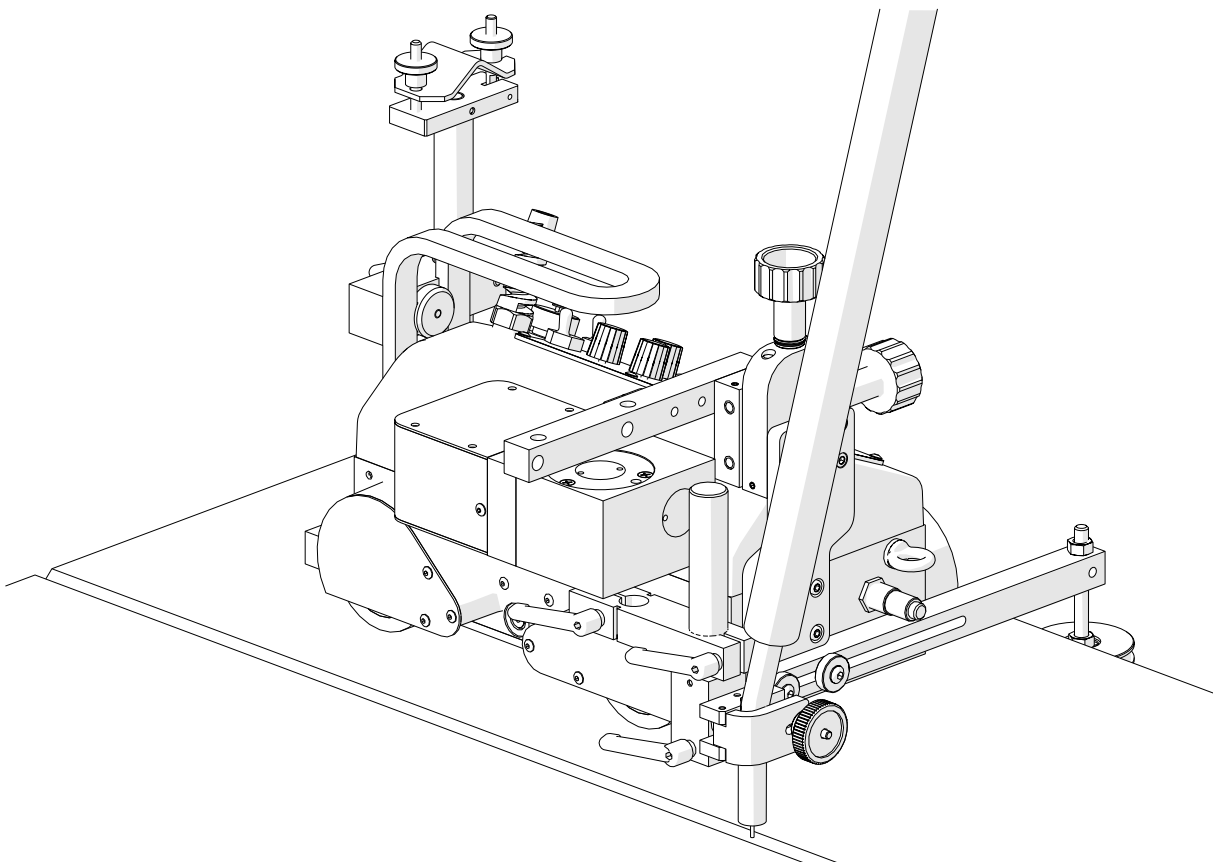
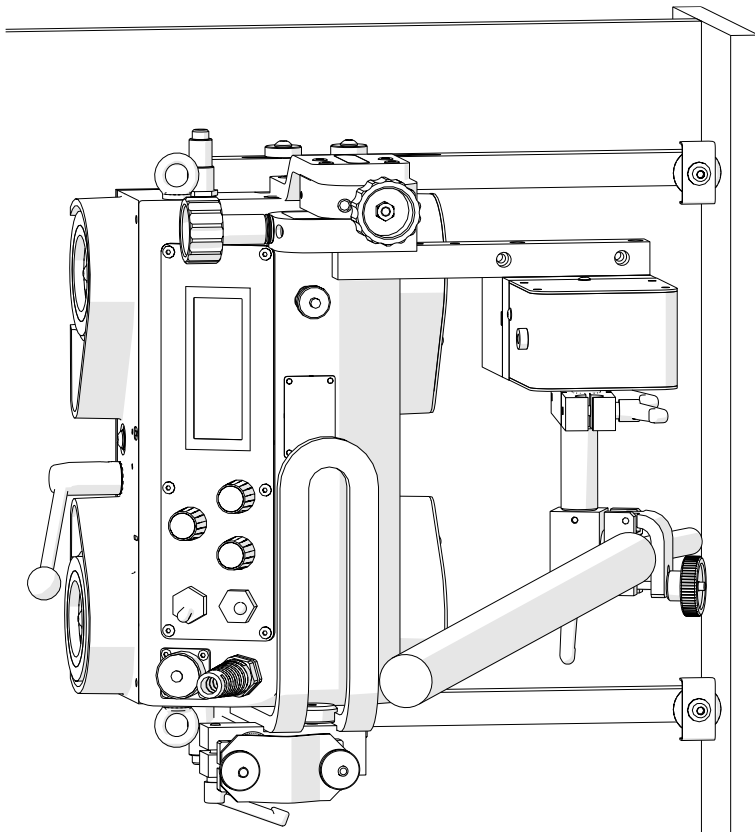
Oscillation type	pendulum (maximum 11°)
Oscillation amplitude at r=150 mm (5.9")	1–30 mm (1–100%)
Oscillation speed at oscillation amplitude of 10 mm (0.4") and zero delay on ends	7–164 cycles/min (1–100%)
Delay on ends	0–5 s
Maximum torque	5 Nm (3.7 lb·ft)
Power	12 W
Weight	2 kg (4 lbs)

To obtain the proper shape of oscillation, the axis of the oscillator's output shaft must cross with the axis of the torch.



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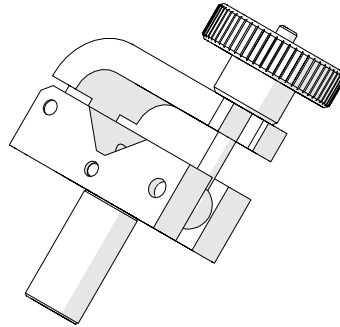
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5.2. 16–22 mm torch clamp

Allows using a torch with the handle diameter of 16–22 mm (0.63–0.87").

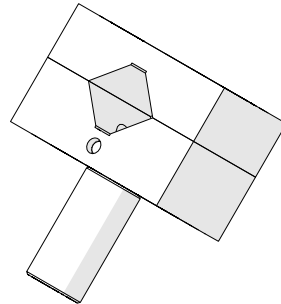
Part number:
ZRZ-0466-04-01-00-0



5.3. 16–22 mm torch clip

Allows using a torch with the handle diameter of 16–22 mm (0.63–0.87"). Tighten the torch in the clip using the 4 mm hex wrench.

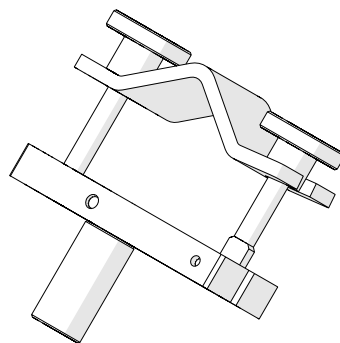
Part number:
ZCS-0476-06-01-00-0



5.4. 22–35 mm torch clamp

Allows using a torch with the handle diameter of 22–35 mm (0.87–1.38").

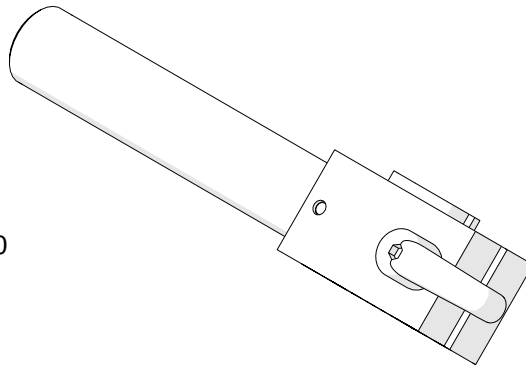
Part number:
ZRZ-0466-19-00-00-0



5.5. Short rod

Provides a 120 mm (4.72") reach.

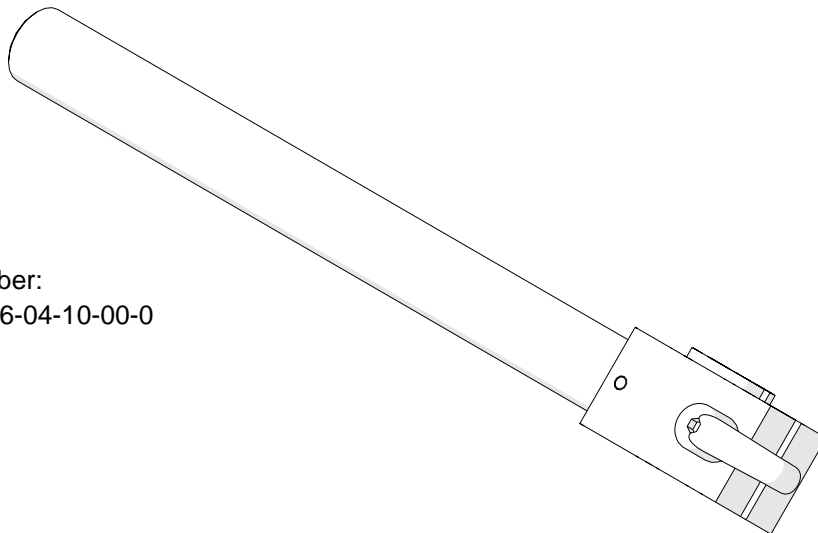
Part number:
WLK-0476-20-01-00-0



5.6. Long rod

Provides a 240 mm (9.45") reach.

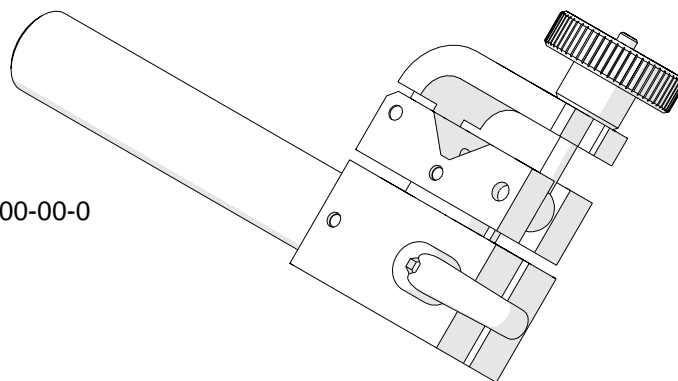
Part number:
WLK-0466-04-10-00-0



5.7. Short rod torch holder with clamp

Allows using a torch with the handle diameter of 16–22 mm (0.63–0.87").

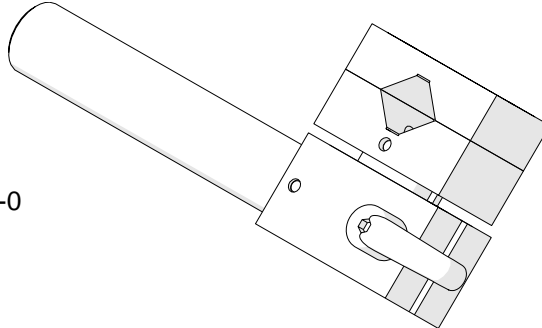
Part number:
UCW-0476-20-00-00-0



5.8. Short rod torch holder with clip

Allows using a torch with the handle diameter of 16–22 mm (0.63–0.87"). Tighten the torch in the clip using the 4 mm hex wrench.

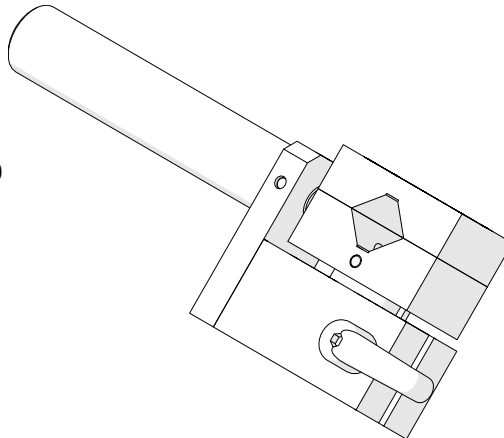
Part number:
UCW-0476-27-00-00-0



5.9. Short rod low torch holder with clip

Allows using a torch with the handle diameter of 16–22 mm (0.63–0.87"). Tighten the torch in the clip using the 4 mm hex wrench.

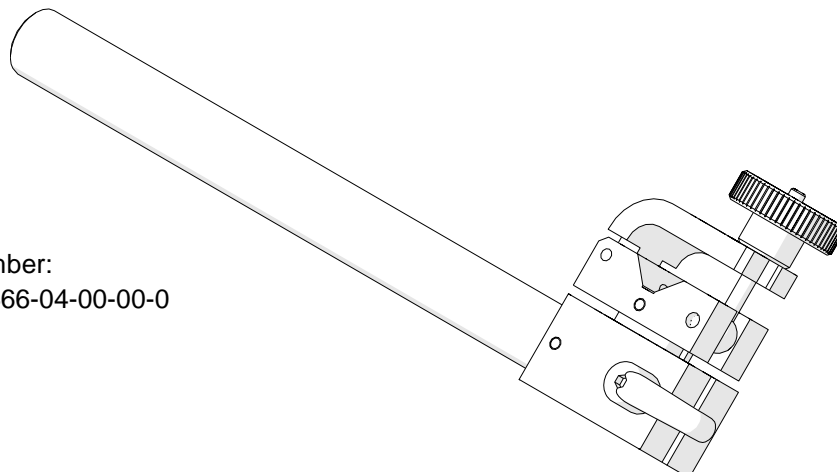
Part number:
UCW-0476-06-00-00-0



5.10. Long rod torch holder with clamp

Allows using a torch with the handle diameter of 16–22 mm (0.63–0.87").

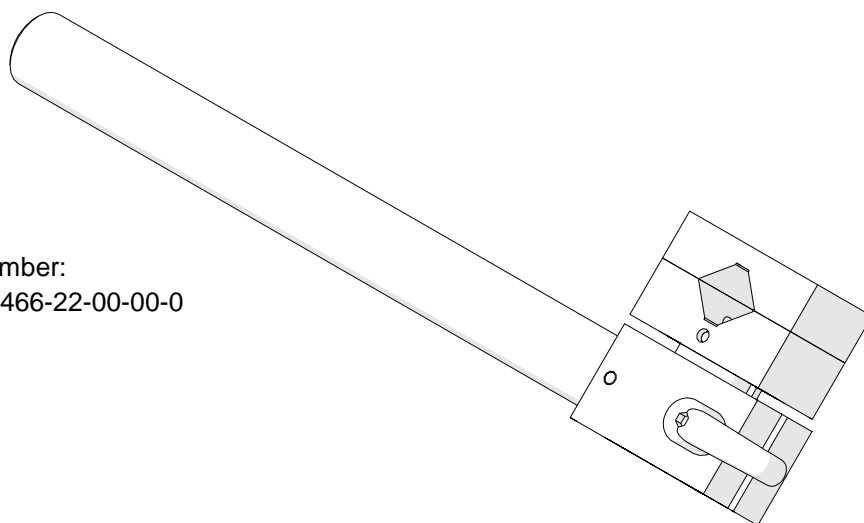
Part number:
UCW-0466-04-00-00-0



5.11. Long rod torch holder with clip

Allows using a torch with the handle diameter of 16–22 mm (0.63–0.87"). Tighten the torch in the clip using the 4 mm hex wrench.

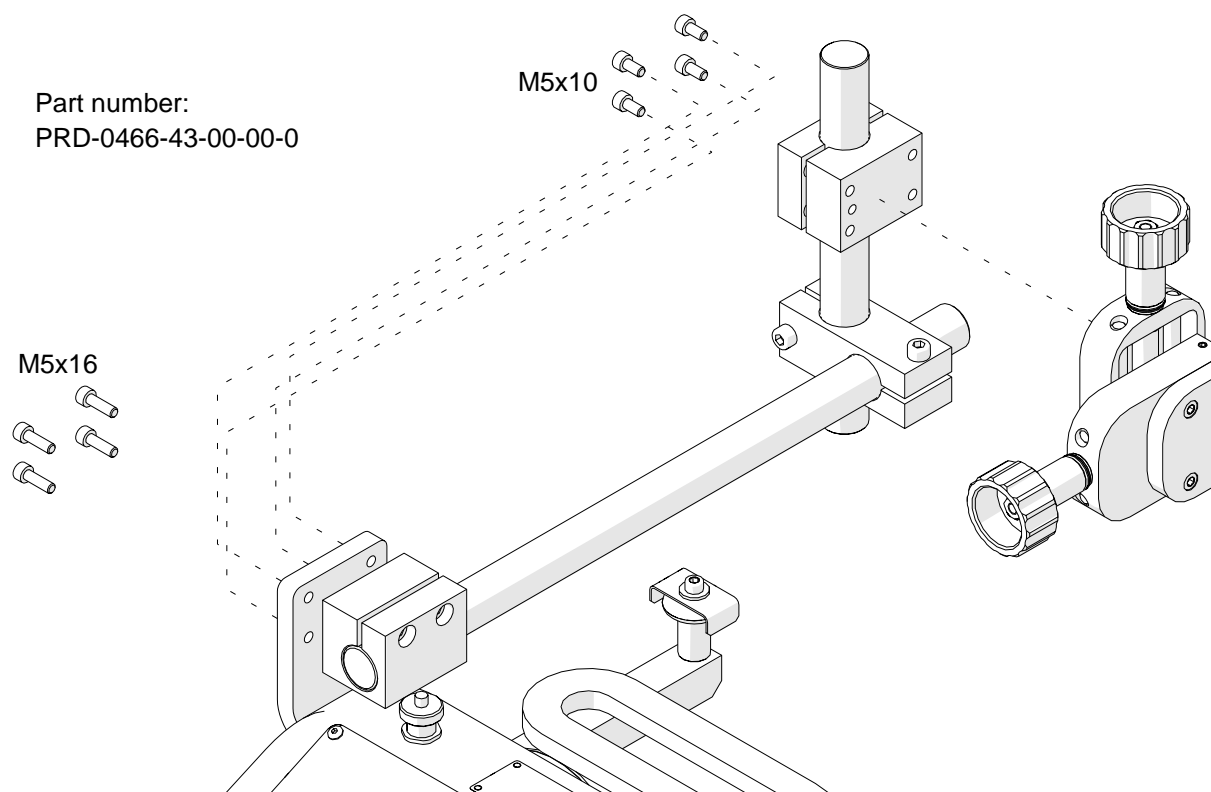
Part number:
UCW-0466-22-00-00-0



5.12. Torch extension arm

Extends the reach of the torch. To install the arm, unscrew the M5x10 screws fixing the cross slide using the 4 mm hex wrench and use the same screws to fix the cross slide at the end of the arm as shown in the figure. Fix the arm to the carriage using M5x16 screws.

Part number:
PRD-0466-43-00-00-0



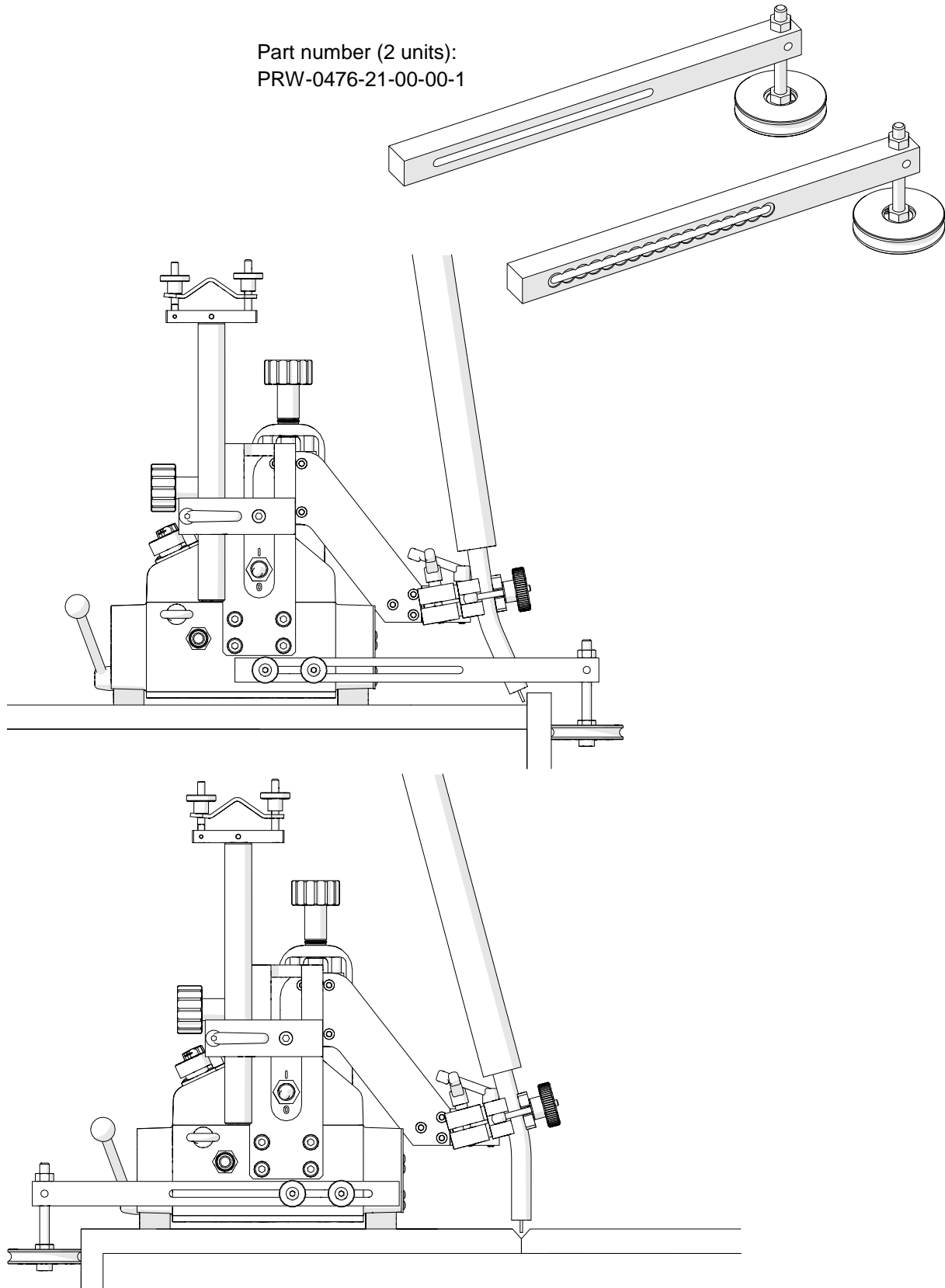
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5.13. Edge following guide arms

Allow guiding the carriage along outside edges. Install the guide arms after unscrewing the standard guide arms using the 4 mm hex wrench.

Part number (2 units):
PRW-0476-21-00-00-1



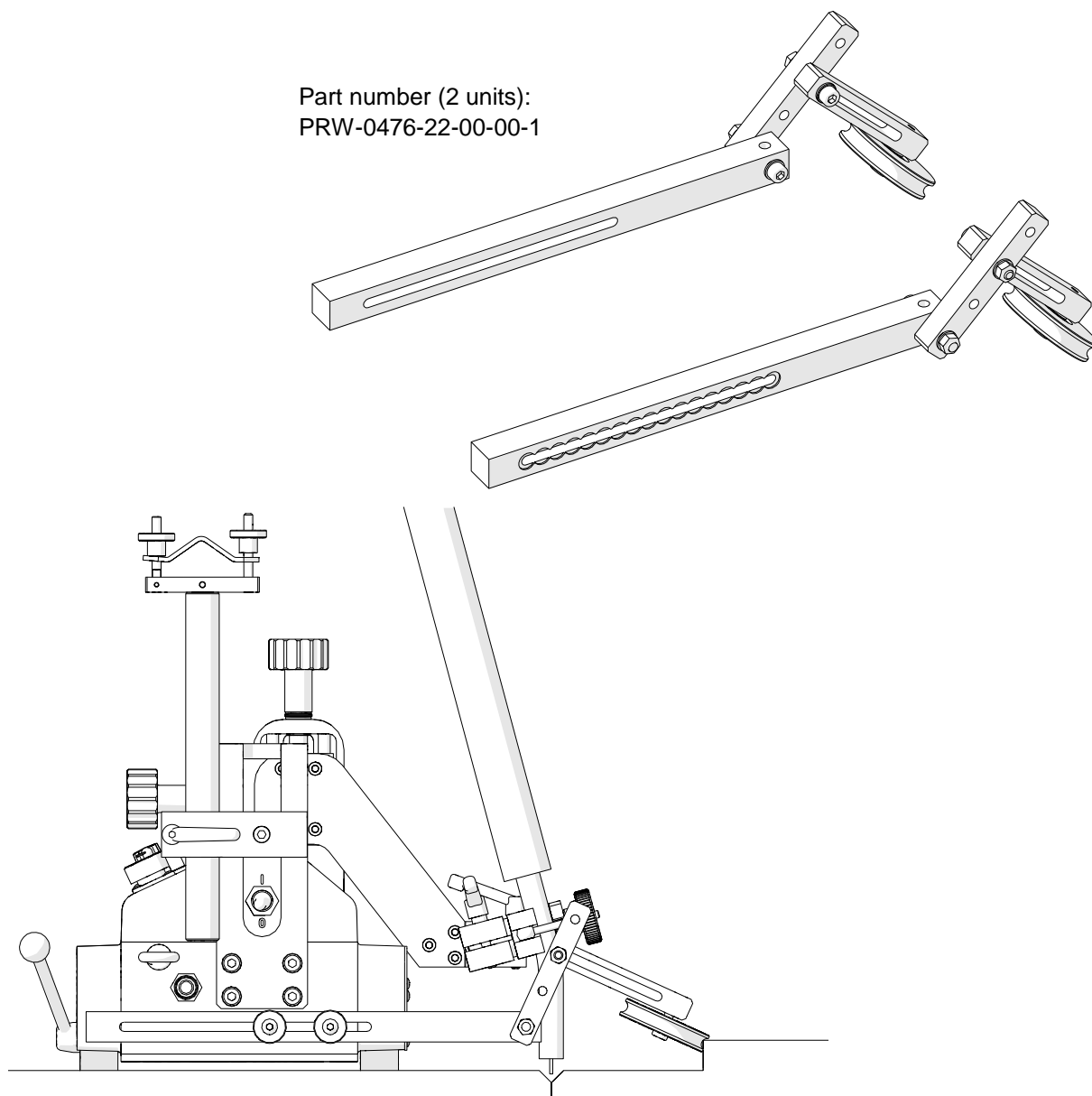
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5.14. Adjustable guide arms

Allow guiding the carriage along lap joints and templates. Install the guide arms after unscrewing the standard guide arms using the 4 mm hex wrench.

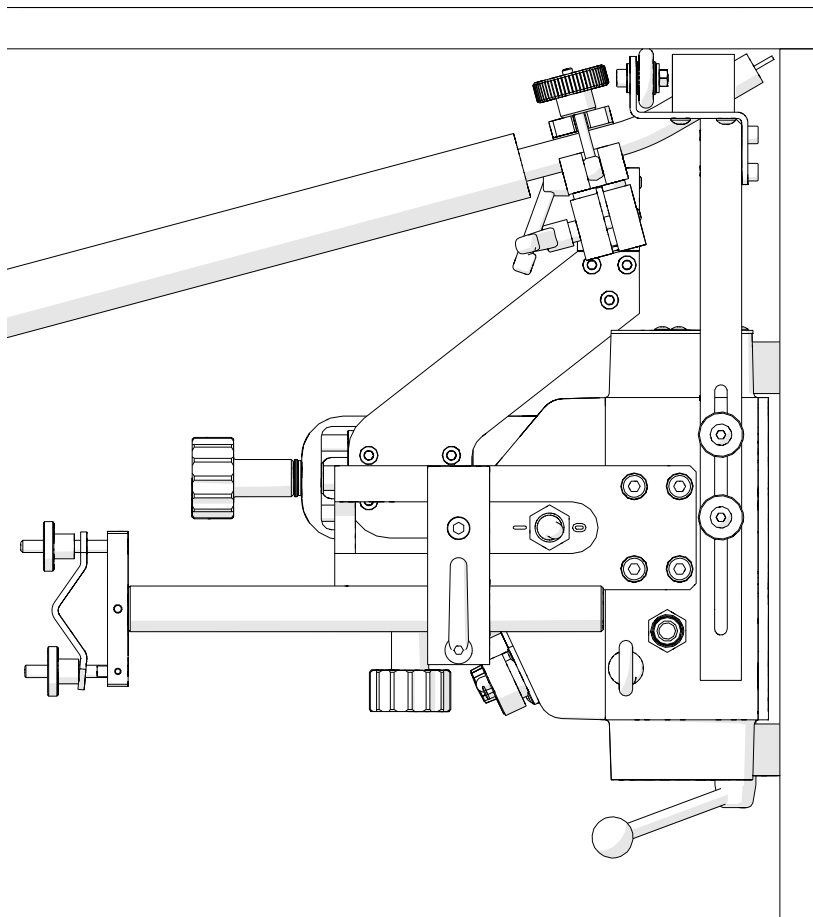
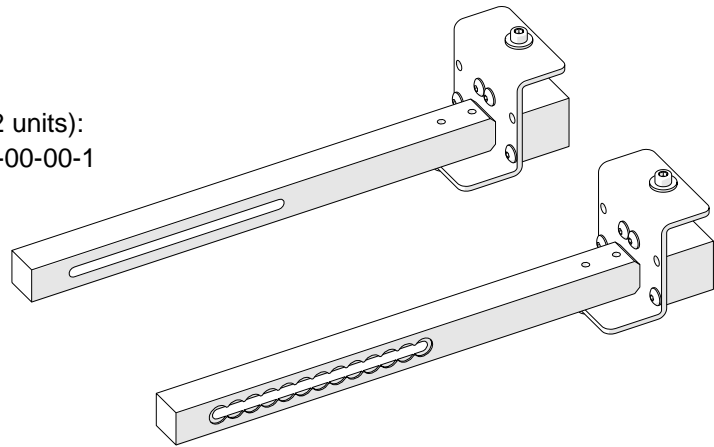
Part number (2 units):
PRW-0476-22-00-00-1



5.15. Magnet guide arms

Allow guiding the carriage on ceilings. Install the guide arms after unscrewing the standard guide arms using the 4 mm hex wrench.

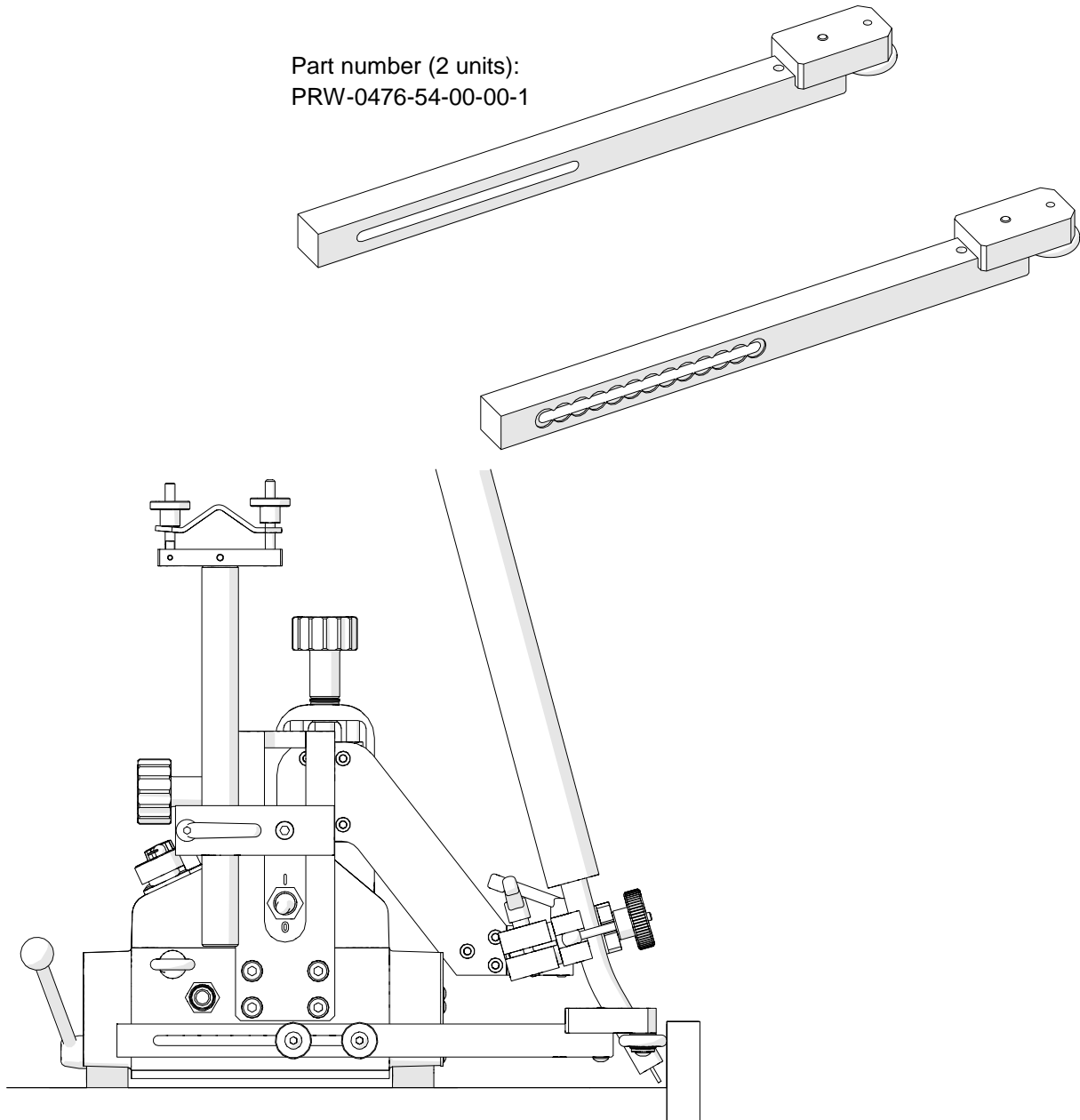
Part number (2 units):
PRW-0476-52-00-00-1



5.16. Low guide arms

Allow guiding the carriage along low walls. Install the guide arms after unscrewing the standard guide arms using the 4 mm hex wrench.

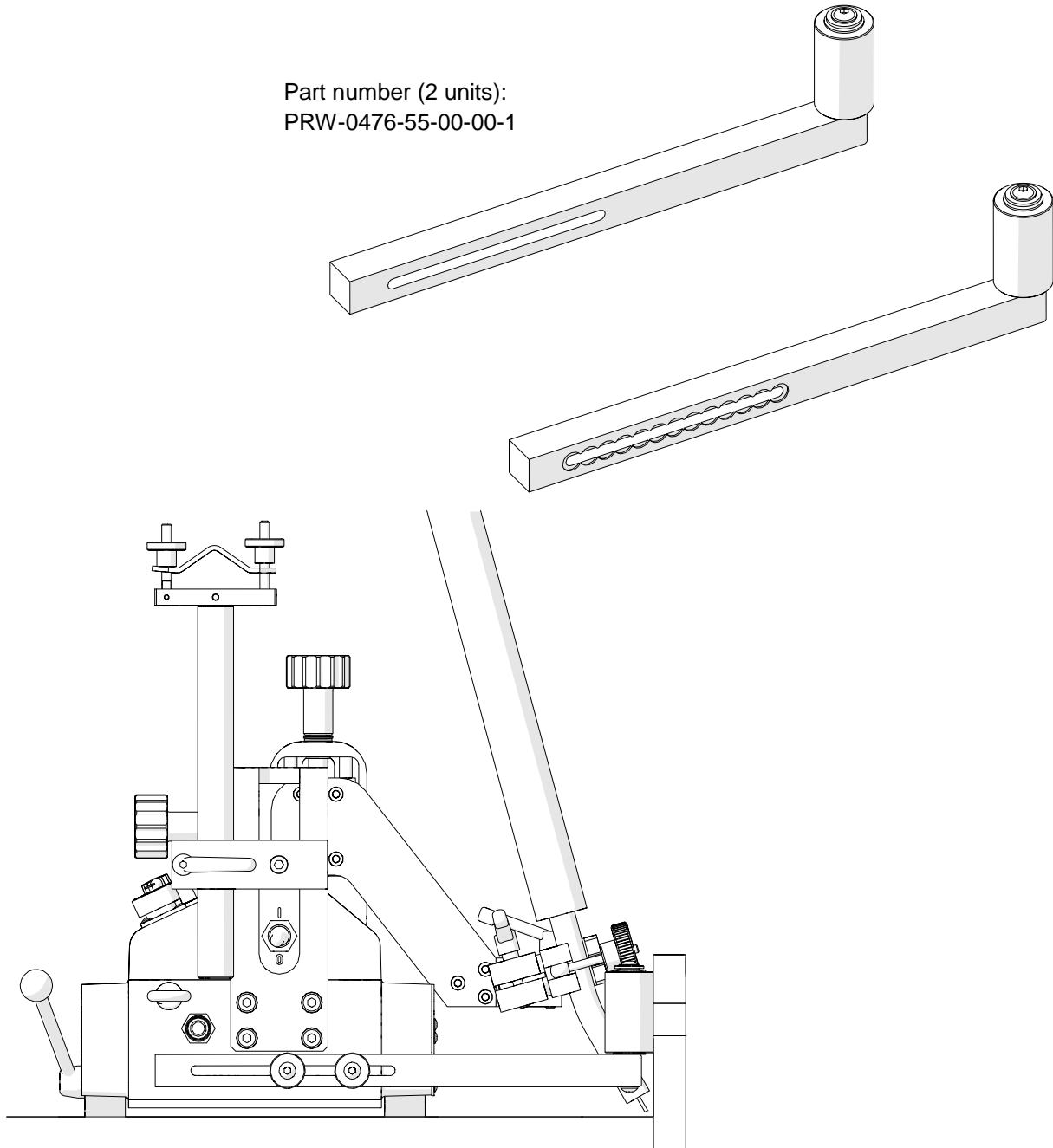
Part number (2 units):
PRW-0476-54-00-00-1



5.17. High guide arms

Allow guiding the carriage along walls with holes. Install the guide arms after unscrewing the standard guide arms using the 4 mm hex wrench.

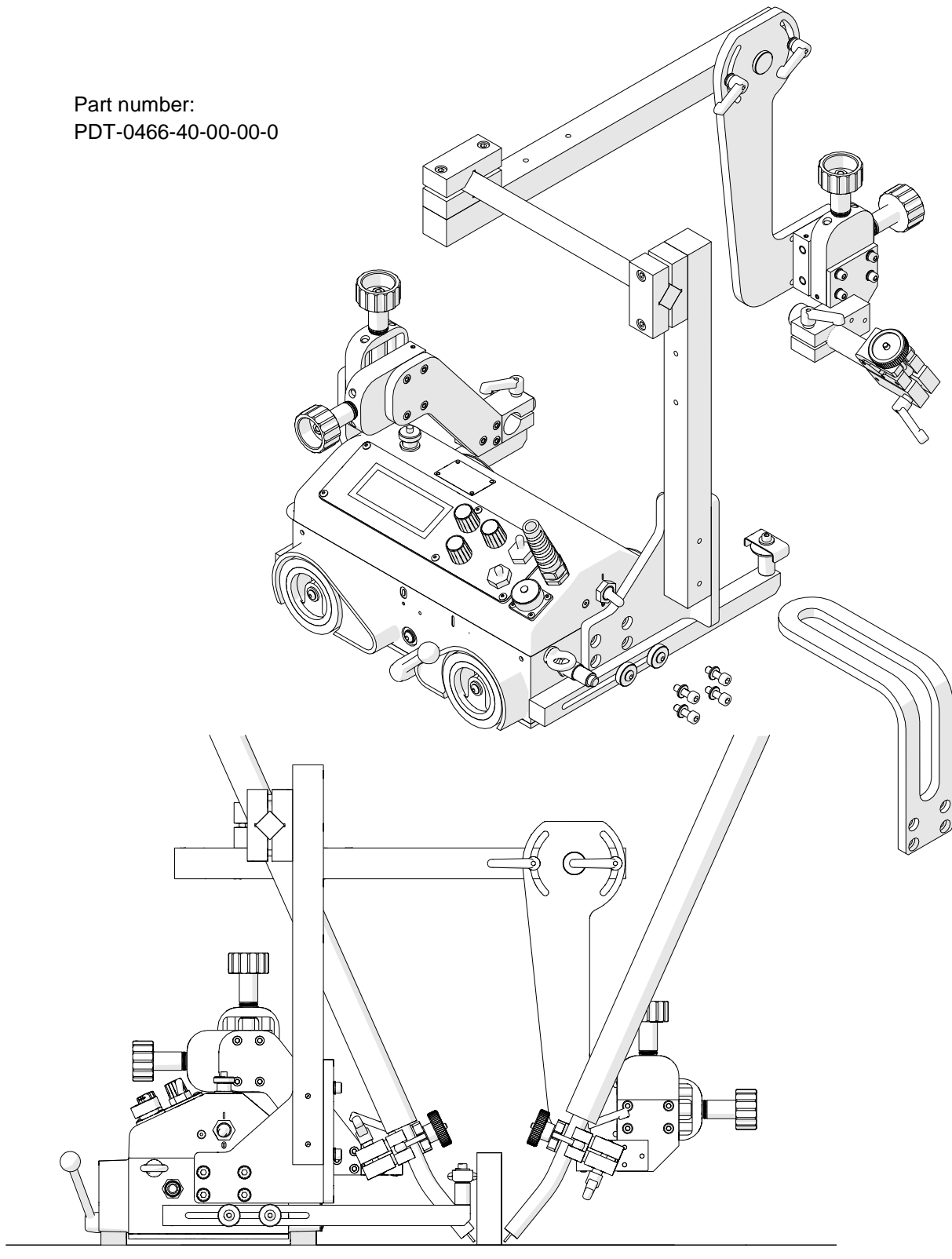
Part number (2 units):
PRW-0476-55-00-00-1



5.18. Dual torch mount

Allows using a second torch. Use the 5 mm hex wrench to unscrew the M6x20 screws and washers fixing the carrying handle, and then use the same screws and washers to fix the mount to the carriage.

Part number:
PDT-0466-40-00-00-0



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5.19. Guiding set

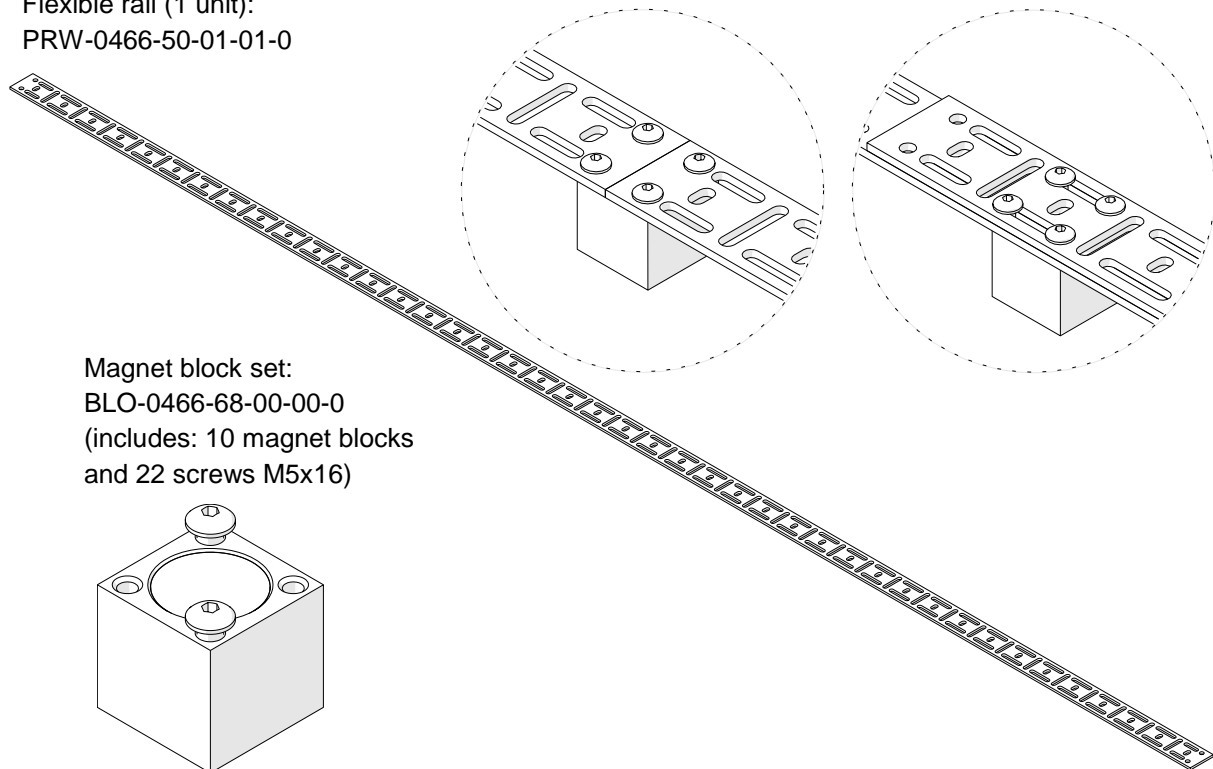
Allows guiding the carriage on planes along a straight line, and on pipes and tanks. A single flexible rail is 1.85 m (6 ft) long. The holding force of a magnet block placed on a 5 mm (0.2") thick ferromagnetic surface is 90 N up to a temperature of 100°C (212°F). At 180°C (356°F) the force decreases to 54 N.

Connect two rails with the M5x16 screws using the 3 mm hex wrench to form a butt or lap joint. Install the guide arms after unscrewing the standard guide arms using the 4 mm hex wrench.

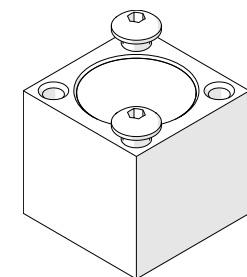
Flexible rail (1 unit):
PRW-0466-50-01-01-0

Butt joint

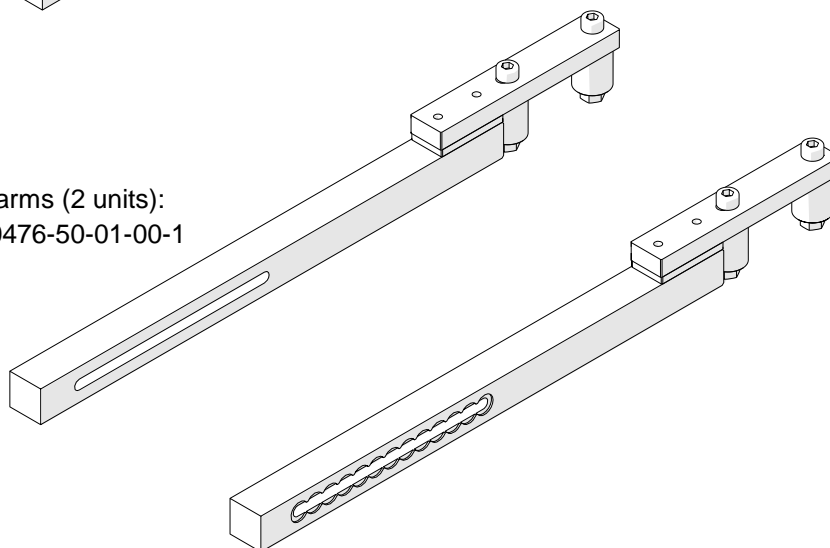
Lap joint



Magnet block set:
BLO-0466-68-00-00-0
(includes: 10 magnet blocks
and 22 screws M5x16)

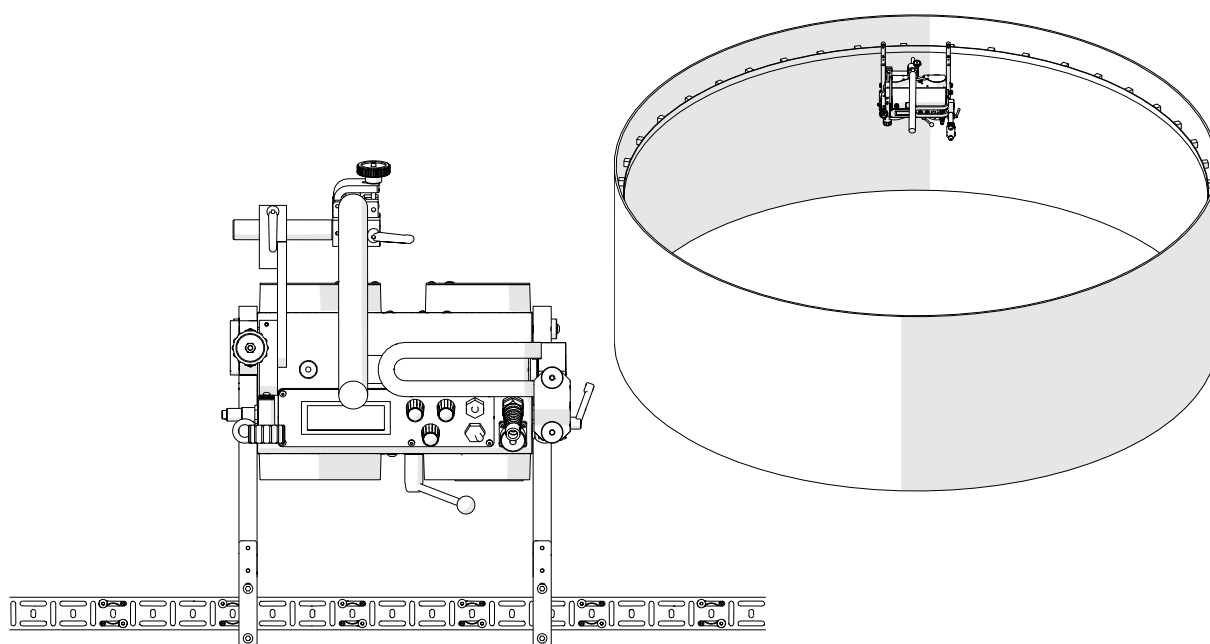
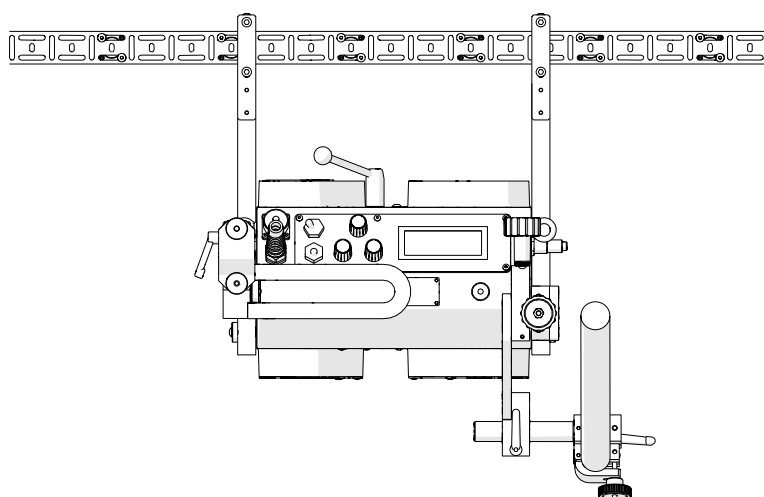
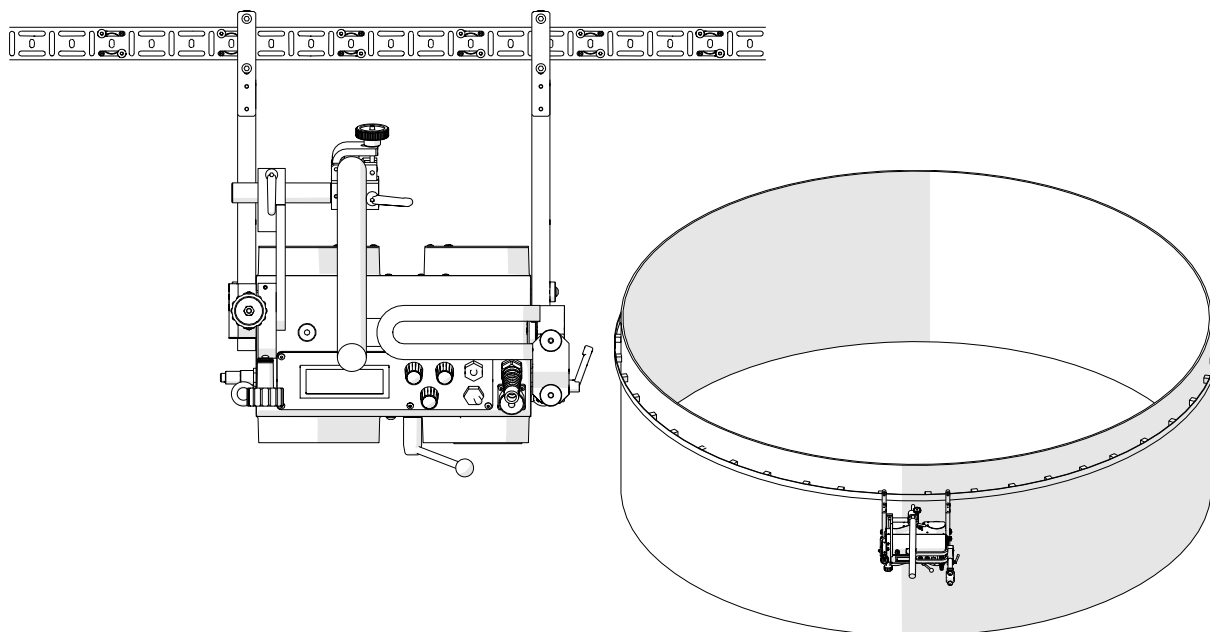


Guide arms (2 units):
PRW-0476-50-01-00-1



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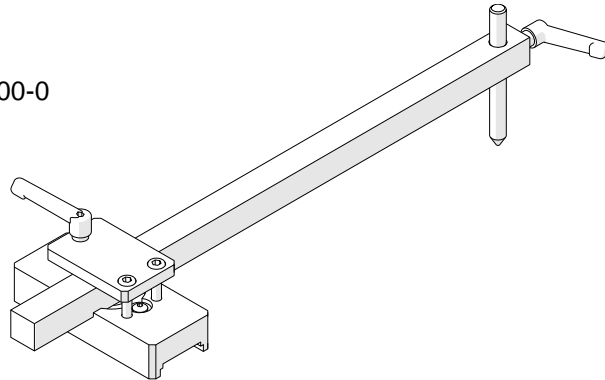
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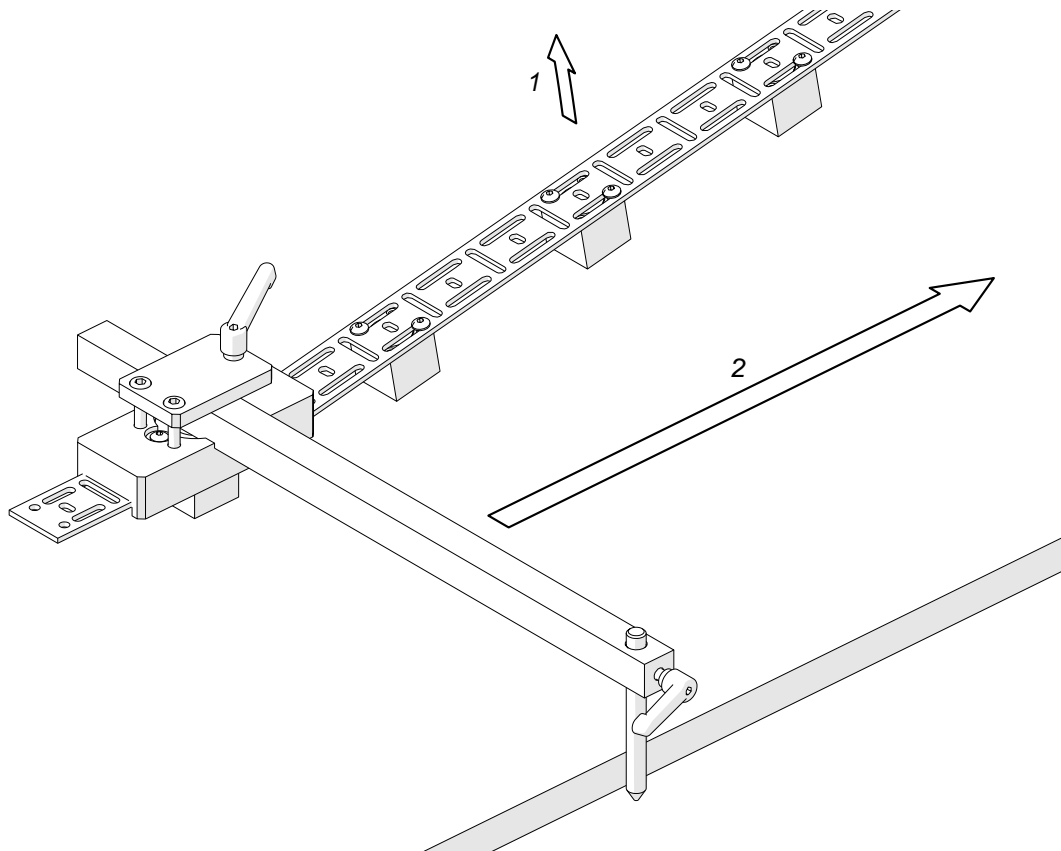
5.20. Guide adjustment tool

Allows the guide to be positioned parallel to an outside edge or a groove.

Part number:
UST-0466-53-00-00-0



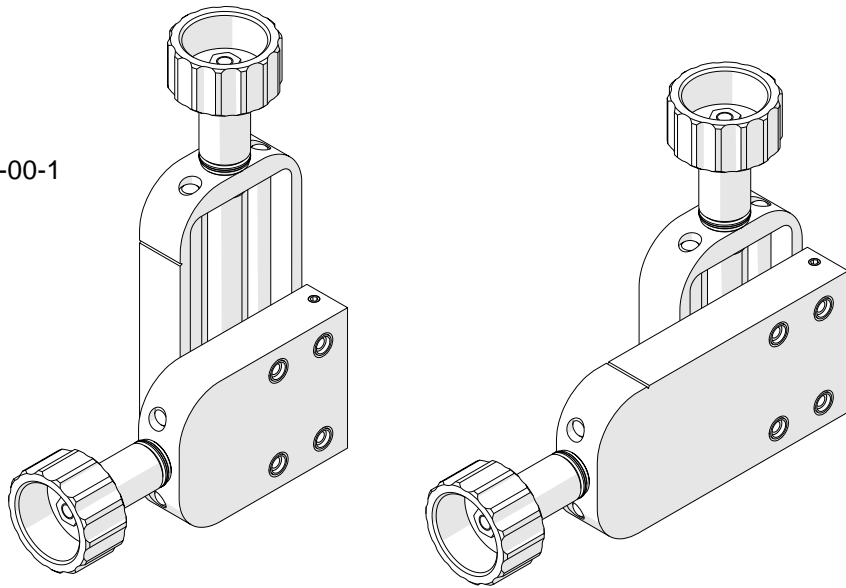
Fix the magnets to the guide, and position the guide on the workpiece along the direction of welding. Loosen the levers and put the tool onto the first magnet, resting the side of the pilot pin on an outside edge as in the figure below or placing the tip of the pilot pin in a groove. Lock the levers in this position, pull the further part of the guide off the workpiece (1), and begin moving the tool along the guide (2) to clamp the successive magnets to the workpiece.



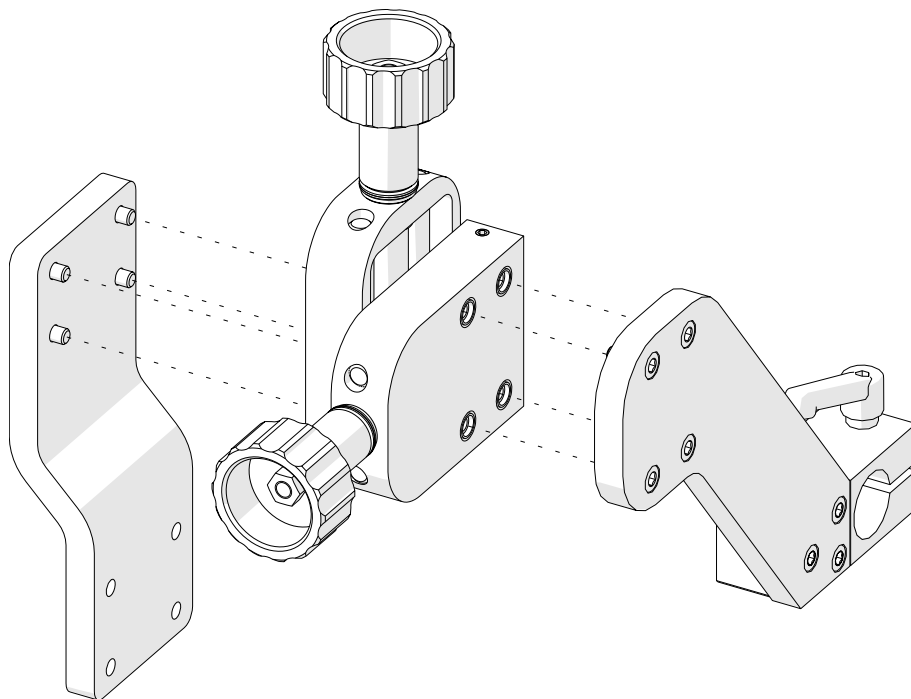
5.21. 76 mm cross slide

Extends either up-down or left-right adjustment range from 0–35 mm (0–1.38”) to 0–76 mm (0–3”).

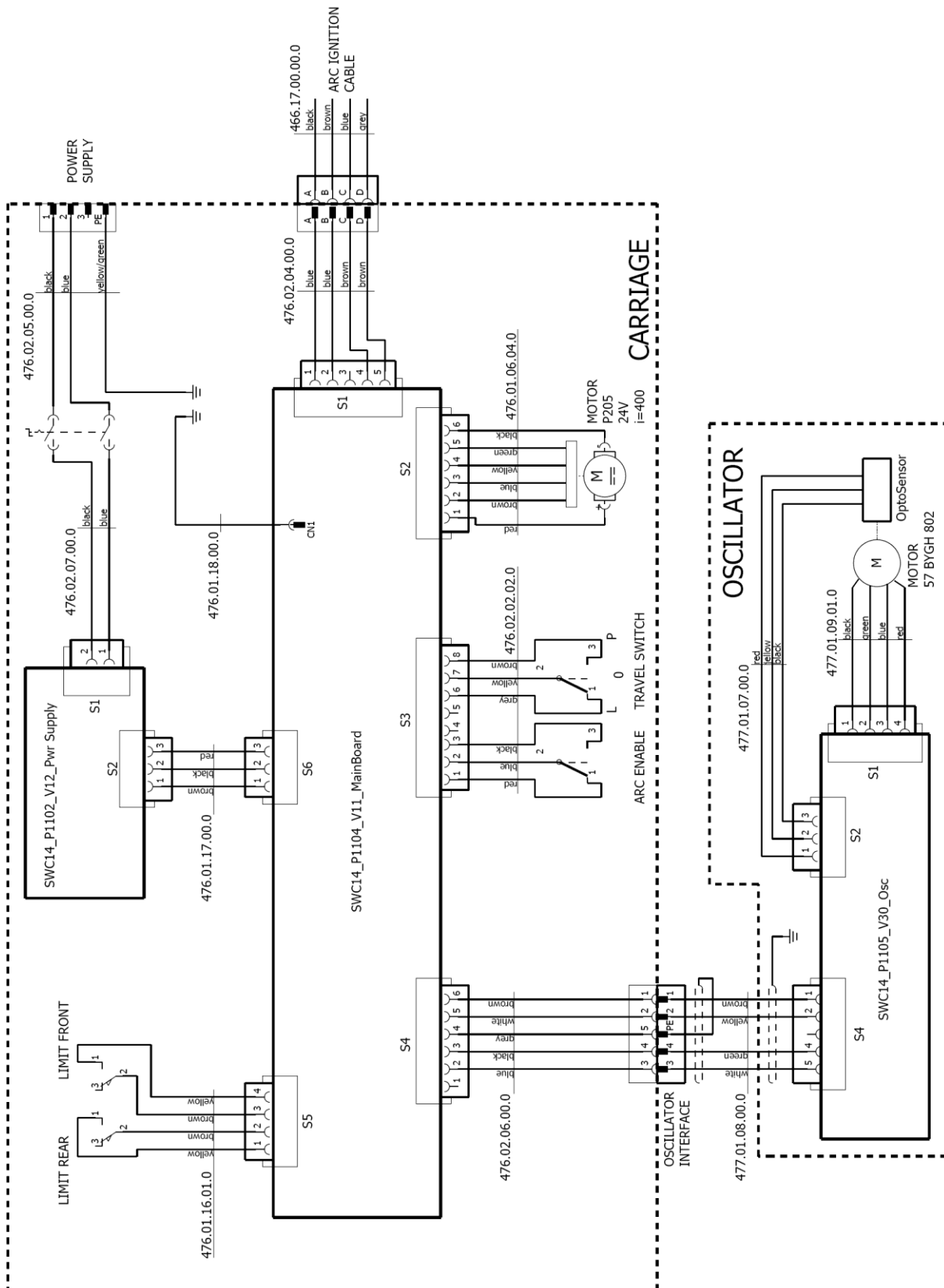
Part number:
ZSP-0466-46-00-00-1



Install in place of the standard cross slide after unscrewing eight screws using the 4 mm hex wrench.



6. WIRING DIAGRAM



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7. DECLARATION OF CONFORMITY

EC Declaration of Conformity

We

***PROMOTECH sp. z o.o.
ul. Elewatorska 23/1
15-620 Białystok
Poland***

declare with full responsibility that:

LIZARD WELDING CARRIAGE

is manufactured in accordance with the following standards:

- EN 12100
- EN 60745-1
- EN 60974-10

and satisfies safety regulations of the guidelines: 2004/108/EC, 2006/95/EC, 2006/42/EC.

Białystok, 22 January 2015



Marek Siergiej
Chair

8. QUALITY CERTIFICATE

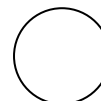
Machine control card LIZARD WELDING CARRIAGE

Serial number

Electric test

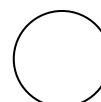
Type of test	Result	Name of tester
Test with sinusoidal voltage (voltage 1000 V, frequency 50 Hz)	 Date
Resistance of the protective circuit Ω Signature

Quality control



Adjustments, inspections

Quality control



9. WARRANTY CARD

WARRANTY CARD No.....

..... in the name of Manufacturer warrants the LIZARD Welding Carriage to be free of defects in material and workmanship under normal use for a period of 12 months from the date of sale.

This warranty does not cover wheels as well as damage or wear that arise from misuse, accident, tempering or any other causes not related to defects in workmanship or material.

Date of production

Serial number

Date of sale

Signature of seller.....

2.07 / 9 February 2016

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