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Gebrauchsanweisung • deutsch
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Manuel d'utilisation • français

1920110

R11T



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1. PREFACE

1.1. INTRODUCTION

Congratulations on having purchased this product. Properly installed Kemppi products should prove to be productive machines requiring maintenance at only regular intervals. This manual is arranged to give you a good understanding of the equipment and its safe operation. It also contains maintenance information and technical specifications. Read this manual from front to back before installing, operating or maintaining the equipment for the first time. For further information on Kemppi products please contact us or your nearest Kemppi distributor.

The specifications and designs presented in this manual are subject to change without prior notice.

In this document, for danger to life or injury the following symbol is used:



Read the warning texts carefully and follow the instructions. Please also study the Operation safety instructions and respect them when installing, operating and servicing the machine.

1.2. PRODUCT INTRODUCTION

R11T is transmitter part for remote control unit which is designed for MMA welding with Master MLS power sources. Master MLS power sources have an incorporated receiver as standard.

R11T is using welding cables for transfer of control information, longest operating range is ca. 200 m. Receiver of power source converts transmitter signal as current rated value and controls power source according to it

You can use wireless remote control unit with following power sources from serial number *) on:

Master 1600 MLS (6102160): all serial numbers

Master 2500 MLS (6104250): from number 1071536

Master 3500 MLS (6104350): from number 1066406

Mastertig 2000 MLS (6112200): all serial numbers

Mastertig 2500 MLS (6114250): from number 1064082

Mastertig 3500 MLS (6114350): from number 1066756

*) Note! You must replace the control card A001 into the machines, manufactured before these.

1.3. OPERATION SAFETY



Be careful for voltage! Between work piece and connector X2 there is in adjustment situation open circuit voltage of power source, do not touch both at the same time.



Do not try to use remote control device with other power sources than with those mentioned above! See to that cables you intend to use are connected to right machine!

Be careful for not touching enclosure of remote control device with hot electrode!

Do not put control device onto hot work piece!

Do not throw or drop remote control device!

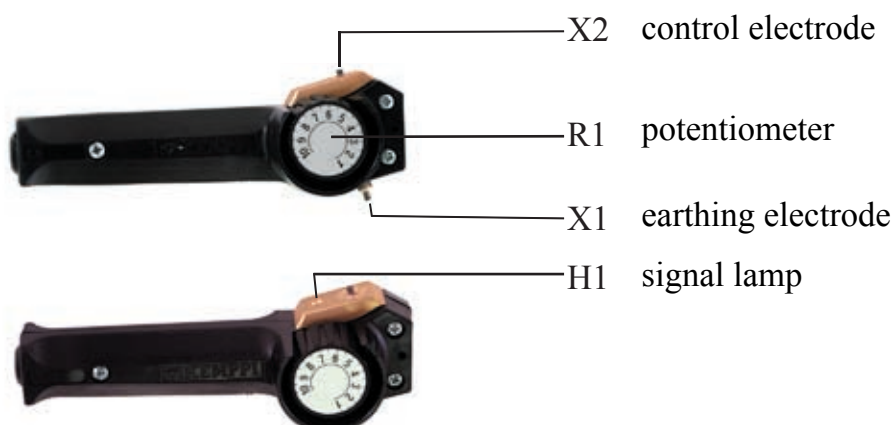
2. OPERATION

Power source

Turn selecting switch for remote/local control of power source **into remote control position.**

Use of a remote control unit with cables is not possible at the same time with R11T. Disconnect remote control unit with cables from power source's connector. Changing over to use remote control unit with cables is made by connecting remote control unit with cables back to remote control connector.

R11T control transmitter





1. Adjust potentiometer R1 to required value according to reference scale.
2. Place R11T between work piece and welding electrode
3. Red lamp H1 of R11T turns on, telling that control data has been transmitted to power source.
When the lamp is on, you can also adjust current level with potentiometer R1. This level is transmitted as set value of power source.
4. Remove R11T and start welding.

If red lamp of R11T is not on, there is no control connection and set value is not transmitted onto the power source.

See that the earthing electrode X1 of R11T is touching uncoated metal and that the cover or slag layer of electrode is not preventing touching of electrode onto the control electrode X2.

R11T is protected against disturbances caused by TIG ignition sparks.

NOTE! Master MLS power sources remember the last adjusted value after switching out.

Control is not possible during welding.

3. OPERATION DISTURBANCES

In case of problems contact the KEMPPI works in Lahti, Finland or your KEMPPI dealer.

In order to avoid operation disturbances:

- Keep R11T clean. Do not open the control device!
- Avoid operating R11T in rain or in corresponding moist circumstances.

4. ORDERING NUMBERS

R11T 6185442

5. TECHNICAL DATA

R11T

Operating voltage		open circuit voltage of power source
Data transmission		control signal is modulated to open circuit voltage
Enclosure		plastic enclosure with suspension hook
External dimensions	length	178 mm
	width	50 mm
	height	56 mm
	weight	210 g
Degree of protection		IP44
Operating temperature range		-20...+40 °C

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