



LTHJ-SUPER-B2

Welding Tractor Flux Recovery Machine

Service Manual

ISO9001:9002 Certificate Enterprise

Wuxi LianTong Welding Machinery Co., Ltd

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Points for attention**Warnings**

Before operators carry out installation, operation or maintenance of the equipment please read and understand all safety provisions in the manual.

- ◆ Before operations of the equipment, please check whether all fixed screws are tightened and the suction interface is tightened.
- ◆ Operation of the equipment shall be carried by professional staff.

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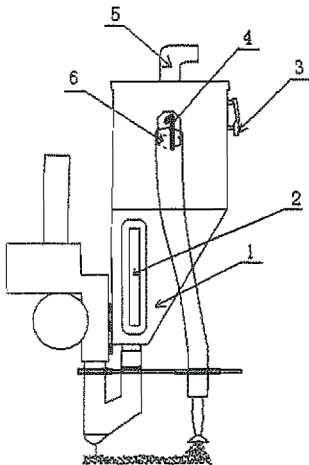
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1. Product summary

In the manufacturing process of domestic and foreign metal welding components, submerged arc welding tractor has been widely applied. In the usage process, the feeding of flux, sweeping flux and the cleaning-up are relied on manual works. This product is specially designed for submerged arc welding tractor which greatly reduces the workload and workforce of workers.

It has the characteristics such as small, tough, powerful, easy to operate and environmental protection. The machine can be applied in most SAW tractor. According to customers' needs it can add heating system (Note: heating to 12 °C)

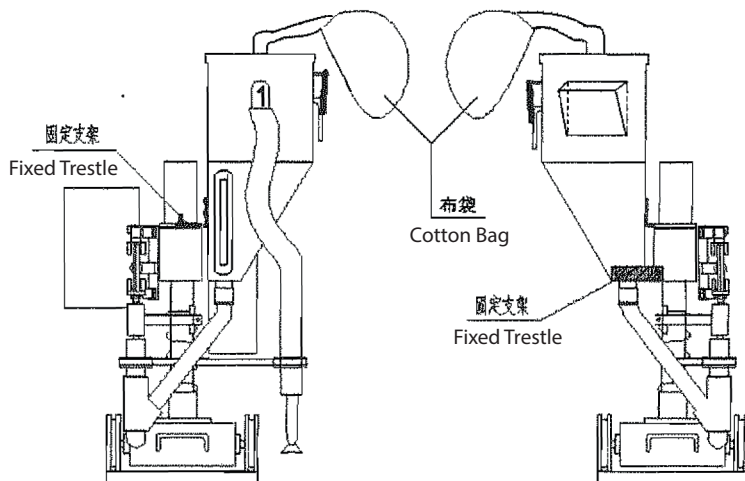
2. Schematic diagram of product structure



| | Name | Note |
|---|----------------|------|
| 1 | Flux hopper | |
| 2 | Sight window | |
| 3 | Feeding handle | |
| 4 | Air valve | |
| 5 | Dust bag | |
| 6 | Recovery hose | |

3. Installation and application

(1) Please install recovery machine on tractor according to following diagram.



(2) Connect 0.6Mpa compressed air to the air valve.

(2) Observe from flux port. If the flux is insufficient, you may add flux through the flux port to maintain welding.

(3) When the flux reach the port, you shall move downward the feeding valve handle for about 3 seconds then make the flux in cycle usage.

(4) Please clean the dust bag every 6 hours. Open the sticker of the dust bag and pat the bag to discharge dust and then close it.

5. Points for attention

(1) Carry out regular checks on bags. It is necessary to clean up on time.

(2) Open shelters and carry out regular checks to see whether the filter in flux separator is damaged. If it is damaged you should replace it promptly.

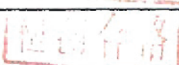
6. Technological index

| Model | Air source pressure | Capacity | Dimension |
|---------------|---------------------|----------|------------|
| LTHJ-SUPER-B2 | 0.6Mpa | 4L | 20*22*70cm |

7. Accessory list

| No | Model | Quantity | Note |
|----|-------------------------|----------|------|
| 1 | B2 | 1pc | |
| 2 | Φ38 hose* 0.8m | 1pc | |
| 3 | Flux pick-up nozzle | 1pc | |
| 4 | Nozzle mounting bracket | 1pc | |
| 5 | Dust bag | 1pc | |
| 6 | Hold hoop | 3pcs | |
| 7 | Service book | 1pc | |
| 8 | Certificate | 1pc | |

Quality Certification

| | | |
|-------------------------------|---|---------------|
| Name | Air Powered Welding tractor flux recovery machine | |
| Model | LTHJ-SUPER-B2 | Number |
| Examination department | Quality Supervision Section | |
| Checker Number | 1 | |
| Result of examination |  | |
| Examination date | 2011年 4月 23日 | |

Wuxi Lian Tong Welding Machinery Co.,Ltd Wuxi Lian Tong Welding Machinery Co.,Ltd

Warranty card

| | |
|--------------------------|--|
| Consignee | |
| Products name | |
| Products of model | |
| No. of shipment | |
| Quantity | |
| Date of Shipment | |
| | |

Note:1. This card is to be kept by unit for examination.
2. This handwriting must be clear, neat and correct.

Warranty card

| | |
|-------------------------|--|
| Consignee | |
| Products name | |
| Products model | |
| No. of shipment | |
| Quantity | |
| Date of Shipment | |
| | |

Note:1. Practice 'Three Guarantees' only if send this card to our factory within a month
2. This handwriting must be clear, neat and correct.

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Air Powered Flux Recovery Machine

