

**LTHJ-B1-2**

**Welding Tractor Flux Recovery Machine**

**Service Manual**

**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.

- ◆ Please verify the required voltage this equipment needs. Check whether the power cord is in line with the required specifications 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.

# Quality Certification

<b>Name</b>	<b>Electric Powered Welding tractor flux recovery machine</b>	
<b>Model</b>	<b>LTHJ-B1-2</b>	<b>Number</b>
<b>Examination department</b>	<b>Quality Supervision Section</b>	
<b>Checker Number</b>		
<b>Result of examination</b>		
<b>Examination date</b>		

**Warranty card**

<b>Consignee</b>	
<b>Products name</b>	
<b>Products of model</b>	
<b>No. of shipment</b>	
<b>Quantity</b>	
<b>Date of Shipment</b>	

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

**Warranty card**

<b>Consignee</b>	
<b>Products name</b>	
<b>Products model</b>	
<b>No. of shipment</b>	
<b>Quantity</b>	
<b>Date of Shipment</b>	

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.

## 5.Points for attention

- (1) Carry out regular checks on filter 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.
- (3) The carbon brushes in motor need to be change every 2000 hours.

## 6.Technological index

Model	Power	Motor	Capacity	Dimension
LTHJ-B1-2	220V	1.1Kw	4L	260*220*500mm 220*220*200mm

## 7.Accessory list

No	Model	Quantity	Note
1	B1-2	1pc	
2	Motor box	1pc	
3	Φ38 hose* 1m	2pcs	
4	Flux pick-up nozzle	1pc	
5	Nozzle mounting bracket	1pc	
6	Dust bag	1pc	
7	Hold hoop	5pcs	
8	Service book	1pc	

# Contents

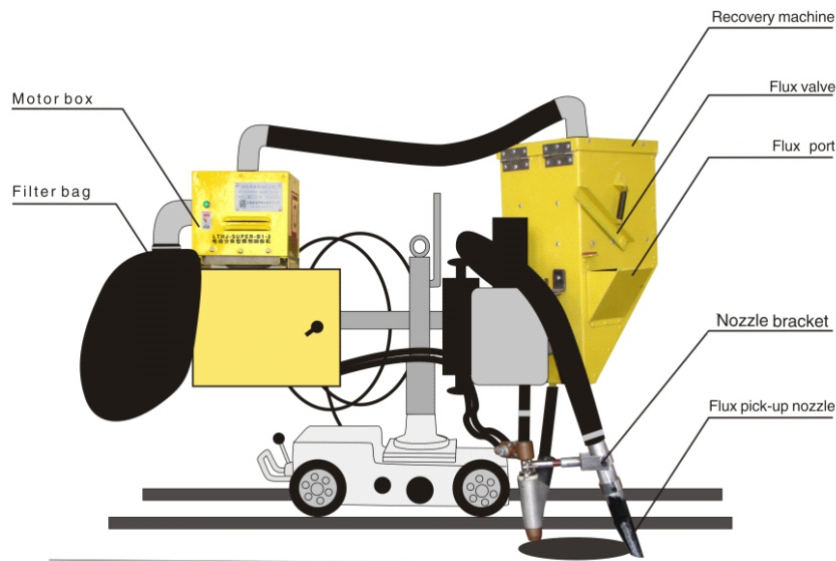
1. Product summary
2. Schematic diagram of product structure
3. Installation and application
4. Circuit diagram
5. Points for attention
6. Technological index
7. Accessory list
8. Quality certification

## 1. Product summary

In the manufacturing process of domestic and foreign metal welding projects, 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.

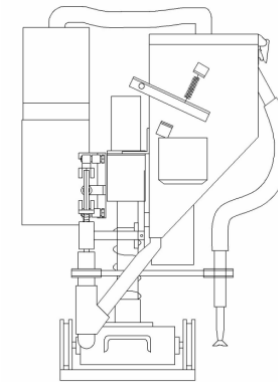
It has the characteristics such as small, tough, powerful, easy to operate and environmental protection. The machine can be applied in most SAW tractor. According to customers' needs it can add heating system (Note: heating to 120 °C).

## 2. Schematic diagram of product structure



## 3. Installation and application

- (1) Please install recovery machine on tractor according to following diagram.
- (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 8 hours. Open the sticker of the dust bag and pat the bag to discharge dust and then close it.



## 4. Circuit diagram

