



KT-WELDING TURNING ROLLS

OPERATION MANUAL

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1、 Overview

With strong points of the same home or abroad products, this KT-type welding turning rolls, are mainly used in fields like pressure vessel manufacturer, pipe or Shipbuilding Company, etc. As the essential equipments to pressure vessel manufacturer, this automation could be applied to manual welding or automatic welding for cylindrical tube, and the strong points are advanced technology, dependable quality and easy operation.

2、 Technical data

This KT-type welding turning rolls, carrying work piece with different diameters within the welding data, can realize step-less speed changing with lower driving noise and stable work piece rotating.

Main technical data as following:

Model	KT-5	KT-10
Load capacity(T)	5	10
Work piece dia. (mm)	250-2500	300-3000
Wheel number	4	4
Wheel material	Rubber & Steel	Rubber & Steel
Wheel diameter(mm)	250	300
Wheel width(mm)	140	170
Wheel speed(m/min)	6-60	6-60
Input power(V)	3×380	3×380
Motor power(kW)	2×0.25	2×0.55

3、 Installment

The driving wheel and idler must be installed on the same level floor parallel, and the frame under surface should be close to the floor completely.

4. Operation

1. Adding oil into the reducer before operation, thin oil to reducer grade one, and fatty oil to grade two.
2. When the turning rolls work, there should be no abnormal noise or vibration; or any malfunction should be cleared off. After put the work piece on the turning rolls, trial run is necessary, checking that turning wheels should be close to work piece, and there should be no axial float. Or the turning rolls should be re-installed.
3. Before start, the switch on the control panel should be turn on, and the speed governor should point to min speed. After start, the speed governor could be adjusted to needed speed, clockwise or anticlockwise. If you want to change turning direction from clockwise to anticlockwise, or from anticlockwise to clockwise, you should first press the "Stop" button, and then press "Clockwise" or "Anticlockwise" buttons.
4. If use manual welding, first, connect the manual welding control switch to the control panel, and then carry the control switch by hand or put on the face mask, operating while welding. Turning off the "Clockwise" "Anticlockwise" buttons before manual welding.

5. Maintenance

This welding equipment should be checked and kept clean before using. The turning wheels should be kept away from oil or ignition sources, and oil in the gear reducer should be checked and added regularly.