



# Make Precision Weave Welds Quickly, Easily, And Economically!

The Speed Weaver II is a compact, precision, all-position machine, designed for maximum versatility in oscillation. Its solid-state controls with graduated dials provide adjustable and readily repeatable control of critical weld parameters.



The Speed Weaver II is designed to mount on any BUG-O carriage, the DCD ROL-O carriage, or, with a special weaver mount, in front of the Super-Flex drive carriage on Super-Flex rail. Its lightweight permits easy movement of the machine from one welding location to another.

*PATENTS WORLDWIDE*



**BUG-O SYSTEMS**

A DIVISION OF WELD TOOLING CORPORATION



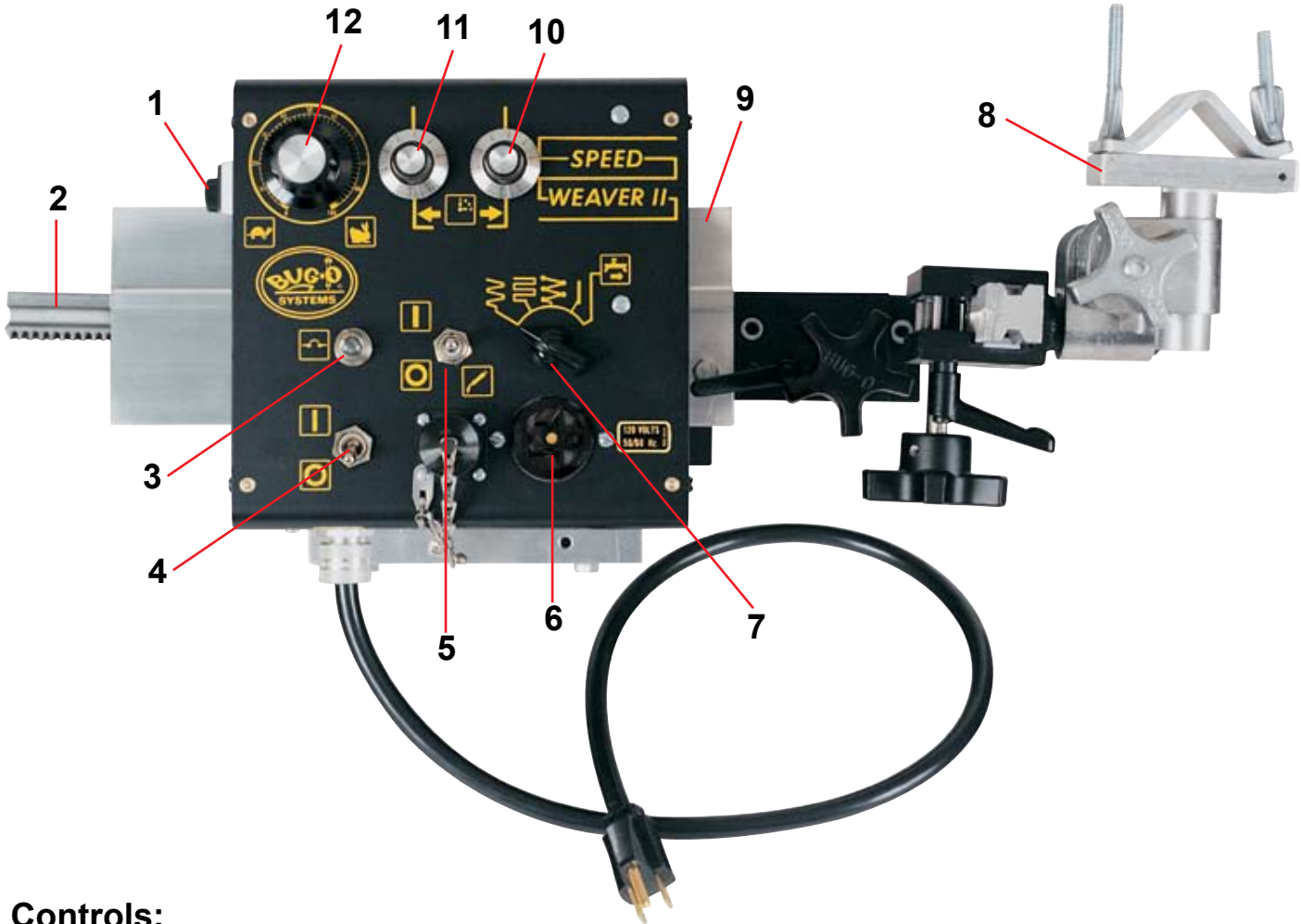
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# SPEED WEAVER II

The **SPEED WEAVER II** with solid-state design eliminates relays and limit switches. Integrated circuits control all functions, and the **SPEED WEAVER II** extends the usefulness

of weld weaving by ensuring accurate control of amplitude and constant speed, up to 150 ipm (3800 mm/min).



### Controls:

- |                    |                                     |                         |
|--------------------|-------------------------------------|-------------------------|
| 1. Stroke Width    | 5. Weld Contactor Switch            | 9. Crossrail            |
| 2. Adjustable Rack | 6. AC Outlet                        | 10. Dwell Right         |
| 3. Circuit Breaker | 7. Mode Selector Switch             | 11. Dwell Left          |
| 4. Power Switch    | 8. All-Position Torch Support Group | 12. Weave Speed Control |

The unit provides infinitely variable speed control 6 to 150 ipm (150 to 3800 mm/min), weld contactor, power on-off, a circuit breaker and adjustable/lockable amplitude 0.125 to 2.0" (3 to 50 mm).

The speed control , dwell selectors and amplitude control are calibrated for quick and easy set up. The **SPEED WEAVER II** housing is anodized black to reduce arc reflection.

The BUG-5300 **SPEED WEAVER II** mounts directly onto the various BUG-O carriages. It can also be supplied with the SFX-1255 Super-Flex weaver mount accessory, which is used to mount the **SPEED WEAVER II** directly onto Super-Flex rail when attached to the Super-Flex carriage.



# SPEED WEAVER II

## Technical Data:

### Power

**Requirement:** BUG-5300 120VAC/50-60/1  
 BUG-5302 240VAC/50-60/1  
 BUG-5304 42VAC/50-60/1

**Linear Speed:** 6 to 150 ipm (150 to 3800 mm/min)

**Dwell:** 0 to 3 Seconds Each Side; Calibrated

### Cycles

**Per Minute:** Maximum; (Zero Dwell Left and Right)

**Stroke:** .125" | .25" | .5" | 1.0" | 2.0"  
 (3 mm) | (6 mm) | (12 mm) | (25 mm) | (50 mm)

**Cycles:** 160 | 120 | 85 | 60 | 37

### Cube

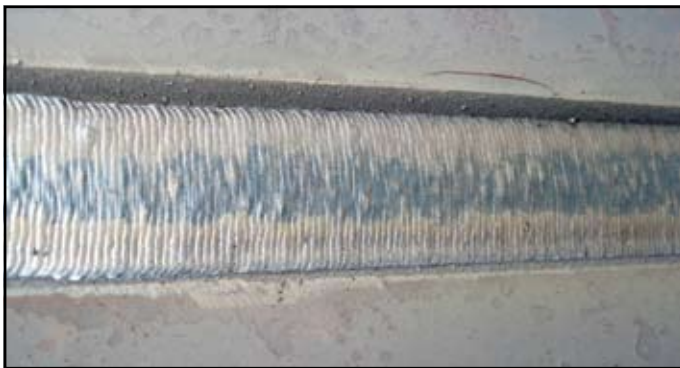
**Dimensions:** 8.5"L x 8.75"W x 6.5"H  
 (216 mm x 222 mm x 160 mm)

### Net Weight:

19 lbs. (8.6 kg)  
 (Not including rail and torch mounting.)

### Shipping

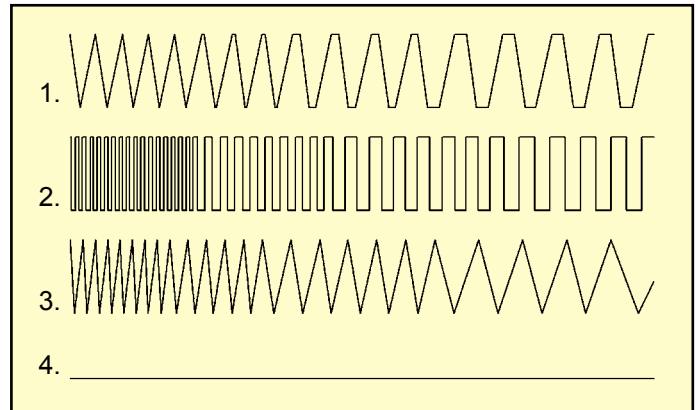
**Weight:** 22 lbs (10 kg)  
 (Not including rail and torch mounting.)



**SAMPLE WELD**

## Weld Patterns:

A rotary mode selector switch allows you to choose the following patterns:



### 1. RUN:

In this mode, power to the drive unit is always on, and the machine travels continuously both during weave and dwell. Weave speed and dwell time both affect the weld pattern.

### 2. STEP:

The unit travels only during dwell, and stops during the oscillator cross stroke. Changing weave speed does not affect the weld pattern, changing dwell time or tractor speed does.

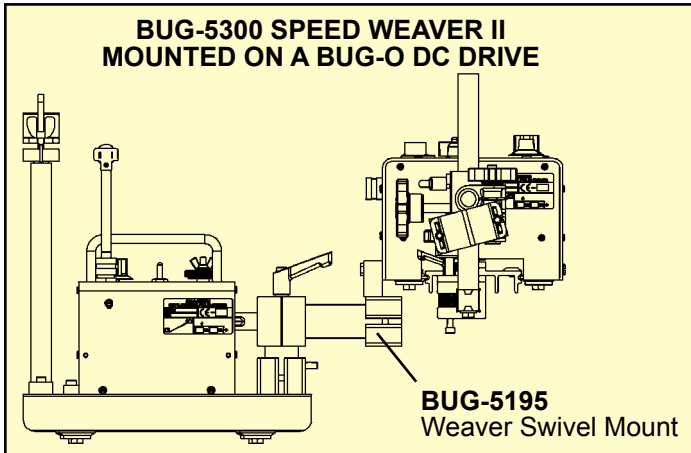
### 3. TRACTOR STOP ON DWELL:

The tractor travels during weave stroke. Tractor and oscillator stop during dwell.

### 4. NO WEAWE:

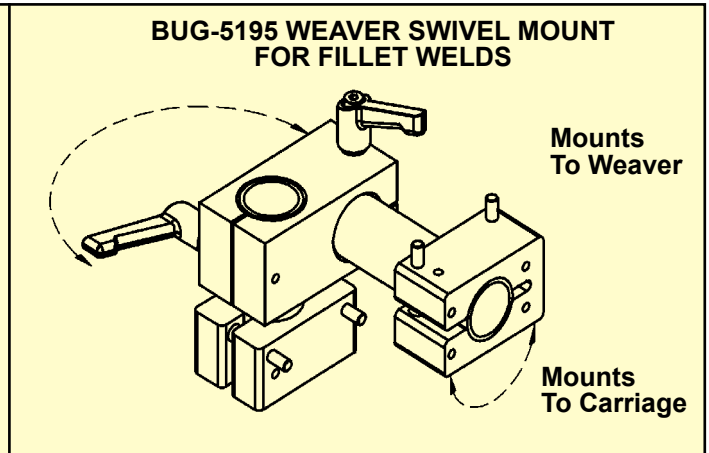
In this mode oscillation is stopped and powers the tractor only for stringer passes.

**BUG-5300 SPEED WEAVER II  
 MOUNTED ON A BUG-O DC DRIVE**



**BUG-5195  
 Weaver Swivel Mount**

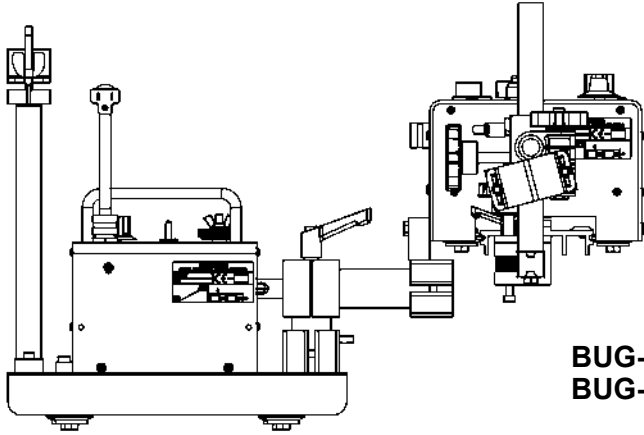
**BUG-5195 WEAVER SWIVEL MOUNT  
 FOR FILLET WELDS**





# SPEED WEAVER II

## BUG-1916 DC SPEED WEAVING KIT (120/50-60/1)



**Includes:**

- 1 BUG-0343      BUG-ODC-IV  
1.5-30 ipm (38-750 mm/min)

**Includes:**

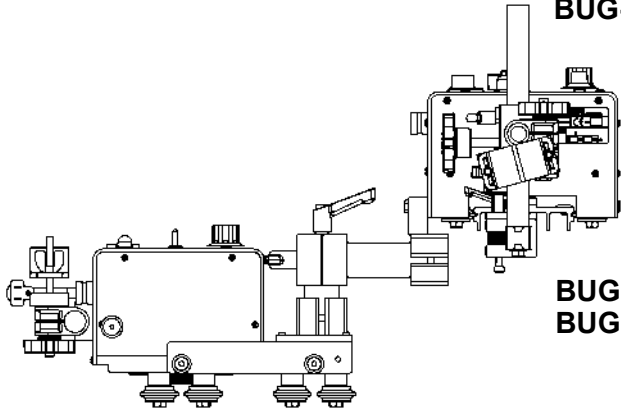
- 1 BUG-9444      Tool Kit
- 1 BUG-5300      SPEED WEAVER II
- 1 BUG-5195      Weaver Swivel Mount
- 1 BUG-2975      Cable Mounting Assembly
- 1 ARR-1080      H.D. Rigid Rail 93-1/2" (2.37 m)
- 1 ARR-1085      H.D. Rigid Rail 46-1/2" (1.18 m)
- 5 ARM-2325      Magnet Bar, Swivel w/Release

## BUG-1917 DC SPEED WEAVING KIT (240/50-60/1)

## BUG-1918 DC SPEED WEAVING KIT (42/50-60/1)

- Net Weight of Kit:      91 lbs. (41.5 kg)
- Shipping Weight of Kit:      101 lbs. (46 kg)

## BUG-1910 ROL-O WEAVING KIT (120/50-60/1)



**Includes:**

- 1 BUG-2990-F      DCD ROL-O CARRIAGE  
2-30 IPM      (38-750 mm/min)

**Includes:**

- 1 BUG-9444      Tool Kit
- 1 BUG-5300      SPEED WEAVER II
- 1 BUG-5195      Weaver Swivel Mount
- 1 BUG-1540      Cable Anchor Assembly

## BUG-1912 ROL-O WEAVING KIT (240/50-60/1)

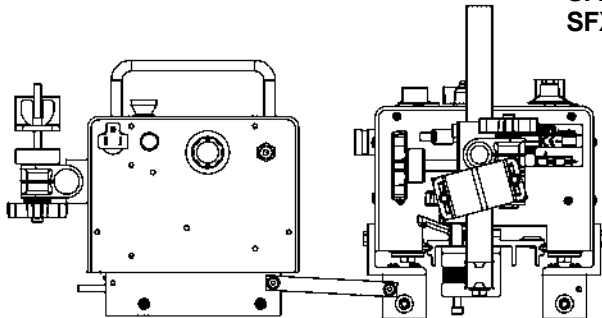
## BUG-1914 ROL-O WEAVING KIT (42/50-60/1)

- Net Weight of Kit:      40 lbs. (18.2 kg)
- Shipping Weight of Kit:      50 lbs. (22.7 kg)

## SFX-1020 SUPER-FLEXWELD WEAVING KIT (120/50-60/1)

## SFX-1022 SUPER-FLEXWELD WEAVING KIT (240/50-60/1)

## SFX-1024 SUPER-FLEXWELD WEAVING KIT (42/50-60/1)



**Includes:**

- 1 SFX-1200-F      SUPER-FLEX CARRIAGE

**Includes:**

- 1 BUG-9444      Tool Kit
- 1 BUG-5300      SPEED WEAVER II
- 1 SFX-1255      Super-Flex Weaver Mount
- 2 SFX-1160      Super-Flex Laminated Rail 5' (1.5 m)
- 8 SFX-1140      Swivel Magnet Bar w/Release
- 8 SFX-1130      Spacer Bar
- 1 BUG-1540      Cable Anchor Assembly

## \*SFX-1020-1 SUPER-FLEXWELD WEAVING KIT (120/50-60/1)

## \*SFX-1022-1 SUPER-FLEXWELD WEAVING KIT (240/50-60/1)

## \*SFX-1024-1 SUPER-FLEXWELD WEAVING KIT (42/50-60/1)

- Net Weight of Kit:      74 lbs. (33.7 kg)
- Shipping Weight of Kit:      86 lbs. (39.2 kg)

\* Uses SFX-1120 Fixed Magnet Bar w/Release