POLYTURN positioners

User Manual PN-1112142

POLYSOUDE
THE ART OF WELDING

SBR

Document revision

Rev. 0	Original issue
Rev. 1	Modification Chuck adaptor, dia. 250 mm0011560702
Rev. 2	Update Illustrated part lists (11/2016)

If this technical manual is to be printed, both sides of the page must be used to improve understanding and readability.

Contents

1. Safety instructions

Warning: Protect yourself and others from injury – Read and follow these precautions.

1.1. Hazards associated with arc welding

The symbols reproduced below are used throughout this Technical Manual in order to draw your attention to and identify the potential hazards. When you see one of these symbols, **refer to the safety instructions in the following section 'Recommendations'.**
This equipment must only be installed, used, maintained and repaired by qualified persons.
While it is in use, anyone not working with the equipment must be kept well away.

1.2. Meaning of the symbols

	**Risk of electric shocks**		**Risk of serious injury caused by rotating parts**
	**Risk of inhaling fumes or gases**		**Risk of explosion**
	**Risk of burns to the eyes or the skin due to heat radiation**		**Risk of exposure to magnetic fields.**
	**Warning: hot surfaces – Risk of burns**		**Danger caused by noise**
	**Risk of burns to the eyes or the skin due to flying sparks**		**Read the instructions**
	**Risk of excessive heat or fire.**		**Safety goggles must be worn**
	**Safety boots must be worn**		**Safety helmets must be worn**
	**Fall hazard**		**Refer to the recommendations on the next page in order to take the necessary precautions to avoid any hazard.**

1.3. Recommendations

Risk of electric shocks

The electrical components include the electrode, the welding circuit, the input circuit and the internal circuits, the welding wire and the metal parts in contact with it, the wire feeder and the housing for the welding wire feed rollers. The slightest contact with these parts may cause an electric shock or even electrocution when the machine is switched on.
Factors increasing the risk of electric shock: Moisture in the immediate area, working on an electrically-conductive surface, inadequate earthing, poor maintenance of the equipment, unsafe working methods.
Preventing risks:

- Avoid any contact with the spools of wire while they are under tension.
- In the case of water-cooled torches, inspect the torch at regular intervals in order to identify any leaks; take care to prevent condensation.
- Do not coil the cables around your body.
- Before replacing the electrode, ensure that it is no longer live.
- Switch off the machine before carrying out any maintenance or repair operations or while it is not in use.
- Wear safety gloves, clothing, aprons and boots which are dry and free from holes.
- Insulate the component and the earth by means of mats or other means of providing sufficient insulation if the welder is required to work on metal surfaces or structures.
- This machine must be installed and earthed in accordance with its User Manual and with national, local and municipal codes of practice.
- The return cable must be attached correctly (clean contact surface, cable securely fastened, as close as possible to the area to be welded.
- Do not use damaged, worn or bare (uninsulated) cables which are of insufficient size or not properly assembled. If this is the case, they must be replaced immediately.
- The welding station must be correctly earthed.
- If the component to be welded has to be earthed, use a separate cable.
- Use the appropriate connectors.

Note the no-load voltage, which is limited to 80 V r.m.s. for alternating current or 113 V for direct current (the voltage required to strike the arc). The maximum value for plasma cutting power sources is: 500 V.

Risk of inhaling fumes or gases

Welding generates fumes and gases which are hazardous to health. Do not inhale the fumes.
Origin of the fumes and gases: Base metal, filler metal, coating (flux) with welding by coated electrode, shielding gas, solvents and materials covering the metal to be welded.

In order to prevent risks:

- Use breathing apparatus, such as filtering masks, assisted-ventilation masks, inducted air masks and disposable masks.
- Avoid chlorinated solvents.
- Ensure that the components are completely dry before welding.
- Do not work alone!
- Trap the fumes and gases at source.
- Remove paint, oil or any other surface coating.

Risk of burns to the eyes or the skin due to radiation

Radiation from arc welding is liable to cause burns to the eyes and the skin.

Identifying the risks: Exposure to the radiation emitted by the arc, generating intense visible and invisible rays (ultraviolet and infrared), reflection of the rays while welding metals such as aluminium and stainless steel, arc strike, sparks, pin-holes created by the tip of a tungsten electrode.

In order to prevent risks:

- Wear gloves or leather gauntlets to protect your hands and lower arms.
- Wear an apron or gaiters to protect your legs, knees and forefoot.
- Wear a mask (headband-type, hand-held or electronic mask) or goggles fitted with a suitable filter.
- Use safety shields to protect nearby workers.
- Tie a scarf around your neck and button the neck of the protective clothing.

Warning: hot surfaces – Risk of burns

Do not touch welded or flame-cut components with bare hands. If such components have to be handled, use the appropriate tools and/or wear welders' gloves, thick and insulated, to prevent any burns. Allow the components to cool before handling them or welding them.

Risk of burns to the eyes or the skin due to flying sparks

- Wear gloves or leather gauntlets to protect your hands and lower arms.
- Wear an apron or gaiters to protect your legs, knees and forefoot.
- Wear a mask (headband-type, hand-held or electronic mask) or goggles fitted with a suitable filter.
- Use safety shields to protect nearby workers.
- Wear garments with long cotton or woollen sleeves, preferably free from any traces of oil or grease. Do not wear clothing made from synthetic fabrics.
- Tie a scarf around your neck and button the neck of the protective clothing.
- Wear welders' safety boots.

Risk of excessive heat or fire.

- Maintain the equipment at the electrical workstation in good operating condition, particularly the cables carrying the feed and return current.
- Maintain a minimum distance of 6 metres between the welding equipment and any greasy, inflammable or dust-laden materials.
- Use safety shields to protect nearby workers.

Risk of explosion

These risks are associated with the use and handling of gas cylinders and flying sparks.

- Do not use damaged cylinders.
- Store the cylinders in a well-ventilated area and restrict access to anyone other than authorised personnel.
- Never exceed a temperature of 55 ºC while storing or using the cylinders.
- Clearly identify empty cylinders to distinguish them from full ones.
- Protect the cylinders from extremes of temperature (ice, sunlight, sparks, etc.).
- Check the connectors and hoses at regular intervals.
- Use protective shields.

Risk of serious injury caused by rotating parts

- Do not place your hands near fans or any moving parts.
- Keep all safety shields closed or in the 'safety' position.

Risk of exposure to magnetic fields.

The distance between the welding circuit and the brain is of fundamental importance.

- Never spool the cables around your body and certainly not around your shoulders.
- Advise your immediate superior if you are wearing a heart pacemaker. The interference generated by the circuit requires special protective measures, which must be applied in consultation with the company doctor.

The operator must ensure that no-one is exposed to the hazardous area.

2. General Information

2.1. Applicable directives

2006/42/EC	Machinery Directive
2004/108/EC	Electromagnetic compatibility
2006/95/EC	Electrical equipment intended for use within certain voltage limits

3. General presentation

3.1. Summary of the specification

Polyturns are machines which enable a workpiece to be maintained in a set position. They allow tubes to be rotated for welding. The Polyturn is controlled by the welding power source. It does not deal with components which are not supplied by Polysoude.

3.2. Environment and conditions of use

This equipment is designed for use in workshops, in a non-explosive atmosphere.

When operating the machine, the following conditions must be observed:

- Ambient air temperature +10° to +40°C.
- Relative humidity:
  - Up to 50% at 40°C.
  - Up to 80% at 20°C.

The ambient air shall not contain abnormal quantities of dust, acids, gas or corrosive substances. Fumes due to welding are considered to be normal.
Examples of abnormal conditions of use:

- Abnormal corrosive smoke.
- Vapour.
- Excessive oil vapour.
- Shaking and vibration.

Ensure that air can enter and leave when using the equipment.

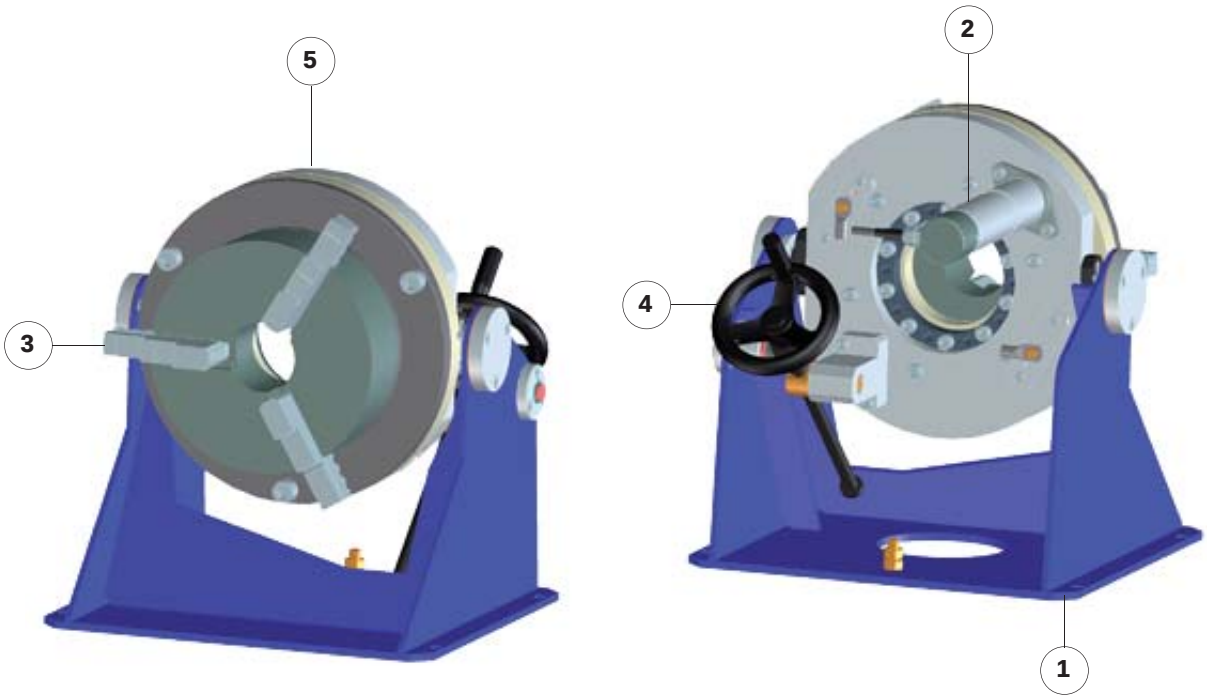
3.3. Equipment compatibility

Polyturns are compatible with Polysoude power sources subject to the configuration of the axes, Eproms and program.

3.4. Description of the equipment

The Polyturn comprises:

- A frame assembly (1)
- A motor-gearbox unit (2) .
- A chuck (3).
- A handwheel (4).
- A rotation assembly (5).



3.5. Technical Specification

Dimensions and weight (ready to weld, including integral wire feeder)	
Overall dimensions	See dimensional drawing
Estimated weight excluding (kg)	
Type of power supply	
Maximum voltage (V)	Connection to the power source
Ambient noise	
In welding mode pursuant to directive 2006/42/EC (dBA)	<70
PO motor drive 1:64	
Min-max speed (rpm)	0.25 to 4.87
Output from motor-gearbox unit (rpm)	3.04 to 60.66
Cable length (m)	9
PO motor drive 1:225	
Min-max speed (rpm)	0.07 to 1.39
Output from motor-gearbox unit (rpm)	0.87 to 17.25
Cable length (m)	9
PO motor drive 1:512	
Min-max speed (rpm)	0.03 to 0.61
Output from motor-gearbox unit (rpm)	0.38 to 7.58
Cable length (m)	9

3.6. Selecting the Polyturn

The Polyturn positioner is available in different versions. According to your application, the basic Polyturn may be fitted with motor drives and different chucks or plates. All combinations are possible.

	PO motor 1:64 Part number 11569903	PO motor 1:225 Part number 11599900	PO motor 1:512 Part number 11599904
Plate, dia. 400 mm Part number 11560701	On request	75500732	On request
Chuck, dia. 250 mm Part number 9001250303 + Adaptor 0011560702 Bore diameter 76 mm	0011562101	75500733	On request
Chuck, dia. 350 mm Part number 11560610 Bore diameter 114 mm	On request	75500734	On request

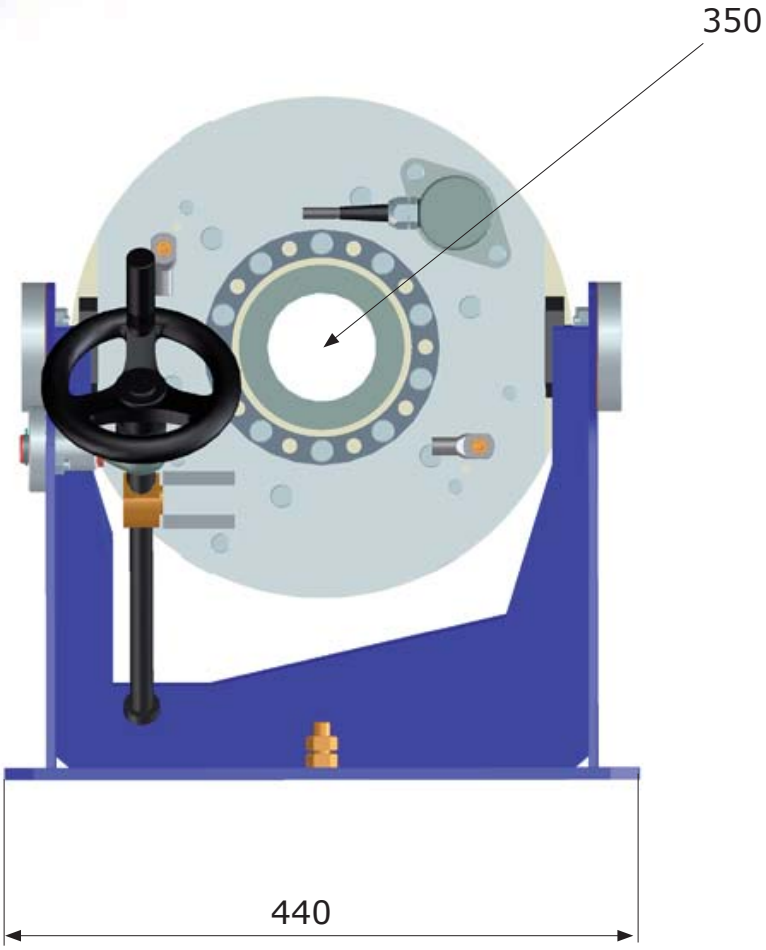
PO motor drives may be sold separately in order to motorise existing machines (welding bench, beam boom, turning gear, etc.) and control them directly via Polysoude power sources.
In this case, Polysoude's Design Office will need to produce a software configuration and carry out a power calculation.

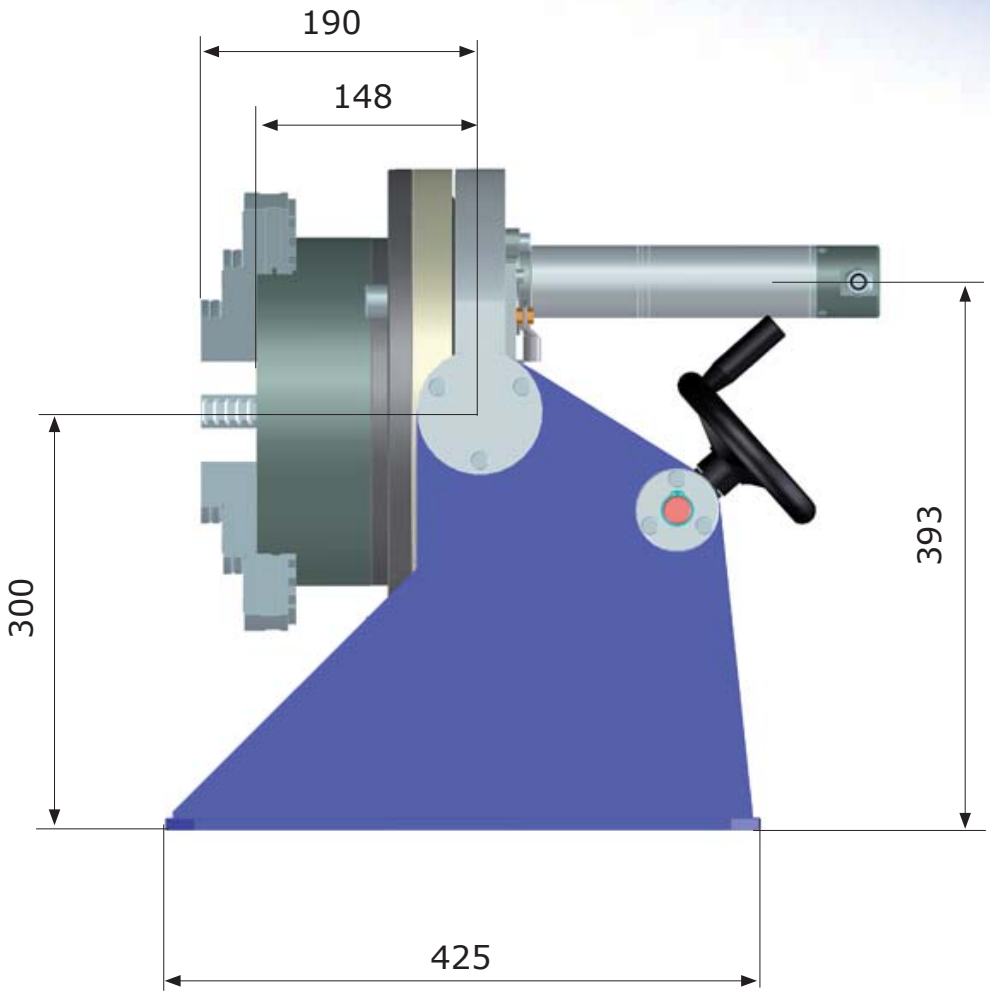
To obtain the welding speed range on the tube, the maximum and minimum speeds must be multiplied by the circumference of the tube to be welded.

Example: Tube dia. 100, motor drive 1:225

Minimum welding speed = 0.07 x 100 x π = 21.99 mm/min
Maximum welding speed = 1.39 x 100 x π = 436.68 mm/min

3.7. Overall dimensions

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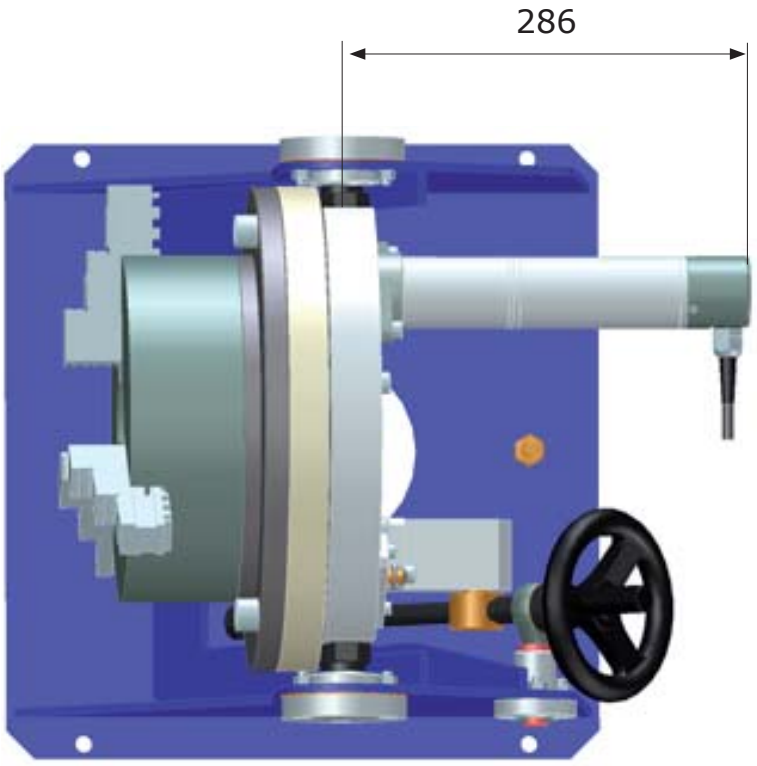
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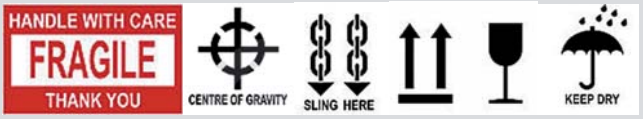
4. Installation

4.1. Handling

This equipment must be unpacked and handled with care. If a component was damaged during transit, write any complaints on the shipping note and immediately notify the carrier.



Comply with any symbols marked on the crate.

The machine is delivered in a packaging - case, protective devices etc. This packaging is specific to the machine. The original packaging must be kept for use each time the machine is transported in order to prevent damage.
When the machine is removed from its support, it should be stored on a suitable support away from any impacts (or in its packing).

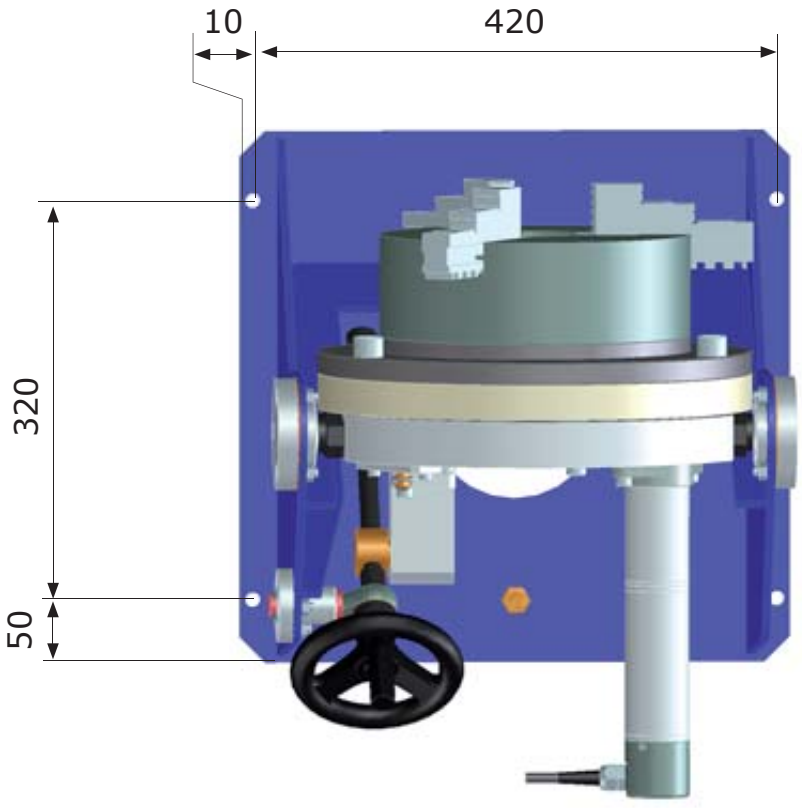
4.2. Installation on site

The complete installation must be fitted with a power supply isolation switch that can be locked.

The machine along with its components and devices must be sufficiently stable to avoid tipping over, falling or uncontrolled movements during transport, assembly, dismantling and any other action involving the machine.
If the very shape of the machine or its planned installation does not provide sufficient stability, appropriate fixing provisions must be employed and indicated in the instruction manual.

All installation and servicing must be carried out with no voltage present. Always use the attachments provided for the purpose when handling the various parts of the installation. Never use parts of the machine to provide a grip for handling. There is a risk that the equipment will be damaged or destroyed.

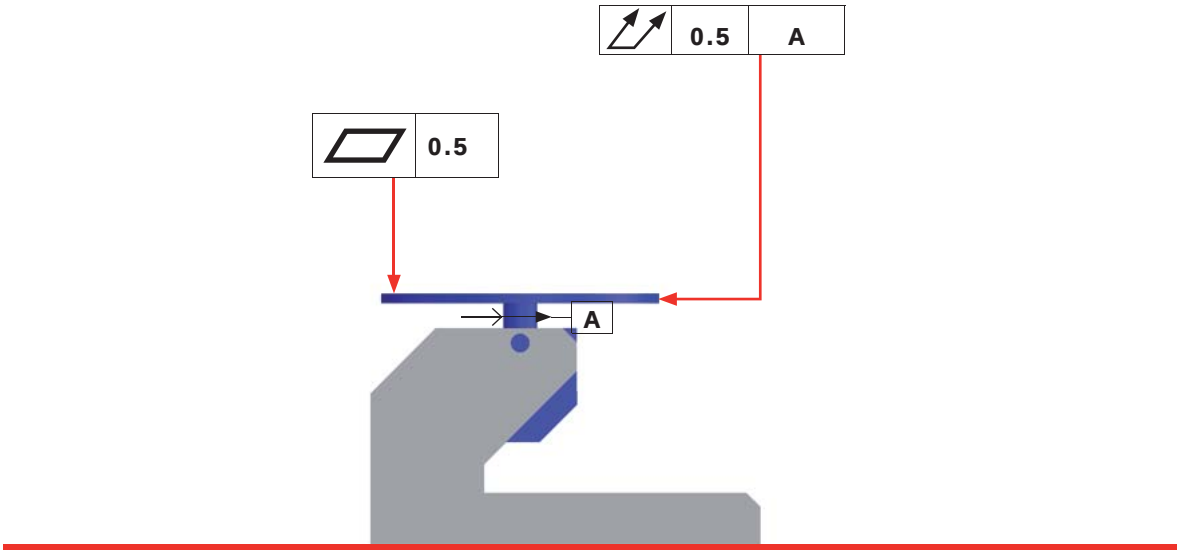
The positioners are provided with 4 holes to enable them to be fixed to the ground using 4 M12 bolts.



4.3. Geometry and accuracy of the positioner

The mechanised installation must be mounted and secured to a flat, horizontal floor to ensure it operates satisfactorily. It is essential that the structure is rigid and that the movements are precise in order to guarantee welding quality.

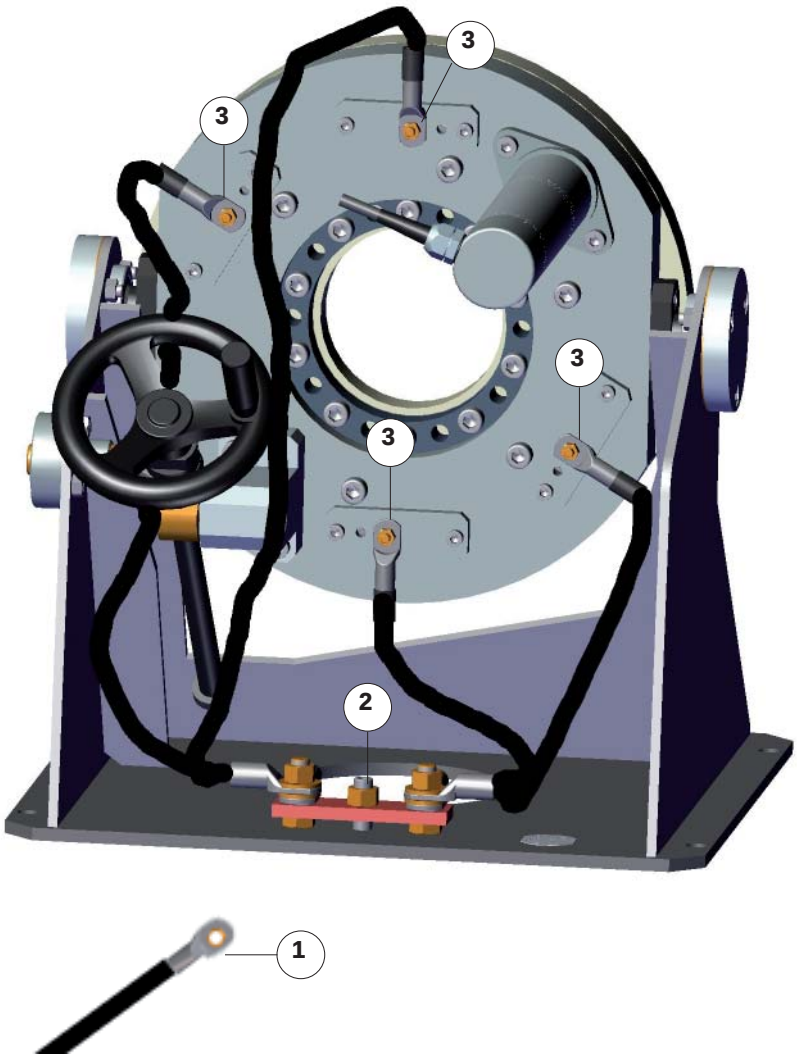
Description	Values
Flatness allowance for the table	0.5 max.
Kinematics of the positioner: vibrations during welding	Minimise as far as possible vibration phenomena, transmission shocks
Axial chatter	0.5 mm max.



4.4. Connection

The positioner must be grounded.

- Connect the ground cable (1) to the socket (2) then connect the 4 cables (3).
- Connect the motor cable to the front panel of the power source (rotation socket).
- Select the type of rotation according to the gear ratio of the PO motor drive.



5. Use

5.1. Precautions for use

This machine must only be used by personnel who are qualified to perform the tasks involved, in accordance with the rules governed by the French Labour Code.

Any work piece touch operation with the AVC axis or auto-centring operation with the oscillation axis must be systematically monitored by the user (unless otherwise indicated).
There is a risk of an incorrect contact (presence of dirt, silicate on the metal etc.). If that is the case, the operator must press the emergency stop in order to avoid destroying the torch or slides.
Operators must be trained in this manoeuvre.

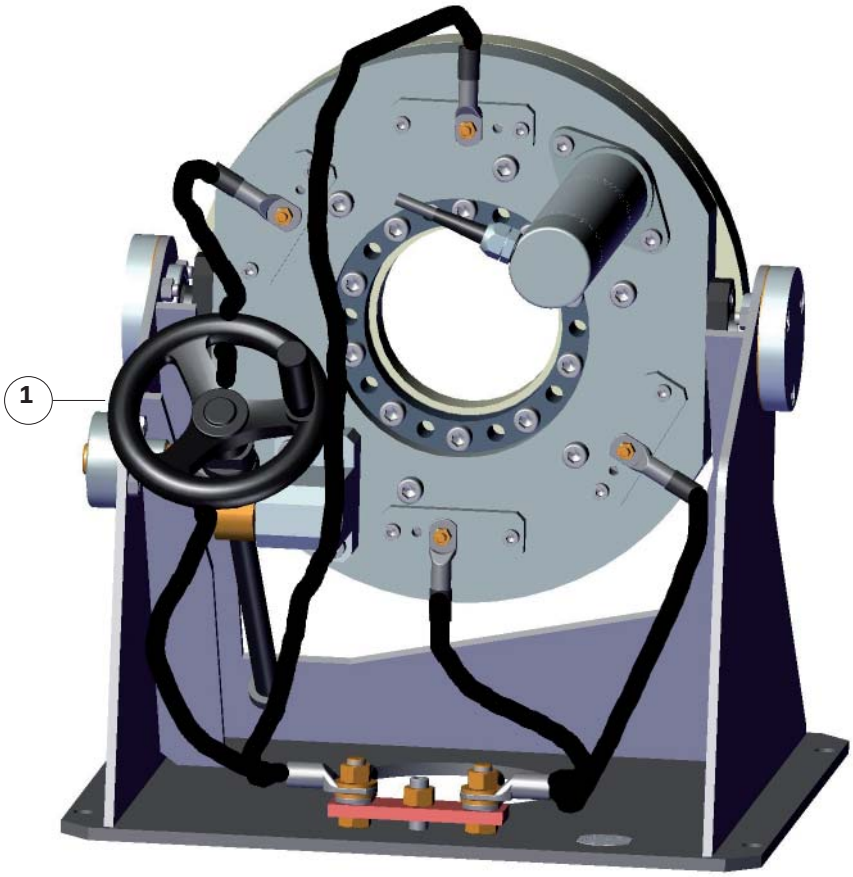
In view of the size of the machine, the lengths of the slides, the boom and the mast, operators are strongly advised to protect themselves by wearing suitable helmets, gloves and boots. Obey the recommendations given by the pictograms fitted to the machine.

When welding particularly large parts whose shape creates a confined space or a tank, the operator must make sure that the oxygen content (between 19.5 and 23% of ambient air) is sufficient before intervening. The use of an oxygen analyser is strongly advised.
Remember that below 18%, a feeling of dizziness may occur, leading to asphyxia.
In addition, the operator must be monitored by a third person located outside the work area who is able to alert the first-aiders in the event of an emergency.

The user is responsible for the installation and use of the arc welding equipment in accordance with the manufacturer's instructions. If electromagnetic interference is detected it must be the responsibility of the user of the arc welding equipment to resolve matters, with technical assistance from the manufacturer (extract of standard EN 60974-10 2008 – Annex A.).

5.2. Adjusting the position of the chuck

The chuck is positioned by means of the handwheel. It is adjusted manually.
With the tube in vertical position, the hole in the frame is big enough to take a tube of maximum diameter 114 mm (depending on the chuck model)



6. Maintenance and troubleshooting

6.1. Preventive maintenance

Trace abnormal noises		
	Frequency	Operation
	Every 3 months.	Machine switched on and operating. Axis movement: • Move the axis in a positive or negative direction within the physical limits of the machine. • Pay particular attention to any suspicious noises (creaking, abrasion, noise caused by abnormal vibrations, etc.). • Repeat the operation on all the axes.
	Every 3 months.	Machine switched on and operating. Motors: • No abnormal noise should be generated while the machine is in operation: rumbling, scraping, creaking or any other unusual noise. • Also check that no unusual noise is emanating from the motor.

Check the electronic connectors		
	Frequency	Operation
	Every 3 months.	Machine switched off, isolating switch locked. • Check that the connections are tight. • Check that there is no sign of overheating of the wiring between the components.

General inspection of the motors		
	Frequency	Operation
	Every 3 months.	Machine switched off, isolating switch locked. • Check that there is no dust or grease on the motor and the ventilation grille. • Check the general condition of the motor: - There must be no sign of impact on the motor casing or on its fins (if any). - The breather cover must not be broken and its grille must not be obstructed or clogged. • Check the multiple conductor cable on the motor. It must not be crushed or pinched and the insulation must not be damaged. • Check the points of attachment of the motor.

6.2. Recommended lubricants

For O-rings	For all motor-driven movements	For mechanical contacts	For electrical contacts
KF 2301 silicon grease	Molykote BR2 Plus	Molykote BR2 Plus	E452 gel

6.3. Repairs and servicing

The Polysoude **After-Sales Service** is available to help you with solving any problems with the machine and to supply any spare parts you may require.
When you order a spare part, do not forget to quote **its order code** as shown in the 'Spare Parts' section of your equipment manual, as well as **the serial number of your machine**.
Furthermore, some subassemblies require factory settings. Some components cannot be supplied separately but are included in their preset and ready-to-fit subassemblies.

Electrical hazards: for the following operations, disconnect the head from the power source completely.

Polysoude recommends regular maintenance (once a year minimum) of the equipment, either by a Polysoude technician or by a technician approved by Polysoude. During the guarantee period the Polysoude contractual guarantee shall not apply if the equipment has not received maintenance once a year by a Polysoude technician or by a technician approved by Polysoude.
The contractual guarantee Polysoude can be incurred if the material has been subject to modifications by the customer without the agreement of Polysoude.
The use of inappropriate spare parts or supplies not provided by Polysoude can cause serious injury and or equipment failure.

6.4. Spare Parts

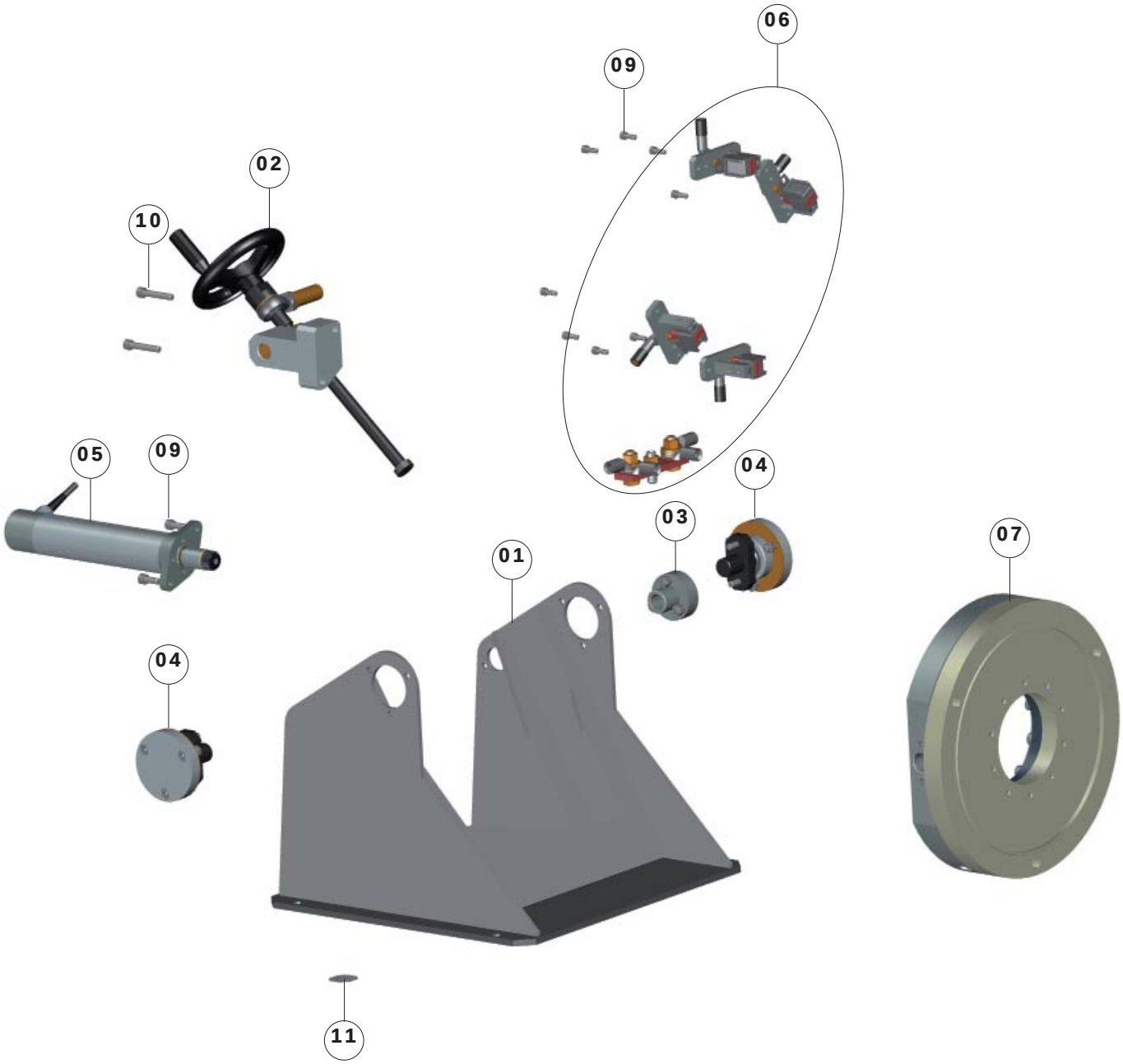
This chapter includes illustrated parts lists for each sub-assembly.
They enable parts to be identified.
Each double-page consists of two sections:

- The exploded view.
- The detailed parts list.

The exploded view shows all of the parts with their reference number.
The parts list includes:

- The name of the article.
- The order code.

To place an order, you will need the information provided in these two columns plus the serial number of your equipment.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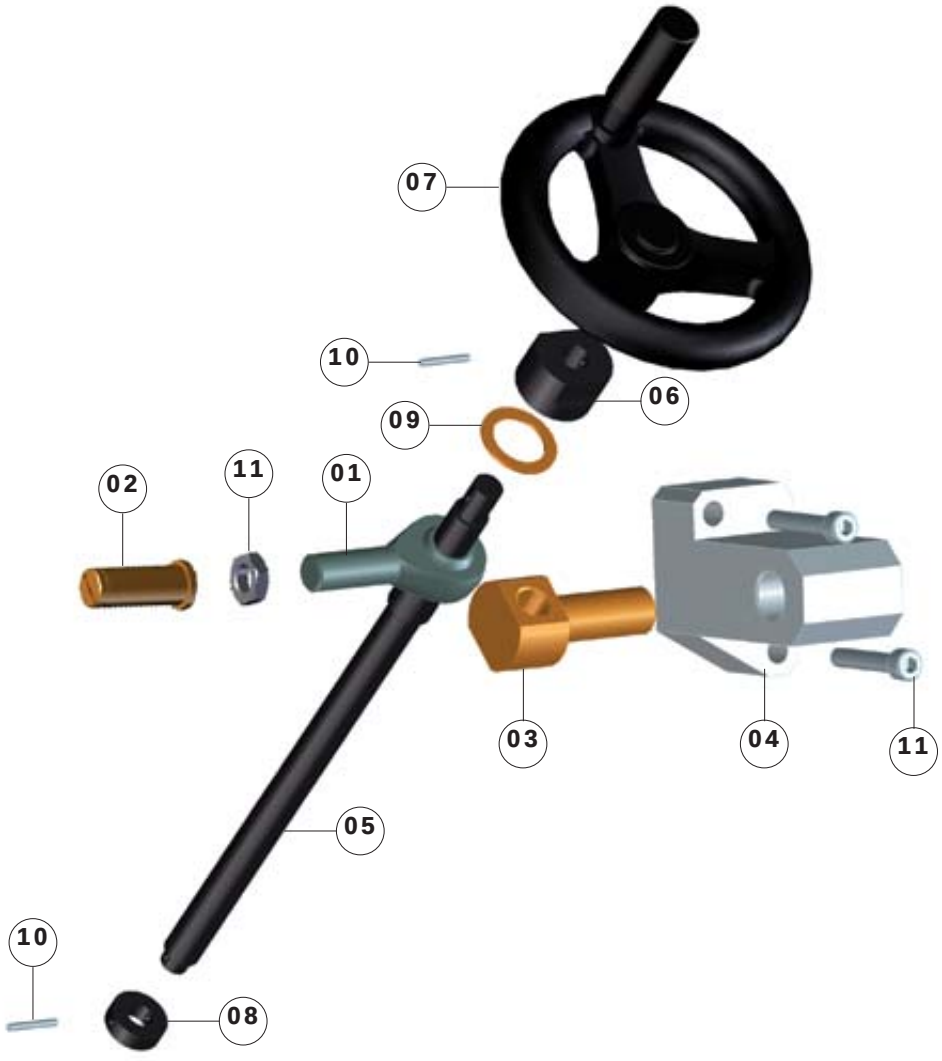
1156 00 00 — Basic Polyturn Positioner 175

No	Order Code	Description	Qty
01	**11560100**	Assembled frame	1
02	**11560200**	Rocker assembly P0	1
03	**11560201**	Fixed bushing ring	1
04	**11560300**	Articulation subassembly	2
05	**0011560400**	Motor assembly P0 + pinion	1
06	**0011560500**	Brush support assembly P0	1
07	**11560600**	Rotation assembly P0	1
08	**9001205020**	Circlip for Ø 20 steel shaft	1
09	**9003020616**	Screw, hex skt head, M6x16	8
10	**9003020820**	Screw, hex skt head, M8 x 20	2
11	**0044411512**	Identification plate	1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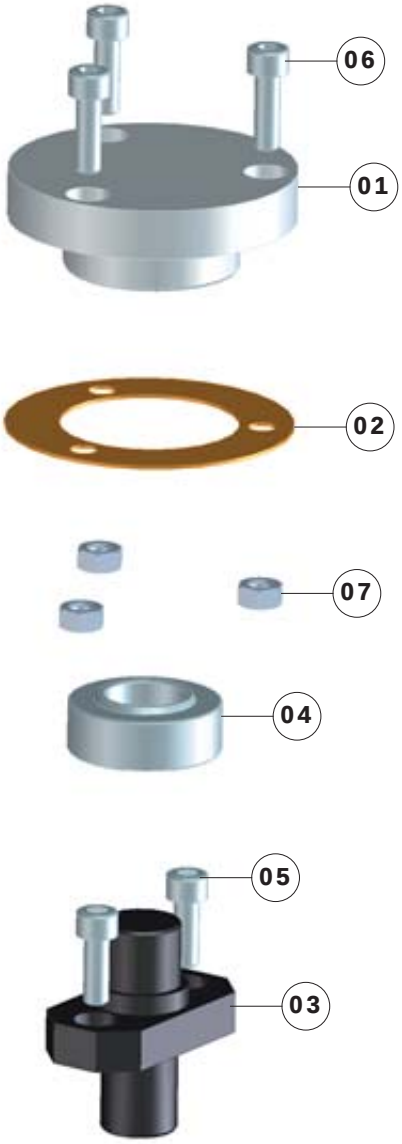
1156 02 00 Rocker subassembly

No	Order Code	Description	Qty
01	**9040001167**	Eye bolt M16x66	1
02	**11560202**	Plain bearing	1
03	**11560203**	Taped bearing	1
04	**11560204**	Mobile bushing	1
05	**11560205**	Screw, control	1
06	**11560206**	Retaining nut	1
07	**11560207**	Modified handwheel	1
08	**11560215**	Stop ring	1
09	**11560216**	Shim washer	1
10	**9003403024**	Pin, Ø 3x23.8	2
11	**9022360532**	Nut, Hm M16	1
12	**9003000405**	Set screw, M4x5, cup point	1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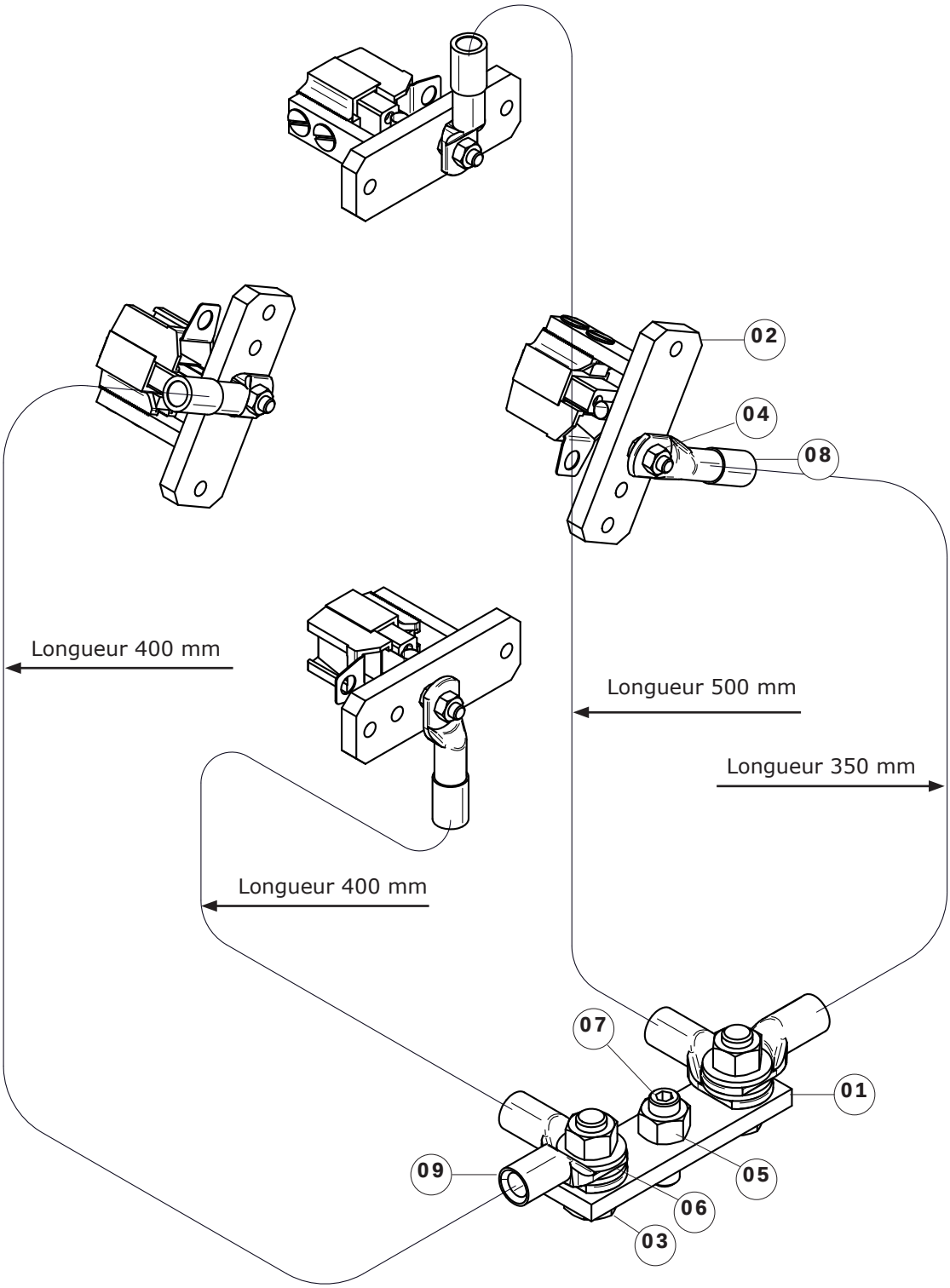
1156 03 00 Articulation subassembly

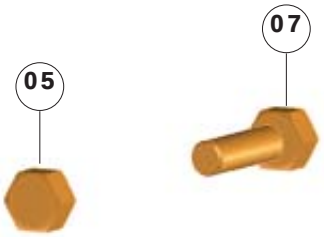
No	Order Code	Description	Qty
01	**11560301**	Bearing	2
02	**11560302**	Shim, peelable	2
03	**11560303**	Hinge pin	2
04	**9040001168**	Radial spherical plain bearing	2
05	**9003020820**	Screw, hex skt head, M8x20	4
06	**9003020825**	Screw, hex skt head, M8x25	6
07	**9003080801**	Nut, hex, M8	6

Les longueurs des câbles seront à ajuster au montage.
La longueur des câbles permet de basculer le positionneur dans toutes ses positions 0° à 90°.



00 1156 05 00 — Brush support assembly

No	Order Code	Description	Qty
01	**0011560503**	Lug interface	1
02	**0011560505**	Brush support	4
03	**9003371235**	Screw, hex head, M12x35, brass	2
04	**9003380601**	Nut, hex, M6, brass	4
05	**9003381201**	Nut, hex, M12, brass	3
06	**9003391227**	Washer, M, M12, brass	4
07	**9040001185**	Headless SHC screw, M12x40, stainless steel	1
08	**61402050**	Welding cable, 50 mm²	4
09	**/**	Terminal lug, crimp type, Ø 8 50 mm²	8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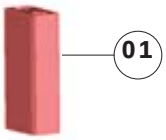
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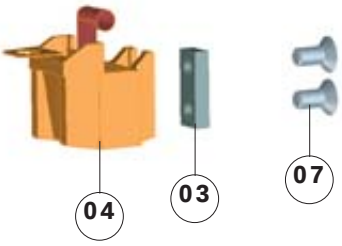
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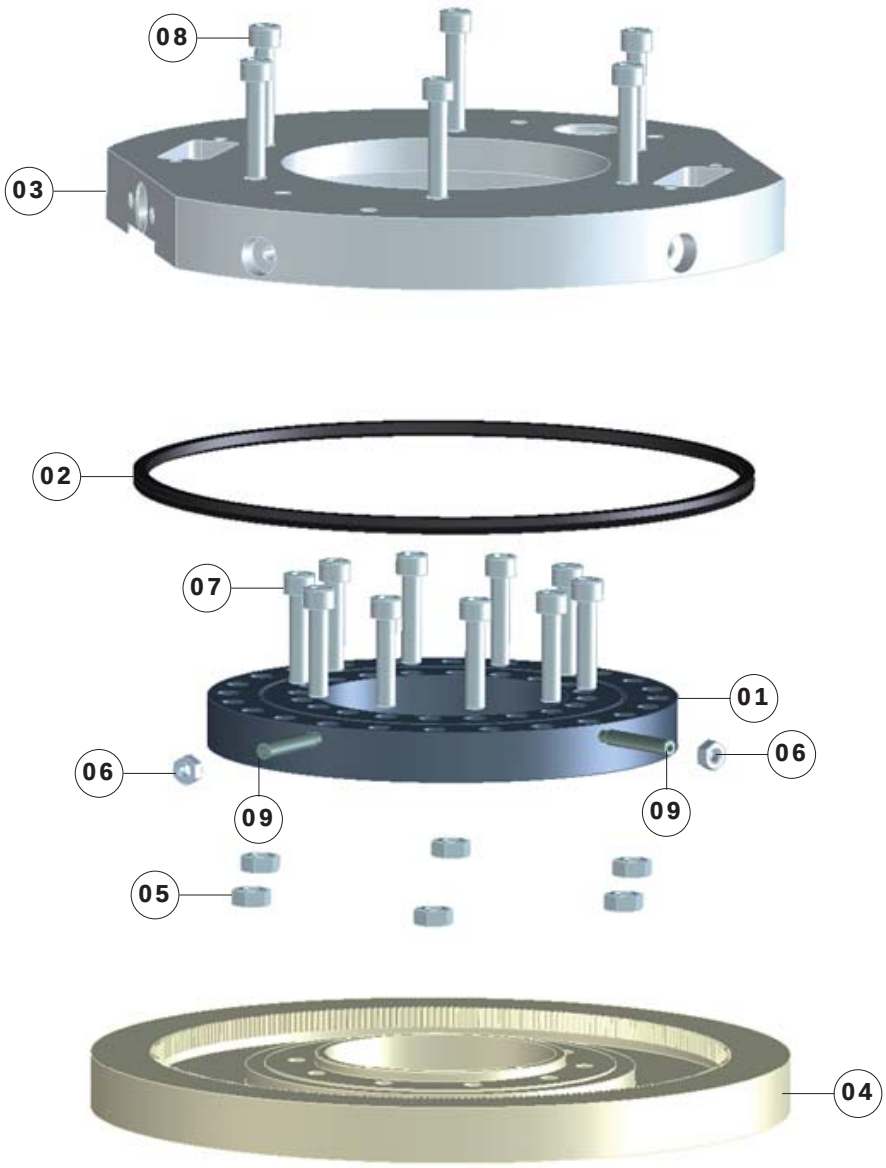
00 1156 05 05	Brush support

No	Order Code	Description	Qty
01	**9000612207**	Equipped brush, 10x20x40 M192	1
02	**11560501**	Brush support bracket	1
03	**11560502**	Tapped strip	1
04	**9000612208**	Brush support	1
05	**9003380601**	Nut, hex, M6	1
06	**9003060612**	Screw, CSK 90° M6x12	2
07	**9003370625**	Screw, hex, M6x20, brass	1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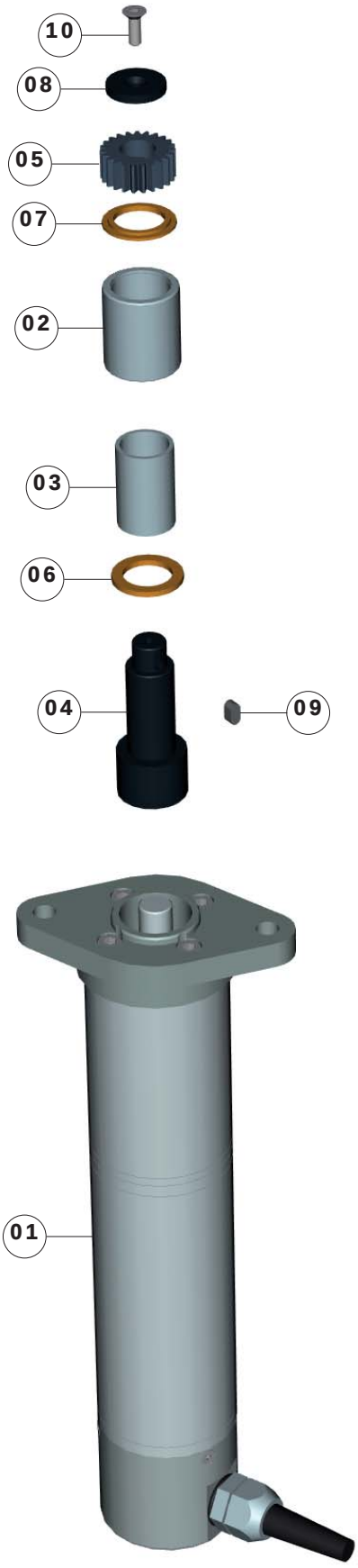
1156 06 00 Rotation assembly

No	Order Code	Description	Qty
01	**01055037**	Guide ring	1
02	**01150002**	Gasket VL 300	1
03	**11560601**	Fixed plateau	1
04	**11560602**	Turntable	1
05	**9003081001**	Nut, hex, M10	6
06	**9003080802**	Nut, Hm, M8	2
07	**9003021040**	Screw, hex skt head, M10x40	10
08	**9003021050**	Screw, hex skt head, M10x50	6
09	**9040001158**	Set screw w/dog point M8x50	2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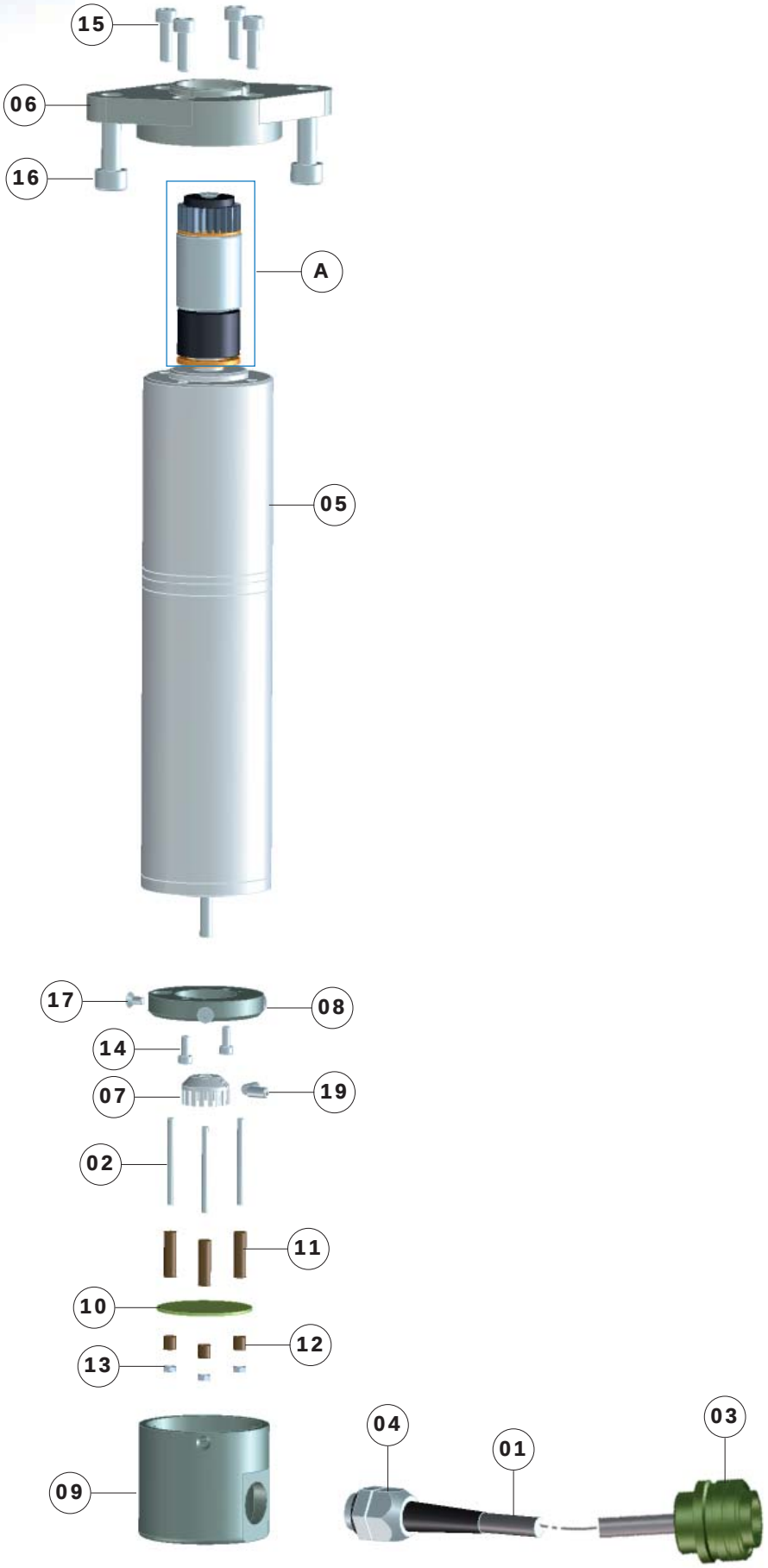
00 1156 04 00 — Motor assembly P0 + pinion

No	Order Code	Description	Qty
01	**11599900**	Motor PO 17e R1:225 cable 9 m	1
02	**01042121**	Needle roller cage HK, 20.-30	1
03	**01046001**	Ring IR 17.20.30,5 C2	1
04	**11560401**	Receiver pin	1
05	**11560402**	Pinion gear, 23-tooth M1	1
06	**11560403**	Rear washer	1
07	**11560404**	Front washer	1
08	**11560405**	Retaining washer	1
09	**9040000573**	Key W:4 L:8 H:4 steel	1
10	**9003050412**	Screw, hex skt csk head, M4x12	1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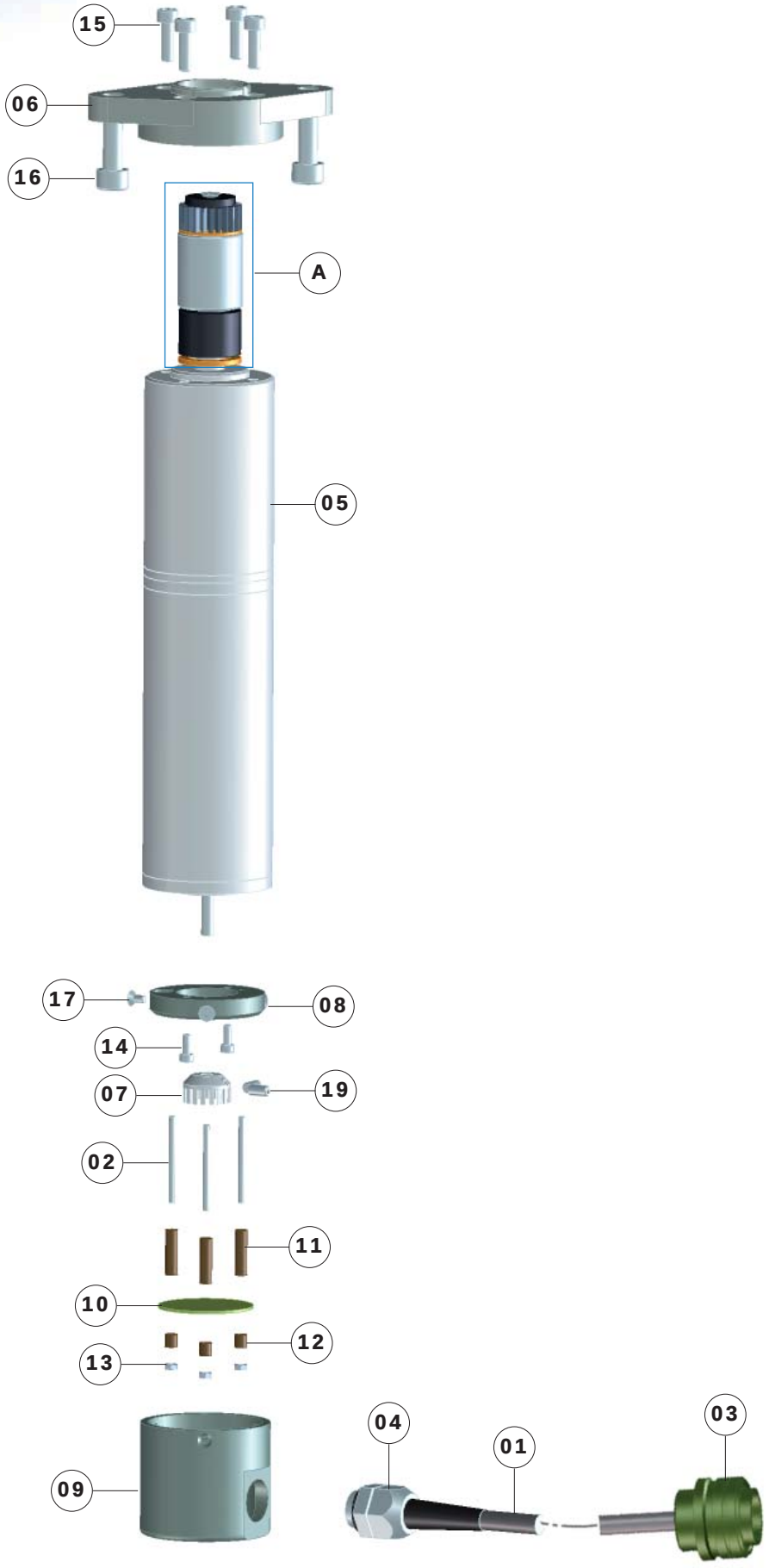
1159 99 03 — PO reduction motor R1:64

No	Order Code	Description	Qty
01	**00551134**	Shielded cable 4x0.5²+3x2x0.22²	9
02	**-**	Stud bolt dia. 2.5	3
03	**00563103**	10-pin plug, 97 3106A 18 19P	1
04	**00569045**	Gland + sleeve 1011-52	1
05	**01421005**	Motor-gearbox unit GR53 3000T R/64:1	1
06	**11560406**	Connecting flange	1
07	**11560801**	Encoding wheel 17	1
08	**11560802**	Circuit support	1
09	**11560811**	Protection cover	1
10	**21700243**	Pulse sensor 243	1
11	**29424602**	Lower bushing	3
12	**29424612**	Upper bushing CI 243	3
A	**-**	See parts list, Detail A, PO motor drive	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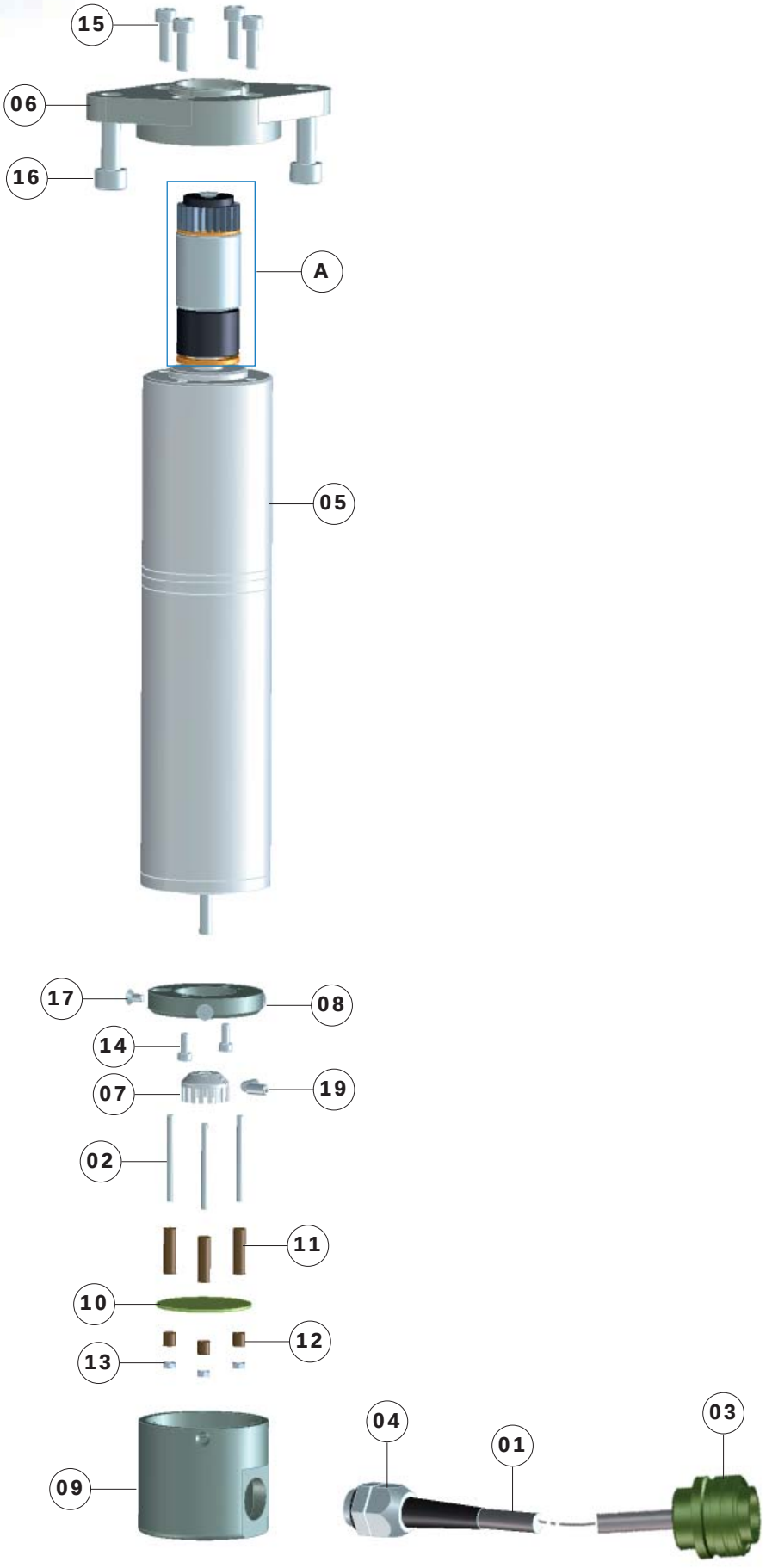
1159 99 00 PO reduction motor R1:225

No	Order Code	Description	Qty
01	**00551134**	Shielded cable 4x0.5²+3x2x0.22²	9
02	**-**	Stud bolt dia. 2.5	3
03	**00563103**	10-pin plug, 97 3106A 18 19P	1
04	**00569045**	Gland + sleeve 1011-52	1
05	**01421004**	Motor-gearbox unit GR53 40V R=225:1	1
06	**11560406**	Connecting flange	1
07	**11560801**	Encoding wheel 17	1
08	**11560802**	Circuit support	1
09	**11560811**	Protection cover	1
10	**21700243**	Pulse sensor 243	1
11	**29424602**	Lower bushing	3
12	**29424612**	Upper bushing CI 243	3
13		Hex nut, M2.5	3
14	**9003020308**	Screw, hex skt head, M3x8	2
15	**9003020516**	Screw, hex skt head, M5x16	2
16	**9003020820**	Screw, hex skt head, M8x20	4
17	**9003050306**	Screw, hex skt csk head, M3x6	3
18	**9003050412**	Screw, hex skt csk head, M4x12	1
19	**9003000306**	Set screw, M3x6	2
NR	**9000563288**	Shielding kit, size 18, DDK connector	1
NR	**00563064**	Right cable clamp	1
A	**-**	See parts list, Detail A, PO motor drive	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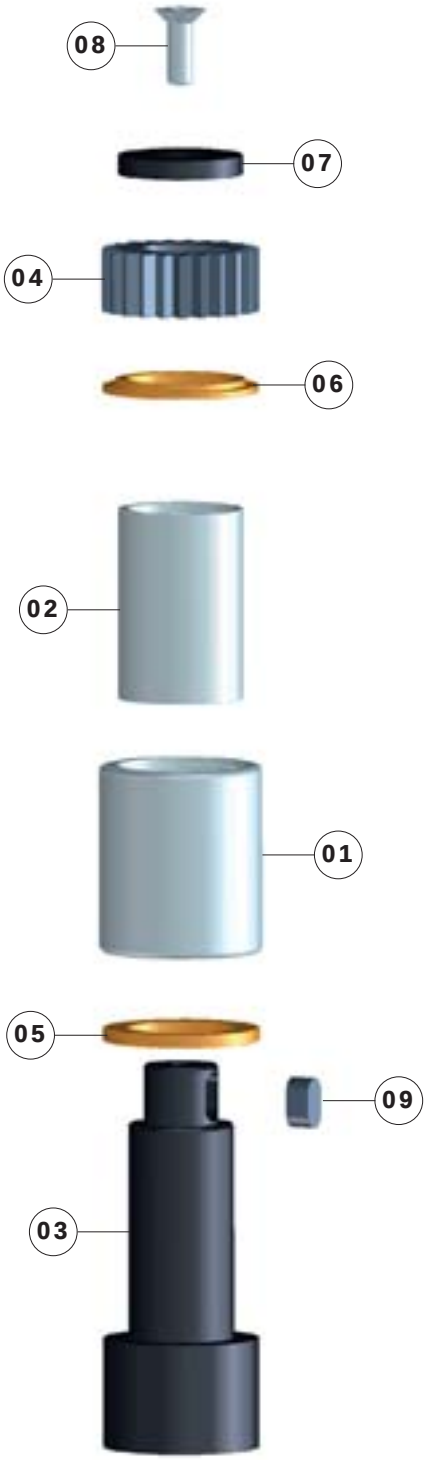
1159 99 04 — PO reduction motor R1:512

No	Order Code	Description	Qty
01	**00551134**	Shielded cable 4x0.5²+3x2x0.22²	9
02	**-**	Stud bolt dia. 2.5	3
03	**00563103**	10-pin plug, 97 3106A 18 19P	1
04	**00569045**	Gland + sleeve 1011-52	1
05	**100011332**	Motor-gearbox unit GR53 type 512	1
06	**11560406**	Connecting flange	1
07	**11560801**	Encoding wheel 17	1
08	**11560802**	Circuit support	1
09	**11560811**	Protection cover	1
10	**21700243**	Pulse sensor 243	1
11	**29424602**	Lower bushing	3
12	**29424612**	Upper bushing CI 243	3
13		Hex nut, M2.5	3
14	**9003020308**	Screw, hex skt head, M3x8	2
15	**9003020516**	Screw, hex skt head, M5x16	2
16	**9003020820**	Screw, hex skt head, M8x20	4
17	**9003050306**	Screw, hex skt csk head, M3x6	3
18	**9003050412**	Screw, hex skt csk head, M4x12	1
19	**9003000306**	Set screw, M3x6	2
NR	**9000563288**	Shielding kit, size 18, DDK connector	1
NR	**00563064**	Right cable clamp	1
A	**-**	See parts list, Detail A, PO motor drive	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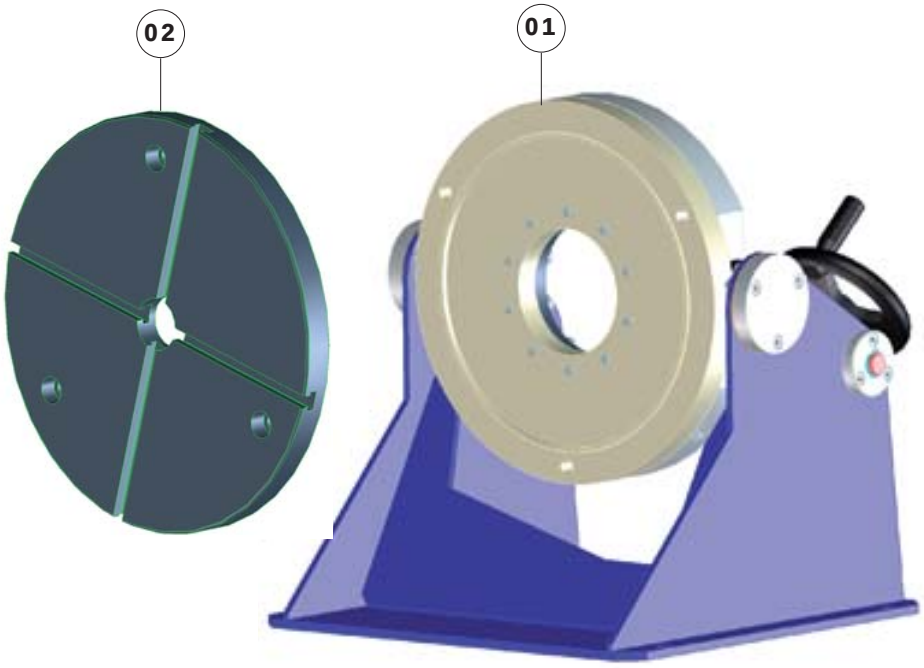
Detail A, PO motor drive

No	Order Code	Description	Qty
01	**01042121**	Bush HK 20-30	1
02	**01046001**	Ring IR 17.20.30,5 C2	1
03	**11560401**	Receiver shaft	1
04	**11560402**	Pinion 23 teeth M1	1
05	**11560403**	Rear washer	1
06	**11560404**	Front washer	1
07	**11560405**	Retaining washer	1
08	**9003050412**	Screw, hex skt csk head, M4x12	1
09		Key 4x4L8	1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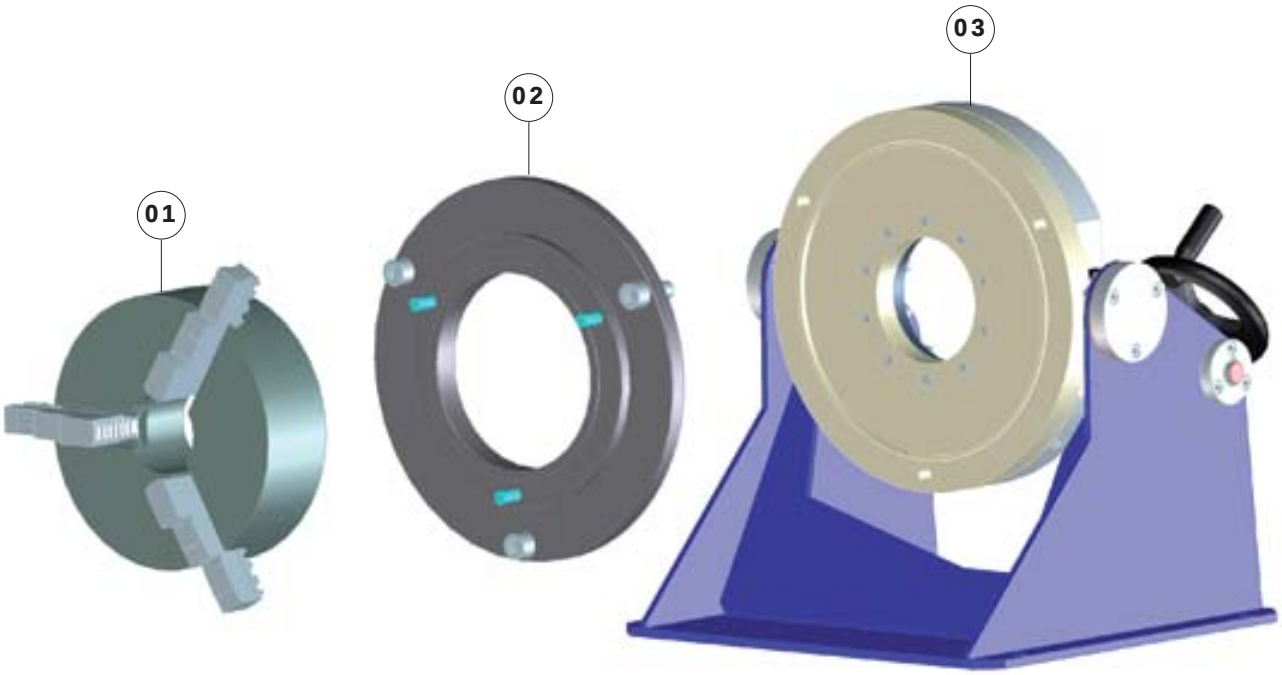
7550 07 32	Polyturn 50 positioner, plate dia. 400 mm

No	Order Code	Description	Qty
01	**11560000**	Polyturn positioner 175	1
02	**0011560702**	Plate, dia. 400 mm	1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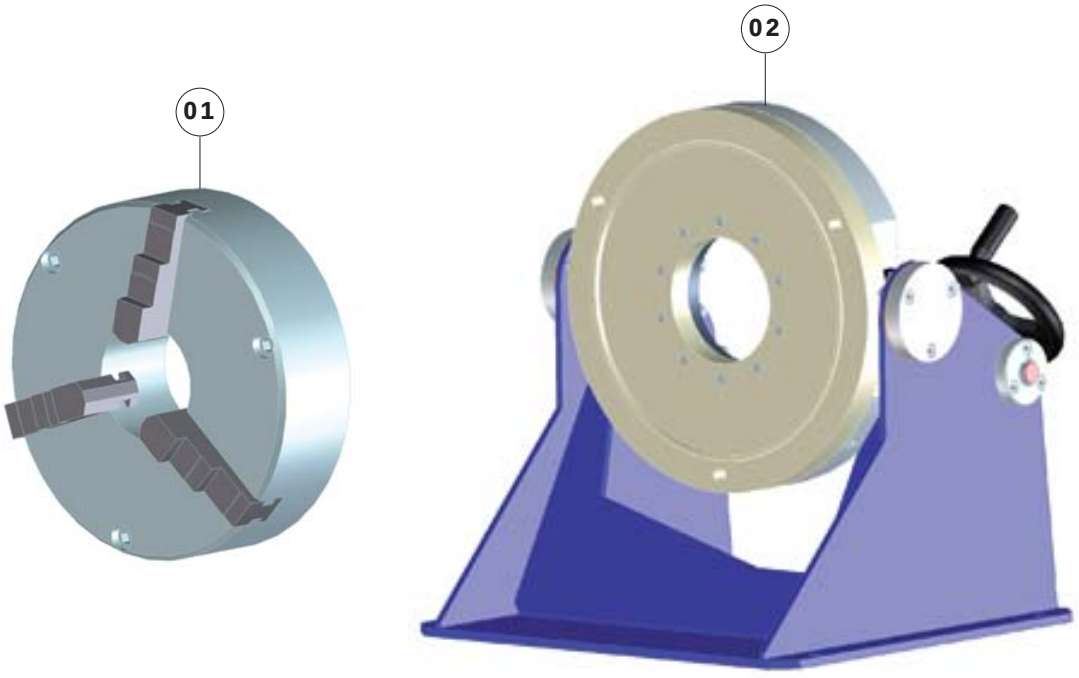
7550 07 33	Polyturn 76 positioner, chuck dia. 250 mm

No	Order Code	Description	Qty
01	**9001250303**	Chuck, dia. 250 mm	1
02	**0011560702**	Chuck adaptor, dia. 250 mm	1
03	**11560000**	Polyturn positioner 175	1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7550 07 34	Polyturn 115 positioner, chuck dia. 350 mm

No	Order Code	Description	Qty
01	**11560610**	Chuck dia. 350 mm modified	1
02	**11560000**	Polyturn positioner 175	1

7. End of service life - Recycling the machine

Our machines incorporate electrical and electronic components which must be recycled in accordance with Directive 2002/96/EC. Any item of equipment which is declared obsolete or out of service must be sent to approved recycling companies in order to reduce the amount of ultimate waste disposal. A number of solutions may be deployed, including:

- Re-use
- Recycling
- Any other form of recovery (including energy recovery) of WEEE (Waste Electrical and Electronic Equipment).

RETURN OF EQUIPMENT

Référence du document : PDS_FOR_032_Retour matériel_EN
Révision : 04
Date d'application :
Nom du rédacteur : ERO

Please fill out and join this sheet when returning equipment to POLYSOUDE

Reseller / Person in charge : .....

Customer / Person in charge / Tel. : .....

1. EQUIPMENT RETURNED :

❑ Power source Type : ..... Serial number : .....

❑ Welding head Type : ..... Serial number : .....

❑ Wire feeder Type : ..... Serial number : .....

❑ Other (*specify designation*) : .....

↳ taken from :

- ❑ Power source Type : ..... Serial number : .....
- ❑ Welding head Type : ..... Serial number : .....
- ❑ Wire feeder Type : ..... Serial number : .....
- ❑ Other(*to be specified*) : ..... Serial number : .....

1. REASON FOR RETURN :

❑ Return of loan equipment
❑ Return of demonstration / fair equipment
❑ Return of hired equipment
❑ Return after exchange
❑ Deficient delivery / incorrect order
❑ Return for modification (*to be specified*) : .....
❑ Return for revision
❑ Return for calibration

❑ Return for repair
(*to be specified*) :
- ❑ systematically occurring error
- ❑ occasionally occurring error

Description of breakdown :

.....

.....

.....

❑ Other issue *(to be specified)* : .....

Date : ..... Signature: .....

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R.C.S. Nantes B 858 800 931
TVA N° : FR 64858800931 - a member of Global Welding Technologies AG

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www.polysoude.com info@polysoude.com

ISO 9001
BUREAU VERITAS
Certification

Translation of original instructions

POLYSOUDE : Related Services

Guidance and technical support
A welding application specialist in your area will advise you on the welding process and appropriate equipment for your application.

Maintenance / Repair
Maintenance and repair operations can be carried out at the Polysoude plant as well as on site by our service network.

Commissioning / Training
A complete training program will enable you to start using the equipment immediately and in the best way possible.

Rental service
Increase the flexibility of your production! A large range of equipment is available for rental from our hire fleet.

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