



Operating Manual for the T-300 Filter option

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The T-300 Filter option power and air sources are ran through the T-300. Please refer to the T-300 operating manual for the correct power and air requirements.

Safety notes

Do not adjust the material while the material is being welded. Keep hands, long hair, loose clothing, and articles such as neckties away from the rollers have pinch points rollers to avoid entanglement and entrapment that can trap body parts or clothing and cause serious injury. Provide enough space around machine to ensure the safe and effective operation. The machine must be motionless and moving parts blocked before any cleaning, oiling, adjusting, repairing or maintaining work is done on any repairing or maintaining work is done on any part of the machine. Always wear Personal protective equipment. (PPE) refers to protective clothing, helmets, goggles, or other garment designed to protect the wearer's body from injury.

Unwind stand



Unwind stand The unwind stand will hold the roll of material. The machine runs off of tension. The unwind stand will keep the tension while the machine is running. The tension is controlled by the tension roller connected to the load cells.

Airing the shaft.



Airing the shaft The shaft must have air in it to hold the roll of material in place. The above picture shows where you air the shaft and release the air. Place the air nozzle in the shafts air valve to inflate. To deflate the air shaft hold in the valve till all the air is released.

Center laser line



The laser line. The laser line will allow the operator to quickly line up new rolls. The laser line is the center line of the machine that all measurements are made from.

Drop Roller



Drop Roller The drop roller will start the folding process of the tube. The drop roller is adjustable for different widths. The drop roller will adjust for the tubes lay flat



Drop roller rotation adjustment

Drop roller rotation adjustment. By loosening the lower handle you will be able to rotate the drop roller up or down to achieve the proper lay flat for different material widths and thickness.

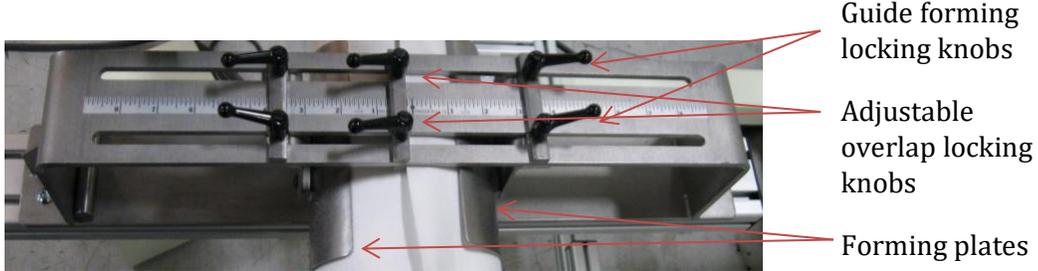
Pre forming Guides



Pre forming guide

Pre forming guide After the drop roller, these guides will keep the edges of the material up and start the folding process before the material reaches the main tube guide.

Main forming guide



Guide forming locking knobs

Adjustable overlap locking knobs

Forming plates

Main forming guide Will form the tube for the correct welding width. The guide is adjustable for tube sizes from 4 inches to 10 inches. The guide forming plates will hold the material to the correct size during the welding process. To adjust the size loosen the guide forming locking knobs and adjust the size accordingly. To adjust the overlap, loosen the adjustable overlap locking knob. You may have to adjust the overlap when changing material and sizes to make sure the overlap is in the center of the T-300. While adjusting for the overlap you may have to adjust the forming plates to achieve the correct overlap welding width.

Encoder



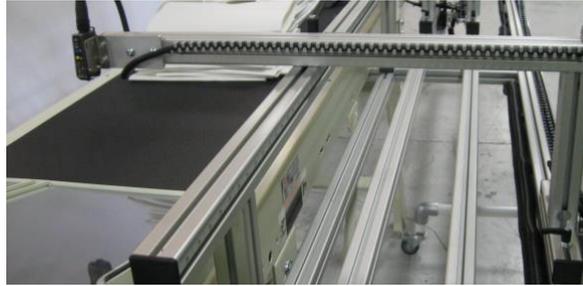
Encoder The encoder will only be used for lengths shorter than 2 feet and lengths longer than 15 feet. The settings for the encoder will be found on the machines HMI.

Accumulator



Accumulator The accumulator is used for a continuous process. As the material is being cut, the accumulator will take up any slack while the machine is being cut so that the machine doesn't stop the welding process.

Cut to Length Photo Eye Sensor

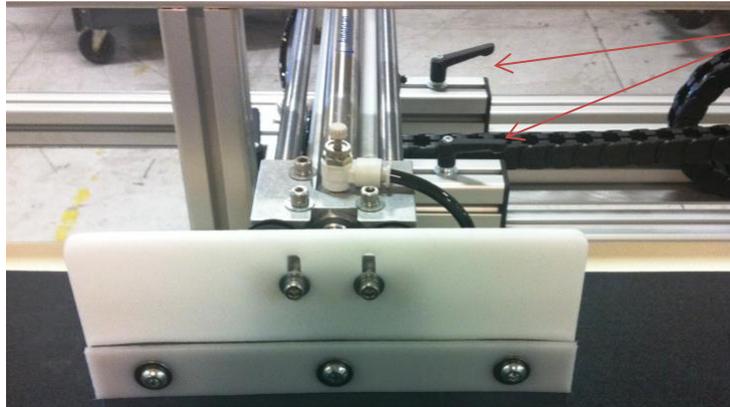


Cut to length photo eye sensor. This will measure the length of material and trigger the cutter to cut to length. By pushing the blue or yellow arrow adjust your sensitivity. To change lengths you must move the sensor bracket left to right depending on size.

Sweeping system

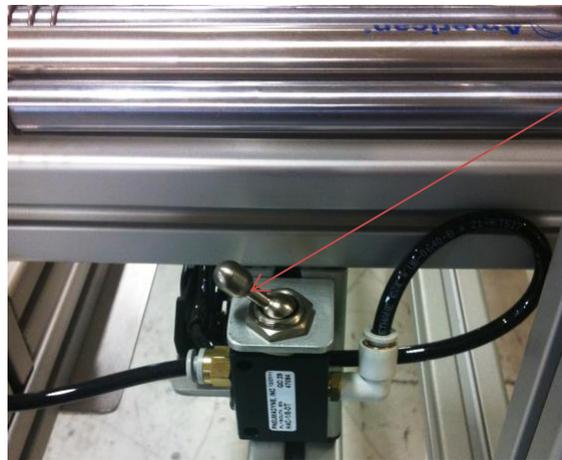


Sweeping system The sweeping system will push the material off the conveyer. The sweeping system is controlled by the cut. After the cut there is an adjustable timer that will trigger the sweeping systems. Each sweep can move left to right to accommodate and length of material. Each sweep can individually be turned on and off.



Sweep slide lock

Sweep slide lock By loosening the slide locks you are able to move the system left and right.



Sweeping system on/off toggle switch

Sweeping system on/off toggle switch Will turn on and off each individual sweeping system.

Guillotine Cutter.



Guillotine Cutter will cut the material at desired length triggered by the Cut to Length Photo Eye Sensor.

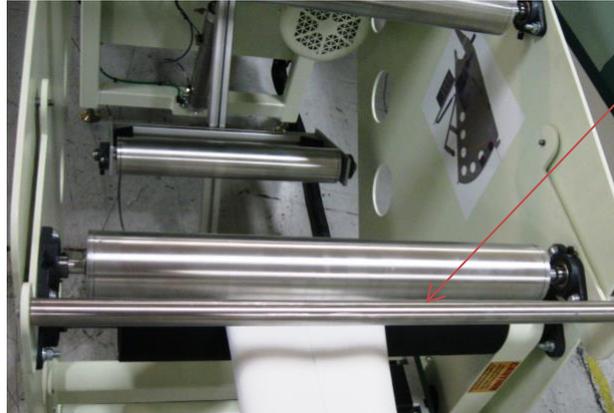
Note: Never operate cutting unit without guards in place. Always disconnect electric and air to the machine prior to servicing.

Conveyor puller roller



Conveyor puller roller The puller roller will pull from the accumulator. The speed of the puller roller is determined by the position of the accumulator. The open/ close button is located on the HMI screen.

Out board puller



Out board
puller roller
open/close
handle

Out board puller Will pull the material after the welding on the T-300. The speed control is located on the T-300 HMI. To open the puller, lift the top puller roller.

Conveyer



Conveyer Will Move the Material To cut length. And feed out the end for finished product.

Rope pull



Rope pull e stop Will shut off power to any moving part of the machine. Once the rope pull has been pulled you must reset by turning the blue button back to the forward arrow.

Puller pressure regulator



Puller pressue regulator Will increase and decrease the pressure of the puller. To increase the pressure turn the knob clock wise and to decrease the pressure turn the knob counter clock wise. When decreasing the pressure it is recommended to turn the pressure to zero then increase to the correct pressure.

Cutter pressure regulator



Cutter pressure regulator Will increase and decrease the pressure of the cutter. To increase the pressure turn the knob clock wise and to decrease the pressure turn the knob counter clock wise. When decreasing the pressure it is recommended to turn the pressure to zero then increase to the correct pressure.

Sweep pressure regulator



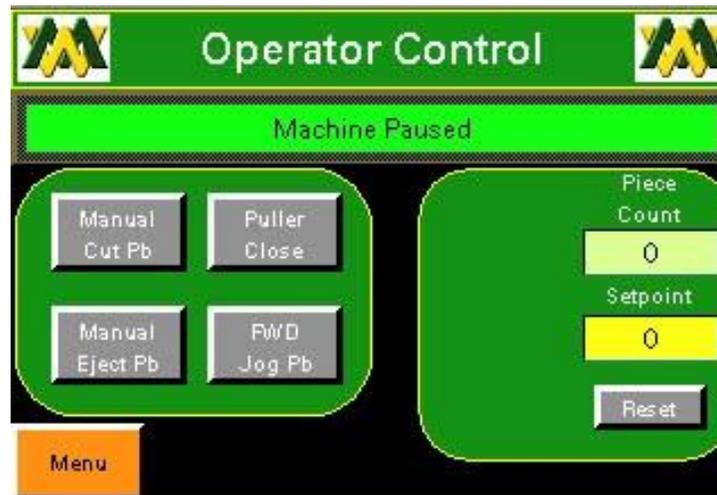
Sweep pressure regulator Will increase and decrease the pressure of the sweep system. To increase the pressure turn the knob clock wise and to decrease the pressure turn the knob counter clock wise. When decreasing the pressure it is recommended to turn the pressure to zero then increase to the correct .pressure.

Dancer pressure



Dancer pressure regulator Will increase and decrease the pressure of the sweep system. To increase the pressure turn the knob clock wise and to decrease the pressure turn the knob counter clock wise. When decreasing the pressure it is recommended to turn the pressure to zero then increase to the correct.

Screen shots



Manual cut pb Will manually trigger the cutter.

Puller close Will manually trigger the cutter.

Manual eject pb Will manually trigger the sweeps.

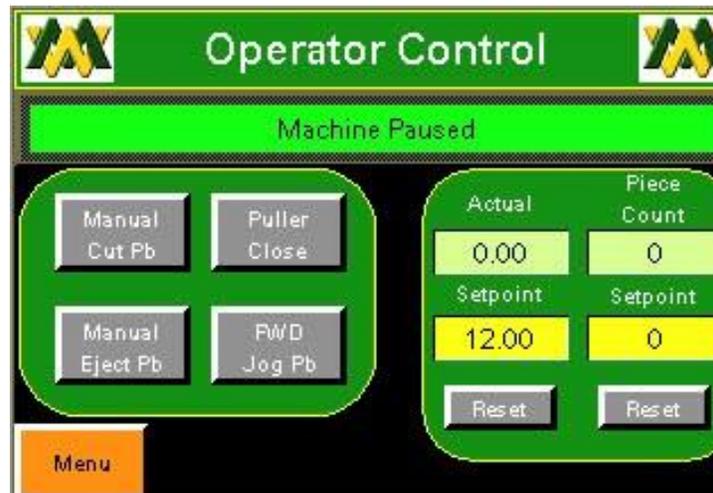
FWD jog pb Will jog the conveyer puller forward

Piece count Displays how many pieces you ran.

Set point Is the number of pieces that you wish to make.

Reset Will reset both actual and set point numbers to zero.

Note: any button in orange will take you to that specific screen. Any button in yellow is able to have the value changed. The buttons in red are for maintenance screens only.



Manual cut pb Will manually trigger the cutter.

Puller close Will manually trigger the cutter.

Manual eject pb Will manually trigger the sweeps.

Fwd jog pb Will jog the conveyer puller forward

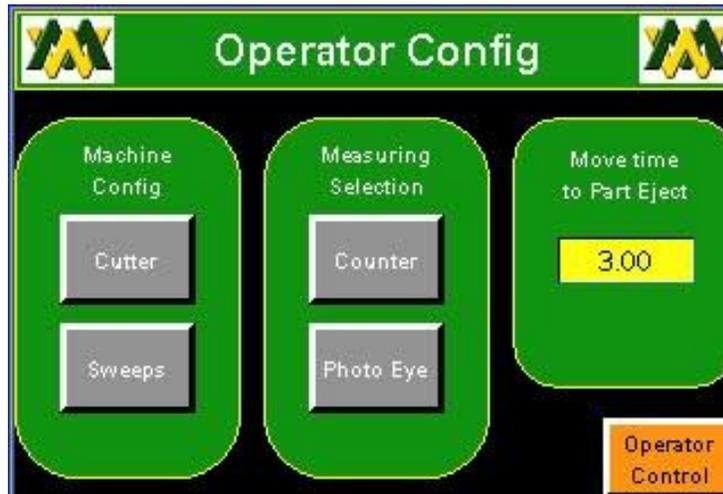
Actual Displays how many pieces have been ran.

Set point Is the number of pieces that you wish to make.

Piece count Displays how many pieces you ran.

Set point Is the number of pieces that you wish to make.

Reset Will reset both actual and set point numbers to zero.



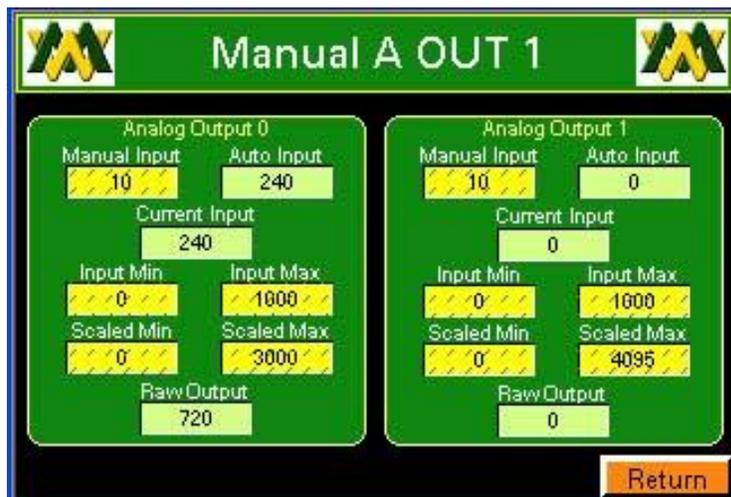
Cutter Will enable the cutter.

Sweeps Will enable the sweeps.

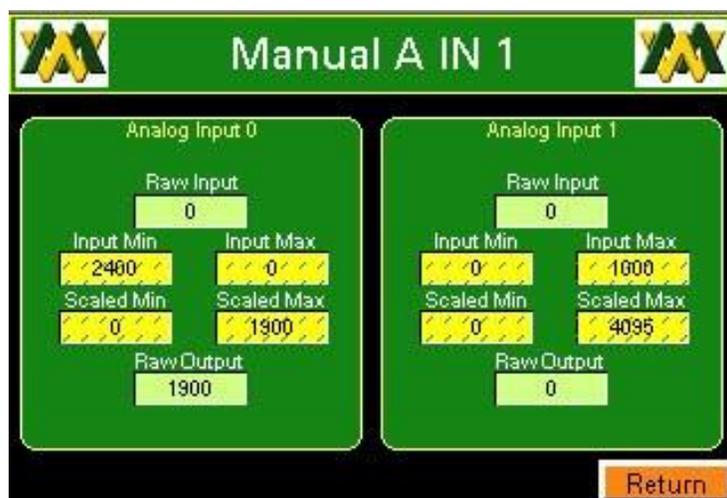
Counter Will enable the counter.

Photo Eye Will enable the photo eye.

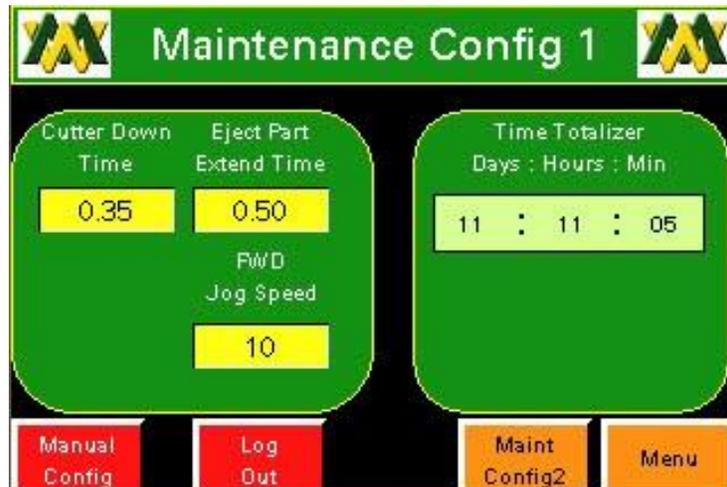
Move time to part eject Is the amount of time after the cut that the sweeps are activated.



Please contact Miller weld master before making any changes to this screen! 330-833-6739.



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Cutter Down time Is the amount of time the cutter will stay down after the cut.

Eject part extend time Is the amount of time after the cut that the sweeps will trigger.

Time totalizer Displays the amount of time the machine has been running.

You must log into the maintenance screen to get to this screen.

Note: any button in orange will take you to that specific screen. Any button in yellow is able to have the value changed. The buttons in red are for maintenance screens only.



Footage counter scaling Will increase or decrease the length of the material. It is recommended to contact Miller Weldmaster before making any adjustments to the scaling factor.

Reset Will reset the length of the material.



Alarm Screen. Displays any alarm that may have occurred. The button tells the machine that you recognized the problem and the proper adjustments have been made. You must push the ack. button to continue to run.



Message	Time	Date

Alarm Active Operator Control

Miller Weldmaster - Filter Line

Alarm History Will display all alarms that have occurred.