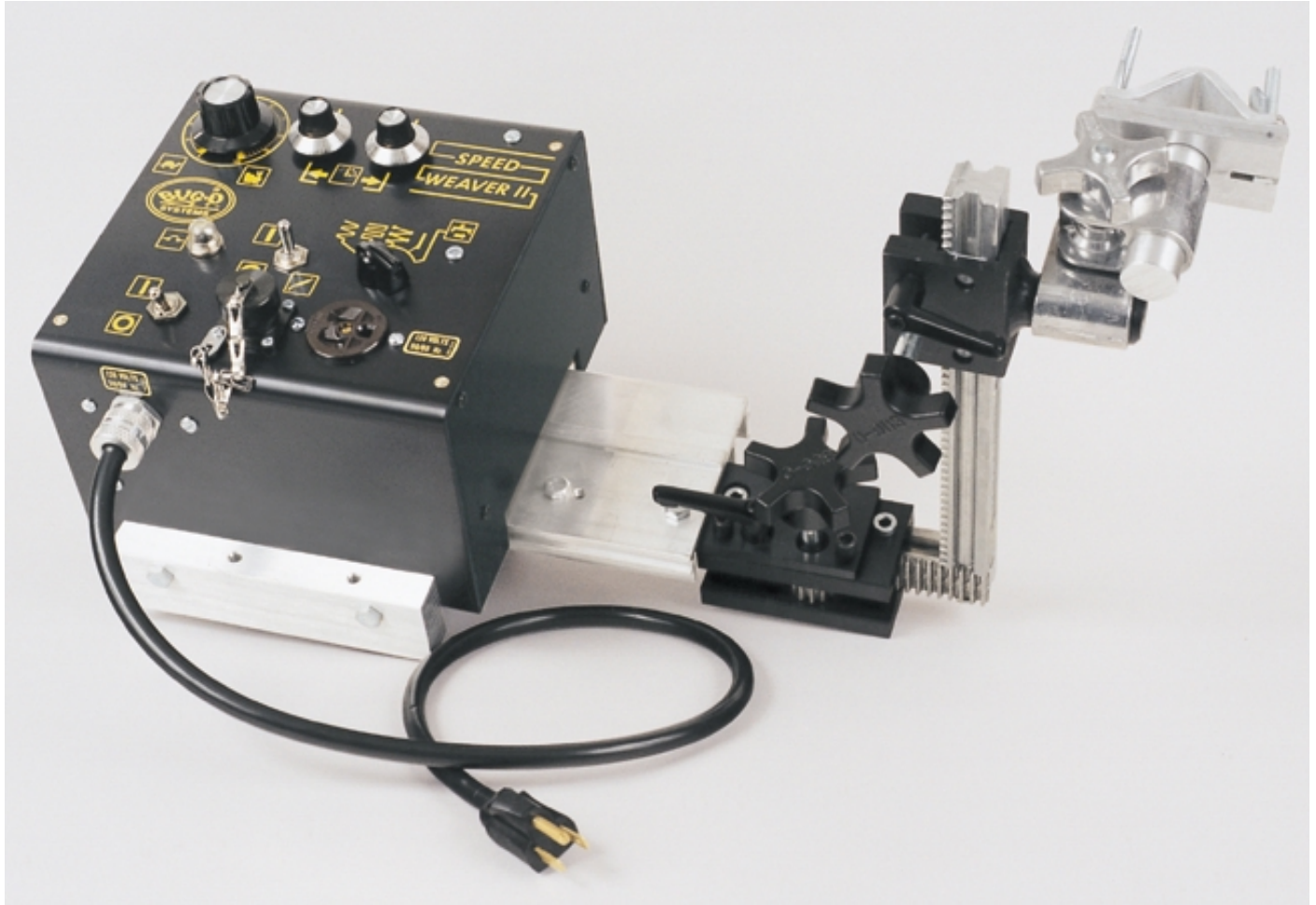




Make Precision Weave Welds Quickly, Easily, And Economically!

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



B U G - O S Y S T E M S

A DIVISION OF WELD TOOLING CORPORATION



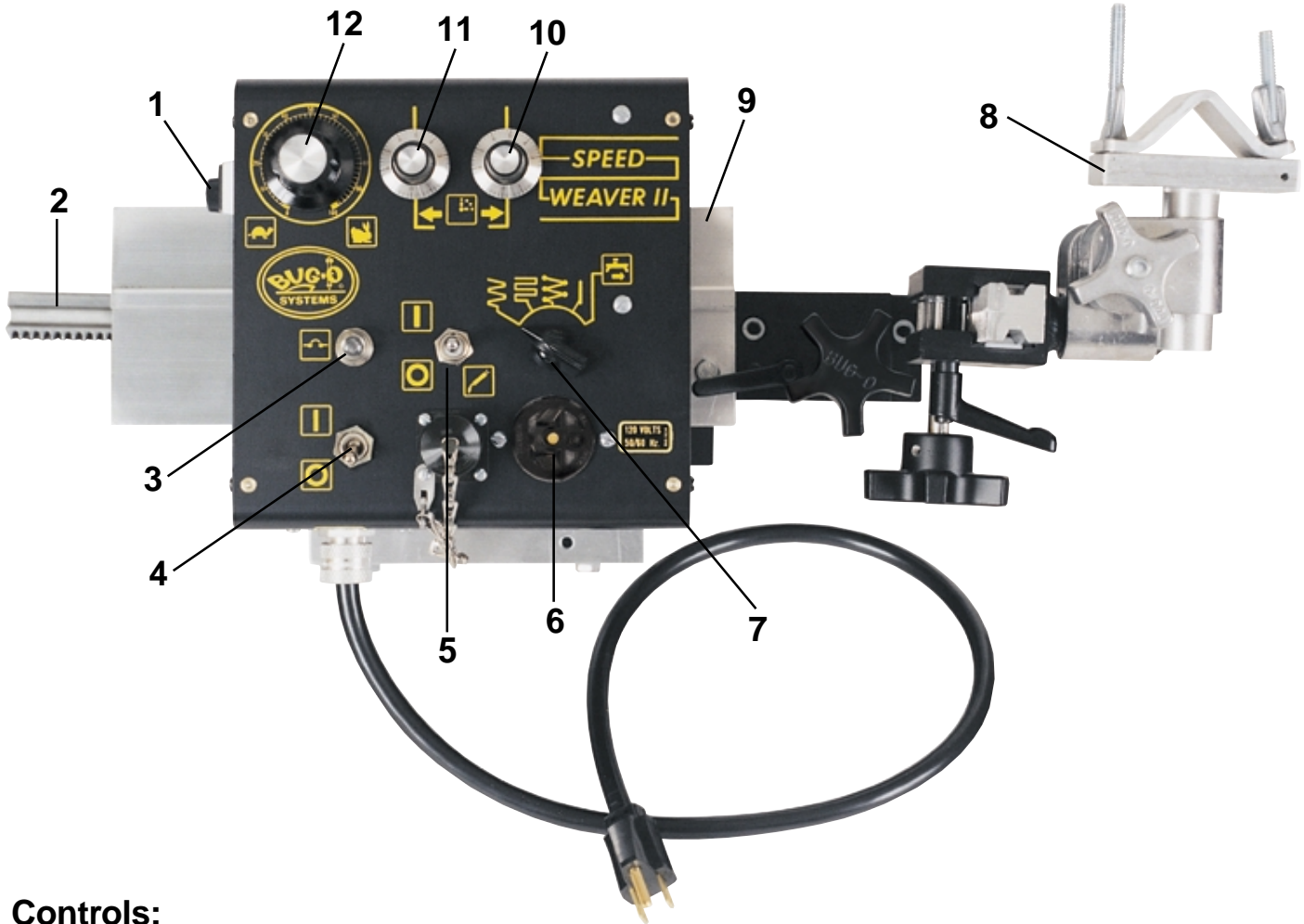
3001 WEST CARSON STREET PITTSBURGH, PENNSYLVANIA USA 15204-1899
PHONE: 1-800-245-3186 <http://www.bugo.com> TELEFAX: 1-412-331-0383



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 SPEEDWEAVER 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)

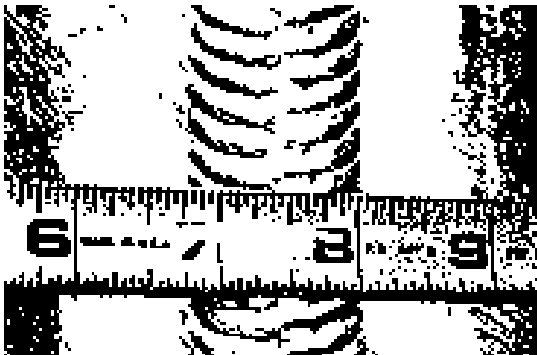
Cycles: 160 | 120 | 85 | 60 | 37

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.)

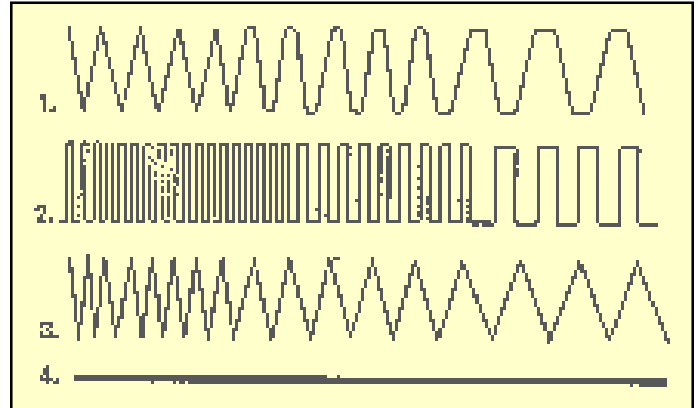
Shipping Weight: 22 lbs (10 kg)
 (Not including rail and torch mounting.)



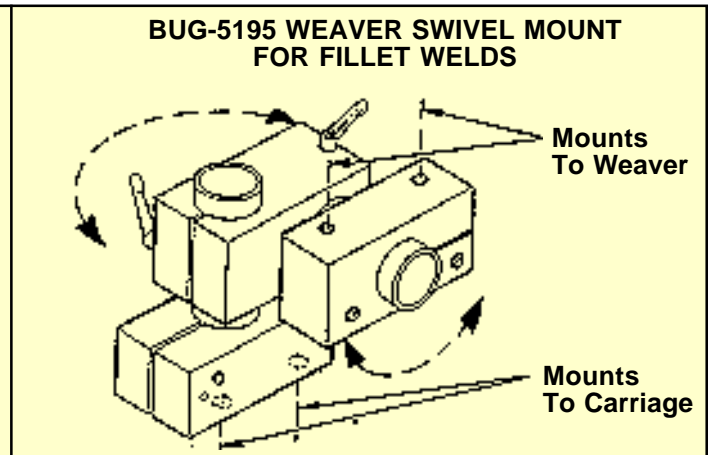
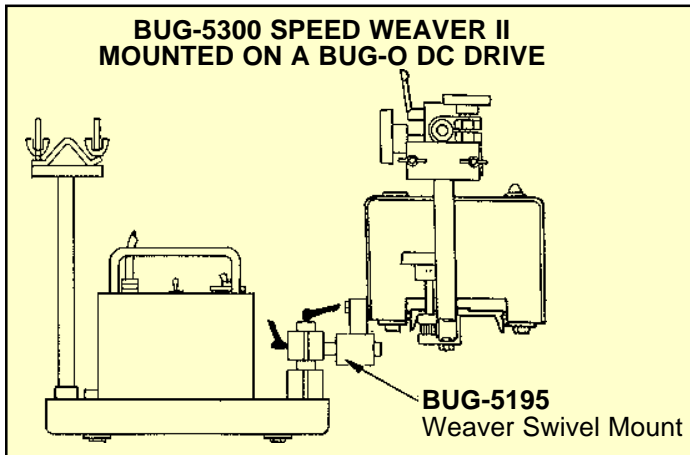
SAMPLE WELD

Weld Patterns:

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



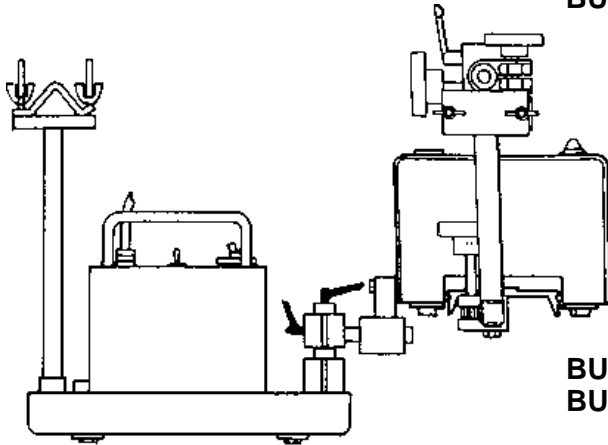
1. **RUN:**
 In this mode, power to the drive unit is always on, and the machine travels continuously both during weave and dwell. Weave speed and dwell time both affect the weld pattern.
2. **STEP:**
 The unit travels only during dwell, and stops during the oscillator cross stroke. Changing weave speed 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 WEAVE:**
 In this mode oscillation is stopped and powers the tractor only for stringer passes.





SPEED WEAVER II

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



Includes:

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

Includes:

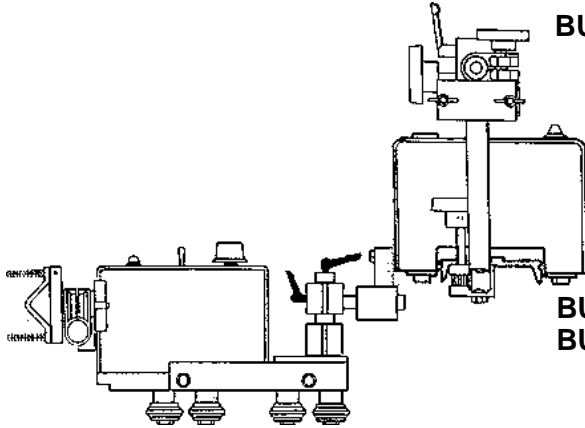
- 1 BUG-9444 Tool Kit
- 1 BUG-5300 SPEED WEAVER II
- 1 BUG-5195 Weaver Swivel Mount
- 1 BUG-2975 Cable Mounting Assembly
- 1 ARR-1080 H.D. Rigid Rail 93-1/2" (2.37 m)
- 1 ARR-1085 H.D. Rigid Rail 46-1/2" (1.18 m)
- 5 ARM-2325 Magnet Bar, Swivel w/Release

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)

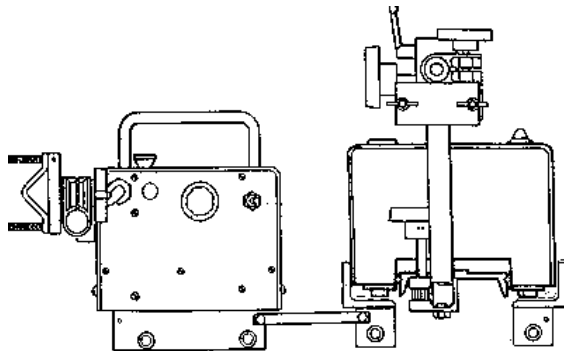
BUG-1914 ROL-O WEAVING KIT (42/50-60/1)

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

SFX-1020 SUPER-FLEX WELD WEAVING KIT (120/50-60/1)

SFX-1022 SUPER-FLEX WELD WEAVING KIT (240/50-60/1)

SFX-1024 SUPER-FLEX WELD 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-FLEX WELD WEAVING KIT (120/50-60/1)

*SFX-1022-1 SUPER-FLEX WELD WEAVING KIT (240/50-60/1)

*SFX-1024-1 SUPER-FLEX WELD 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

