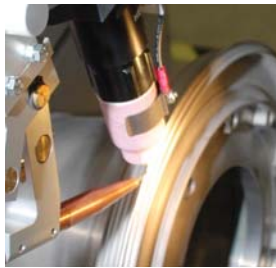


Dabber® Pro

Liburdi Automated Welding Systems



3 - 8 Axes

Precision Seal Welding

Precisely Controlled Beads
on Thin Edges with Minimal
Heat Affected Zones

Available in GTAW
and/or PAW Processes

Automated Articulated Arm
Configuration Available

Our Legendary Control
System can be retrofitted onto
any Existing Welding System

Precision Welding

The Liburdi Dabber® Pro produces narrow weld buildups on tightly spaced thin edges with minimal heat affected zones. The reduced heat input of a dabber weld solves the problems of shrinkage, distortion and cold overlaps that can occur with other weld processes. The Dabber® Pro offers versatility in applications ranging from titanium, super alloy jet engine seals, alloy steel molds and diesel engine valves. The Liburdi Dabber® is currently being used in facilities throughout the world by engine OEM's, military installations, major airlines and third party repair shops. The Liburdi Dabber® Pro builds on the extensive service history of the original Hobart Dabber® of the 1980's. The Liburdi Dabber® is the only true Dabber® in the industry.

Industry Proven LCX™ Controller and Puls weld® Power Source

The Dabber® Pro is built with the same state of the art control architecture used in Liburdi's complete line of orbital welding systems and boasts a proven track record across many different industries and processes. The LCX™ Controller performs high resolution data acquisition and precise synchronization of

reciprocating wire feed and pulsed arc that is critical to the dabber process. The industry leading Puls weld® power source is renowned for superior arc characteristics that are unmatched by its competitors. Power supply configurations include GTAW (standard) and/or PAW (optional) and Variably Polarity (optional) with multiple current output capacities.

Dabber® Pro Software Technology

The Dabber® Pro graphical user interface has been designed by combining our twenty-plus years of experience in the welding industry with valued customer feedback to provide a new generation, easy to use controller. The Dabber® Pro software utilizes a touch screen to give finger tip control of all system functionalities; from managing weld programs and executing welds, to testing, calibrating, and troubleshooting the system. The user interface also comes complete with a full size keyboard and mouse pad as an alternative to the touch screen. A hand held operator pendant is included for making changes to the weld program, jogging axes or performing overrides during a weld.



Dabber® Pro

Liburdi Automated Welding Systems



Physical Characteristics

Design: Circumferential Welding
 Height: 121" (3.7 m)
 Length: 103" (2.6 m)
 Width: 71" (180 cm)
 Weight: 4800 lbs (2200 kg)
 Available Axes: 2 axis (Y,Z) RBM along with 3 axis positioner (Rotary and Tilt Standard), manual X rails optional. 2 axis on weld head (AVC/manual OSC)

Operating Environment

Temperature: 50°F to 86°F (10°C to 30°C)
 Relative Humidity: 5% to 95% (Non-Condensing)

Utilities

Primary Voltage: 240 VAC Three Phase ± 10% (Step Down Transformer Available)
 Current: 50/60 Hz @ 30 Amp
 Argon: 60 psi (400 kPa)

GTAW/PAW Output Rating

GTAW Welding Current: 0.1 to 200 Amperes
 PAW Pilot Arc Current: 29 Amps Maximum
 PAW Welding Current: 0.1-200 A, Others Available
 Duty Cycle: 100%
 Arc Voltage Range: 0-32 V

Water Circulator

Coolant Tank Size: 2 gallons (8 L)
 Input Power: Integrated
 Water Flow Switch: 0.1 - 1.0 gpm (0.37-3.7 l/min)

Wire Feeder Control

Wire Feed Speed Control: Smart Motor
 Dabbing Cycle Frequency: 0 to 10 Hz
 Wire Feed Rate: 0 to 100 ipm (0 to 254 cm/min)
**Optional Speeds Available*

Torch Manipulator

Z-Axis Travel Distance: 65" (165 cm) RBM , 6" AVC
 Y-Axis Travel Distance: 63" (160 cm) RBM
 X-Axis Travel Distance: 37" (94 cm) on rails, 6" OSC

Precision Rotary Positioner

Load Capacity: 1000 lbs (453 kg)
**Optional Sizes Available*
 4" - 4" (10 cm - 10 cm)
 Eccentricity, Overhang: **Optional*
 Anti-Backlash Features: **Optional*
 Table Diameter: 30" (76 cm), Others Available
 Table Flatness: 0.006"/ft. (0.05 cm/m)
 Rotation Speed: 0.03 - 2.0 RPM
 Tilt Range: -5 to +95
 Tilt Speed: 0.5 RPM

Gas Control

Shield Gas Flow Rate: 0-50 CFH (0-23.5 L/min)
 Trail Gas Flow Rate: 0-170 CFH (0-80 L/min)
 Plasma Gas Flow Rate: **0-6 CFH (0-2.83 l/min) Optional*
 Fixture Gas Flow Rate: Connector provided - no control
 Gas Flow Switches: Adjustable Trip Points

Computer Components

- Embedded CPU with custom controller board
- 17" industrial touch screen monitor and keyboard
- USB printer port
- USB removable flash drive
- LAN communication

Standard Wire Sizes

- 0.025", 0.035", 0.045", 0.063"

System Options:

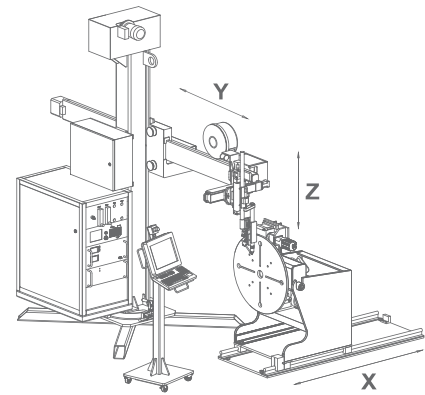
- Positioner Rails (X Axis)
- Motorized Oscillation (X Axis)
- Micro Plasma Welding
- Hot Wire Welding
- Variable Polarity Welding

Remote Pendant

- Cycle Start/Stop
- E-Stop the torch
- Travel, Wire, AVC, Oscillation Axis Jog
- Parameter Override
- Parameter Display

Automatic Voltage Control (AVC)

- 5-32 Volts
- Programmable Sensitivity
- Touch / Retract (GTAW only)
- 20 Hz Update



Software Technology



Run Weld Screen - Welding telemetry and rotary position are displayed in real time.



Schedule Editing Screen - Load and save schedules, set weld parameter values and view a graphical representation of the weld sequence, rotary position and pulse shape.



Event Log Screen - Review system events like alarms, user login/logout and emergency stops.

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