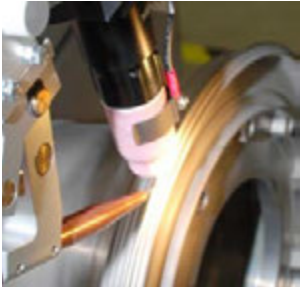


# Dabber® with Pulsweld

Liburdi Automated Welding Systems



3 - 5 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

The industry standard for precision welding, the Liburdi Dabber® produces precisely controlled beads on thin edges with minimal heat affected zones.

The Dabber® offers versatility in applications ranging from titanium, super alloy jet engine seals, alloy steel molds and diesel engine valves. Built in feature allows the ability to seam in a straight line up to 42" with linear boom.

#### Controlled by our Industry Proven LCX™/FireView™ Controller

The state of the art control architecture is expandable to 8 servos of motion control including wire feed, and comes standard with high speed data monitoring. The welding package used is our legendary Pulsweld power supplies which are unmatched within the industry and comes in GTAW (standard) and/or PAW (optional). The LCX™

controller comes complete with USB and Ethernet ports and supports the latest technology in connectivity to the internet, MODBUS. Our FireView™ graphical user interface combines over 20 years experience in the welding industry to provide an easy to use controller for both programming and executing the weld. When coupled with our optional viewing system, it gives the operator a single screen to view the weld, modify necessary parameters and view the telemetry all at once.

In addition to the standard welding functions, the servo and I/O functions can be connected through the auxiliary port and used to operate custom applications such as lathes, seamers, machining and inspection equipment.



# Dabber® with Pulsweld

Liburdi Automated Welding Systems

## Physical Characteristics

Design:	Circumferential Welding
Standard Floor Space:	144" x 120" (3.7 m x 3.1 m)
Overall Height:	103" (2.6 m)
Width:	57" (145 cm)
Weight:	4800 lbs (2200 kg)
Number of Axes:	3 axis (x,y,z) RBM along with 2 axis positioner (rotary and tilt)

## 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:	5 gallons (19 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:	Stepper Motor
Dabbing Cycle Frequency:	0 to 10 Hz
Wire Feed Rate:	0 to 100 ipm (0 to 254 cm/min) *Optional 300 ipm

## Gas Control

Plasma Gas Flow Rate:	*0-6 CFH (0-2.83 l/min) Option
Shield Gas Flow Rate:	0-50 CFH (0-23.5 l/min)
Fixture Gas Flow Rate:	0-50 CFH (0-23.5 l/min)
Gas Flow Switches:	20 psi (1.4kg/cm2)
(Other Rates Available)	

## Computer Components

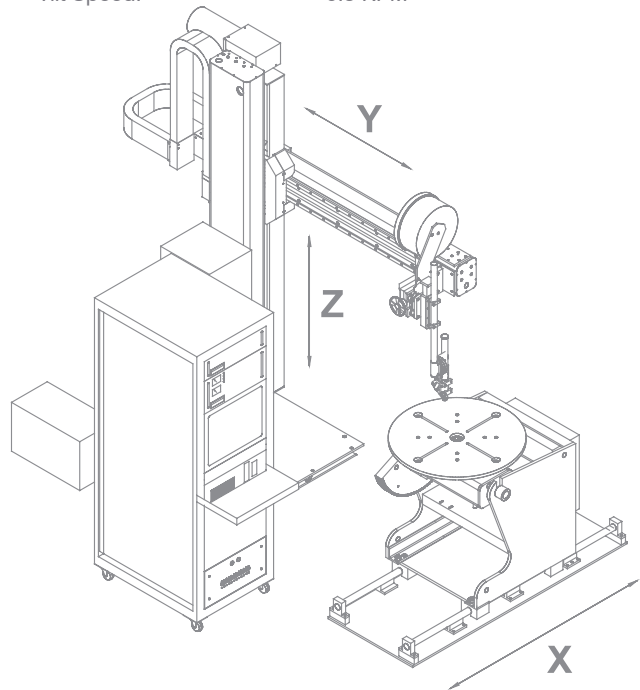
- PC based computer
- Industrial touch screen colour monitor
- Standard printer port
- CD-ROM drive
- LAN communication

## Torch Manipulator

Z-Axis Travel Distance:	50" (127 cm)
Y-Axis Travel Distance:	42" (107 cm)
X-Axis Travel Distance:	36" (91 cm)
Platform:	64" x 84" (162 cm x 213 cm)
Height with Lifting Eye:	117" (300 cm)

## Precision Rotary Positioner

Load Capacity:	1000 lbs (453 kg) *Optional Sizes Available
Eccentricity, Overhang:	4"- 4" (10 cm - 10 cm)
Anti-Backlash Features:	Available
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



## System Options:

- Positioner Rails
- Oscillation
- Micro Plasma Welding
- Hot Wire Welding
- Internet Capabilities

## Remote Pendant

- Cycle Start/Stop
- E-Stop the torch
- Travel, Wire, AVC, Oscillate, and Jog
- Parameter Trim
- Parameter Display

## Automatic Voltage Control (AVC)

- 5-40 Volts
- Programmable Sensitivity
- Touch / Retract (GTAW only)
- 20 Hz Update

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