

# WELDTRON Weldtron Products

Manufacturer and designer of electronic controls for industrial and welding machinery

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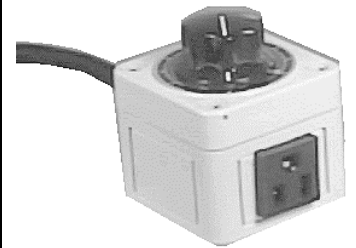
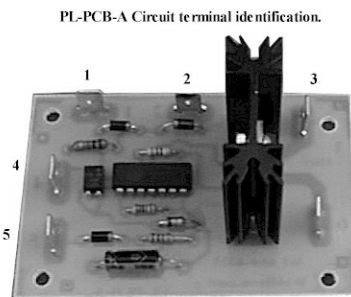
## Installation and use of the PIPELINER Remote Amperage Control.

The PIPELINER is truly a breakthrough in remote amperage controls for welding machines which have AC power and separate DC field control systems. Our system **allows the user to utilize a standard 3 wire extension cord** to link the remote control to the welding machine while having both complete control and the use of AC or DC power from the hand control itself. No more special cords or bulky hand control units.

The PIPELINER is designed to operate a wide range of Lincoln, Miller and Hobart engine driven welding machines but only the Lincoln wiring connection diagram is enclosed within the unit's package. Simply contact us for a complete set of connection schematics.

### NOTICE!

If you have any problems installing this Remote Control visit our website at [www.weldtron.com](http://www.weldtron.com) and use our **TECHNICAL SUPPORT** pages to find Pipeliner troubleshooting support data. This data will allow you to troubleshoot and diagnose your problem, whether it is installation or a later malfunction of the unit.



The PIPELINER is comprised of two components:

- The Machine circuit board.
- The Hand control unit.

The unit may also be upgraded so that a miniature hand control (small enough to mount on a TIG torch) can become an accessory to your unit while still having full control of the standard hand control unit.

**The PIPELINER-I is the same as the PIPELINER except it is designed to operate with an auxiliary mini hand control accessory.**



## The PL-MINI Mini Hand Control

Use of the mini hand control is very simple.

Tuesday, April 30, 2002

When it is plugged into the PIPELINER main hand control it **bypasses** the hand control's own rheostat. You have full control from 0-100% of the machine from the mini control and not the main hand control. Unplug it and full control reverts back to the main hand control.

When looking down at the mini hand control, minimum machine amperage is to the right (or counter clockwise). Machine amperage increases as the hand control is turned to the right (clockwise).

## **Using the Remote Amperage Control**

**The PIPELINER is only operable when the hand control is plugged into the remote control receptacle.** When it is unplugged full control of the machine is performed by the machine's own rheostat. The extension cord used to connect the PIPELINER to the machine may be used as a standard AC or DC power outlet without damage to the machine's internal circuit board. When the hand control is plugged in it then becomes an outlet for power but the control of the welding machine is now performed by the remote control.

When using the PIPELINER we recommend that the machine's own rheostat (fine current control) be turned down to its lowest range. The remote will give you full control over that range. However, for very fine adjustments within any range, simply set the machine's rheostat to the highest range you wish to weld in and the remote will control the amperage from minimum up to the maximum you set the range on the machine to. This is very useful when welding stringers and then capping out without having to remember what the settings were.

Older models of the PIPELINER (RC-series) required the use of different machine circuit boards for various machines such as one for DC excited machines (SA-200) and another for AC rectified DC excited machines such as the Classic series. **The current model of our PIPELINER fits all without any special adapters or circuits.** This means that you can use a single hand control to operate various types of machines by simply installing one machine circuit board in each--without the need to purchase multiple hand control units.

An additional note: The 0-100% setting on the machine will not correspond to the dial on the hand control. While being approximately the same setting as the machine, the dial on the hand control relates to a linear control while the rheostat on the machine relates to a tapered control.

### **When installing the PIPELINER**

**DO NOT GUESS--contact us if you need information installing or using the product.**

**361-664-4413**

## **WARNING!**

**DO NOT IMMERSE THE HAND CONTROLLER INTO WATER OR MUD!**

**Keep extension cord plugs and receptacles clean and dry!**

**Although the hand control is protected against the weather it is not designed to be submerged under water. The electronics will be damaged.**

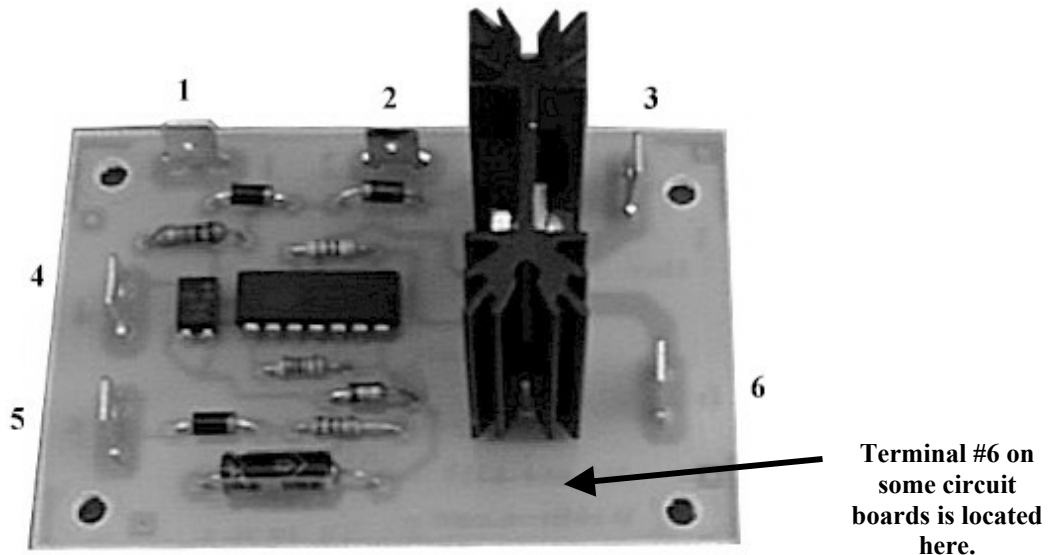
**All units have water indicators internally. Warranty is voided if water has entered the case.**

## INSTALLATION OF THE PIPELINER

Installation is very simple if the wiring diagrams are read and utilized properly. Failure to comply with them will insure a problem when installing the unit.

Two sets of electrical drawings are supplied with the unit. **IF YOU DO NOT UNDERSTAND THEM--DO NOT ATTEMPT TO INSTALL THE UNIT YOURSELF!** Utilize the services of a professional welding machine repair shop. Damages caused by failure to follow (or understand) the directions VOID all warranty. Warranty is for a period of 1 year from date of purchase.

PL-PCB-A Circuit terminal identification.



THE LAYOUT AND TERMINAL IDENTIFICATION ON THE PIPELINER MACHINE CIRCUIT BOARD.

Mount the machine circuit board so that it is protected from water and the elements. We recommend that it be mounted behind the main control panel of the machine.

Use the diagrams to connect the new wiring to the machine and board. The **dotted lines** indicate new wiring while the solid lines indicate the machine's original wiring.

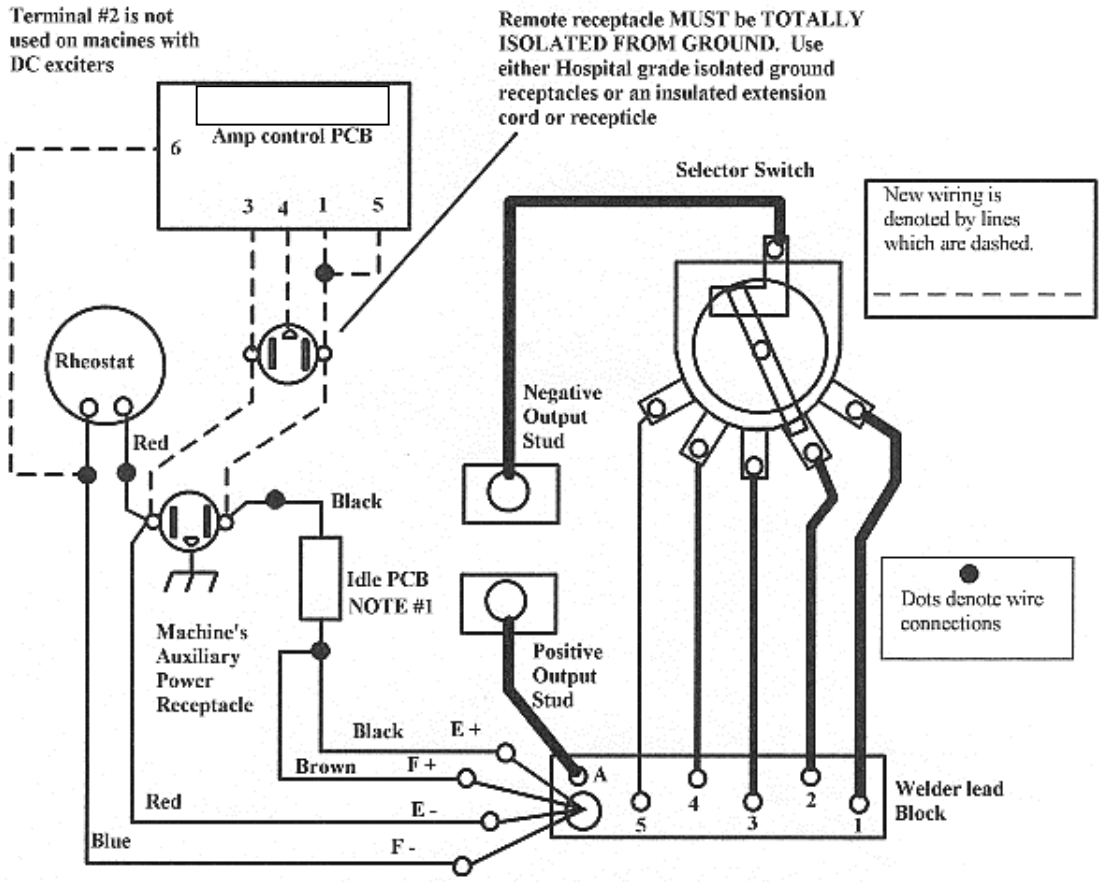
Once installed, the remote hand control may be used on other types of machines by simply installing a control circuit board (PL-PCB) to that machine.

**Notice: Use an isolated receptacle for the remote connection to the machine or the unit may be damaged or simply will not operate. If installation problems are experienced FIRST CHECK TO INSURE THAT AN ISOLATED RECEPTACLE WAS USED.**

**We supply only the drawings for connection to Lincoln SA and Classic machines with our product.**

**The remote control may be used on Miller, Hobart and a wide range of other engine driven machines and the installation drawings are available upon request.**

**Drawing for installation to DC excited machines.  
SA-200/250, Classic I and Pipeliner 200G machines**



**Note #1:** Wire upgraded R-57 vacuum idlers with our model IC-104 the same as shown above. Simply substitute the idle PCB with the hole in the sensor.

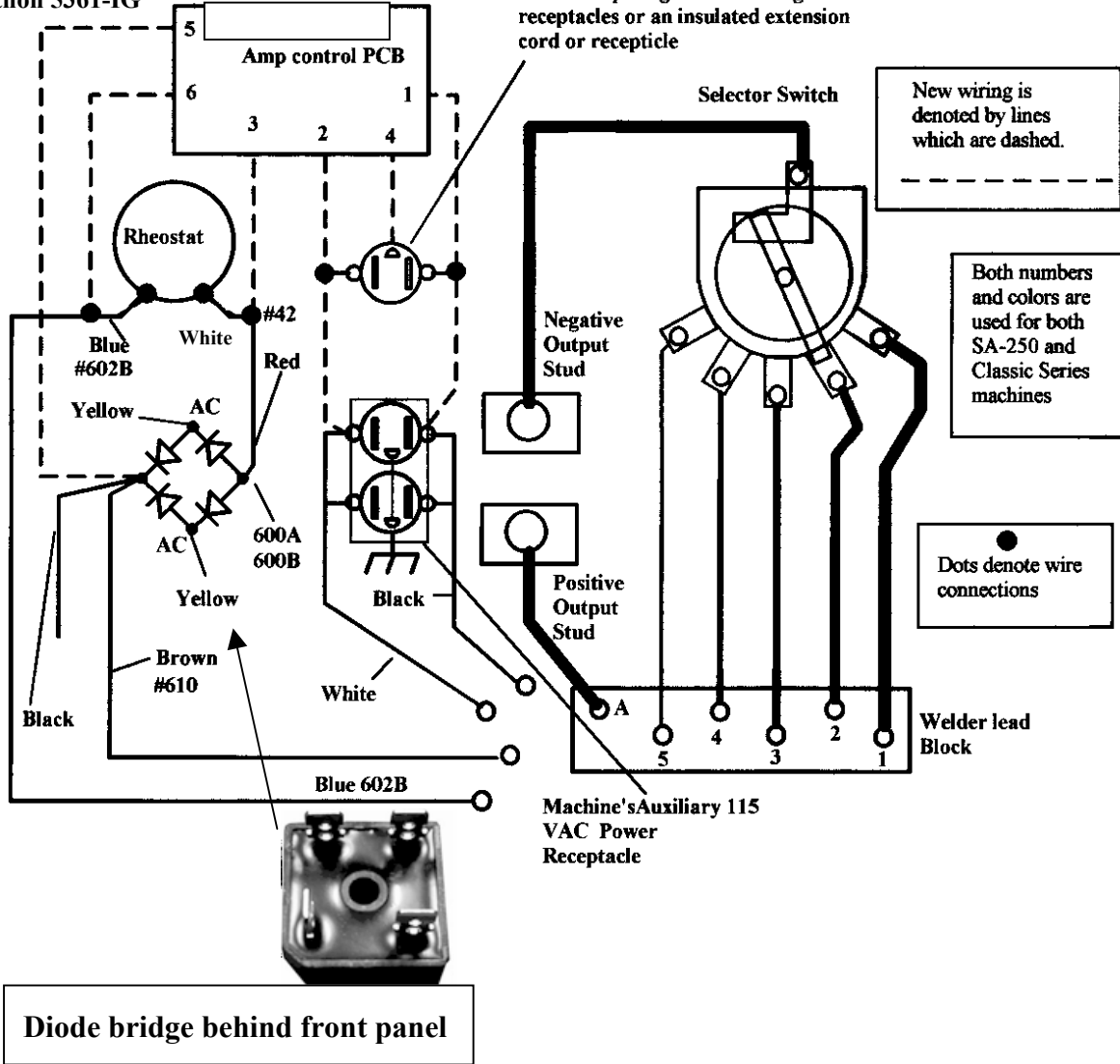
**Single isolated receptacle may be purchased at a local electrical supply house. Use part:**

**Levathon 5361-IG**

Installation to SA-250, Classic II, III & 300D machines with AC power.

Single isolated receptacle may be purchased at a local electrical supply house. Use part: Levathon 5361-IG

Remote receptacle MUST be TOTALLY ISOLATED FROM GROUND. Use either Hospital grade isolated ground receptacles or an insulated extension cord or receptacle



# Weldtron Products

PO Box 30 Alice, TX 78332 Tel: 361-664-4413 Internet: www.weldtron.com

## Connection of a Pipeliner remote control to the GFI system on a Lincoln SA-250 with AC, Classic II, Classic III and Classic 300D machine.

