

Jetline® Mechanical Oscillators



Quick Specs

Applications

- Longitudinal seam welders
- Side beam track and carriage systems
- Powered turning roll drivers
- Welding positioners
- Welding lathes
- Weld head locators

Processes

- TIG (GTAW)
- Plasma arc welding (PAW)
- MIG (GMAW)
- Submerged arc welding (SAW)

Input Power

120 V (can be configured by end user for 240 V), 1-phase, 50/60 Hz

Power Cord

Standard 120 V, 6 ft. (1.8 m) long

Jetline oscillators (weavers) are for applications where precision and repeatability are critical to avoid costly defects such as sidewall fusion issues, as well as eliminating voids and undercuts, improving productivity and quality in overlay, hard-facing, cladding and banding operations.



Also available:
JMO-80-2 package
(includes MO-80-101-2
slide shown at right).

JMO-150-5 package shown
(includes MO-150-101-5 slide).

Packages include:

- Slide
- Control module
- Pendant control
- 15-foot pendant cable
- 10-foot slide cable

Two different capacity slides available:

- **MO-150-101-5:** 150-pound (68 kg) payload capacity at 2 inches (50 mm) with 4.5 inches (114 mm) of stroke.
- **MO-80-101-2:** 80-pound (36 kg) payload capacity at 2 inches (50 mm) with 1.5 inches (38 mm) of stroke.

User-friendly operator pendant layout with large screen and graphic backlit display for complete operation, set up and configuration.

Micro-stepper drive provides precision arc oscillation.

Integrates with existing Jetline control packages.

Pendant control provides:

- Ability to store four oscillator programs.
- Ability to program independent left and right speeds.
- Ability to program independent left and right dwells.
- Ability to program taper time.

Sturdy bellows protect lead screw assembly and precision linear guide assemblies from dirt for smooth operation.

Slide Specifications (Subject to change without notice.)

Stock No.	Length	Width	Depth	Net Weight
MO-150-101-5	20.125 in. (511.2 mm)	7 in. (177.8 mm)	4.75 in. (120.7 mm)	25.75 lb. (11.7 kg)
MO-80-101-2	12.625 in. (320.7 mm)	5.625 in. (142.9 mm)	2.375 in. (60.3 mm)	10.15 lb. (4.6 kg)



Warranted for three years, parts.

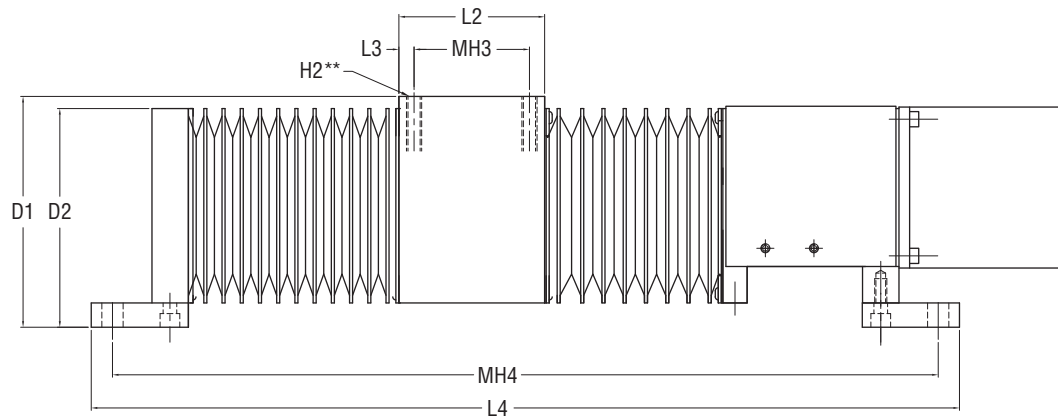
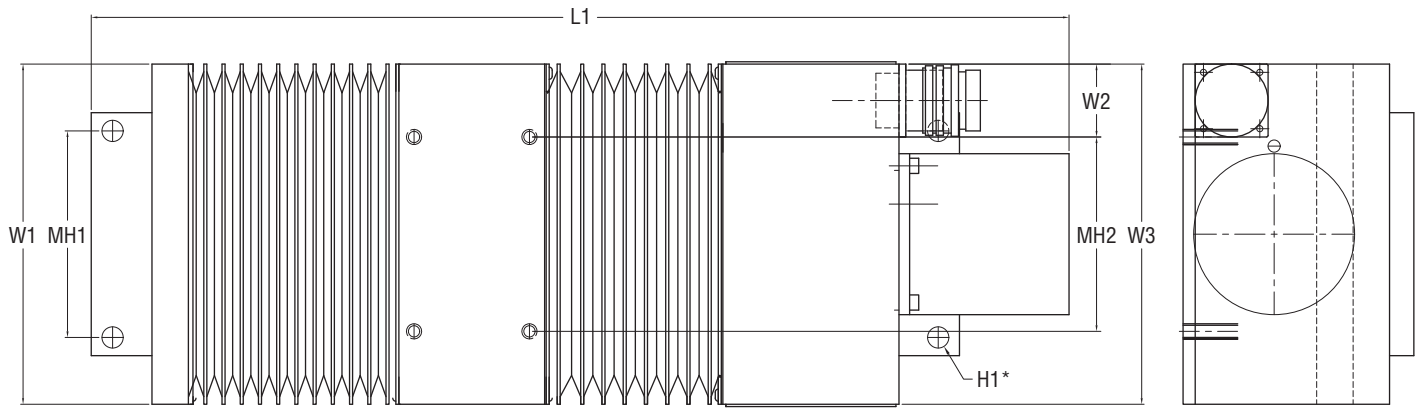


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f t y i n

MO-150-101-5 Slide Dimensions

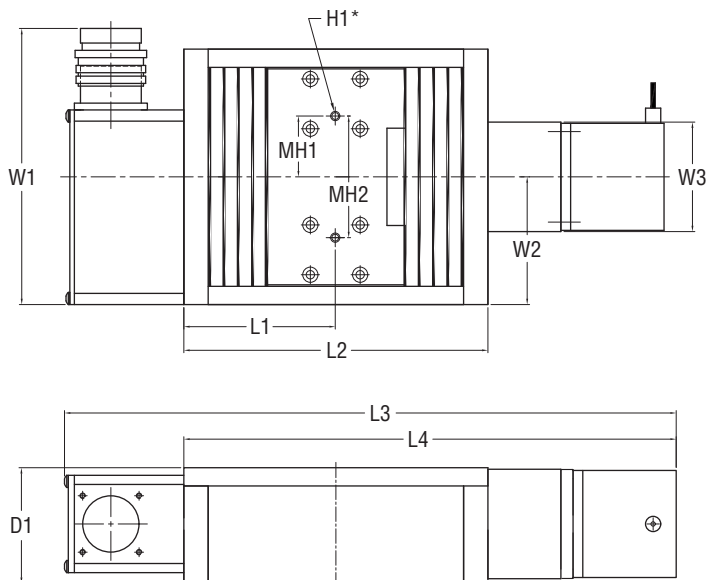


*Four corner holes (3 shown) for mounting the oscillator slide to the weld fixture.

**Four holes for mounting weld head (torch) to the oscillator slide.

	MO-150-101-5
L1	20.125 in. (511 mm)
L2	3 in. (76 mm)
L3	.312 in. (7.9 mm)
L4	17.875 in. (454 mm)
W1	7 in. (178 mm)
W2	1.5 in. (38 mm)
W3	7 in. (178 mm)
D1	4.75 in. (121 mm)
D2	4.5 in. (114 mm)
MH1	4.25 in. (108 mm)
MH2	4 in. (102 mm)
MH3	2.375 in. (60 mm)
MH4	17 in. (432 mm)
H1*	(4) 7/16 in. (11 mm)
H2**	(4) 5/16-18 UNC x 1 in. (25 mm) deep

MO-80-101-2 Slide Dimensions



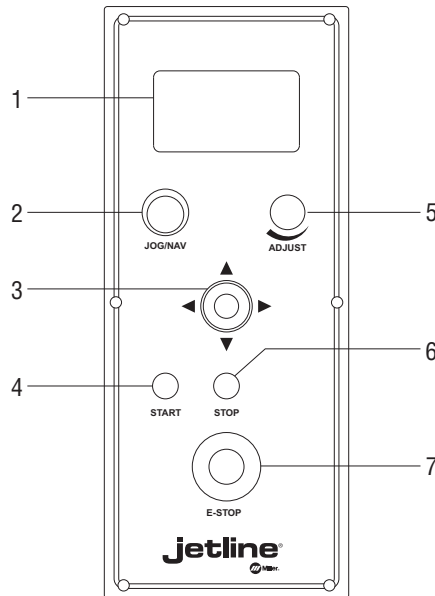
	MO-80-101-2
L1	3.125 in. (79 mm)
L2	6.25 in. (159 mm)
L3	12.625 in. (321 mm)
L4	10.125 in. (257 mm)
W1	5.625 in. (143 mm)
W2	2.625 in. (67 mm)
W3	2.25 in. (57 mm)
D1	2.375 in. (60 mm)
MH1	1.25 in. (32 mm)
MH2	2.5 in. (64 mm)
H1*	(2) #10-24 UNC x 1/2 in. (13 mm) deep

*Two holes for mounting weld head (torch) to the oscillator slide.

Control Module Specifications (Subject to change without notice.)

Stock No.	Power Cable	Input Power	Length	Width	Depth	Net Weight	Mounting Type
9900-OSC-2	115 V, 6 ft. (1.8 m) included	115/220 V, 1-phase, 50/60 Hz, 10 A	12.25 in. (311.2 mm)	12.25 in. (311.2 mm)	6 in. (152.4 mm)	18.75 lb. (13.0 kg)	Wall mount

Pendant Control



1. Four-line LCD Display
2. Jog / Nav (changes function of joystick)
3. Navigation and Jog Controls
4. Start
5. Adjustment Knob
6. Stop
7. Emergency Stop

Specifications (Subject to change without notice.)

Stock No.	Input Power	Length	Width	Depth	Net Weight	Mounting Hole
9780MSP	12 VDC at 2.5 A (supplied from control box)	12.95 in. (329 mm)	5 in. (127 mm)	2.56 in. (65.1 mm)	4 lb. (1.8 kg)	.315 in. (8 mm) diameter thru-hole

Program screens — Allows the oscillation width, right speed, left speed, right dwell, left dwell, taper, run number (program), run, calibration, and configuration to be adjusted.

Calibration screens — Allows the following settings: type (5- or 2-inch slide), units (inches or centimeters), max speed, ramp (stop to high speed), program 1, program 2, program 3, program 4 to be adjusted, backed up and saved. The restore screen restores all calibration settings to the last stored backup state.

Configuration screens — Allows dual configurations for speed, dwell, and jog speed. The jog direction in relation to the joystick movement can be configured. The width adjust, speed adjust, and dwell adjust allow for how much of a movement is adjusted for every click of the dial when operating the oscillator.

Features

- The calibration and configuration screens are password protected.
- Oscillator allows four programs to be saved.
- When connected to an optional Jetline 9700T control, oscillation can be automatically started and stopped as part of the weld program on the 9700T control.
- A mechanical oscillator is also available for the Jetline 9900 controller.
- Pressing the E-STOP button on the pendant will stop all oscillator motion and end the cycle.

Package Operating Parameters (Subject to change without notice.)

Stock No.	Speed 1	Speed 2	Dwell 1	Dwell 2	Oscillation Width (depends on center position)	Center (from center of electrical stroke)
JMO-150-5	0.1–120 ipm	0.1–120 ipm	0.01–10 seconds	0.01–10 seconds	0.1–4.5 in. (2.5–114 mm)	+/- 2.3 in. (58 mm)
JMO-80-2	(2.5–3,048 mm/min.)	(2.5–3,048 mm/min.)			0.1–1.5 in. (2.5–38 mm)	+/- 0.75 in. (19 mm)

Ordering Information (Order from Miller Welding Automation.)

Equipment	Stock No.	Description	Qty.	Price
Mechanical Oscillator Packages	JMO-150-5	Includes 150 lb. slide, control module, pendant control, 15 ft. pendant cable and 10 ft. slide cable		
	JMO-80-2	Includes 80 lb. slide, control module, pendant control, 15 ft. pendant cable and 10 ft. slide cable		
Replacement Components				
Slides	MO-150-101-5	150 lb. (68 kg), 4.5 in. (114 mm) slide		
	MO-80-101-2	80 lb. (36 kg), 1.5 in. (38 mm) slide		
Control Module	9900-OSC-2			
Pendant Control	9780MSP			
Pendant Cable	JMSPC15	15 ft. (4.6 m)		
Slide Cable	ALC-401-CAB	10 ft. (3 m) cable connecting control module to slide		

Date:

Total Quoted Price:

Distributed by:

