

# Jetline® Seam Tracking Systems

Automation Accessories 

## Quick Specs

### Applications

Tank and pressure vessel fabrication  
 Beam and structural assemblies  
 Pipe and tubing fabrication  
 Transportation  
 Rail car

### Processes

MIG (GMAW)  
 Flux-cored (FCAW)  
 Submerged arc welding (SAW)

### Input Power

115/220 V, 1-phase, 50/60 Hz .

### Power Cord

Standard 115 V, 6 ft. (1.8 m)  
 included on control module

**Jetline Tactile Seam Tracking systems simplify welding operation, ensuring the weld head is consistently positioned for optimal arc performance.**



**Superior tack detection** improves weld quality by compensating for variation in sizes and shape of weld tacks.

**Programmable slide positions** simplify operation and reduce time of locating the weld joint by programming home and weld positions.

**Multiple joint location options** can be programmed to best adapt to the workpiece to simplify weld head positioning.

**Contact closure** available from the seam tracker allows the system to start and stop the GMAW or SAW process.

**Auto and manual modes** allow the system to be used as a seam tracker or a motorized slide system depending upon weld requirements.

**Heavy-duty motorized slides** provide 330-pound (150 kg) payload capacity at 15.7 inches (400 mm). Available in 5.9 inch (150 mm) and 9.8 inch (250 mm) stroke lengths.



### Packages include:

- Two motorized slides
- Seam tracking control module
- Seam tracker pendant
- Complete probe assembly
- Two 15-foot motor cables
- 15-foot pendant cable
- 15-foot probe cable
- 6 mm probe tip

**User-friendly pendant layout** with large screen and graphic backlit display for complete operation, setup and configuration.

**Sturdy bellows** protect linear guide rails and hardened ball screw and nut to ensure smooth operation.

**Travel limit switches and electronic overload protection** protect slides from damage during operation.

## Slide Specifications (Subject to change without notice.)

Stock No.	Input Power	Length	Width	Depth	Net Weight	Face Mounting Pattern
JMS150	24 VDC, 8 A per axis	21.95 in. (557.5 mm)	16 in. (406.5 mm)	4.25 in. (108 mm)	35 lb. (15.9 kg)	5.9 x 5.9 in. (150 x 150 mm) M8 mounting holes
JMS250	(supplied from control box)	26.47 in. (672.3 mm)	16.14 in. (410 mm)	4.25 in. (108 mm)	37 lb. (16.9 kg)	



Warranted for three years, parts.

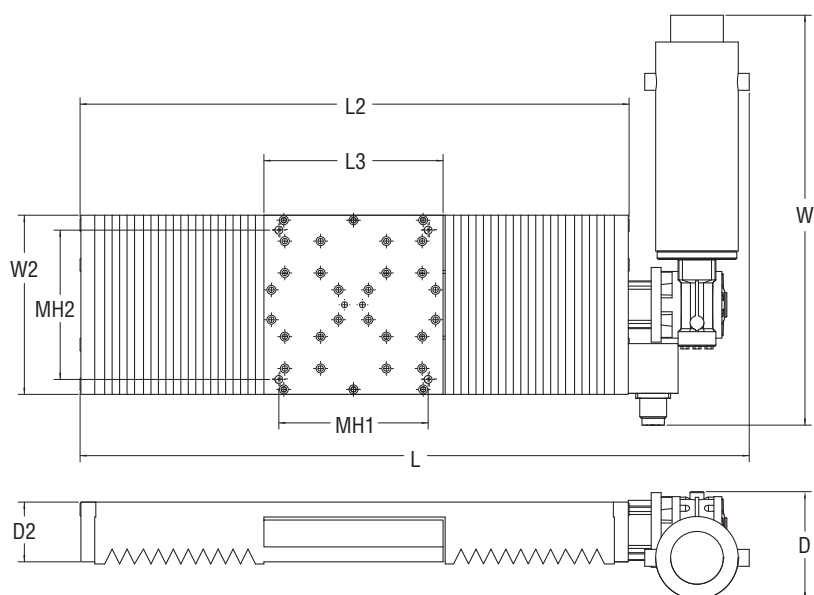


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## Motorized Slide Dimensions

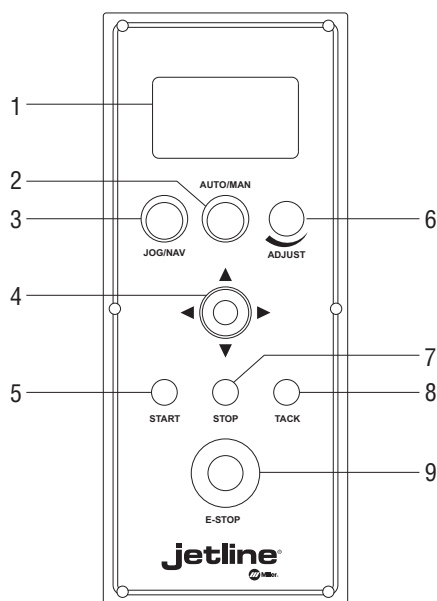


	JMS150	JMS250
<b>L</b>	21.95 in. (557.5 mm)	26.47 in. (672.3 mm)
<b>L2</b>	17.13 in. (435 mm)	21.72 in. (551.6 mm)
<b>L3</b>	7.09 in. (180 mm)	7.09 in. (180 mm)
<b>W</b>	16 in. (406.5 mm)	16.14 in. (409.9 mm)
<b>W2</b>	7.09 in. (180 mm)	7.09 in. (180 mm)
<b>D</b>	4.25 in. (108 mm)	4.25 in. (108 mm)
<b>D2</b>	2.36 in. (60 mm)	2.36 in. (60 mm)
<b>MH1</b>	5.9 in. (150 mm)	5.9 in. (150 mm)
<b>MH2</b>	5.9 in. (150 mm)	5.9 in. (150 mm)
<b>Hole Pattern</b>	M8 mounting holes	M8 mounting holes

## Control Module Specifications (Subject to change without notice.)

Stock No.	Power Cable	Input Power	Length	Width	Depth	Net Weight	Mounting Holes
JTST9700	115 V, 6 ft. (1.8 m) included	115/220 V, 1-phase, 50/60 Hz, 10 A	12.25 in. (311.2 mm)	15.5 in. (393.7 mm)	8.2 in. (208.3 mm)	29 lb. (13.2 kg)	5.9 x 5.9 in. (150 x 150 mm) .315 in. (8 mm) diameter thru-holes

## Pendant Control



1. Four-line LCD Display
2. Mode of Operation (Auto / Manual)
3. Jog / Nav (changes function of joystick)
4. Navigation and Jog Controls
5. Start
6. Adjustment Knob
7. Stop
8. Tack (Manual mode)
9. Emergency Stop

## Specifications (Subject to change without notice.)

Stock No.	Input Power	Length	Width	Depth	Net Weight	Mounting Hole
9780STP	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

# Pendant Control Operation and Programs

## Modes of Operation

**Auto mode** — Auto mode allows seam tracker to automatically track the joint on a wide variety of parts. The tactile probe provides feedback to the motorized slides to keep the weld head in the desired position during the welding process.

**Manual mode** — Manual mode allows the operator to manually control the weld-head position using the joystick on the pendant.

## Program Options

### Slide movement

- Up/down
- Left/right
- Diagonal

### Seam tracker

- Programmable start/find joint location
- Multiple joint locating options
- Contactor to enable power source
- Track seam/joint
- Auto tack detection
- Programmable end of weld
- Programmable return to home

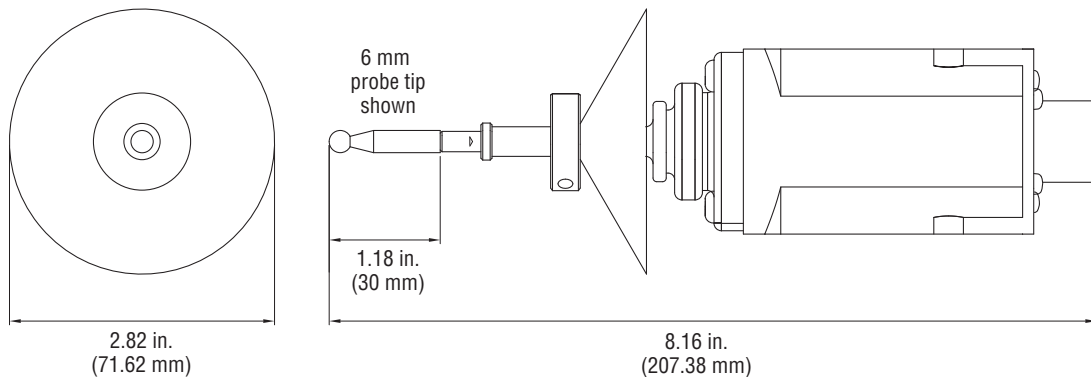
### When connected with a Jetline® 9700T

- Control speed of weld from seam tracker pendant

### When interfaced with a Auto-Continuum™

- Change weld schedule
- Jog wire
- Purge gas

## Probe Assembly Dimensions



## Accessories



### Probe Tips

- JTSTPT3 3 mm probe ball
- JTSTPT6 6 mm probe ball
- JTSTPT10 10 mm probe ball
- JTSTPT15 15 mm probe ball
- JTSTPT20 20 mm probe ball
- JTSTPT30 30 mm probe ball



**Copper Wheel Probe**  
JTSTPTWH



**Probe Extension**  
JTST100PE 100 mm



### Extension Rods

- JMS115R 115 mm
  - JMS200R 200 mm
  - JMS300R 300 mm
- Extension rods define distance between torch holder and probe. Standard system includes 200 mm rod.

## Recommended Spare Parts



**Replacement Probe Shaft (Break Away)**  
JTSTPRS01



**Probe Insulator** JTSTPTI

**Replacement Probe Shaft End Screw**  
JTSTPRS02

## Ordering Information (Order from Miller Welding Automation.)

Equipment	Stock No.	Description	Qty.	Price
Dual-Axis Seam Tracking System Packages	JTST150XP	5.9 x 5.9 in. (150 x 150 mm)		
	JTST250XP	9.8 x 9.8 in. (250 x 250 mm)		
<b>Accessories</b>				
Ball Probes	JTSTPT3	IGP03 3 mm		
	JTSTPT6	IGP06 6 mm		
	JTSTPT10	IGP10 10 mm		
	JTSTPT15	IGP15 15 mm		
	JTSTPT20	IGP20 20 mm		
	JTSTPT30	IGP30 30 mm		
Copper Wheel Probe	JTSTPTWH			
Probe Extension	JTST100PE	100 mm		
Extension Rods	JMS115R	115 mm		
	JMS200R	200 mm		
	JMS300R	300 mm		
<b>Recommended Spare Parts</b>				
Replacement Probe Shaft (Break Away)	JTSTPRS01			
Probe Insulator	JTSTPTI			
Replacement Probe Shaft End Screw	JTSTPRS02			

Date:

Total Quoted Price:

Distributed by:

