Jetline® Seam Tracking Systems

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.

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.)

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Input Power</th>
<th>Length</th>
<th>Width</th>
<th>Depth</th>
<th>Net Weight</th>
<th>Face Mounting Pattern</th>
</tr>
</thead>
<tbody>
<tr>
<td>JMS150</td>
<td>24 VDC, 8 A per axis (supplied from control box)</td>
<td>21.96 in. (557.5 mm)</td>
<td>16 in. (406.5 mm)</td>
<td>4.25 in. (108 mm)</td>
<td>35 lb. (15.9 kg)</td>
<td>5.9 x 5.9 in. (150 x 150 mm) M8 mounting holes</td>
</tr>
<tr>
<td>JMS250</td>
<td></td>
<td>26.47 in. (672.3 mm)</td>
<td>16.14 in. (410 mm)</td>
<td>4.25 in. (108 mm)</td>
<td>37 lb. (16.9 kg)</td>
<td></td>
</tr>
</tbody>
</table>

Warranted for three years, parts.

Miller Welding Automation
An ITW Welding Company
281 E. Lies Rd.
Carol Stream, IL 60188 USA

Equipment Sales
Phone: 630-653-6819
Email: JetlineSales@millerwelds.com

MillerWelds.com
Motorized Slide Dimensions

Control Module Specifications (Subject to change without notice.)

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

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.)

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Input Power</th>
<th>Length</th>
<th>Width</th>
<th>Depth</th>
<th>Net Weight</th>
<th>Mounting Hole</th>
</tr>
</thead>
<tbody>
<tr>
<td>9780STP</td>
<td>12 V DC at 2.5 A (supplied from control box)</td>
<td>12.95 in. (329 mm)</td>
<td>5 in. (127 mm)</td>
<td>2.56 in. (65.1 mm)</td>
<td>4 lb. (1.8 kg)</td>
<td>.315 in. (8 mm) diameter thru-hole</td>
</tr>
</tbody>
</table>
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

<table>
<thead>
<tr>
<th>Slide movement</th>
<th>When connected with a Jetline® 9700T</th>
</tr>
</thead>
<tbody>
<tr>
<td>Up/down</td>
<td>Control speed of weld from seam tracker pendant</td>
</tr>
<tr>
<td>Left/right</td>
<td></td>
</tr>
<tr>
<td>Diagonal</td>
<td></td>
</tr>
</tbody>
</table>

**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 interfaced with an Auto-Continuum™

- Change weld schedule
- Jog wire
- Purge gas

Probe Assembly Dimensions

![Probe Assembly Dimensions Diagram]

2.82 in. (71.62 mm)

1.18 in. (30 mm)

8.16 in. (207.38 mm)

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
- Replacement Probe Shaft End Screw JTSTPRS02
- Probe Insulator JTSTPTI
## Ordering Information
(Order from Miller Welding Automation.)

<table>
<thead>
<tr>
<th>Equipment</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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</thead>
<tbody>
<tr>
<td><strong>Dual-Axis Seam Tracking System Packages</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>JTST150XP</td>
<td></td>
<td>5.9 x 5.9 in. (150 x 150 mm)</td>
<td></td>
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<tr>
<td>JTST250XP</td>
<td></td>
<td>9.8 x 9.8 in. (250 x 250 mm)</td>
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<td></td>
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<tr>
<td><strong>Accessories</strong></td>
<td></td>
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<tr>
<td>Ball Probes</td>
<td>JTSTPT3</td>
<td>IGP03 3 mm</td>
<td></td>
<td></td>
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<tr>
<td></td>
<td>JTSTPT6</td>
<td>IGP06 6 mm</td>
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<td></td>
<td>JTSTPT10</td>
<td>IGP10 10 mm</td>
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<td>JTSTPT15</td>
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<td>Copper Wheel Probe</td>
<td>JTSTPTWH</td>
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<tr>
<td>Probe Extension</td>
<td>JTST100PE</td>
<td>100 mm</td>
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</tr>
<tr>
<td>Extension Rods</td>
<td>JMS115R</td>
<td>115 mm</td>
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<tr>
<td></td>
<td>JMS200R</td>
<td>200 mm</td>
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<tr>
<td></td>
<td>JMS300R</td>
<td>300 mm</td>
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<td><strong>Recommended Spare Parts</strong></td>
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Date:                                        Total Quoted Price: