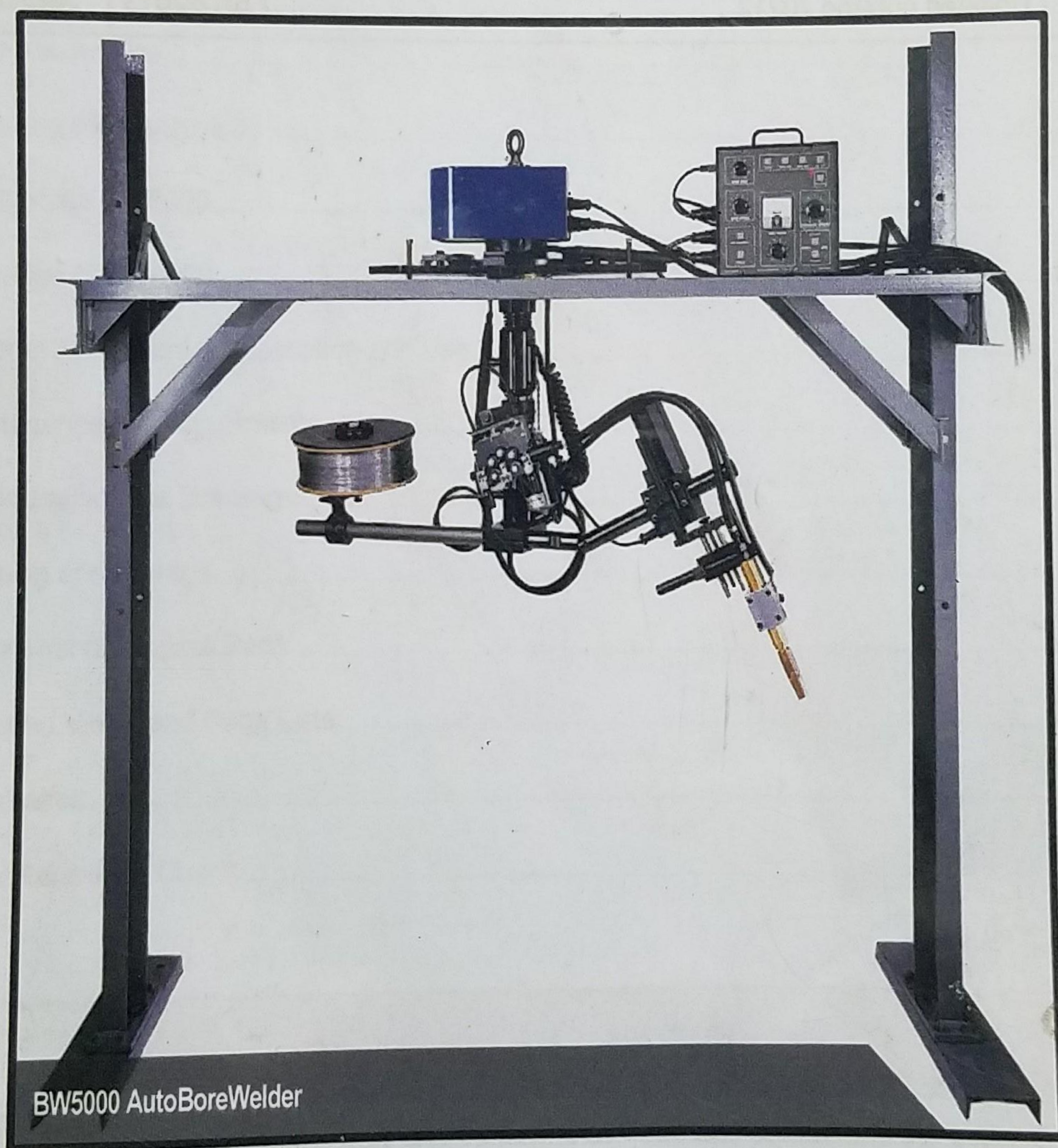


BW5000 AutoBoreWelder OPERATION & MAINTENANCE MANUAL

Part No. 68191

June 2013

Serial Number:



 **CLIMAX**
Portable Machining & Welding Systems

Email questions or comments about this manual to:
documentation@cpmt.com

ITEM #7



ITEM #7







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TORCHES #0 THROUGH #12: BORE DIAMETER RANGES

TORCH USED	IN INCHES	IN CM	APPROXIMATE DIAL SETTING	SECONDS PER REVOLUTION
00	.875 - 1.75	2.2 - 4.4	10	8.5
0	1.75 - 3	4.4 - 7.6	9	10
1	2.75 - 5.5	7 - 14	8	14
2	4.5 - 7.5	11.4 - 19	7	20
3	6 - 9	15.2 - 22.9	6	28
4	8 - 11	20.3 - 27.9	5	43
6	10 - 13	25.4 - 33	4	71
8	12 - 15	30.5 - 38	3.5	87
10	14 - 17	35.6 - 43.2	3	108
11	16 - 19	40.6 - 48.3	2.5	135
12	20 - 23	50.8 - 58.4	2	168
	22 - 25	55.9 - 63.5	1.5	211
	24 - 27	61 - 68.6	1	242
			.5	280
			0	295

18 IPM = Bore Diameter x 10.4 = Seconds per rotation
20 IPM = Bore Diameter x 9.4 = Seconds per rotation
22 IPM = Bore Diameter x 8.5 = Seconds per rotation
IPM = Inches Per Minute of Torch Travel

Commands When Welding
(press and hold the Function key, then press the desired key)
FUNCTION + ARC INTERRUPT = Toggle Auto Skip On/Off
FUNCTION + RETRACT = Toggle Step Function On/Off

Commands When Not Welding
(press and hold the Function key, then press the desired key)
FUNCTION + ROTATE = Reverse Rotation
FUNCTION + WIRE JOG = Retract Wire
FUNCTION + ROT HIT = Check Step Size
FUNCTION + EXTEND = Reverse Step
FUNCTION + WELD = Toggle Auto Skip/Pie Mode/Carriage Return

Recommended Travel Speeds
In Position 18-20 IPM
Out of Position 20-22 IPM

Note: Powering off the Control Box will reset all programs to default settings.
For Technical Support, Service, Replacement Parts, or a Replacement Owners Manual, contact Climax at 1-800-333-8311 or on line at www.cpmc.com

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Auto Skip Pie Mode Carriage Return
Light ON - Skip Enabled
OFF - Skip Disabled
ARC INTERRUPT

STOP

1-800-333-8311

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www.climaxportable.com

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