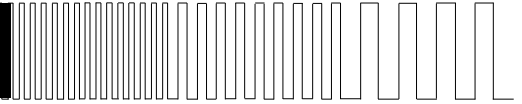


## Operator Controlled Mechanization

# AUTOMATIC HEIGHT CONTROL



The BUG-6553 integrated into the Universal Bug-O-Matic.  
(Factory installed option)



The CAS-2100 integrated into the Free Standing Torch Support.



**CAS-1550**  
(Included in all systems)



**CAS-2100**

**CAS-2060**



The CAS-2060 integrated into the MDS Pendulum Weaver System.

**CAS-2050**



The CAS-2050 can be used with the MDS Linear Weaver System or the MDS Straight Line Welding System.

Bug-O Systems' **AUTOMATIC HEIGHT CONTROL** is a compact, easy to use accessory designed to maintain a constant welding torch-to-work distance. This control can be used with Sub Arc, Flux-Core and MIG welding. It includes a solid-state control box and a motorized slide which will bolt onto any standard Bug-O Systems carriage or fixture. It can be used for a wide variety of welding applications where precise control of welding current is critical. This system requires a constant voltage (CV) power supply for operation.

Bug-O Systems is committed to empowering our customers by providing operator controlled mechanized solutions for their welding, cutting and custom applications.

# BUG-O SYSTEMS

A DIVISION OF WELD TOOLING CORPORATION



280 TECHNOLOGY DRIVE CANONSBURG, PENNSYLVANIA 15317-9564 USA  
PHONE: 412-331-1776 <http://www.bugo.com> FAX: 412-331-0383



# AUTOMATIC HEIGHT CONTROL

Maintaining constant welding current (arc length) is critical for producing consistent, quality welds. BUG-O Systems **Automatic Torch Height Control (AHC)** is your solution. Automatic height sensors monitor welding current and adjusts torch height in response to changes in the current. Maintaining a constant weld tip to work piece distance produces uniform weld penetration and controlled heat input.

BUG-O's **AHC** can be installed on any welding device. It works with any constant voltage (CV) welding power source and is compatible with SAW, FCAW and GMAW Welding processes.

If needed, the welder can temporarily override the **AHC**, using the manual jog switch while welding. **AHC** resumes as soon as the jog switch is released.

Automatic shut-off of the height adjusting drive happens when current is off, or falls below a pre-set lower limit.

The motorized slide provides a total of 2" (50.8 mm) of travel with a 10 lb. (4.54 kg) weight carrying capacity. It also features a built-in time delay after arc is struck, and shuts off automatically when the current drops too low (generally below 60 amps).

Minimum welding current is 60 Amps. If the welding current falls below 60 Amps, the unit may not correctly adjust torch height. (Standard Capacity is: 500 Amps)

## There's an Automatic Height Control that's right for you.

BUG-O Systems has designed an **AHC** to work with your mechanized welding system:

### MDS Configuration:

- CAS-2050 **AHC** for MDS Drive w/ Linear Weaver
- CAS-2060 **AHC** for MDS Drive w/ Pendulum Weaver

### For Universal BUG-O-MATIC (Factory installed option):

- BUG-6553 Retrofit **AHC** for Universal Bug-O-Matic

### For all other BUG-O machines, or other mechanized, welding systems\*

Select one of the following AHC options:

- CAS-2100 120VAC/50-60Hz/1Ph Power Supply
- CAS-2102 240VAC/50/60Hz/1Ph Power Supply
- CAS-2104 42VAC/50-60Hz/1Ph Power Supply

\* Consult with Bug-O to make certain appropriate mountings are supplied for height and control units.

## Technical Data:

- Travel:** 2" (50.8 mm)
- Load Capacity:** 10 lbs. (4.54 kg)
- Operating Range:** 60 to 500 Amps
- Net Weight:** Approximately 14.5 lbs (6.6 kg)

## Integration:

