

Wils-Tronic Model	Type	Low-Torque 1/2" to 1 1/2" tubes 0-1400 RPM 1-30 FT-LBS	Mid-Torque 3/4" to 3" tubes 0-400 RPM 15-120 FT-LBS	High-Torque Up to 3" tubes 0-400 RPM 80-300 FT-LBS
Tube Rolling Kit: Motor, Telescopic Shaft, Control Box, Foot Switch, Power Cable	3Ø 230 V 60 Hz	46000-0000	46500-0000	47000-0000
Tube Rolling Kit: Motor, Telescopic Shaft, Control Box, Foot Switch, Power Cable	3Ø 230 V 50 Hz	46005-0000	46505-0000	47005-0000
Tube Rolling Kit: Motor, Telescopic Shaft, Control Box, Foot Switch, Power Cable	3Ø 440 V 60 Hz	46040-0000	46540-0000	47040-0000
Tube Rolling Kit: Motor, Telescopic Shaft, Control Box, Foot Switch, Power Cable	3Ø 440 V 50 Hz	46045-0000	46545-0000	47045-0000
Accessories				
MOBILE STAND		46000-5400		
STATIONARY STAND		46000-5010		
QUICK CONNECTOR, 3/8" SQ.		46000-4200		
QUICK CONNECTOR, 1/2" SQ.		46000-4250	21489-0500	
QUICK CONNECTOR, 3/4" SQ.			21489-0750	
EXTENSION COUPLING, 3/4" SQ.			46500-4400	
EXTENSION COUPLING, 1" SQ.			46500-4500	
1/2" JACOBS CHUCK		46000-4600		
#2 MORSE TAPER ADAPTER			46500-6000	
TELESCOPIC SHAFT		46000-4000	46500-4000	

Initial* RPM and Torque Settings for Wils-Tronic:

- For 2.0" OD Tube Beading: 145 RPM, 60-65 ft-lb
- For 2.5" OD Tube Flaring: 145 RPM, 65-70 ft-lb
- For 2.5" OD Tube Beading: 145 RPM, 70-75 ft-lb
- For 3.0" OD Tube Flaring: 145 RPM, 81-86 ft-lb
- For 3.0" OD Tube Beading: 145 RPM, 90-95 ft-lb
- For Hydraulic Tube Cutting: 230-250 RPM, No torque needed, set Torque to max.

* Offered above is a suggested starting point of given torque and rpm. The end user is responsible for selecting the appropriate setting and should use this information only as a guide to get started. The torque needs to be fine tuned for each specific application.

Wils-Tronic Quick Start Up Guide

1 - Plug in the Wils-Tronic to the appropriate 3 Phase - power source.



Insert twist lock plug



Turn on "Main Switch"



Observe "Phase OK" lamp

2 - Unlatch the E-stop button.



3 - Press the "Power ON" button



4 - Select the appropriate mode with the rotary knob "Hand" or "Auto".



5 - Select the appropriate function Key on the HMI "F1" for Manual mode or "F2" for Program Mode



Man = Manual mode, in this mode Speed is set via the analog potentiometer, and Torque limit via the keypad. In this mode Forward and Reverse functions are separate and have to be manually invoked. There are no automatic features in this mode.

Pgm = Program mode, in this mode enter the desired torque and speed via the keypad. In this mode Forward and Reverse functions are automated and user can enter the reverse speed, reverse time and the dwell time.

6 - Enter the desired trip off torque and the RPM setting.



Note: If password is required, enter: 0 0 0 0 and press ↵

7 - Begin expanding tubes



Select F1 to get to run mode



Use Foot pedals to start

NOTE: Ensure that motor is rotating in proper direction.

Forward-Clockwise

Reverse-Counterclockwise

If it is not rotating in the proper direction, switch any two wire connections of three inside motor.