

Our Position  
is to Help Welder's Jobs  
Go Easier, Faster, Safer



Take the Sweat Out of  
Positioning, Rotating,  
Supporting & Handling



# XT-100 XT-200 500

XT-100

The Atlas Model XT-100 Welding Positioner is a compact machine suited for smaller weldments up to **100 pounds**, properly balanced, and with the table in the horizontal position. The standard **9" table** is driven by a **DC permanent magnet gear head motor** and precision ground and hardened secondary gearing. The grounding circuit handles up to 200 amps of welding current. Model XT-100 is suitable for stick electrode, MIG or TIG processes and is high frequency protected. Operating speed is set on the front control panel by adjusting the solid state **speed control**. The **variable speed foot switch** initiates table rotation and also allows the operator to feather the speed from slow, up to the maximum speed dialed in at the main speed control. A **forward-off-reverse switch** is also provided along with an easily accessible 2 amp fuse for motor overload protection.

## XT-100 Specifications

Table Speeds	Low Speed	Maximum Speed
XT-100 (Standard)	2.5 RPM	11.0 RPM
XT-100-0-2 (Optional)	0.5 RPM	2.8 RPM
XT-100-0-4 "	1.0 RPM	4.7 RPM
XT-100-0-18 "	4.5 RPM	18.5 RPM
<b>Motor</b>	DC Permanent magnet motor	
<b>Power Requirement</b>	115 V AC 60 cycle @ 1.3 amps. 10' conductor cord with plug supplied.	
<b>Speed Control</b>	Solid State electronic feedback	
<b>Start/Stop Control</b>	Rheostat-type foot switch with 10' cord	
<b>Dimensions</b>	H = 7.5", W = 11.5", Depth = 9"	
<b>Net Weight</b>	32 lbs.	
<b>Shipping Weight</b>	34 lbs.	

*\*Listed Table Speeds may vary by ± 10%. Please specify speed desired when ordering.*

XT-200

The Atlas Model XT-200 Welding Positioner handles properly balanced loads up to **200 pounds** with the table in the horizontal position. Model XT-200's unique base tilts the table **130° forward and 15° backward**. Table angle is adjusted by means of a worm gear and locking hand nut. The standard **10" table** is driven by a **DC permanent magnet gear head motor** and precision ground and hardened secondary gearing. The grounding circuit handles up to 200 amps of welding current and features a back mounted threaded stud for securing your ground lug. Model XT-200 is suitable for stick electrode, MIG or TIG processes and is high frequency protected. Operating speed is set on the front control panel by adjusting the solid state **speed control**. The **variable speed foot switch** initiates table rotation and also allows the operator to feather the speed from slow, up to the maximum speed dialed in at the main speed control. A **forward-off-reverse switch** is also provided along with an easily accessible 2 amp fuse for motor overload protection.

## XT-200 Specifications

Table Speeds	Low Speed	Maximum Speed
XT-200 (Standard)	2.4 RPM	9.5 RPM
XT-200-0-2 (Optional)	0.4 RPM	2.3 RPM
XT-200-0-4 "	1.0 RPM	5.2 RPM
XT-200-0-18 "	5.0 RPM	21.0 RPM
<b>Motor</b>	DC Permanent magnet motor	
<b>Power Requirement</b>	115 V AC 60 cycle @ 1.3 amps. 5'3" conductor cord with plug supplied.	
<b>Speed Control</b>	Solid State electronic feedback	
<b>Start/Stop Control</b>	Rheostat-type foot switch with 6' cord	
<b>Dimensions</b>	H = 9.25", W = 10.625", Depth = 12.25"	
<b>Net Weight</b>	41 lbs.	
<b>Shipping Weight</b>	45 lbs.	

*\*Listed Table Speeds may vary by ± 10%. Please specify speed desired when ordering.*

500

The Atlas Model 500 Welding Positioner handles those tough turning jobs with a capacity of up to **500 pound loads**, properly balanced, with the table in the horizontal position. It's **¼ horse power**, DC permanent magnet motor provides plenty of power and torque. Four brass grounding brushes in contact with the table mounting boss route up to 400 amps of welding current to a **½"-13** grounding stud at the rear of the machine. Table speed is set by adjusting the **speed control dial**. A **forward-off-reverse switch** controls table rotation direction. A full speed override switch allows the operator to advance the table at full speed to a new position for intermittent or stitch welding technique. The brake-on-off control allows the operator to select **Dynamic Braking** which stops table rotation almost instantly when the foot control is released. Model 500's foot switch controls the on-off function of the table rotation. A safety enclosure guards the foot switch. All circuit boards, switches and wiring are mounted in the front panel, which can be quickly removed for diagnostics and repair.

## 500 Specifications

<b>Table Speed</b>	0 – 3.0 RPM
<b>Motor</b>	1/4 HP, DC
<b>Power Requirement</b>	115 V AC 50/60 Hz. 10' cord with plug.
<b>Start/Stop Control</b>	Foot switch with 8' cord.
<b>Welding Grnd. Circuit</b>	400 Amps.
<b>Control Panel Functions</b>	
<b>Table Rotation</b>	Forward-Off-Reverse.
<b>Speed Control</b>	Full Range Precision control with IR compensation.
<b>Full Speed Override</b>	On-Off.
<b>Dynamic Braking</b>	On-Off.
<b>Dimensions</b>	H = 10", W = 14.5", Depth = 15.5"
<b>Net Weight</b>	95 lbs.

*\*Listed Table Speeds may vary by ± 10%. Please specify speed desired when ordering.*

# POSITIONERS



## XT-100



### Optional Features:

- Dynamic braking.
- Simple tilt plate accessory for angular work.
- 10" Table, 12" Table.
- 230 volt controls for certain off-shore countries.
- 3-jaw, 5" chuck attaches to table via predrilled holes.

Atlas compact welding positioners, built with the welder in mind, are ideally suited for short-to-long run welding jobs requiring fixturing and positioning.

Their ergonomic, low profile keep welding positioners at a comfortable level for the welder working at a standard height work bench.

## XT-200



### Optional Features:

- Dynamic braking.
- Hollow shaft and Argon fittings for inert gas purge.
- 12" Table.
- 230 volt controls for certain off-shore countries.
- 3-jaw, 5" chuck attaches to table via predrilled holes.

Atlas positioners can help boost production on hard to handle jobs requiring circular welding (small spheres and pressure vessels; flange-to-pipe; pipe-to-pipe; etc.) Heavy duty grounding circuit allows use of stick electrode, MIG or TIG welding processes.

## 500



### Optional Features:

- Remote control panel.
- Hollow shaft for gas purge.
- Optional higher speed ranges. (up to 8.0 RPM)

### Selecting The Right Speed Range

To determine the speed range (in RPM's) needed for a particular job, you need to do the following: calculate the **arc travel speed** (expressed in inches per minute) at which you will weld, and then determine the **circumference** of the part to be welded by either direct measurement around the outside, or you may multiply the **diameter** by 3.14 to calculate circumference. Now, apply this simple formula:

$$\text{Arc travel speed} \div \text{part circumference} = \text{RPM}$$

### Example:

3" diameter part welded at 35" per minute.  
3" dia. X 3.14 = 9.42" circumference.  
35" speed  $\div$  9.42" = 3.7 RPM

This simple exercise will help you select the proper Atlas Welding Positioner for your welding needs.





# 1200 PIPEMATE

The Atlas **dual speed** Model 1200 Pipemate easily rotates pipe and tube sizes from 1 1/2" to 17" diameter weighing up to 1,200 pounds (with one end of the pipe supported on an appropriate free turning roller, such as our optional **Idler Rolls**). Two 6" x 2" rubber tired wheels are driven at identical speed and are heat and abrasion resistant. Power is provided by a **DC permanent magnet motor** and hardened secondary gearing. Pipemate features dual speed ranges; **0-35 IPM or 0-70 IPM**. Speed range is changed by removing the side cover and reversing the position of the secondary gears. The **speed control** dial is located on the front panel, along with a **forward-off-reverse switch** and easily accessible 2 amp fuse for overload protection. A broad spectrum, high frequency filter prevents erratic motor operation when TIG welding. The on-off foot switch initiates rotation and is protected by a steel safety enclosure.

An optional, non-powered, Atlas **IDLER ROLL** is an ideal mate for supporting the other end of work pieces. Wheel size, wheel stance and tires are identical to those on the PIPEMATE.

A specially designed, heavy duty work stand for the PIPEMATE and IDLER ROLL is also available for welding convenience.

## 1200 PIPEMATE



### Optional Features:

- Variable Speed Foot Switch.
- 230 volt controls for certain off-shore countries.

### 1200 PIPEMATE Specifications

<b>Power Requirement</b>	115 V AC 50/60 Hz.
<b>Dimensions</b>	H = 9.25", L = 18", W = 8"
<b>Shipping Weight</b>	56 lbs.

### IDLER ROLL



### IDLER ROLL Specifications

<b>Non-Powered</b>	
<b>Dimensions</b>	H = 9.25", L = 16.75", W = 8"
<b>Shipping Weight</b>	23 lbs.

### PIPEMATE and IDLER ROLL stand



### 1200 PIPEMATE STAND Specifications

<b>Dimensions</b>	H = 28.125", L = 27.5", W = 24"
<b>Shipping Weight</b>	22 lbs.



### Atlas Welding Accessories, Inc.

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### WARRANTY

Atlas, XT-100, XT-200, 500 and 1200 PIPEMATE are warranted against defects in workmanship or materials under normal use (rental service excluded) for a period of 90 days. Liability is limited to the purchase price paid and liability under the aforesaid warranty is limited to replacing or repairing any parts which are defective in workmanship or materials.