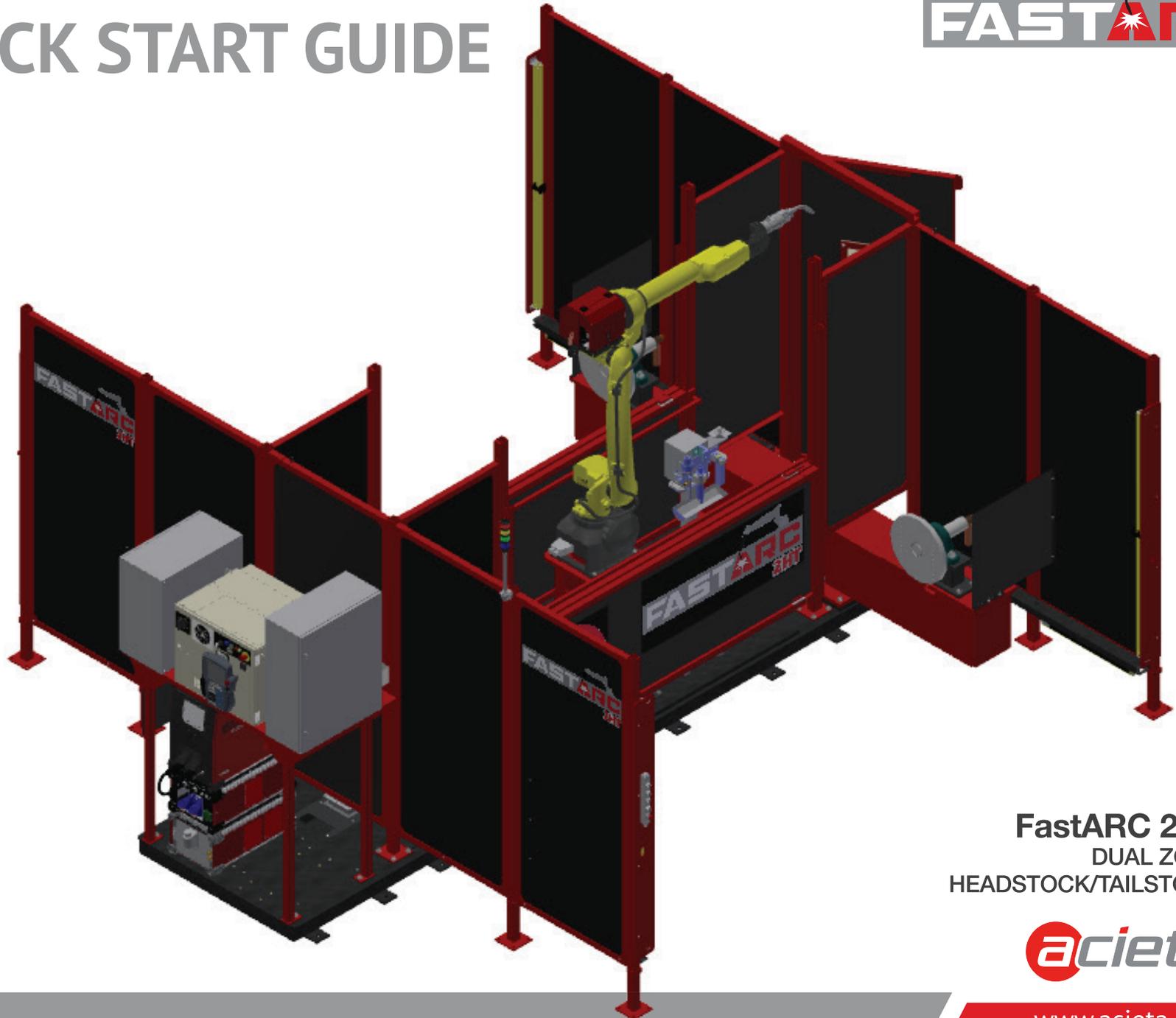


# FastARC® 2HT

Dual Zone Headstock/Tailstock



## QUICK START GUIDE



**FastARC 2HT**  
DUAL ZONE  
HEADSTOCK/TAILSTOCK



[www.acieta.com](http://www.acieta.com)

# Table of Contents

Space and Utility Requirements.....	3
Unloading Your Acieta FastARC 2HT .....	4-6
Rigging Details .....	7
Anchoring and Utility Connection.....	8-9
Service & Support.....	11

# Space and Utility Requirements

## Specifications and Dimensions

- System Dimensions: 16' Wide X 15'5" Deep X 7'10¾" Tall
- System Weight: 12,500 lbs (5,700 kg)

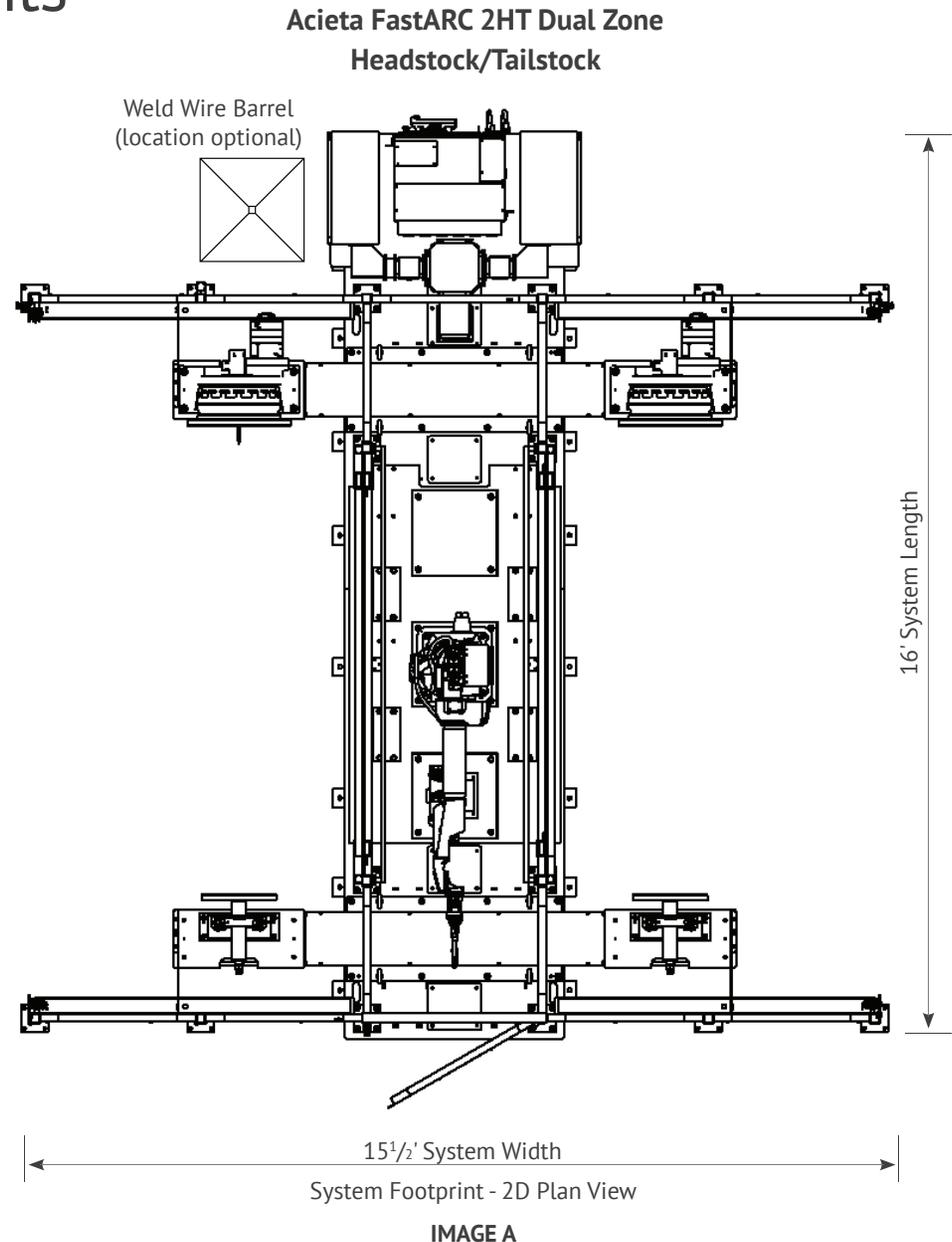
## Utility Requirements

- Compressed air requirement: Minimum 80 psi
- Electrical requirement: 480 Volt 3 phase – 100 amp
- Shielding gas as required for your welding process, preferred delivery system is a bulk tank
- If portable gas tanks are used, they may be placed and chained in close proximity to the gas flow sensor

## Facility Prep

- Workplace must be clean and uncluttered
- Plan enough room to unpack and assemble the FastARC 2HT and the components
- It is recommended to allow for 3' of clearance on all sides of the cell  
*(See Image A right)*

Note: Plan where your weld wire and gas will be located outside of the cell prior to setup.



# Unloading Your Acieta FastARC 2HT

Locate the packing slip and check that all of the items on the list have been received.

The components that are loose from the system are in a *loose components box* attached to the fence panel/side shields pallet - 1,300 lbs. (590 kg)

- 25' Wire Wizard conduit
- Anchor hardware
- Filter regulator lubricator
- Headstock & tailstock guards
- Light stack
- Teach pendant
- Shielding gas flow sensor
- Welding consumables

Headstock beam 3,200 lbs. (1,450 kg) and tailstock beam 1,800 lbs (820 kg) on separate pallets.

If there are any signs of damage or any discrepancies between the packing slips and the items received, call the Acieta Service Department at (844) 422-8282.

## Forklift Method for Unloading Your FastARC 2HT

STEP

1

**USE FORK POCKETS TO UNLOAD THE COMMON BASE STRUCTURE WITH A FORKLIFT AND PLACE IN DESIRED LOCATION**

- Forklift must be rated at 6,500 lbs. (2,950 kg) or larger
- Forks maximum dimensions 7.5" Wide X 3.75" Tall (*Reference Image E on page 7*)
- Anchor common base

STEP

2

**REMOVE FENCE PANELS ON THE COMMON BASE FROM THE POP-UP DOORS TO THE OUTSIDE OF THE UNIT**  
(*Reference Image B right*)

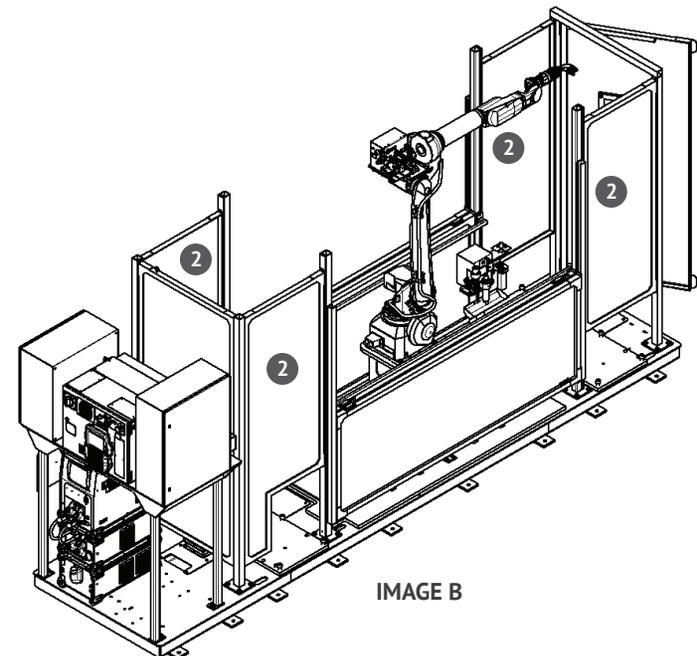


IMAGE B

STEP  
**3**

**PICK HEADSTOCK BEAM FROM THE EYE BOLTS INSTALLED IN THE BASE OF THE BEAM**

- Lift into location, while feeding Bundle A through the hole in the center of the beam
- Install locating bolts with Loctite and torque to 394 ft lbs
- Install cables to FANUC motors and encoder; welder sensory leads go through the center of the positioner and will attach to fixturing once installed
- Install headstock beam cover. Loctite bolts and torque to 5.7 ft lbs

STEP  
**4**

**PICK TAILSTOCK BEAM FROM THE EYE BOLTS INSTALLED IN THE BASE OF THE BEAM**

- Lift into location, while feeding the ground wire through the hole in the center of the beam
- Install locating bolts with Loctite and torque to 394 ft lbs
- Attach ground cable to junction block with Loctite and torque to 81 ft lbs
- Install tailstock beam cover. Loctite bolts and torque to 5.7 ft lbs

STEP  
**5**

**REMOVE FENCE PANELS FROM THEIR PALLET AND INSTALL IN MARKED LOCATION**

- Mount panels to fence post and torque to 23.7 ft lbs
- Anchor the panels with the remaining hardware

STEP  
**6**

**REINSTALL THE FENCE PANELS THAT WERE REMOVED FROM THE COMMON BASE**

- Torque fence panel bolt to 23.7 ft lbs

STEP  
**7**

**REMOVE FENCE PANELS FROM THEIR PALLET AND INSTALL IN MARKED LOCATION**

- Mount panels to fence post and torque to 23.7 ft lbs
- Anchor the panels with the remaining hardware
- Install light curtain ducting
- Install match-marked cables in the appropriate ducting
- Install headstock and tailstock guards  
*(Reference Images C and D on page 6)*

# Unloading Your Acieta FastARC 2HT (cont.)

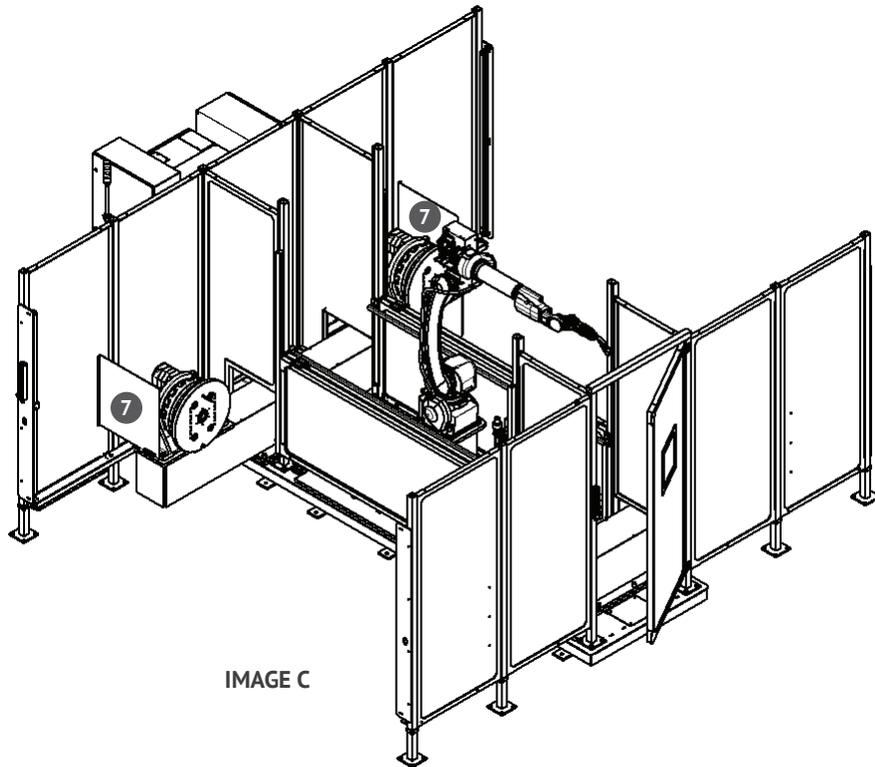


IMAGE C

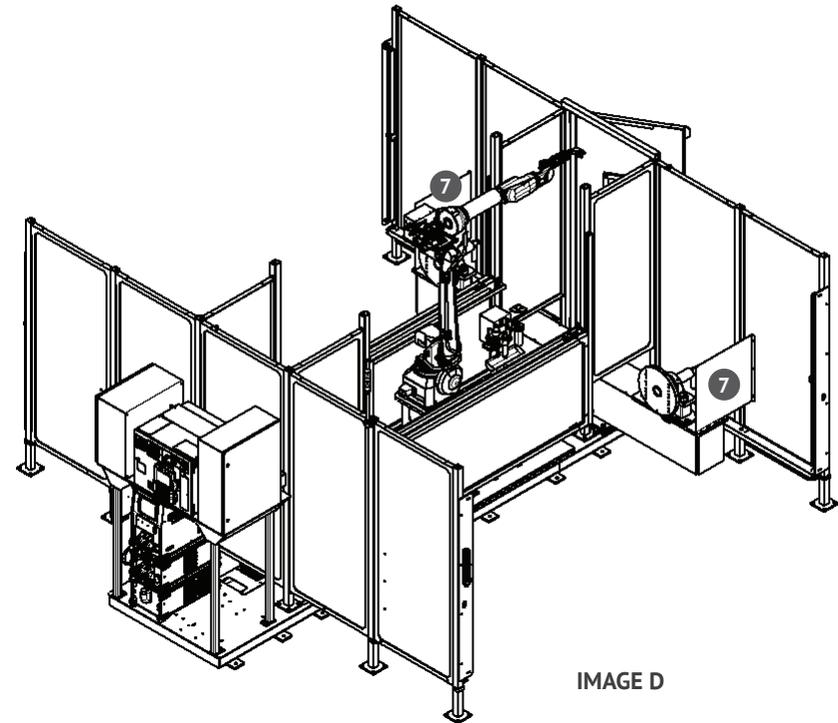
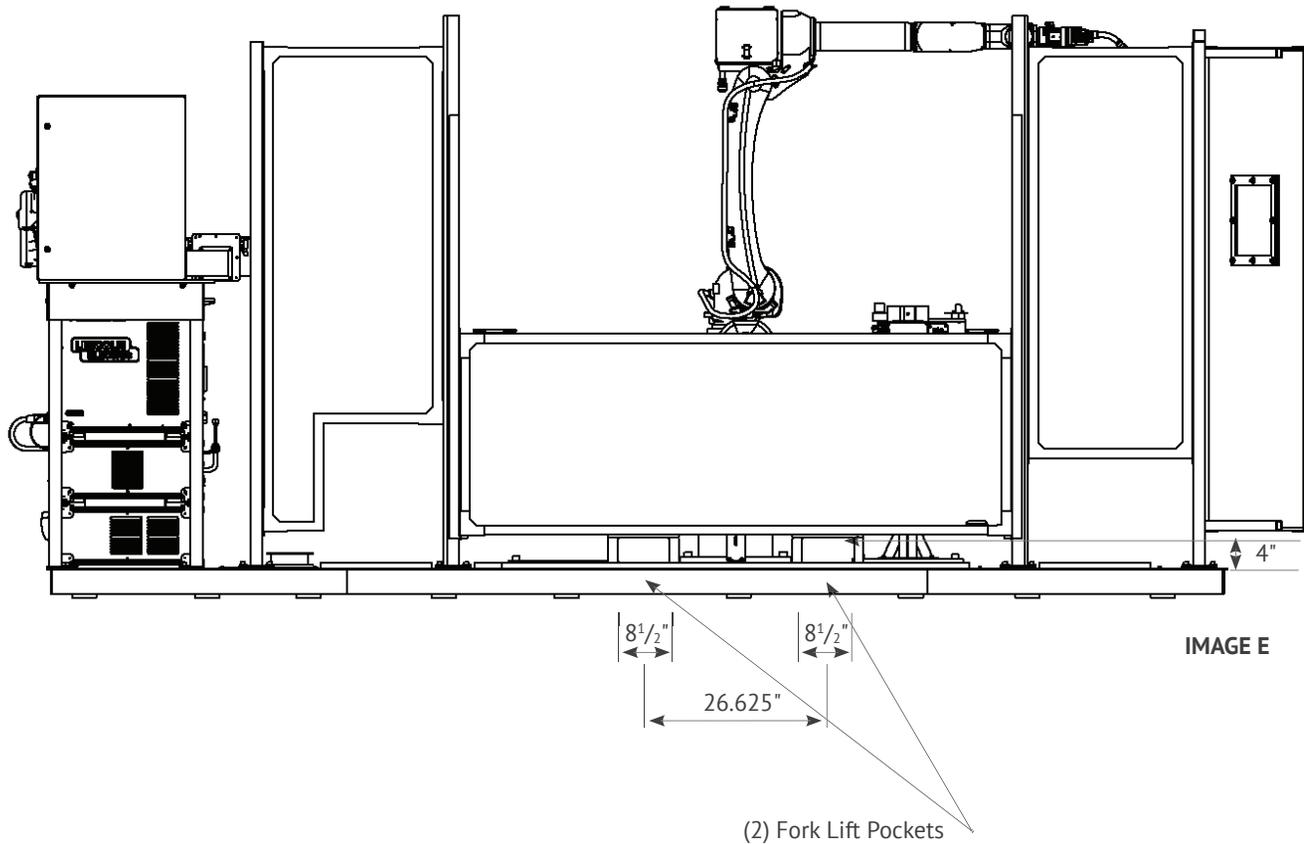


IMAGE D

# Rigging Location

Lifting With Forklift Capacity of at Least 6,500 lbs



# Anchoring and Utility

## STEP 1

### ANCHOR TO THE FLOOR WITH EIGHT SUPPLIED ANCHORS

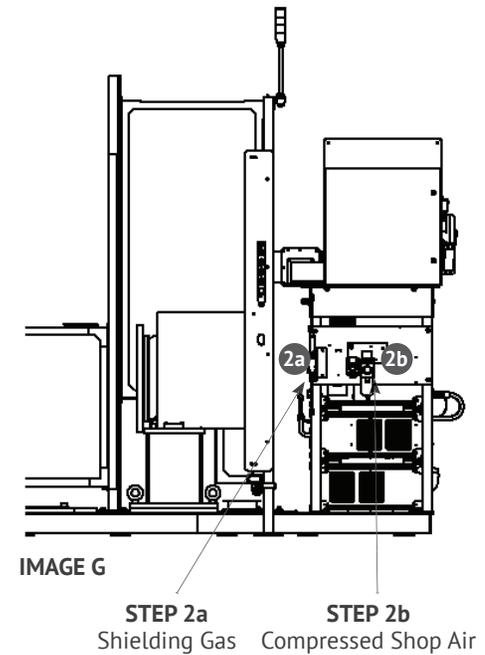
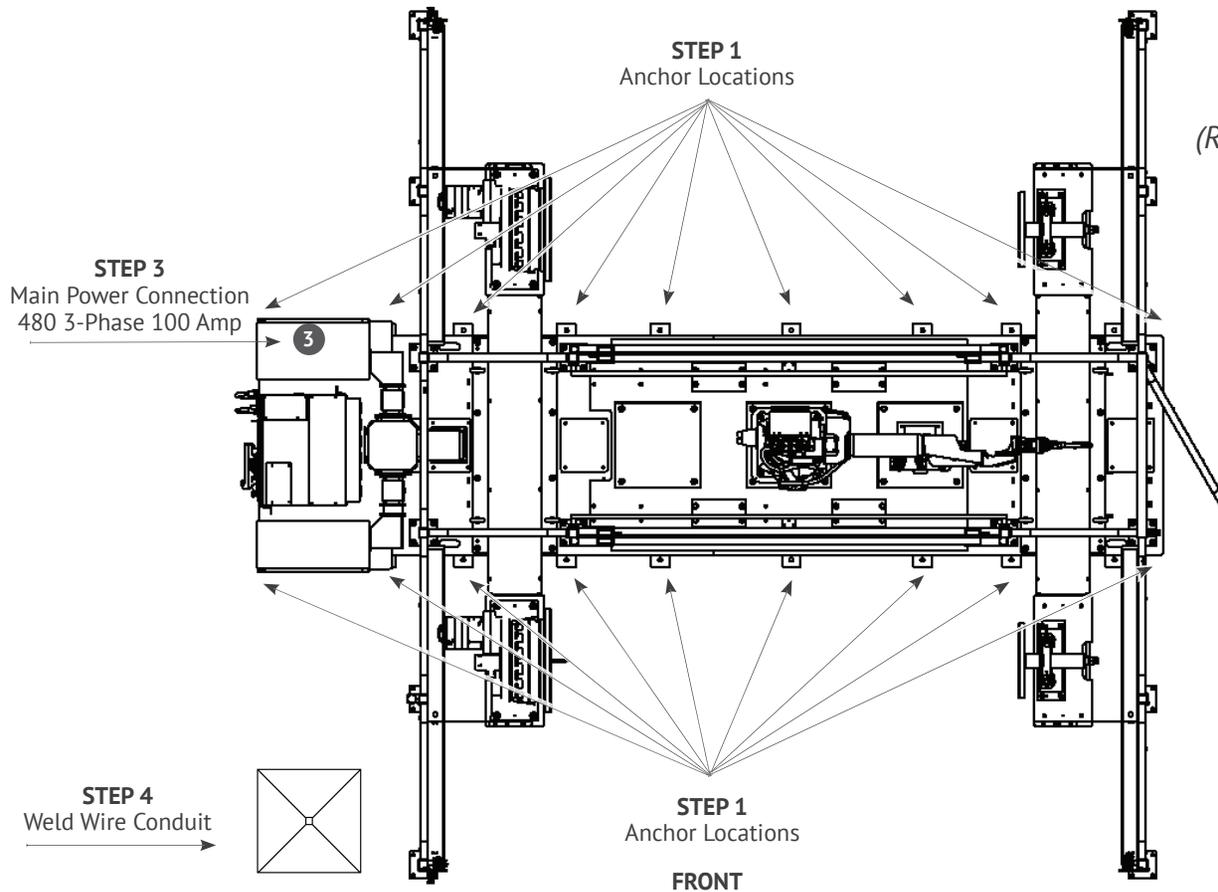
- Supplied anchors are 3/4" floor anchors; Secure in the floor and shim as needed  
(Reference Image F below)

## STEP 2

### CONNECT COMPRESSED SHOP AIR AND SHIELDING GAS

- Install the Filter-Regulator-Lubricator on the Acieta FastARC 2HT
- System is equipped with a female 1/2" NPT fitting
- Install the shielding gas flow sensor (found on the same side) is equipped with a male 1/4" NPT fitting

(Reference Image G below)



STEP  
**3**

**CONNECT POWER TO THE SYSTEM**  
These steps must be performed  
by a licensed electrician.

- Electrical connection is attached to the main electrical panel from above
- A hole must be placed in the top of the box to accommodate the conduit being used and supplied by the user's electrician

*(Reference Image F on page 8)*

STEP  
**4**

**INSTALL THE WELD WIRE CONDUIT**

- Weld wire conduit goes over the side panel of the system and attaches to the wire feeder located on J4 of the robot
- Weld wire must be in a location within 25 feet to the center of the robot

*(Reference Image F on page 8)*

STEP  
**5**

**INSTALL THE LIGHT STACK**

- Remove the light stack from loose components box
- Unscrew the top of the light from the extension tube
- Pass the wire through the mounting bracket and conduit
- Screw the connector to the light
- Reassemble the light stack and place it in its holder

*(Reference Image H left)*

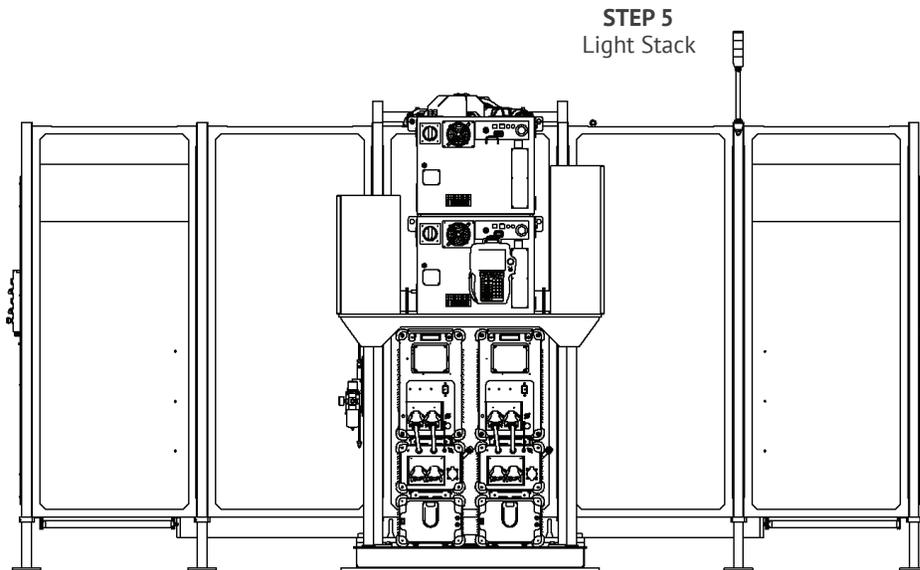


IMAGE H

## Operating Acieta FastARC 2HT

Please see the Operator's Manual for the Acieta FastARC 2HT.

# Keep Your Robotic Weld Cell Running at Peak Performance

A well-maintained FANUC robot can last decades. Keep your facility productive and running with annual preventive maintenance service. Acieta maintenance and training services help manufacturers maximize uptime. Virtual service calls are also available to help you remain productive (and healthy) during any uncertain times.

## Virtual and Onsite Service Call Options

<b>OPTION 1</b>  <b>24 HOUR PHONE SUPPORT</b> 844-4-ACIETA Ext 1 (call back within one hour)	<b>OPTION 2</b>  <b>VIDEO CHAT SUPPORT</b> (Facetime, Skype, Teams, etc.)	<b>OPTION 3</b>  <b>ONSITE SUPPORT</b>
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## Acieta's Service Team is Here to Support You 24/7/365

### 24/7 TECHNICAL SUPPORT

Acieta technicians are available 24/7/365 to help troubleshoot problems and minimize downtime. *Call backs are within one hour.*

### PREVENTIVE MAINTENANCE

Acieta's certified maintenance technicians will help give you peace of mind that your system stays as productive as the day it was first installed.

### PARTS

Acieta has access to FANUC and other branded parts for your robotic cell. Plus, there is no restocking fee for most parts used for troubleshooting when installed by Acieta.

### TRAINING

Proper employee training decreases lost production time while boosting ROI. Acieta offers training hosted at your facility or one of ours. Each class is tailored to fit the attendees specific needs.

## Service & Support

 844-4-ACIETA

 acieta.com

 customerservice@acieta.com

# QUICK START GUIDE

## FastARC<sup>®</sup> 2HT

Dual Zone Headstock/Tailstock



A leader in the robotics business for nearly 40 years, Acieta provides a wide range of robotically automated solutions and services for the manufacturing industry. With locations in Waukesha, Wis., and Council Bluffs, Iowa, Acieta has integrated more than 5,000 automation systems for customers across the United States, Mexico and Canada. As part of its mission to be a true partner to its customer base, Acieta is committed to solving challenges facing all manufacturers, such as lowering costs, increasing productivity and addressing labor shortfalls. Serving most manufacturing segments, Acieta has 110+ employees across the United States and is committed to creating a positive future for North American manufacturing. For more information about Acieta, visit [www.acieta.com](http://www.acieta.com).

Acieta holds industry certifications from FANUC and the Robotic Industries Association.

