



# SWC2000TT

TWIN TANK AC/DC WELD CLEANER

## OPERATING INSTRUCTIONS



IMPORTANT: BEFORE USING THE EQUIPMENT, READ THE CONTENTS OF THIS MANUAL. THE MANUAL MUST BE STORED IN A PLACE FAMILIAR TO ALL USERS FOR THE ENTIRE OPERATIVE LIFE-SPAN OF THE MACHINE. THIS EQUIPMENT MUST BE USED SOLELY FOR WELDING OPERATIONS.

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## SWC2000TT

### **Congratulations on your new Strata product!**

The Strata range from Euroquip uses latest technology design and engineering to produce welding products that combine market leading value and features with durability. Designed for discerning operators who seek professional results and optimum performance, productivity and value. Design emphasis is placed on simple, functional design and operation. Strata product is subject to stringent quality control and designed and manufactured to NZ & Australian standards.

Common use of Strata products include:

- Light Engineering
- Automotive
- Home/Hobby Engineering
- Farming
- Industrial Maintenance & Repairs

For industrial welding solutions, check out the Strata range from Euroquip:

**[www.strata.co.nz](http://www.strata.co.nz)**

Euroquip is a market leading provider of innovative power equipment solutions to a wide range of industries across New Zealand and Australia. Key product categories are; welding equipment, air compressors, power generators and cleaning equipment.

Euroquip's slogan is 'empowering industries', find out more about the advantage Euroquip brings at **[www.euroquip.co.nz](http://www.euroquip.co.nz)**.



## **Contents**

|   |    |
|---|----|
| 1. Safety precautions.....                      | 4  |
| 2. Summary.....                                 | 4  |
| 3 .Optional Accessories.....                    | 5  |
| 4. Description of technical specifications..... | 6  |
| 5. Description of controls.....                 | 6  |
| 6. Installation and operation.....              | 7  |
| 7. Notice.....                                  | 8  |
| 8. Trouble shooting.....                        | 9  |
| 9. Patent cleaning gun: .....                   | 10 |
| 10. Warranty.....                               | 12 |



## 1. Safety precautions

**CLEANING OPERATION CAN BE HARMFUL TO YOURSELF AND OTHERS.** The user must therefore be aware of the hazards, summarized below, resulting from cleaning operations.

**ELECTRIC SHOCK** - May be fatal.

Install and earth the machine according to the applicable regulations.

Do not touch live electrical parts or electrodes with bare skin, gloves or wet clothing.

Isolate yourselves from both the earth and the work piece.

Make sure your working position is safe.

Don't operate the machine, without the machine covers in place. Remove the power supply, before repairing the machine.

Always replace any damaged part of the machine with genuine soar parts.

**FUMES AND GASES** - May be hazardous to your health.

Keep your head away from fumes.

Work in the presence of adequate ventilation, and wherever possible use extraction around the arc to prevent gases from forming in the work area.

**RISK OF FIRE AND BURNS**

Sparks may cause fires and burn the skin; you should therefore make sure there are no flammable materials in the area, and wear appropriate protective garments.

**PACEMAKERS**

The magnetic fields created by high currents may affect the operation of pacemakers. Wearers of vital electronic equipment (pacemakers) should consult their physician before beginning any arc welding, cutting, gouging or spot welding operations. **EXPLOSIONS** Do not weld in the vicinity of containers under pressure, or in the presence of explosive dust, gases or fumes.

All cylinders and pressure regulators used in welding operations should be handled with care.

**ELECTROMAGNETIC COMPATIBILITY**

This machine is manufactured in compliance with the instructions contained in the harmonized standard and must be used solely for professional purposes in an industrial environment. There may be potential difficulties in ensuring electromagnetic compatibility in non- industrial environments.

**IN CASE OF MALFUNCTIONS, REQUEST ASSISTANCE FROM QUALIFIED PERSONNEL.**

## 2. Summary

The machine is used for cleaning the weld bead of TIG or MIG welding. The machine is complete with a patented fluid feeding unit. When the trigger on the gun is activated, it will apply the cleaning liquid. Wipe the surface of work piece with the brush, to remove discolorations. After cleaning, the work piece is bright with no damage to the surface. The passivating method of cleaning is faster and lower cost than pickling and polishing. The advantage for weld bead cleaner:

- 1) No need for polishing, there is no dust produce, less time taken.
- 2) The machine comes complete with four protections. They are excess output current protection, excess input current protection, output current short circuit protection, power source over heat protection.
- 3) Patent fluid feed unit: It can supply cleaning liquid automatically and improve working efficiency by up to 50%.
- 4) Patent cleaning gun: It is design to prevent short circuit and burning of the carbon brush. It is safe and reliable, and will increase the service life by up to 50%.
- 5) It has a power cleaning function enabling the removal of the marks from heavy heat and welding, thoroughly.



# SWC2000TT

## Included with your machine

|    |                  |  |   |
|----|------------------|--|---|
| 1  | STRATA SWC2000TT | AC/DC Weld bead cleaner 230V with twin tanks and turbo cleaning function, 3m torch and 3m earth cable. | 1 |
| 2  | 42487            | Ceramic Insulation Sleeve for 9mm Brush  | 2 |
| 3  | 42614            | Weld Cleaning Brush 9mm  | 2 |
| 4  | 42488            | Ceramic Insulation Sleeve for 11mm Brush   | 2 |
| 5  | 42615            | Weld Cleaning Brush 11mm   | 2 |
| 6  | 42489            | Ceramic Insulation Sleeve For Wiper  | 2 |
| 7  | 42616            | Wiper Support 15mm   | 2 |
| 8  | 42617            | Weld Cleaning Wiper Cloth 15mm   | 2 |
| 9  | 42490            | Wiper Support 40mm   | 2 |
| 10 | 42491            | Weld Cleaning Wiper Cloth 40mm   | 2 |

## 3 .Optional Accessories

There are the following optional accessories available for your machine:

|       |   |   |
|-------|---|---|
| 42475 | <p><b>Weld Cleaner Trolley</b><br/>The optional Trolley is a perfect accessory for your weld cleaner, raising the height of the machine to ideal cleaning height and allowing easy portability anywhere in your workshop.</p> |  |
| 42492 | <p><b>Marking/Etching Attachment</b><br/>This marking/etching attachment allows you to easily and accurately mark your logo/serial numbers etc on to your job.</p>  |   |



# SWC2000TT

## 4. Description of technical specifications

The contents are for your reference.  
Please check the name plate of your specific machine in case of updates.

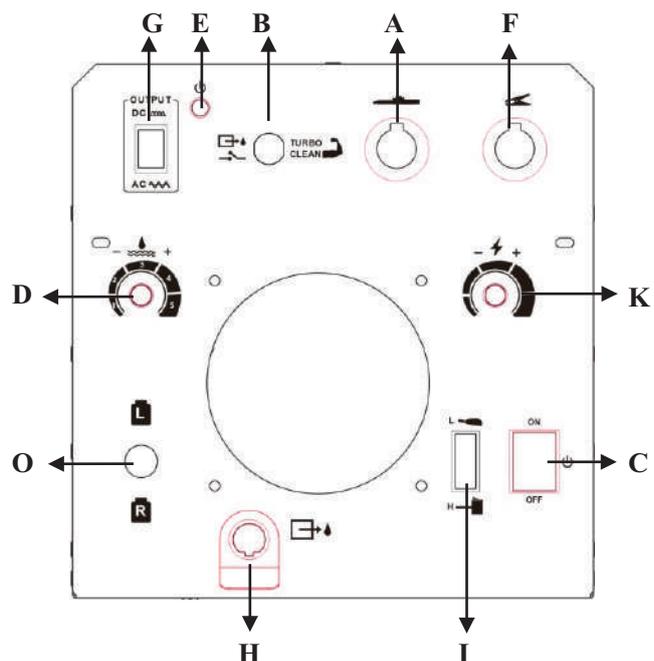
| STRATA AC/DC WELD CLEANER |                      |                     |         |                                       |
|---------------------------|----------------------|---------------------|---------|---------------------------------------|
| SWC2000TT                 |                      | SN:                 |         |                                       |
|                           |                      | 5405                |         | AS/NZS/EN60974-2<br>AS/NZS/EN60974-10 |
|                           | X=100%               | V <sub>0</sub> (DC) | L 13.5V | H 25.8V                               |
|                           |                      | U <sub>2</sub> (DC) | 10V     | 22V                                   |
|                           | U <sub>1</sub> =230V | I <sub>2</sub> (DC) | 18A     | 16A                                   |
|                           |                      | I <sub>1</sub> (AC) | 1.6A    | 3A                                    |
| WATER VOLUME              |                      | 2L                  |         | IP21S                                 |

- MODEL:** The model of the machine
- SN:** Machine Serial Number which must appear on requests or inquiries concerning the machine.
- CE ,EN ,ISO:** International standards
- U<sub>1</sub>:** Rated supply voltage
- U<sub>2</sub>:** Secondary voltage with welding current
- I<sub>1</sub> I<sub>2</sub>:** Input current
- I<sub>12</sub>:** Output welding current
- V<sub>0</sub>:** Open-circuit voltage
- Water volume :** Volume of cleaning liquid
- IP21S:** Machine case protection class. The 1 in the means that this unit is not designed to work outdoors in the rain.

## 5. Description of controls

- A, Output terminal for gun
- B, Control socket for cleaning gun.  
Turbo clean
- C, Power switch
- D, Flow adjustment
- E, Power indicator
- F, Output terminal for earth
- G, AC/DC selection switch
- H, Cleaning liquid connector
- I, Low/high power choice:

- L: brush
- H: cloth wiper

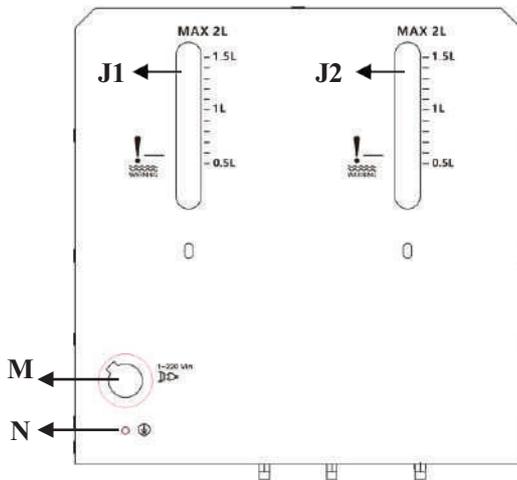


**Warning:** Please don't use the brush in H mode. It will cause the output current protection and over heat protection to active In severe cases, the machine may be damaged.



# SWC2000TT

- K, Power adjustment
- O, Cleaning liquid selector switch.
- When (L) is selected, L is output, and when (R) is selected, R is output.
- J1, (R) Level for cleaning liquid
- J2, (L) Level for cleaning liquid
- M, Input power cable
- (Confirm the power voltage before use)
- N, Ground connector



- 5). When using the cloth wiper, if the cloth cover is damaged, please replace it immediately. If the internal metal is exposed, it will contact with the work piece and short circuit.
- 6). During the cleaning process, if there are stains that cannot be removed, you can press and hold the power cleaning button, and the stains will temporarily become darker. Release the powerful cleaning button to continue cleaning, and the stains will emerge clean.
- 7). The cleaned work piece still needs to be washed with clean water to avoid cleaning liquid residue.
- 8). After use, it is recommended to wash the brush with clean water to increase the service life of the brush. Note: The cleaning gun or brush head can not contact the earth clamp directly. If so, the machine will be short circuit protection. The machine will sound and alarm, the power indicator will twinkle and the machine will stop output.. until the brush head is remove from contact with the earth clamp, the machine protection will active. Once the brush head has been remove from contacting the earth clamp, after 8 seconds, the machine will return to normal.

## 6. Installation and operation

- 1). Input AC230V to the machine, connect the gun and earth cable to the machine, turn on the machine, the power indicator (green LED) will light. Attach the earth cable clamp to the work piece, depress the trigger on the cleaning gun. The cleaning liquid will come out automatically. Wipe with the surface lightly with the brush or cloth wiper, the weld bead will be clean. Finally, wipe the excess fluid from the weld with a damp cloth.
- 2). The machine is applied to stainless steel TIG welding bead and welding spot. If the work piece was welded through from the back or welded with insufficient shielding gas, it will reduce the cleaning effect.
- 3). Warning: Please don't use the brush in H1 (only for small cloth wiper) and H2 (only for large cloth wiper) mode. It will cause output current to become too high and activate overheat protection. In severe cases, the machine may be damaged.
- 4). When using the brush, it must be mounted fixed sleeve allowing 10mm of the brush to be expose If the brush length is shorter, the fixed sleeve can be slide back to restore the 10mm length. Don't operate without the fixed sleeve in place. Incorrect operation can lead to excessive output current and burn the brush.



# SWC2000TT

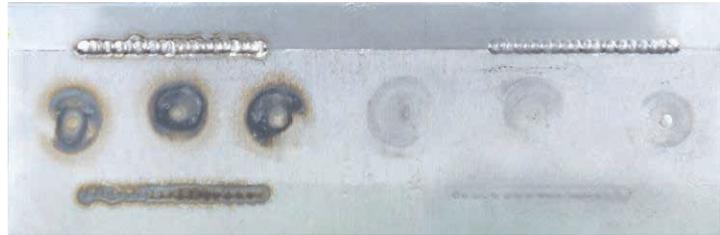
## Patent cleaning gun

When the trigger on the gun is activated, it will spray cleaning liquid

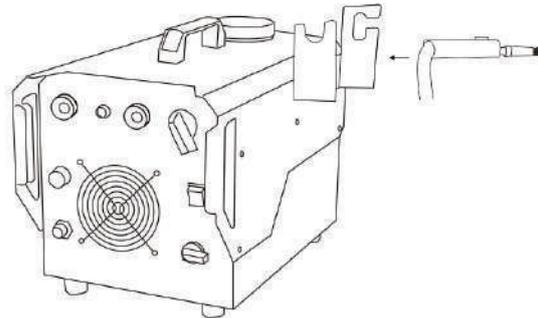
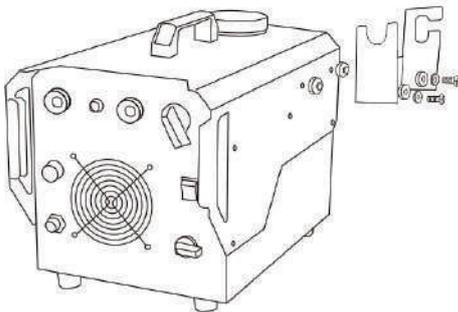


## Before cleaning

## After cleaning



## Installation of gun support



## 7. Notice

1. When cleaning with a brush, if the tip of the brush sparks a lot, please check that there is sufficient cleaning liquid in the cleaning part. If there's a lot of smoke, in addition to increasing the cleaning liquid, lower the output power level. Please ensure that the machine is used in a ventilated environment and the user should also wear a mask to reduce smoke inhalation. When the machine, please wear protective goggles, mask and gloves to avoid the cleaning liquid irritating your eyes.

2. Before using the machine, please confirm the gun and earth cable connection are correct.

- 1) To fit the brush: a) mount the fixed sleeve b) fit the brush (hand tighten is sufficient) c) pull up the sleeve and then tighte the brush.
- 2) The large (standard) brush is used for clean surfaces and edges, the middle brush is use for cleaning corners. When cleaning a corner section, the output current should be low, if using large brush, some of the output current will be dissipated the side face.
- 3) Cleaning cloth is used for high current, brush (large or middle) is used for low current. High current will increase acid, it is good for the cleaning speed, but it will not produce a bright surface. Please use it according to the actual situation.

- 4) Before using, please immerse the torch head with cleaning brush into the cleaning liquid with a depth of more than 4cm and keep it for more than 4 seconds. In this way, the cleaning liquid can be fully absorbed to ensure good electrical conductivity and normal output.

3. Maintenance (Before Maintenance and checking, power must be turned off, and before Opening the housing, make sure the power supply is turned off.)

- 1) Remove dust by with dry and clean compressed air regularly, if the welding machine is operating in a high dust enviroment it will require this to be done daily.
- 2) Check inter circuit of welding machine regularly and make sure the cable circuit is connected correctly, and the connectors are tight (especially insert connector and components). If scale and oxidation is found, please give clean and polish then connect them again tightly.
- 3) Do not allow water or steam to enter into a machine.
- 4) Please place the gun in the gun support or the position higher than the liquid tank. If you do not use this machine for more than 24 hours. Discharg the torch and flush with clean water to clean the gun. (Repeat the the operation twice, to avoid liquid crystal or corrosion, and to ensure the machine is in good condition)



# SWC2000TT

5) If the machine is not being used more than 24 hours, please fill up water to clean the machine before use. Trigger the torch to inject water and remove air and liquid crystal from inside the pump and torch.

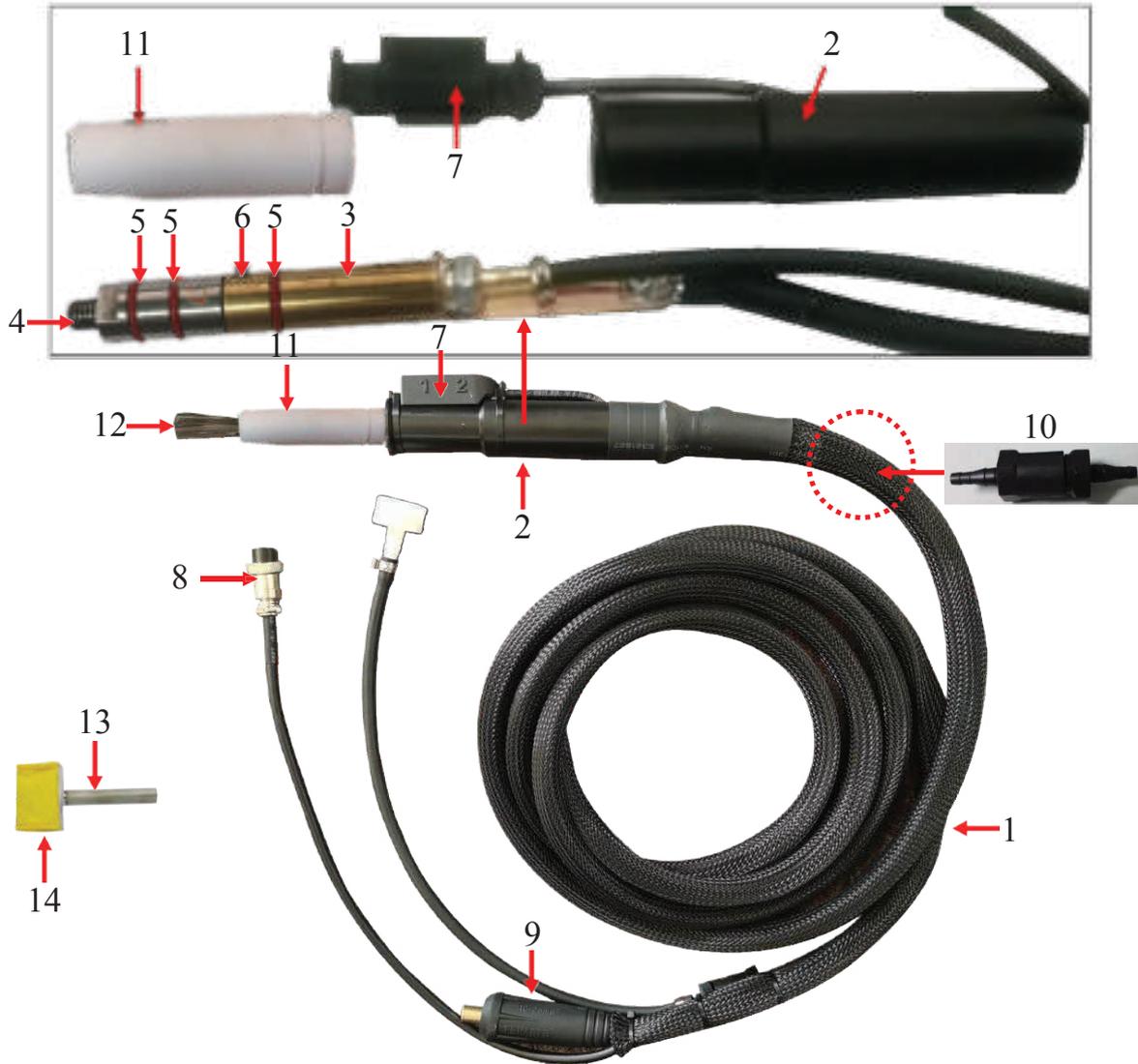
## 8. Trouble shooting

| TROUBLE  | PROBABLE CAUSE  | REMEDY  |
|--|---|---|
| 1. Turn on power switch, the indicator is not lit.                 | <ul style="list-style-type: none"> <li>A. The switch has failed.</li> <li>B. The power cable is damaged.</li> <li>C. Input voltage is abnormal.</li> </ul>  | <ul style="list-style-type: none"> <li>A. Replace power switch.</li> <li>B. Replace power cable.</li> <li>C. Supply correct power voltage.</li> </ul>   |
| 2. No output voltage.  | <ul style="list-style-type: none"> <li>A. Bridge rectifier is damaged.</li> <li>B. Switch is damaged.</li> <li>C. The breaker is not reset.</li> </ul>  | <ul style="list-style-type: none"> <li>A. Replace the rectifier.</li> <li>B. Replace the switch.</li> <li>C. Reset the breaker.</li> </ul>  |
| 3. The machine sounds an alarm and the power indicator is blinking | <ul style="list-style-type: none"> <li>A. Main transformer over heating</li> <li>B. Torch and earth cable in short circuit</li> <li>C. Overcurrent protection for output</li> </ul> <p>(The reason in item B may also cause output overcurrent) ; D. Machine internal failure</p> | <ul style="list-style-type: none"> <li>A. Stop operation and wait for the transformer to cool down.</li> <li>B. Make sure the torch has no metal parts in direct contact with the earth cable and work pieces.               <ul style="list-style-type: none"> <li>-Check if the cloth wiper is damaged and the metal parts are making contact with the work piece.</li> <li>-Check if the brush fixed sleeve is properly installed to protect the brass shaft of the torch from contact with the work piece.</li> </ul> </li> <li>C. Check if the brush stickout is too short causing the output resistance to be too low and over current.</li> <li>D. Main control PCB or rectifier PCB failure. Please contact the manufacturer for professional maintenance.</li> </ul> |
| 4. Water yield is abnormally low                                   | <ul style="list-style-type: none"> <li>A. The filter screen of the one-way valve on the cleaning gun is blocked by foreign material</li> <li>B. The inlet filter screen in the tank is blocked.</li> </ul>  | <p>Check whether the one-way valve on the cleaning gun and the inlet filter screen in the bucket are blocked by foreign material. Dismantle, clean them, and then install them again. Observe whether the flow returns to normal.</p>   |



# SWC2000TT

## 9. Patented cleaning gun:





## SWC2000TT

### Parts list

| Item | Code   | Description                               |
|------|--------|---|
| 1    | 42476  | Complete Torch Assembly for SWC2000TT     |
| 2    | 42477  | Cleaning Torch Handle                     |
| 3    | 42478  | Torch Shaft Rear Section                  |
| 4    | 42479  | Torch Shaft Front Section                 |
| 5    | 42480  | O Ring for Torch Shaft                    |
| 5    | 42481  | Cleaning Torch Main Shaft                 |
| 6    | 42482  | Grub Screw                                |
| 7    | 42483  | Dual Control Trigger                      |
| 8    | 18175  | 4-Pin GX16 Black/Silver Plug              |
| 9    | CP1625 | Cable Plug for 10-25mm <sup>2</sup> Cable |
| 10   | 42486  | Liquid Valve                              |
| 11   | 42487  | Ceramic Insulation Sleeve for 9mm Brush   |
| 12   | 42615  | Weld Cleaning Brush 11mm                  |
| 11   | 42488  | Ceramic Insulation Sleeve for 11mm Brush  |
| 12   | 42615  | Weld Cleaning Brush 11mm                  |
| 11   | 42489  | Ceramic Insulation Sleeve For Wiper       |
| 13   | 42616  | Wiper Support 15mm                        |
| 14   | 42617  | Weld Cleaning Wiper Cloth 15mm            |
| 13   | 42490  | Wiper Support 40mm                        |
| 14   | 42491  | Weld Cleaning Wiper Cloth 40mm            |



## SWC2000TT

### 10. Warranty

As part of an on-going commitment to excellence in product support, Euroquip offers a comprehensive product warranty program.

**Warranty period for SWC2000TT:**

**Commercial Use: 48 Months**

**Domestic Use: 48 Months**

Warranty covers failure caused by manufacturing and material defects in the product, during the warranty period specified. The warranty period begins when the product is purchased by the end user. Warranty is not transferrable and is only claimable by the original purchaser.

Warranty does not cover parts that are subject to wear and tear from usage.

Warranty covers failure of a product caused by defective materials and/or manufacturing for the period given and the usage specified by Euroquip. The warranty period begins when the product is purchased by the end user. Warranty is not transferrable and is only claimable by the original purchaser.

Warranty also does not cover failure caused by the untimely replacement or service of the above wearing parts. Evidence must be provided that the product has been maintained and serviced suitably for a claim to be considered under warranty.

Failure caused by incorrect operation of the product, lack of proper care and maintenance of the product, external damage, external circumstances such as contaminated fuel or poor water supply, modifications to the product, attempted repair/ service by a party other than an Approved Service Agent, is not covered under warranty.

Warranty does not cover pre delivery service and adjustment, or failure that may occur as a result of lack of/ incorrect pre delivery service and adjustment.

Warranty does not cover any incidental, indirect or consequential loss, damage or expense that may result from any defect, failure or malfunction of a product.

Should any issue be found to be a combination of a warranty failure and a non-warranty issue, the repair cost component to rectify and repair the non-warranty failure is the customers' full responsibility.

The decision that an issue with a product qualifies as a warranty claim is made at the sole jurisdiction of Euroquip.

No costs incurred will be considered under warranty if repairs are carried out by a party other than a Euroquip Approved Service Agent, unless with prior consent in writing from Euroquip.

It is the responsibility of the purchaser to deliver a product under warranty to the nearest relevant service agent or product reseller. Warranty does not cover call outs, mileage and freight costs.

If a product is repaired under warranty, parts and labour required for the repair will be supplied at no charge. Warranty assessment and repair will be scheduled and executed according to the normal work flow at the service location and depending on the availability of suitable replacement parts.

This warranty policy is an additional benefit and does not affect the legal rights of any end user, reseller or service agent.



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Congratulations on your new STRATA product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty. To locate your nearest distributor or service agency visit [www.strata.co.nz](http://www.strata.co.nz), or email us at [customerservice@euroquip.co.nz](mailto:customerservice@euroquip.co.nz)

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