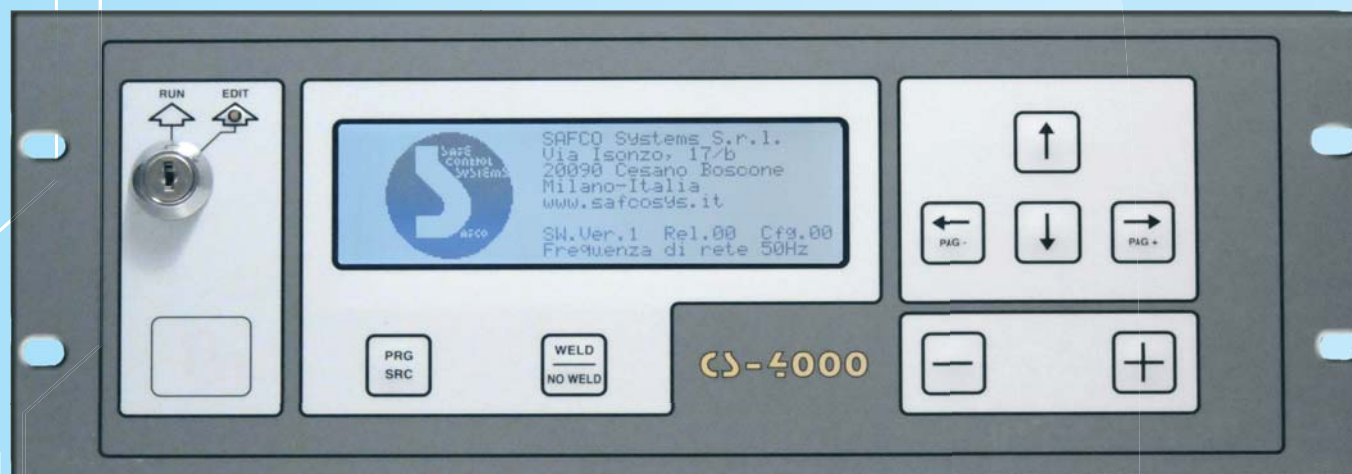


CS-4000 DP



Control with constant weld current for double Pliers



Main Features:

- Synchronous welding control with silicon controlled rectifiers for the regulation of the weld current by mean of phase cut off procedure.

Response speed: 2 cycles for the first weld and then ½ cycle for every successive weld.

Three different control modes:

- Voltage percentage V%
 - Current percentage I% (set in feed - forward)
 - Constant current IK (1,0 – 99,0 KA)
- Suitable for machines with single phase welding transformer.
 - Management of Spot-weld cycles.
 - Resolution of times settings: ½ cycle.
 - Readout of the RMS weld current and of the first cycle, positive and negative half wave.
 - All inlets and outlet are galvanic insulated.
 - Set and run of 4 programs: 1 and 2 are associated to welding clamp A -IC1-; 3 and 4 are associated to welding clamp B -IC2-.
 - Line voltage compensation available in V% and I% modes.
 - Serial communication line interface RS232 point to point for connection to a printer or to a PC.
 - Start cycle with concomitance (dual push button) or with footswitch.
 - Monitoring (Quality control) of weld current limits or of firing angle available in spot-weld and IK or I% modes.
 - Programmable function of continuous weld current auto increase under variable curve for each welding clamp to compensate the electrodes consumption.
 - Independently programmable first insertion delay and first insertion delay after a pause.
 - Four solenoid valves associated to weld clamp A and B for presqueeze and squeeze phases.
 - Prestroke solenoid valve for each weld clamp.
 - Automatic power line frequency recognition.
 - Three language setting capability; further languages upon request.
 - Possible drive from a PLC.
 - Secondary current measurement with Rogowsky coil or primary current measurement with current transformer.
 - L x W x H: 360 x 133 x 91 mm.