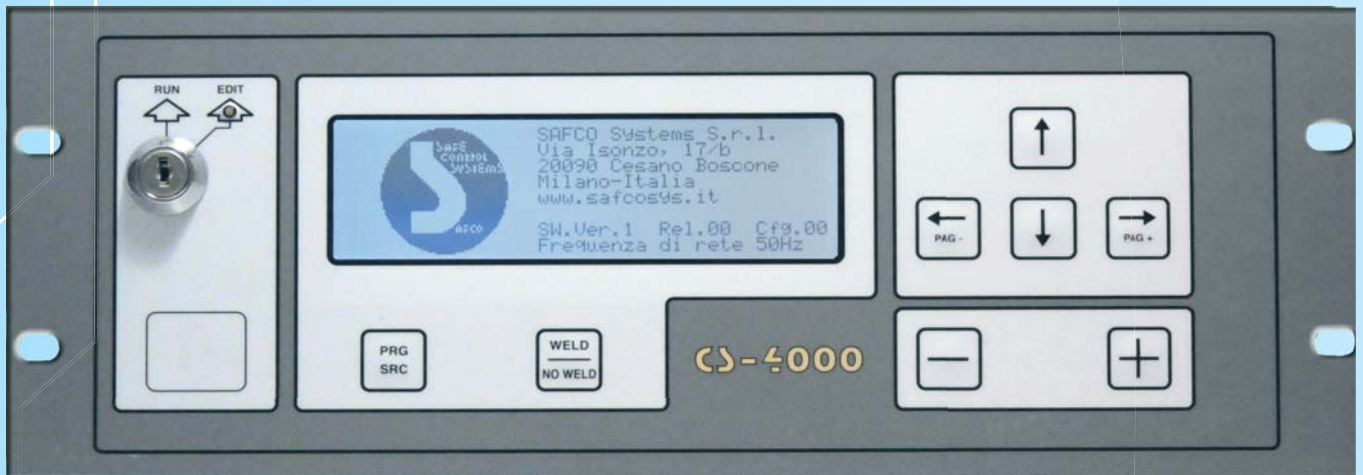


# CS-4000 P/R



Control with constant  
weld current



## Main Features:

- Synchronous welding control using silicon controlled rectifiers for the regulation of the weld current by mean of phase cut off procedure.
- The response speed is within 2 cycles for the first weld, and then 1 cycle for every successive weld.

Three different control modes are available:

- Voltage percentage  $V\%$
  - Current percentage  $I\%$  (set in feed – forward referred to the max. current of the transformer)
  - Constant current  $IK$  (1.0 – 99.0 KA)
- Suitable for machines with single phase and three phases welding transformer.
  - Management of spot-weld cycles and seam weld cycles.
  - The resolution of times settings is  $\frac{1}{2}$  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 capability of 64 programs.
  - 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 (twin push button) or with footswitch.
  - Monitoring (Quality control) of the weld current limits or of the firing angle available in  $IK$  and  $I\%$  modes.
  - Programmable function of continuous weld current auto increase under variable curve.
  - Independently programmable first insertion delay and first insertion delay after a pause.
  - Automatic power line frequency recognition.
  - Three languages choose capability; further languages upon request.
  - Signals for control trough external PLC.
  - Secondary current measurement with Rogowsky coil or primary current measurement with current transformer.
  - Sizes - L x W x H: 360 x 133 x 91 mm.