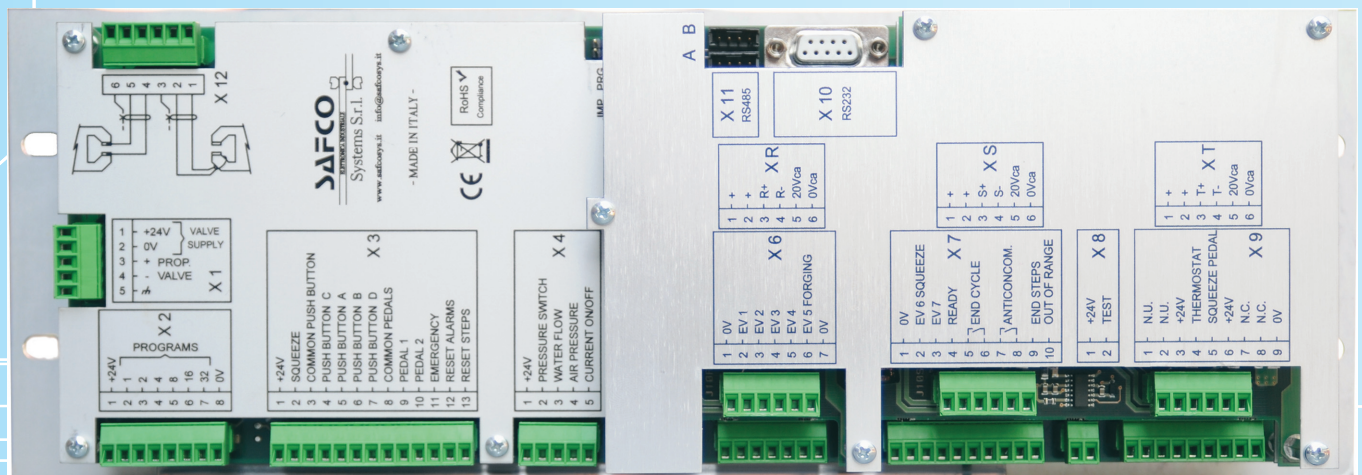
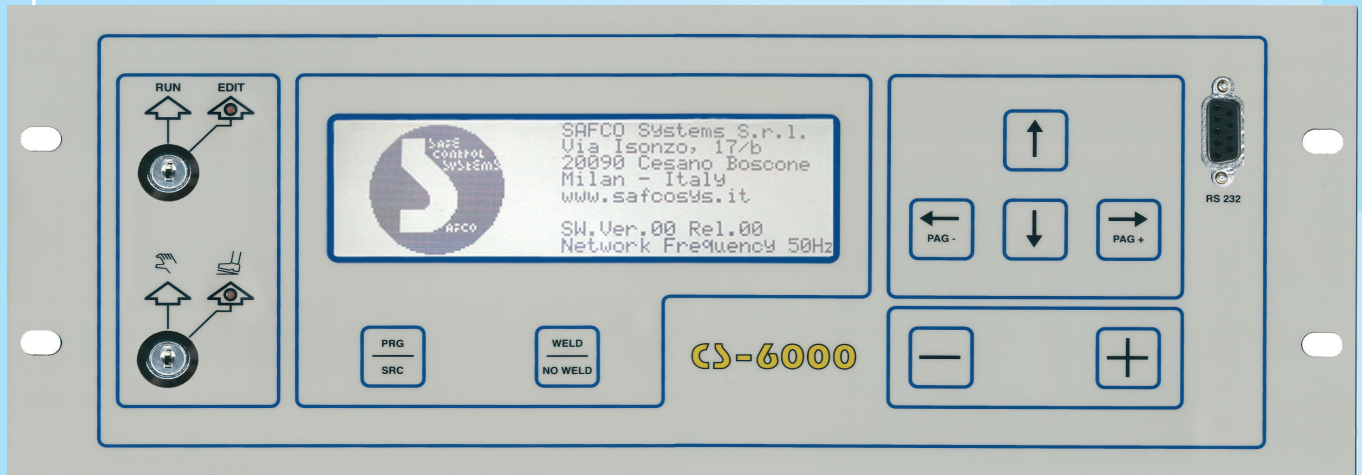
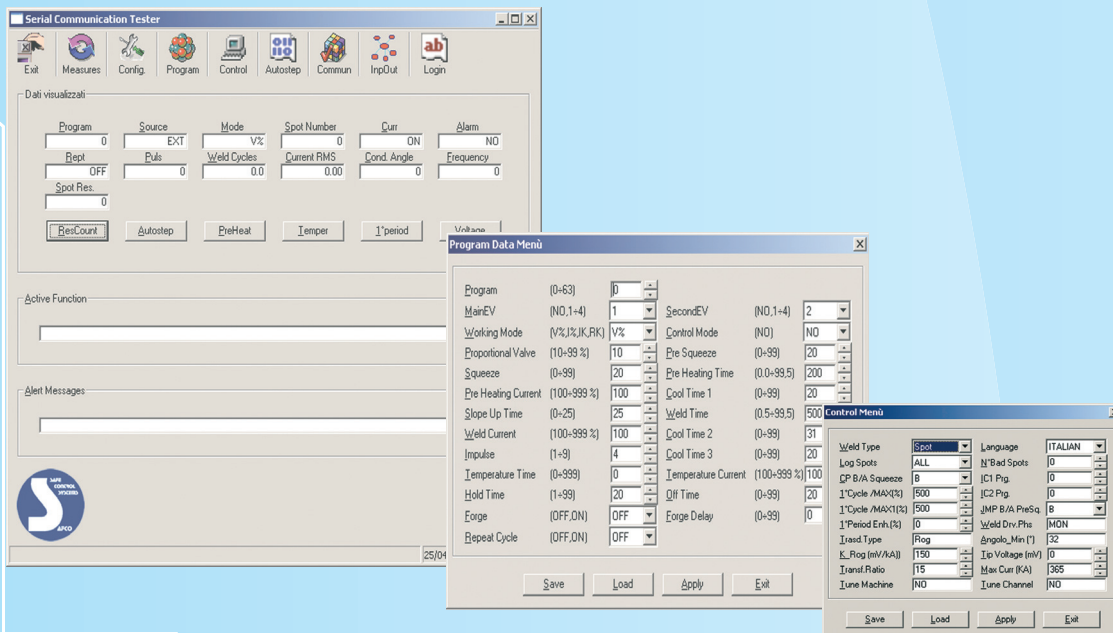


CS-6000



Control with constant weld current





- Synchronous drive for silicon controlled rectifiers with phase cut off current regulation.
- Regulation speed within 2 cycles for the first welding spot and then within 1/2 cycle
- Four operation modes are available:
 - Voltage percentage V%
 - Current percentage I% (Feed Forward mode)
 - Constant current IK (1 - 99 KA)
 - Constant resistance RK
- Single and three phase's transformer (Star and triangle) drive capability.
- Suitable for spot and roll welding machines.
- Welding time control resolution is 1/2 period.
- Display of RMS welding current and of the first period positive and negative half wave.
- Inlets and outlets are galvanic insulated.
- Selection and running of 64 programs that can be called from external inlets; internally or under association to start cycle IC1 or start cycle IC2.
- Compensation of line voltage fluctuations is available in I% and V%
- Point to point serial communication RS232 for connection to a printer or to a personal computer.
- Serial network communication RS 485.
- Communication Extension: Profibus - DeviceNet - CANopen - CC/Link - Modbus/RTU - Profinet/IO - EtherNet/IP - EtherCAT - Modbus/TC
- Start cycle with contemporary: Twin hand buttons or foot switch.
- Qualitative control of welding current limits or of ignition angle are available in Spot welding mode and by IK and I%.
- Welding current limits control and control of phase cut off angle.
- Programmable function for continuous self increase of the welding current to compensate the consumption of the welding electrodes.
 - The current curve is adjustable.
- Welding counter with warning and locking function.
- The delay of first welding current and the delay of first welding current after a pause can be programmed independently.
- Four solenoid valve drive capability that can be associated to program in pre squeeze and squeeze sequences.
- Galvanic Isolated outlet for proportional valve.
- Range limit for proportional valve (99%) can be set: 5-10 Volt.
- Forging solenoid valve.
- Pre stroke solenoid valve.
- Possible pressure link in: pre-squeeze, squeeze, pre-heat, weld, forge, phases via proportional valve (pressure cycle).
- Automatic line frequency recognition.
- Self Calibration.
- Setting Triple Language.
- PLC drive.
- Secondary current reading via Rogosky ring or Primary current reading via current transformer C.T.
- L x H x T 360 x 133 x 91 mm.