

DIGICONTROL AUX / 274

READY -
DIGICONTROL READY

PROGRAMS - SETTING OR
EXECUTION PROGRAMS

MAX VALUE -
UPPER LIMIT

MIN VALUE -
LOWER LIMIT

READING DELAY PERIODS -
PERIODS SETTING OF READING DELAY

READING NUMBER -
NUMBER PERIODS SETTING TO READ

M VALUE - SETTING
QUANTITY OF READINGS IN
WHICH HAVE THE MAX
NUMBERS 'N' OF REJECTS

N VALUE - SETTING MAX
NUMBER REJECT
READING ON 'M'

REJECT DELAY -
SETTING DELAY OF
REJECT

ALARM - ENABLE ALARM
OUTPUT.
- READING STORE DISPLAY

MV - INPUT SIGNAL
AMPLIFIER

RANGE AMPLIFIER

RS232 - SERIAL INTERFACE
PC OR PRINTER

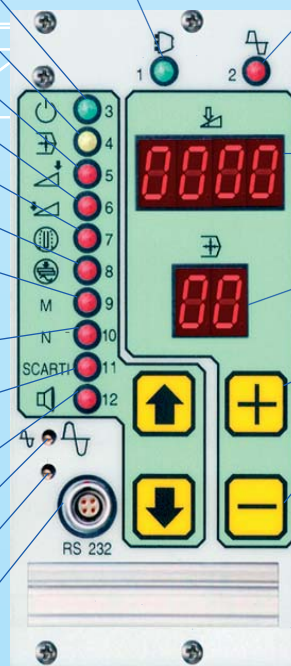
POWER SUPPLY

TOO AMP - TOO SIGNAL
AMPLIFIER

DATA - DATA DISPLAY

PROGRAM - PROGRAM
SETTING DISPLAY

PARAMETER SETTING



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DIGICONTROL PRESENTATION

Considering the heavy environment conditions of the workshops, the DIGICONTROL offers high reliability. The electronic is all solid state with silicon elements; this allows the equipment to withstand wide temperature changes from -10°C to +60°C. A filtering system at high frequency on the power supply circuitry, the high level logic of control voltage, the shielding of the different circuits prevent eventual troubles caused by electric alterations coming from outside. Studied to operate without any technical maintenance in large workshops, the DIGICONTROL offers a non destructive quality control that applies to the 100% of weldings; therefore it is a specialized solid state digital calculator highly reliable.

WORKING PRINCIPLE

The **DIGICONTROL** has the purpose to assure the better welding conditions. Therefore the equipment must be tuned with reference values occurring by quality weldings. In order to calibrate properly the equipment you must be sure of the following conditions.

- The welding machine is in good working conditions;
- The control parameters (pressure,time,heat, etc.) are set according to the welding program;
- The electrodes have correct dimensions and that they are clean;

The equipment is tuned up setting amplifier potentiometer as far as the equipment indicates weldings that matches the stored tolerances when the welding is executed. This welding must be of very good quality according to some destructive tests verifying the core diameter or the resistance. After having calibrated the equipment for exact welding conditions, the DIGICONTROL will automatically check the welding conditions while each of point is executed. Any variations will cause a variation in the reading which is different from the preset one. If the variation of the reading exceeds the tolerance limits, this will provoke the intervention of some alarm signals. The area between these two numbers states the wideness of the tolerances according to which the welding is accepted. Since any welding application has different principles about the acceptability, the equipment has been studied to allow the predisposition to different specifications. The position of the tolerance index is accepted by artificially introducing a width variation. You proceed then increasing the wideness of the variation and at the same testing each time the welding up to when you have not acceptable welding. The relevant tolerance number is now fixed on a lower number. You came back now to the initial welding conditions. The equipment will automatically compare the factors that influence welding and will provoke an indication of the equipment within the limits chosen each time that an acceptable welding is executed. If the variation of a parameter or of the combination of the same is so large to produce a not acceptable welding, the equipment will go out from the tolerance field and an alarm device will be set in action.

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