EN1000 Series Controls

Multiple Schedule/Multiple Sequence Controls

Date: April 2006 Supercedes: August 2000

SPECIFICATIONS

Absolute Count: Push Button Data Entry with Display

Squeeze Count:	0 to 99 cyc, 50/60 Hz
Weld Count/Heat Count:	0 to 99 cyc, 50/60 Hz
Cool Count:	0 to 99 cyc, 50/60 Hz
Hold Count:	0 to 99 cyc, 50/60 Hz
Off Count:	0 to 99 cyc, 50/60 Hz
Weld Impulse Counter:	1 to 99 Impluses
Slope Control/Up and Down Slope:	0 to 99 cyc, 50/60 Hz

Digital Phase Shift Current Control, 10 to 99% in 1% current steps, all weld current functions

It is NOT necessary to program functions NOT required, program only functions required

Standard RWMA/NEMA Programmable Functions

Including the following as examples:

- Up Slope and Down Slope
- Quench/Temper
- Pulsation Sequence
- Multi-Weld Count/Multi-Current Select
- Pre-Heat/Post-Heat
- Forge Delay
- Seam Weld (Continuous and Intermittent)

4 Cycle Modes

Non-Repeat:	Single Schedule upon initiation
Repeat:	Single Schedule repeated with pilot circuit held closed
Successive:	Upon each initiation, unique successive schedules are automatically selected
Chained:	Multiple schedules can be linked to operate sequentially upon a single initation

Additional Features

- Error Code/Fault Outputs
- 87° First Half Cycle Delayed Firing, Anti-Saturation Circuit
- Dynamic Automatic Power Factor Equalization
- Dynamic Automatic Voltage Compensation, ±20% of Nominal Line
- Emergency Stop Circuit
- Interlocking Pressure Switch Circuit
- Single Stage Pilot/2 Stage Pilot, Beat/Non-Beat Operation
- Operational Lights: Power On
  Weld Current
  Indicator Lights for all functions on display panel
- Valve Transformer: 150VA 230/460-115V, E, D & T Cabinets
  50VA 230/460-115V, S Cabinet
- 3 Valve outputs standard, all controls
  Valve select 1 of 7, optional

Exclusive ENTRON two year warranty