

# ENTRON™

## EN1000 Series Cascade/Multi-Valve Controls Multiple Schedule/Multiple Sequence Controls

Date: April 2006      Supercedes: October 2001

### 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

#### 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 initiation

#### Additional Features

- Error Code/Fault Outputs
- 87° First Half Cycle Delayed Firing, Anti-Saturation Circuit
- Dynamic Automatic Power Factor Equalization
- Dynamic Automatic Voltage Compensation,  $\pm 20\%$  of Nominal Line
- Emergency Stop Circuit
- Interlocking Pressure Switch Circuit
- Single Stage Pilot/2 Stage Pilot, Beat/Non-Beat Operation
- Indicator Lights: Weld Contactor Output Position Indicators  
Valve Output Position Indicators
- Indicator Lights for all functions on display panel
- Valve Transformer: 150VA 230/460-115V, Standard
- Order 1 - 8 contactors; 8 Valve outputs standard, all controls



*Exclusive ENTRON two year warranty*

# EN1000 Series Cascade/Multi-Valve Controls

Multiple Schedule/Multiple Sequence Controls



The EN1000 Cascade/Multi-Valve Series Control is ideal for programming schedules for single or multiple transformer resistance welding machines with multiple valve operations.

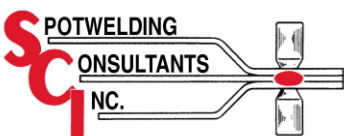
- Store up to 100 UNIQUE SCHEDULES
  - Every parameter of each schedule individually accessible
  - Each schedule can store 13 distinct and totally different parameters
  - All schedules retained in memory with power off
  - It is NOT NECESSARY to program functions not required
- Four Cycle Modes can be programmed for complex welding schedules
- Select and Program up to 8 VALVE CIRCUITS, STANDARD
  - Independently selectable and programmable
- Control can be configured with 1 to 8 CONTACTORS, independently selectable and programmable
- Process Control Outputs
- Additional Standard Features:
  - External Schedule Select
  - Contactor Failed Detection (Circuit breaker with shunt trip, optional)
- Control can be INTERFACED with external Programmable Logic Control (PLC); Advanced interfaces available

CABINET STYLE & DIMENSIONS				CONTACTOR STYLE & RATINGS			
STYLE	H	W	D	AIR COOLED	WATER COOLED		
D or T	610 mm 24"	645 mm 25-3/8"	254 mm 10"	Firing Circuit or 300A	1200A		
LS or LF	914 mm 36"	794 mm 31-3/8"	254 mm 10"	Firing Circuit or 300A	1200A	1800A	
HS or HF	1067 mm 42"	949 mm 37-3/8"	254 mm 10"	Firing Circuit or 300A	1200A	1800A	2200A
GS or GF	1219 mm 48"	949 mm 37-3/8"	254 mm 10"		1200A	1800A	2200A
US or UF	1524 mm 60"	949 mm 37-3/8"	254 mm 10"		1200A	1800A	2200A

- Vault Closing Door Mechanism Standard on all enclosures.
- Water barrier between contactors and electronic components in L, H, G, and U Cabinets.
- All SCR contactors complete with temperature limit switch.

See COMPREHENSIVE PRICE LIST for a complete list of Options, Circuit Breakers, Accessories and Special Features.

Contact your ENTRON Controls Representative or Your Local Resistance Welding Equipment Source



Contact SCI for additional information and pricing.  
 (888) 255-6780 toll free order line  
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