



## EN6001 Constant Current AC Controls

### OPTIONS

- Program Lockout (key switch)
- Operation Mode Switch (Program Lockout and Weld/No Weld)
- Error Reset Switch
- Optional plug-in Ether-net card provides PLC compatibility via MODBUS and EtherNet/IP for remote I/O

### TECHNICAL SPECIFICATIONS

#### BENEFITS:

- Low cost
- Easier to program
- More I/O
- USB backup Port
- Schedule Number: 0 to 63
- Squeeze Delay: 0 to 99 cycles
- Squeeze: 0 to 99 cycles
- Valve Mode: None / All combinations of 3 valves
- Weld1: 0 to 99 cycles
- Weld1 Current Regulation Mode: Phase Shift / Constant Current
- Heat1: 0 to 99%
- Current1: 0 to 100.00 kA
- Cool1: 0 to 99 cycles
- Slope: 0 to 99 cycles
- Weld2: 0 to 99 cycles
- Weld2 Current Regulation Mode: Phase Shift / Constant Current
- Heat2: 0 to 99%
- Current2: 0 to 100.00 kA
- Cool2: 0 to 99 cycles

- Hold: 0 to 99 cycles
- Off: 0 to 99 cycles
- Impulses: 1 to 99 cycles
- Heat/Current Offset: -15 to +15%
- Cycle Mode: Non-repeat / Repeat / Chained / Successive / Wait-here

## **FEATURES**

- Constant current regulation; Primary / Secondary feedback
- Current monitoring with high, low, and pre-limits
- Up to 64 programs (internal or 16 external selection)
- On Timer Membrane Keyboard with backlit 128x64 (8 lines) LCD graphic display
- Six (6) inputs and four (4) outputs with output protection on CPU
- Electrode management functions, including stepping, tip-dressing and preset curves
- Welding programs may be linked together for complex spot schedules (chained or successive) Refresh firmware through USB device
- Load/export control settings from/to USB device
- AC 60/50 Hz welding supported
- Spot / Pulsation / Seam welding / Flash or Butt welding / Brazing
- Multiple weld intervals plus pulsation, upslope and downslope
- Air-over-oil gun operation
- Retraction – maintained, and momentary
- Water Saver (contactor timer)
- Head lock function
- Phase shift monitor
- Half-cycle operation (Alt. / Pos. / Neg.)

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