



EN1000 Series Cascade/Multi-Valve Controls

Multiple Schedule/Multiple Sequence Controls

Date: April 2014

Supersedes: April 2006

SPECIFICATIONS

Absolute Count: Push Button Data Entry with Display

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

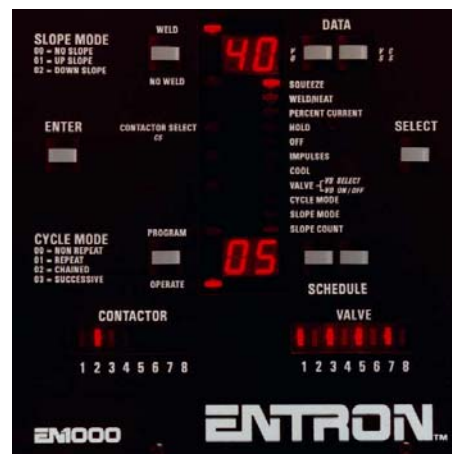
- Up Slope and Down Slope
- Quench/Temper
- Pulsation Sequence
- Multi-Weld Count/Multi-Current Select
- Pre-Heat/Post-Heat
- Forge Delay

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

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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 24O	645 mm 25-3/8O	254 mm 10O	Firing Circuit or 300A	1200A		
LS or LF	914 mm 36O	794 mm 31-3/8O	254 mm 10O	Firing Circuit or 300A	1200A	1800A	
HS or HF	1067 mm 42O	949 mm 37-3/8O	254 mm 10O	Firing Circuit or 300A	1200A	1800A	2200A
GS or GF	1219 mm 48O	949 mm 37-3/8O	254 mm 10O		1200A	1800A	2200A
US or UF	1524 mm 60O	949 mm 37-3/8O	254 mm 10O		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

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