

## Short-Form Catalogue

# Akzent-1000 Weld Time Controller

**Your application:** 2-phase welding transformer

- spot welding
- seam welding
- projection welding
- special welding machines for resistance welding

The process conditions are stable and reproducible. An effortful adaptive process control and process monitoring isn't mandatory.

### Your requirements:

The way of operation of the weld time controller must be easy. Important information's about the process status must be readable on a look. The machine operator is allowed to change settings only in a predefined range. The supervisor must be able to change the predefined parameter range and to protect the parameter settings by code.

### Our answer:

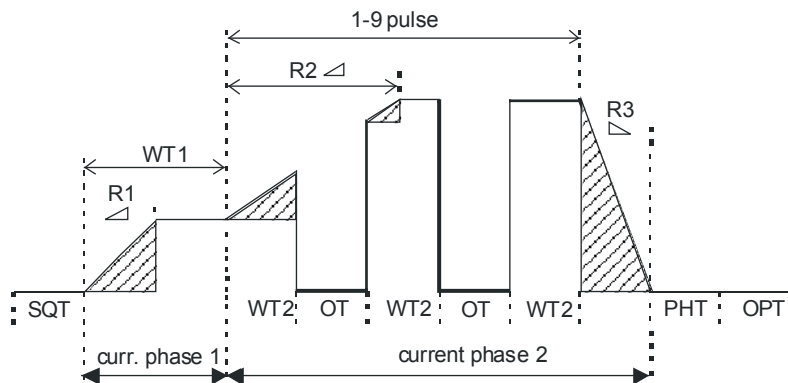
The Akzent 1000 is a standard weld time controller for 2-phase resistance welding applications. It can be easily adapted to customer specific requirements.



The prompt is clear and understandable. The significance of the buttons and display elements is in the plain text besides this. The operation is self-explanatory. The welding parameters settings can be locked against inadvertent alter.

The operation terminal T-1000 is connected to the Thyristor power module TS-1 only by one wire. The small size of the terminal allows the installation very close to the machine head.

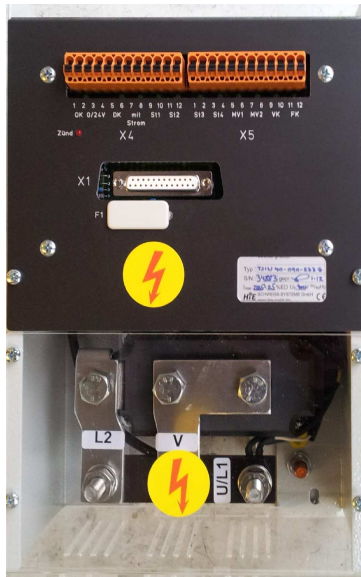
## Welding cycle times



## Technical Specifications

### Operating terminal T-1000

Solenoid valves (sv):	2 sv-output on the thyistor power supply. 24V DC switching power max. 25 VA	
Mains compensation:	compensation of voltage fluctuations from +15% to -20%.	
Eos-contact:	programmable after current or hold switching time: 3 periods.	
Interlock-contact:	closes 10ms before start of welding current time and opens with end of welding current time.	
Number of programmes:	8	
50/60 Hz:	self detection	
Operating modes:	single spot, series spot, projection and seam welding	
Input channels:	pressure contact, OK [ready], with/without current, 4 start input channels	
Welding parameters:	squeeze time	0-99 Per.
	hold time	0-99 Per.
	off time	0-99 Per.
	slope time 1,2,3	0-15 Per.
	current time 1,2	0-99 Per.
	pulses	1-9 pulses
	current 1,2	4-99 %
Dimensions (WxHxD) mm:	T-1060/8	Standard 182 x129 x 25 (without connectors)
	T-1060/8-3	19" (483) x133 x 25 (without connectors)
	T-1060/8-P	Pocket 200 x120 x 55 (without connectors)

**Thyristor modules TS-1/G ...****TS-1/G ...**

water or air cooled

size:

100A - 250A

dimensions (WxHxD):

190 x 293 x 135 mm

(without electrical and water supply connectors)

water cooled

size:

500A - 2335A

dimensions (WxHxD):

190 x 293 x 135 mm

(without electrical and water supply connectors)

For higher power demands  
please ask the manufacturer

Please order thyristor diagrams from the manufacturers.