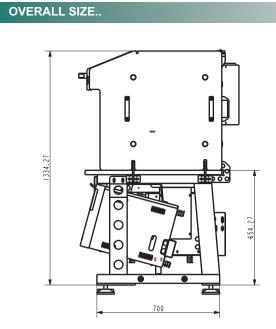
OVERALL AND SPECIFICATION



SPECIFICATIONS..

FS 1000-4020, FS 100-4020 Plus, FS1200-4020,

FS1000-4020 Plus models. POWEF Input Voltages Standard.. 200-240V AC 50 or 60 Hz Input Current.. 13-15 A

Line Voltage Range.. -10% + 15% Peak Power.. 60 KW Weld Energy ..1-200 Joules [thin tab models] 1-400 Joules [thick tab TN1000 peak Weld Current 10000A / TN 1200 peak Current 12000A Welding Voltage.. 0.1v to 9.5v Welding Speed.. 0.75 sec/ weld [including XY travel time] WELD POWER AND CONTROLLER

FS1000-5 / FC1000-7 Weld power unit and controller X-Y TABLE AND DRIVER

Driving motors.. 100W AC servo motor X 2, Driving lead screw.. synchronous belts + 12mm D, 4mm pitch ball lead screw X 2 XY table size.. 600mm x 375mm x 80 H mm XY table travels 400 x 200 mm Servo motor driver.. FEXTO S-3 Standard fixture size.. 490mm x 275mm x 83mm [20S10P 18650

cells] WELD HEAD

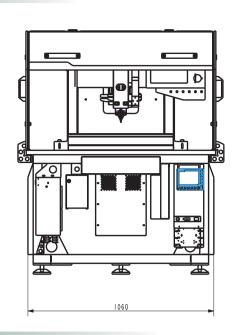
ELE BS-7 / ELE BS-8 Spring loaded DC servo motor drive weld head Driving motor.. 100W DC servo motor Driving lead screw.. 12mm D, 4mm pitch ball lead screws Throat depth.. 240mm Working Height.. max 180mm. Min 80mm Stroke., 30mm

WELD HEAD WATER COOLER Model No.. WS01 recycling weld head water cooler.

ENHENCE POWER BANK [only availiable for FS1200-4020 models Model No.. MF 132 power bank

Capacitancs.. 2200uf x 58 POWER MODULE AND CONNECTION Switching Device High Power IGBT

Weld Head Cable 9 pins RS232 port cable Communication Cable 15 pins game port cable OVERALL AND WEIGH Overall Dimension.. 1280mm x 780mm x 1420 H mm



TRARON FC1000-5 WELD CONTROLLER

SETTING Setting Weld Time 0- 5.9ms Output Accuracy +/- 1% Current (A) ± 2 % [Short Circuit Testing] Power (Joules) ±1% Weld Power Release Mono direction / bi-direction/Weld Monitor Energy Measure Accuracy ±0.2 Joules Weld Data Storing Size 60,000 ntrol Tolerance Accuracy ±0.5% Control Tolerance Range ±10% Weld Data Display Distribution chart plus numericData Transfer hought front data port

DISPLAY AND CONTROL Display Screen 5.6" TFT fully color LCD module Panel Control Keys 11 Function Keys + Enter Key Security Data electrical key lock

TRARON FC1000-7 WELD CONTROLLER. Setting Weld Time.. 0- 5.9ms. Output Accuracy.. +/- 1 %

Current. (A) ± 2 % [Short Circuit Testing] ower (Joules) ..±1% Weld Power Release. Mono direction / Bi-Directional WELD MONITOR

Energy Measure Accuracy.. ±0.2 Joules Weld Data Storing Size.. >2,500,000 Control Tolerance Accuracy.. ±0.5% Control Tolerance Range ..±10% Weld Data Display.. Distribution chart plus numerical reading

Data Transfer.. Thought WiFi connection or from front data port DISPLAY ADN CONTROL Display Screen.. 14" fully color LCD module + touch screen with Jog

Panel Control Keys..11 Function Keys + Enter Key Security.. Data electrical key lock

INTERGRADING COMPUTER Computer.. industrial grade PC computer SoftWare.. EasyPro V1

Note.. TRARON 7 is not a standing along power unit, it must linking up with PC computer and touch Screen monitor, installed with EasyPro V1 soft ware to formed a completed power unit and controller, Commonly apply to automatic tab weld stations.

> WWW.poronHK.com Email: info@poronhk.com

MODELS AND COMBINATION

UP TO 0.2MM.	S THICKNESS
STANDARD MODEL- 10000A output weld current, Portal fran head, X-Y travels 400X200 mm.	me motor drive wel
COMBINATION 1. FC 1000-5 "Transformer Output Manipulation"	
10000 amperes weld power and control [input	
220VAC, 13-15 Amperes]	1 Unit
 TN-1000 weld transformer [maximum output current 10000 amperes] 	1 Unit
3. ELE BS-7 spring loaded AC servo motor drive weld head	1 Unit
4. FEXTO XY-4020 two axes AC servo platform	
travels 400 x 200 mm] 5. FEXTO servo S-3 two axes AC servo driver	1 Unit 1 Unit
6. 2.0 / 3.0 diameter electrodes and holders	1 Set
7. AWS01 recyclying weld head water cooler	1 Unit
8. WS-6 portal frame work bench and hangers	1 Unit
FSIDD-4D20 INTERGRATED	
	0 mm. Equipped
FS DDD - JDED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION	0 mm. Equipped
FS DDD -ADED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m	0 mm. Equipped
INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes]	0 mm. Equipped
INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current	0 mm. Equipped onitor built in. 1 Unit
INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes]	0 mm. Equipped onitor built in.
INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera]	0 mm. Equipped onitor built in. 1 Unit
INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera] 4. FEXTO XY-4020 two axes AC servo platform	0 mm. Equipped onitor built in. 1 Unit 1 Unit 1 Unit
INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera]	0 mm. Equipped onitor built in. 1 Unit 1 Unit
INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera] 4. FEXTO XY-4020 two axes AC servo platform travels 400 x 200 mm] 5. FEXTO servo S-3 two axes AC servo driver 6. 2.0 / 3.0 diameter elecrtodes and holders	0 mm. Equipped onitor built in. 1 Unit 1 Unit 1 Unit 1 Unit
 INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera] 4. FEXTO XY-4020 two axes AC servo platform travels 400 x 200 mm] 5. FEXTO servo S-3 two axes AC servo driver 6. 2.0 / 3.0 diameter electrodes and holders 7. Equipped with PC computer, adapting 14" touch panel 	0 mm. Equipped onitor built in. 1 Unit 1 Unit 1 Unit 1 Unit 1 Unit 1 Set
INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION 1. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera] 4. FEXTO XY-4020 two axes AC servo platform travels 400 x 200 mm] 5. FEXTO servo S-3 two axes AC servo driver 6. 2.0 / 3.0 diameter electrodes and holders 7. Equipped with PC computer, adapting 14" touch panel color screen, running Window 7 software.	0 mm. Equipped onitor built in. 1 Unit 1 Unit 1 Unit 1 Unit 1 Unit
 INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION I. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera] 4. FEXTO XY-4020 two axes AC servo platform travels 400 x 200 mm] 5. FEXTO servo S-3 two axes AC servo driver 6. 2.0 / 3.0 diameter electrodes and holders 7. Equipped with PC computer, adapting 14" touch panel color screen, running Window 7 software. 8. SPC2 (Statistical Process Control) monitor *Built in with PC computer, internet configuration. *Both showing weld energies [Joules] and weld pressure 	0 mm. Equipped onitor built in. 1 Unit 1 Unit 1 Unit 1 Unit 1 Set 1 Set
 INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION I. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera] 4. FEXTO XY-4020 two axes AC servo platform travels 400 x 200 mm] 5. FEXTO servo S-3 two axes AC servo driver 6. 2.0 / 3.0 diameter electodes and holders 7. Equipped with PC computer, adapting 14" touch panel color screen, running Window 7 software. 8. SPC2 (Statistical Process Control) monitor "Built in with PC computer, internet configuration. 	0 mm. Equipped onitor built in. 1 Unit 1 Unit 1 Unit 1 Unit 1 Set 1 Set
 INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION I. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera] 4. FEXTO XY-4020 two axes AC servo platform travels 400 x 200 mm] 5. FEXTO servo S-3 two axes AC servo driver 6. 2.0 / 3.0 diameter electrodes and holders 7. Equipped with PC computer, adapting 14" touch panel color screen, running Window 7 software. 8. SPC2 (Statistical Process Control) monitor *Built in with PC computer, internet configuration. *Both showing weld energies [Joules] and weld pressure 	0 mm. Equipped onitor built in. 1 Unit 1 Unit 1 Unit 1 Unit 1 Set 1 Set
 INTERGRATED INTERGRATED COMPUTER INTERGRADED MODEL. 1000A output weld motor drive pressure sensing weld head, X-Y travels 400X20 with intelligent weld path self programming soft ware. SPC m COMBINATION I. FC 1000-7 "Transformer Output Manipulation" 10000 amperes weld power and control [input 220VAC, 13-15 Amperes] 2. TN-1000 weld transformer [maximum output current 10000 amperes] 3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera] 4. FEXTO XY-4020 two axes AC servo platform travels 400 x 200 mm] 5. FEXTO servo S-3 two axes AC servo driver 6. 2.0 / 3.0 diameter electodes and holders 7. Equipped with PC computer, adapting 14" touch panel color screen, running Window 7 software. 8. SPC2 (Statistical Process Control) monitor "Built in with PC computer, internet configuration. *Both showing weld energies [Joules] and weld pressure [Newton] *Out put data to other computer through internet. 	0 mm. Equipped onitor built in. 1 Unit 1 Unit 1 Unit 1 Unit 1 Set 1 Set 1 Unit

. Industrial grade PC computer built in, pre-installed with Window 7, internet configuration, with 10.4" Colour touch screen monitor. All parameters can be set and adjust by screen panel or handle job wheel right by. t. Installed with intelligent self-routing weld path software, automatically determined efficiency weld path once position of cells been set or Auto Cad drawing was inputed into the system.. s. SPC monitor [Statistical Process Control], both displaying real time historical charts of weld energy in "joules" and weld pressure in "Newton", switching between distribution chart and listorical Chart, weld quality of each point even whole pack are carefully monitoring and awaken 4. All weld data were stored as data base in the computer memory, files can easy transfer to other computer or mobile phone thought internet for further analysis or send report to customers in instant 5. Equipped with Bar code and QR code scanner, once assigned codes has been scanned into the system, weld data recorded according cells or packs. Quality can easy chasing even packs been sold For long time. 6. Functionally permitted extending machine work area, by add on an optional range extender "EX600 manual model" or "pneumatic model EX 600-P" on the X-Y table. Through the call out

. Weld Parameters Store And Recall

OPTIONAL ACCESSORIES.

1. AWS01 UNIVERSAL WELD HEAD WATER COOLER. [Add on weld head water cooler only suitable for model FS 1000-3012]. 2. WELD DATA CARRIER. [only necessary for FS1000-3012 and FS1000-4020 models without PC computer intergrading] Up and down loading weld set parameters from the machine to machine, or to PC, for extending storage and transfer control program. 3. EX-600 RANGE EXTENDER. Manual operation. [Only suitable for FS1000-4020 Plus and FS1200-40122 Plus computer Itergraded

- models].Add on range extender. Extending X axis travel from 400 to 600mm, By hand pulling, equipped with position sensors. Attachment for Multiple-welding .
- 4. EX-600p RANGE EXTENDER. [Only suitable for FS1000-4020 Plus and FS 1200-4020 Plus computer intergraded models]. Add on range extender, an attachment for Multiple-welding, both manual and pneumatic models are available. Extending X axis travel from 400 to 600mm, extending Y axis travel from 200 to 400mm by apply turn around welding
- 5. CN-3 ELECTRODE TIPS CLEANING TURRET. [Improper for Model FS 1000-3012]. Installed on top of XY platform, automatically carrying electrode tips cleaning, cycle time preset and operation control by main controller.

INTRODUCTION

There are two types of controller in FS 4020 family. Know as FC1000-5 and FC 1000-7 resistance weld power and coordinates controllers.

FC1000-5 is a stand along standard controller, it equipped with a 6" color LCD screen surround by key pads on the angle edges, where weld energies and running program can be set from the front panel. However, FC1000-7 is a computer intergraded controller, since it was linked up with PC computer, with compatible all computer relate functions, internet interference. Resultants direct reflect as quick access in programming, straight forward for setting and convenient in operation!

FC1000-7 built in with SPC [Statistical Process Control] Monitor, where welded readings are real time recorded and showing in both in numerical data and graphical charts simultaneously on the monitor screen. Besides, weld data can be transfer to other computers, through internet or internal WiFi for recording and further analyzing.

1. Patented "TOM" Technology

Built according company patented "TRANSFORMER OUTPUT MANIPULATION [TOM]" weld energy control theory, adapting with unique software and latest solid state power switching devices.



T full color LCD display with wide viewing angle and back lighting. Easy standing in screen graphics and instructions, similar to MS window rface, plus close surrounding key sets, data inputting is a very simple and ght forward way.

3. Simple On Screen Set Up..

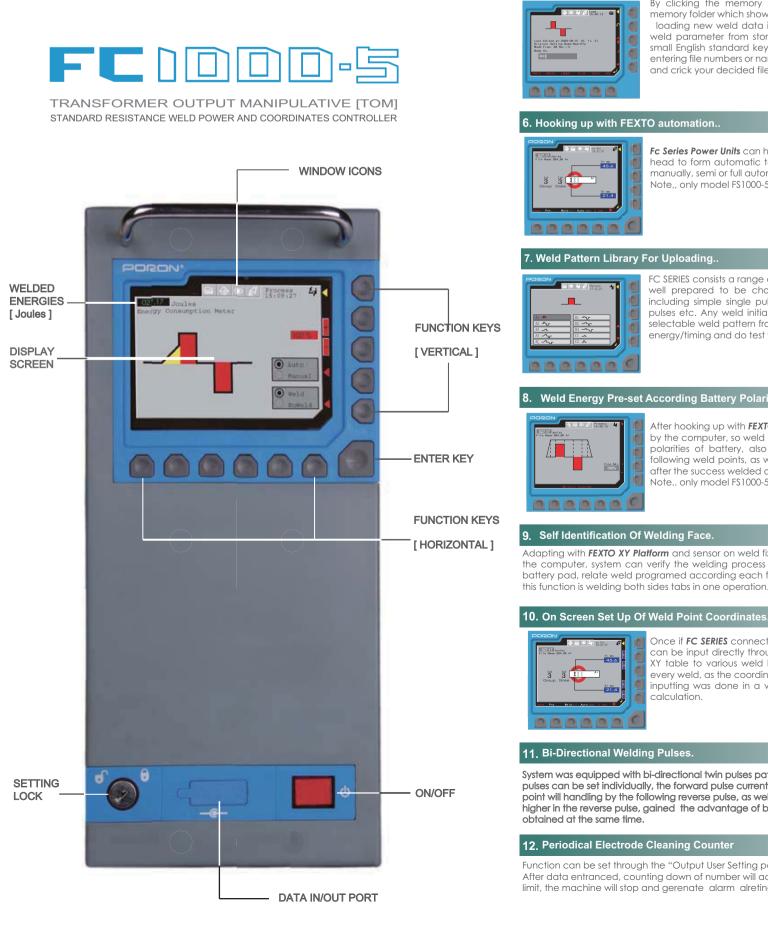
friendly on screen set up, each function folders are open thought sign ted on the left top corner on the screen, comments selection are jus chosen/press and opening. In pattern or set up folders, every weld ern was separated and divided into several segments, only two weld eters needed to be consent. Traveling between portions is just goggling nt two assigned keys besides the panel. These simplicity in design make lignments done in a very clear and straight forward way, even unskilled er after short training can fully handle the job.

4. Weld Energy Monitor Built-in.



ulate the energy for each weld in Joules, this feature indicating change nergy. Joules for every weld was calculated and converted as graphically a point and shows on the color screen, it was also advernized within the per and lower limits, once exceeded or out off the range, warning alarm rate at the same time temporally terminate the following processes lution been obtained. Under weld energy monitor mode, management are allow to read number of fault welds and defective percentage direct the machine color screen. naging staff can direct read the analysis report from the screen, or an

nal USB DISK [Part No..301-0-102] are recommended, this device can down load a certain amount of weld data direct from the front USB socket, by the helps of enclosed software running in the PC, customer will fully understand weld history recorded for the production lots, including defective rate, faults distribution, etc, which is a powerful tooling for weld quality control and weld



THICK TAB MODELS	
WELDING PURE NICKEL OR NICKEL PLATED TABS V	WITH DIMPLES
THICKNESS UP TO 0.4MM. STANDARD	
FS 200-4020 CONTROLLER	
STANDARD MODEL- 10000A output weld current, Portal frame drive weld head. X-Y travels 400X200 mm.	motor
COMBINATION	
1. FC 1000-5 "Transformer Output Manipulation"	
10000 amperes weld power and control [input	
220VAC, 13-15 Amperes]	1 Unit
2. TN-1200 weld transformer [maximum output current 12000 amperes]	1 Unit
3. ELE BS-7 spring loaded AC servo motor drive weld head	1 Unit
4. FEXTO XY-4020 two axes AC servo platform	1 Offic
travels 400 x 200 mm]	1 Unit
5. FEXTO servo S-3 two axes AC servo driver	1 Unit
6. MF 132 weld energy enhance power bank	1 Uint
7. 2.0 / 3.0 diameter elecrtodes and holders	1 Set
8. AWS01 recyclying weld head water cooler	1 Unit
9. WS-6 portal frame work bench and hangers	1 Unit
FS 200 - 4020 INTERGRATED	
COMPUTER INTERGRADED MODEL. 1200A output weld curr motor drive pressure sensing weld head, X-Y travels 400X200 m with intelligent weld path self programming soft ware. SPC monit	nm. Equipped
COMBINATION	
1. FC 1000-7 "Transformer Output Manipulation"	
10000 amperes weld power and control [input	
220VAC, 13-15 Amperes]	1 Unit
2. TN-1200 weld transformer [maximum output current	
12000 amperes]	1 Unit
3. ELE BS-8 spring loaded AC servo motor drive weld head [equipped with pressure sensors and video camera]	1 Unit
4. FEXTO XY-4020 two axes AC servo platform	1 Offic
travels 400 x 200 mm]	1 Unit
5. FEXTO servo S-3 two axes AC servo driver	1 Unit
6. MF 132 weld energy enhance power bank	1 Unit
7. 2.0 / 3.0 diameter elecrtodes and holders	1 Set
8. Equipped with PC computer, adapting 14" touch panel	
color screen, running Window 7 software.	1 Set
 SPC2 (Statistical Process Control) monitor *Built in with PC computer, internet configuration. 	1 Unit
*Both showing weld energies [Joules] and weld pressure	
[Newton]	
*Out put data to other computer through internet.	

10. AWS01 recyclying weld head water cooler 11.WS-6 portal frame work bench and hangers 12 Bar code and Or code scanner

of "multiple-welds" programming, easily increased original weld area from 400 x 200mm to 400 x 600mm. which is in the range of EV power pack applications!



EX-600 RANGE EXTENDER

1 Unit

1 Unit

1 Unit

INTRODUCTION AND FEATURES

Modern industry places growing emphasis on agility, the need for systems with flexibility at scales not previously possible is becoming critical. As flexible automation can handle a wide array of manufacturing tasks with few configuration changes and little downtime, these benefits especially important for manufacturing plan which frequent changeovers of parts or firms handling small production lot sizes. FS4020 family automatic tab welding station is an ideal system by apply reprogrammable processing. computer coordination of cycles to enable the simultaneous production of different type of batteries with minimum on-line setup time and costs. The power system of our tab weld station was designed according one of company patent, technology "TRANSFORMER OUT PUT MANIPULATION [TOM]". It is a brand-new welding control theory which invented by our R&D team at 2005. latest and reliable high energy control method adapted to resistance welding.

There are two kind of controllers for FS 4020 family, an economic type with basic functions is FC 1000-5 standard weld power and coordinates controller. It equipped with resistance weld power unit enclosed a 6" color LCD panel, weld energies set up and XY travels can be adjust and set accordingly through in screen and surrounding keys. if system hooking up with TN1000 weld transformer [model FS1000-4020]. Energies enough to weld tabs up to 0.2mm in thickness. Once equipped with MF 132 power bank and TN 1200 weld transformer, [model FS1200-4020]. Can easily manage tabs with weld dimples up to 0.4mm. Another advance controller is FC1000-7 intergraded with computer, as the system is intergrading with industrial grade computer. Except consists all powerful functions of PC computer and transfer data to the internet, it also built in with SPC [Statistical Processes Control] weld monitor, where weld data can be instantly in process monitoring, recording and alerting once with false weld. Besides, it equipped with in head weld force sensors, positioning camera, hand held bar and Qr code scanner, installed with EasyPro V1 software, those facilities providing superiority both for easy/ quick programming as well as in operation.

Weld data can easy transfer through internet by in line or WIFi connection, readings are recorded in data base format, which easy manage by Excel or other softwares, or hocking up with ERP system, to chase and analyses according codes assigned on each pack even every cell !. There are also two intergraded models, FS1000-4020 Plus is suitable welding thin tab under 0.2mm, however, FS1200-4020 Plus is ideal for handling thick

tabs with dimples up to 0.4mm. Factory set of welding speed is 0.75 sec/ weld, including move timing of XY travels, referring to the standard, machine efficiency or daily production rate of 8000-10000 cells /shift of 8 hours can be easy been obtained!

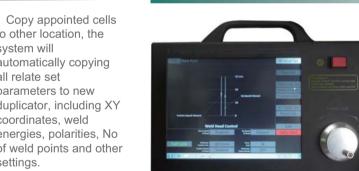




- 1. Patented "TOM" advance technology 2. Ergonomically design both for performance and appearance.
- 3. Full color graphical display.
- 4. Simple on screen setting up.
- 5. Weld energy monitor built-in. 6. Weld patterns library for uploading
- 7. Weld perimeters store and recall.
- 8. Bi-directional welding pulses. 9. Pre-check function.
- 10. Weld Monitoring
- 11. Fine forces weld head with rapid ollowing up. 12. Spring loaded motor /ball screw pressure actuating system. 13. Computer intergraded models are internet interfacing.
- Real time data easy In/Out put through in line or WiFi
- connection.
- 14. Weld energies set various according battery polarities and joint location. 13. Large working platform.
- 14. Tuning screw throat alignment with clearance fine tune.
- 15. Production flexibility.
- 16. Single phase power source.



Weld Head Set Up Window



Motion of weld head can be set through this window, including up/down speed. cushioning softness and activating distance Appropriate adjustment will increase production efficiency, as well as reduce exceed impact damage!

Face Set Window

Copy Window



setting window, inside where "Shift Set"." User Set", "Camera Set, "Finalization" "Dxf Import" can be set accordingly, even enter into Operation Mode

Copy appointed cells

to other location, the

automatically copying

duplicator, including XY

energies, polarities, No

parameters to new

coordinates, weld

system will

all relate set

ettinas

Face set is a main can be find there.

FILE AND

ORIGIN

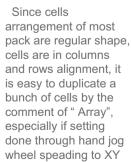
DISPLAY

AREA

Array Window



Auto Routing Window



Once cells location

generate all possible

letermined, the system

running paths according

the assignment. As well

routes on the screen.

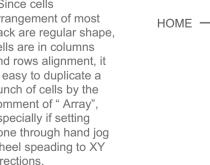
Operator can select a

desire path to weld the

as showing welding

been inputted and

will automatically



CONTROL OPTIONS VARIABLES

~~~~~~~~

## Group Set Window



"Group Set" composing all joints set up on each cell face. Determine No of weld joint to be weld, ioints aperture, and energies set various according weld position and sequence. The ombination assigned as Group" and can be set as



eries Power Units can hooking up with Fexto XY Working Platform and weld d to form automatic tab weld station, where tab weld can be done by ually, semi or full automatically. Details please refer to relate catalogues. e,, only model F\$1000-5 Fexto are availiable.

cking the memory store or recall sign icons, entered into machine older which shows also on screen, this two folders are assigned for up

ding new weld data into memory for long term saving or down load old

d parameter from storage for further processing. During data storing, a

I English standard key pad will appear on the bottom of the screen for

g file numbers or name, however for file down loading, just simple select

consists a range of weld patterns storing inside the library, they were prepared to be chosen for adapting in different weld applications ding simple single pulse, pre-weld pulses, up/down slope, bidirectiona es etc. Any weld initial set up, technician are allow direct down load a table weld pattern from the machine memory, after simple alignment of gy/timing and do test welding, quality joints can be easy been obtained.

### Weld Energy Pre-set According Battery Polarities And Weld Loca

crick your decided file name for opening.

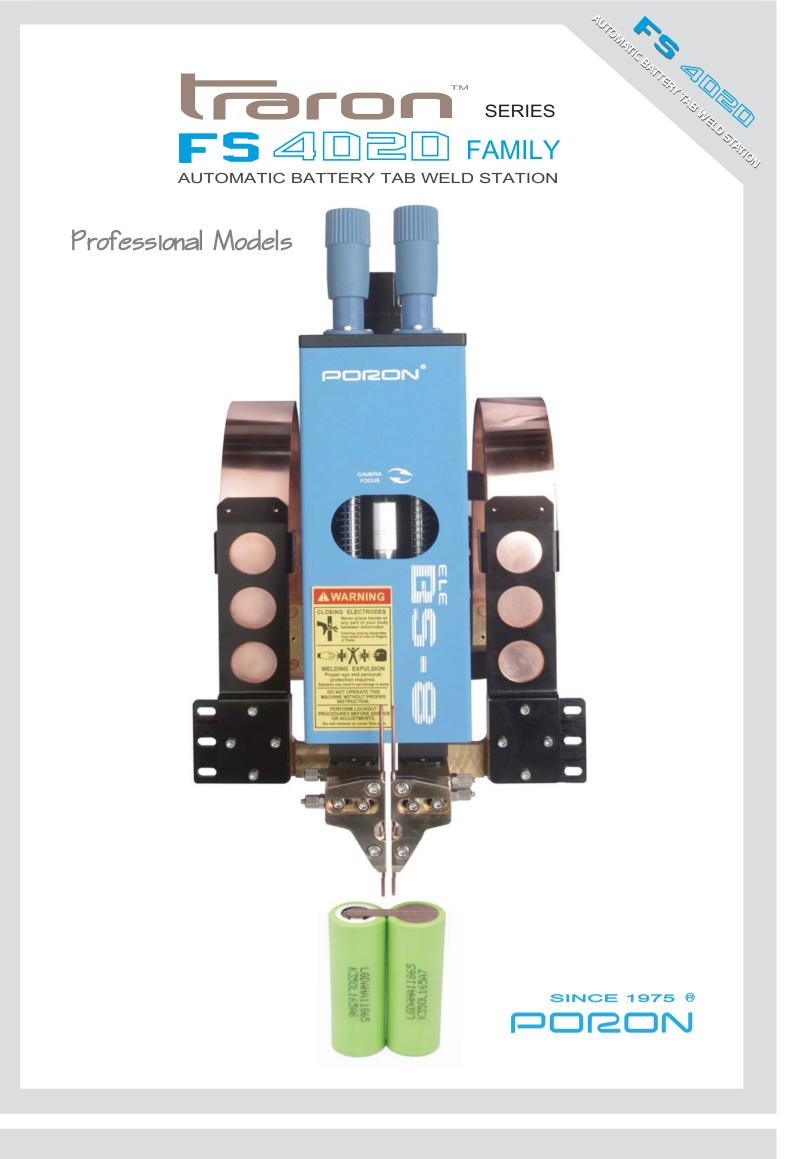
ooking up with **FEXTO XY platform**, as the whole operation is controlling e computer, so weld energy can be set differently according +ve or -ve rities of battery, also an increment of energy is allow added to the ving weld points, as welding current is already by pass by weld nuggets the success welded of the first point only model F\$1000-5 Fexto are available.

Adapting with **FEXTO XY Platform** and sensor on weld fixture, once face identification signal was input into the computer, system can verify the welding process is taking place on the top or bottom face of the battery pad, relate weld programed according each face will instantly call out to do the weld. Benefit of

if FC SERIES connected with FEXTO XY Platform, weld point coordinate be input directly through the control panel, by pressing keys moving the

ble to various weld locations, step by step inputting weld positions of weld, as the coordinate input was designed as " see than set ", so data tting was done in a very straight forward way without any arithmetical

#### System was equipped with bi-directional twin pulses patterns, also weld parameters and direction of weld pulses can be set individually, the forward pulse current only taking care to weld the first point, another point will handling by the following reverse pulse, as weld energies can be set seperately and pulling higher in the reverse pulse, gained the advantage of bi-directional weld, quality and clean can be easily



## PC COMPUTER INTERGRADED CONTROLLER

#### Weld Set Up Window



Once weld pattern been selected, entering this window to set all weld parameters, like weld energies, welding time, hold and post times etc, Since settings in this window are particular important for obtaining reliable

#### Finalization Window



#### Weld Pattern Window



#### Camera Window



### Move and Flip Window



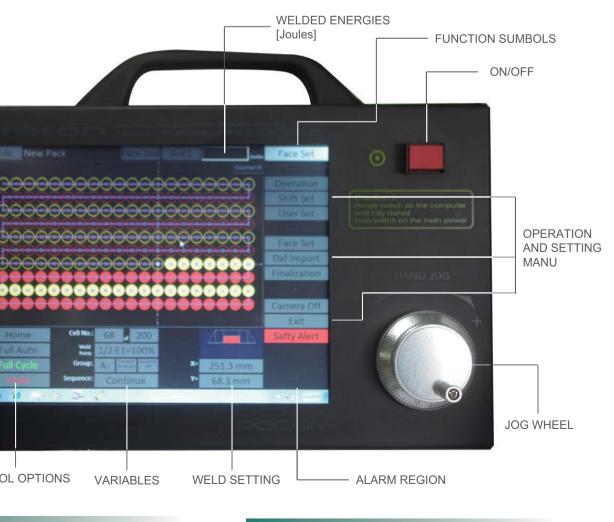
After cells coordinates and weld parameters has been set, programming will enter -inalization " window for further setting up. Where Auto Route, Change Polarities, Weld Direction, and Deleting etc functions can be individually be apply

There are total 9 weld patterns in the library, which consist pulses of "Mon-direction" "Bi-direction" and Multi-pulses" also with "Up-slope" to reduce over sparking! Careful selection according design and tabs various or obtaining superior welding result.

4020 Plus models equipped with positioning camera, which provide convenience for weld points alignment! Once camera been activated, 200% enlarged view will shows on the monitor screen, any deviation of weld point can perfectly be correct

#### Under "Copy" comment, all cell set up can be copy individually even whole combination to other location. duplicator including all data been set initially. "Filp" change welding direction, it is useful comment to adjust direction of running path

sequentially.



#### SPC Monitor Window



SPC "Statistical Process Control" Monitor. monitoring weld parameters during processing, including total weld energies "Joules" weld pressure "Newton" showing both numerical readings and Charts. With olerance set as Go / No Go and warning alarm once un-normal.