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Control unit TE90 Mark II

TE 90 is a microprocessor welding control unit for single-phase resistance welders. The welding control unit is used to control the welder parts and, in particular, the thyristor regulating the welding current. The working cycle carried out by the TE 90 is described through the programming parameters. The TE 90 can be used for both manual and pneumatic-operated welders.



MAIN FEATURES

- Synchronous thyristor drive.
- Phase shift control for welding current adjustment.
- Simplified programming by means of four push-buttons.
- Twin presetting for time and current, recallable by two independent controls.
- Slope and pulse functions.
- Single and repeat operating mode.
- Secondary current compensation function for welding of oxidised sheets and rods.
- Autoretain disabling for manually operated welders.
- First phase shift delay adjustment. It enables the machine line current best balance.
- Control of solenoid valve 24 Vdc 7,2 W Max with protected output against short circuits.

PROGRAMMABLE PARAMETERS

PARAMETER	RANGE
SQUEEZE	01 - 99 cycles
WELD TIME	01 - 99 cycles

CURRENT	00 - 99 %
HOLD	01 - 99 cycles
OFF TIME	01 - 99 cycles
COMP. OFF / COMP. ON	00 - 01
SINGLE / REPEAT	00 - 01
WELD TIME 2	00 - 99 cycles
CURRENT 2	01 - 99 %
SLOPE	00 - 29 cycles
COLD	01 - 50 cycles
IMPULSE NUMBER	00 - 09

Specifications subject to change without notice.