



MICROPROCESSOR WELD CONTROL

NASH - 815 V / H

- Simple operation
- 15 Programs
- Single & Dual Gun operation
- Multiple Heats & Pulsation
- Password Protected
- Constant Current
- Primary and Secondary Feedback
- Force Test Function
- Solenoid short error
- Current tolerance
- Built in Spot, Job counter, Tip Dress & Tip Change Counter
- Proportionate Valve Output
- PC Connectivity



Features

LED Display, Simple operation can be programmed easily.

Controller can be configured with only 7 keys

With the help of Large Display panel **Set Parameters and Monitored Data** can be continuously viewed which helps operator manage the welding process.

Error number will be displayed on the Display panel along with error alarm.

Description of the error code is mentioned on the face plate which helps operator resolve the problem instantly.

Solenoid short circuit detection with error.

Force Test Function.

Interlocking between two controllers.

Combination of constant current and voltage compensation.

To achieve high quality weld in Zinc coated sheets. Combination of constant current and voltage compensation is available.

Multiple heats and pulsation are also available.

Program memory of upto 15 programs / channels to set different welding conditions.

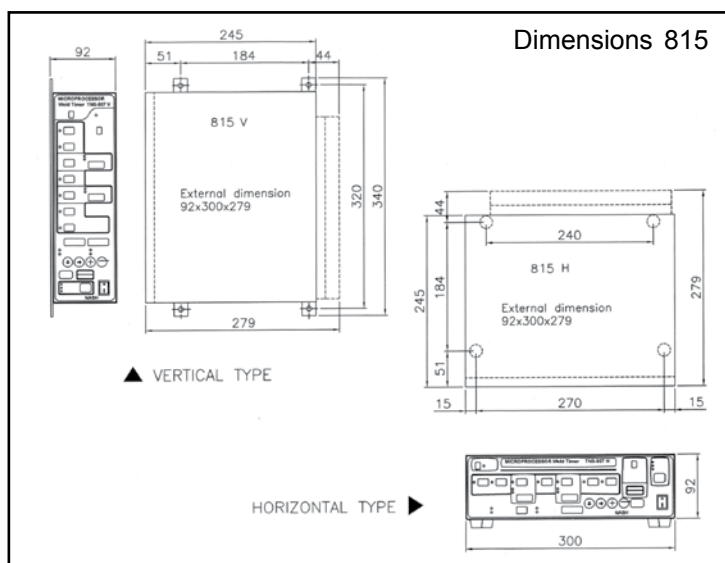
Suitable for Spot & Projection

Built in Spot, Job counter, Tip Dress & Tip Change Counter

2 separate Displays for Spot & Job count, this helps to monitor production quantity at any given time.

High lift toggle and non toggle selection.

Features	Parameters	Specifications
Standard Features	Programs / Channels	15 Channels/Programs
	Squeezing Solenoid	2 output
	Heating time	2 Steps
	Sequence step	6 Steps
Time set	Heating time -1/-2	0-99 cycles
	Setting range of other parameters	0 - 99 cycles
	Pulsation Control	0-99 times
	Current up-slope	0-29 cycles
Current Controls	Welding current (Secondary)	2.0-49.9kA (2.0-80kA High range application)
	Constant current response time	0.5 cycles
	Voltage compensation response speed	0.5 cycles
	Constant current/voltage compensation control	Equipped
	Current Detector Coil	NASH - WDC 550
Monitoring Function	Constant current monitor	0 to 50% of current set
	Full-heat check	Under voltage compensation
	Water flow check	Thyristor input
	Welding power presence	Monitoring Welding Power
	Thyristor short-circuit detection	Welding power presence
	Solenoid short circuit detection	
	Counter Enable Input	
Counter	Spot Counter	0-99 units
	Job counter	0-9999 units
	Tip Dress Counter	0-9999 units
	Tip Change Counter	0-9999 units
External Input/output	Heating interlock output	Solid-state circuit
	Weld OK	One make-contact
	Alarm Output	One make-contact
	Controller Ready Output	One make-contact
Data Storage	Non-volatile memory	Data stored for 45 years
	Operation temperature	0-45° C
Ambient Condition	Storage Temperature	- 10 - + 60° C
	Allowable Humidity Range	45-85% RH (without condensation)
	Control Power	110/220/415AC+10%/-15%, 50/60Hz, 30 VA (voltage selectable in plug Connection)
Power Supply	Welding power	220v/440AC+10%/-20%,50/60 Hz
Dimensions	Vertical (Wall mount) type	W90 X H300 X D275mm
	Horizontal type (bench-top)	W300 X H90 x D275mm
Net Weight		4.7 kgs



Thyristor Contactor



NASH reserves the right to change specifications and appearance without prior notice.

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