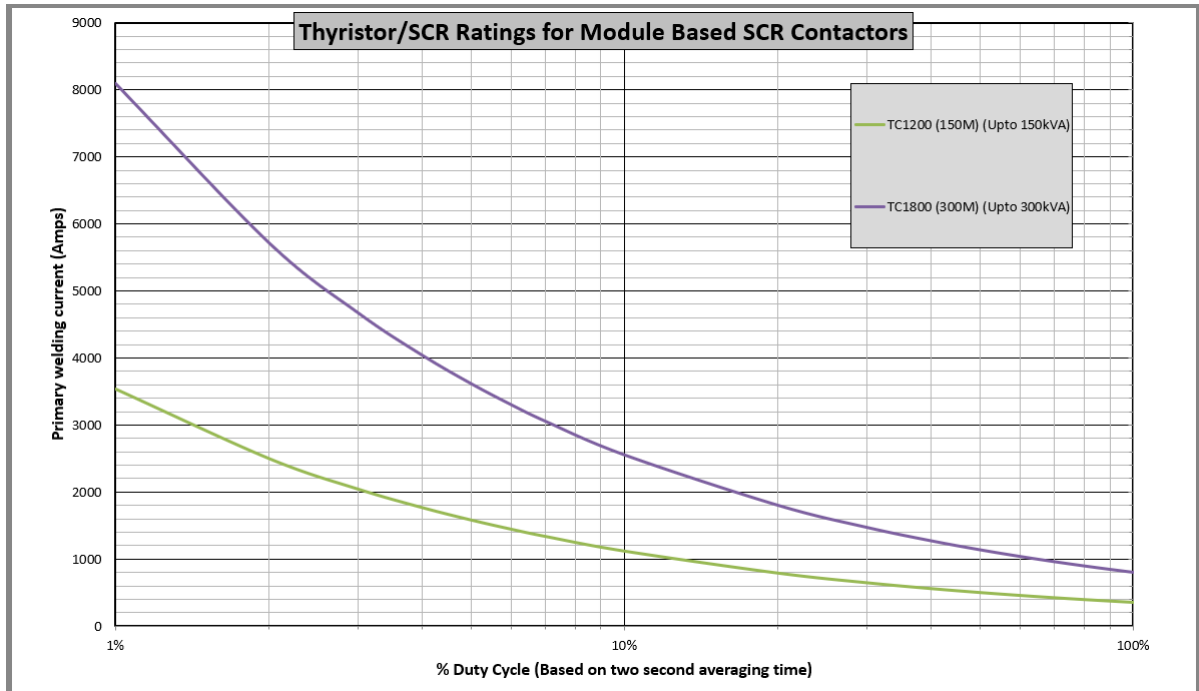




Water Cooled Module based SCR's



Two second averaging time (2000 ms) = 100 cycles @ 50Hz

Two second averaging time (2000 ms) = 120 cycles @ 60Hz

Important notes

a. Water cooled SCR's

- i. TC1200A (150M) and TC1800A (300M) are water cooled, the minimum flow rate should not be less than 1.3 US Gallons (5 litres) per min when used in spotwelding applications.
- ii. If used in seam welding applications the TC1200 (150M)150, TC1800 (300M) should be cooled at a flow rate of not less than 2 US Gallons (7.5 litres) per min.
- iii. (7.5 litres) per min.
- iv. Maximum inlet water temperature should not be more that 30°C (86°F).

b. Duty cycle Definition

The % duty cycle is defined as the total number of milliseconds of current flow (weld time) during the worst case two seconds.

$$\text{Duty cycle \%} = (\text{Total milliseconds of Weld}/2000) \times 100$$

Note

1 cycle @ 50Hz = 20 milliseconds

1 cycle @ 60Hz = 16.66 milliseconds