



Low cost resistance
welding control

MTR



Cost effective – Simple to use – Flexible

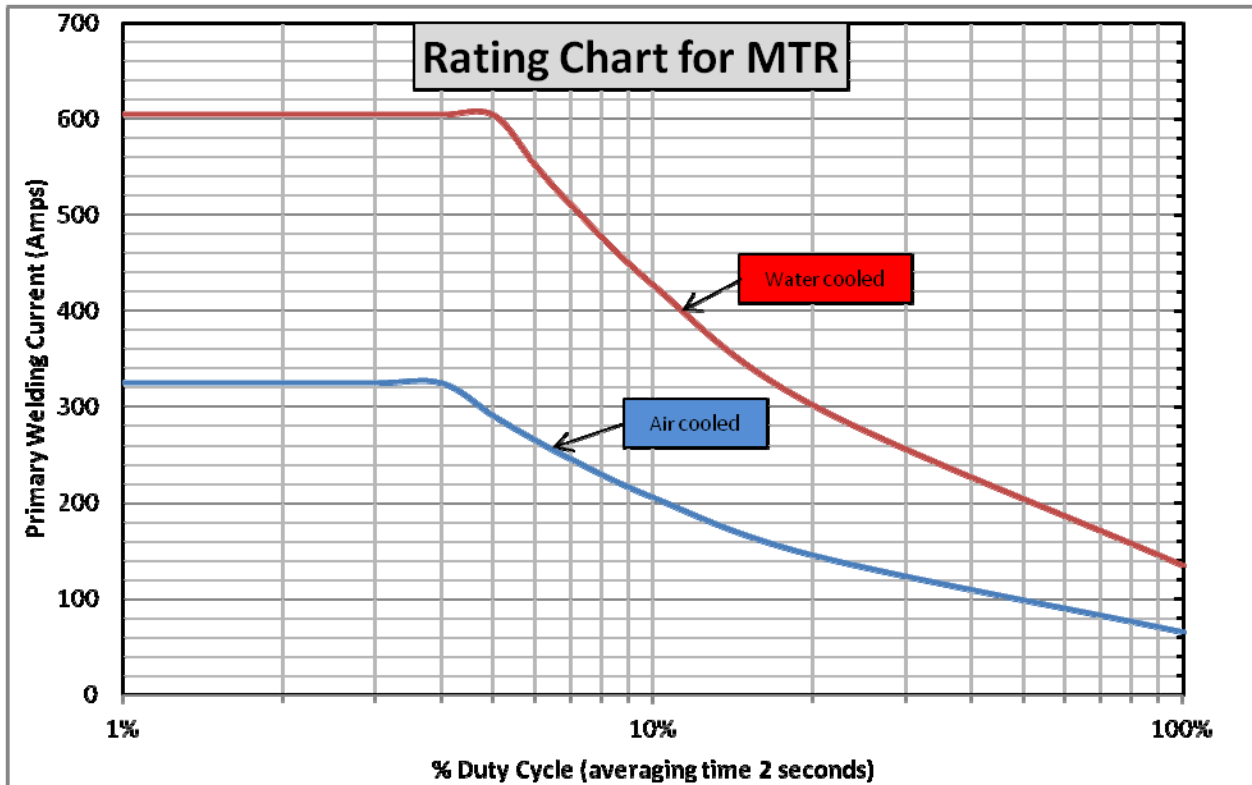
The MTR has been designed as a low cost welding control system intended for customers who are working on a tight budget but require a high degree of accuracy. A comprehensive and easy to use set of features are built into a very compact package. The inherent flexibility of the MTR allows it to be used in a wide range of applications including poke guns, spot welding, projection welding, seam welding and bench welding applications. The MTR has an integrated programmer and SCR rated for applications of up to 50kVA.

Programmable parameters	Range of values
Mode	Single or Repeat.
Heat 1	0-99% Percentage of available heat range.
Heat 2	0-99 % Percentage of available heat range.
Presqueeze**	0-99 Time in cycles.
Squeeze	0-99 Time in cycles.
Weld 1	0-99 Time in cycles.
Cool 1	0-99 Time in cycles.
Weld 2	0-99 Time in cycles.
Cool 2	0-99 Time in cycles, period of time between pluses of Weld 2 when pulsation is used.
Pulses (Pulsation)	1-9 Number of repeat pulses of Weld 2 in the weld sequence.
Hold	0-99 Time in cycles.
Off**	0-99 Time in cycles.

General features	
Up to 8 programmes.	Low cost.
Repeat Operation.	Integrated programmer.
Single Operation.	24VDC inputs and outputs.
Seam Mode up to 10kVA maximum. (Available as a software option). Note the SCR must be water cooled	Counter with optional sequence lock, can be used as an aid to electrode management.
Integrated SCR up to 50kVA at 20% duty cycle. (with water @5ltr/min)	Easy installation and use.
Integrated SCR up to 25kVA at 20% duty cycle. (without water)	

Electrical specifications	
Mains voltage	110,120,220,240,260 volts AC or 380,415,440,480,500 volts AC
Mains frequency	50 Hz or 60 Hz
Duty cycle	100% up to 10 kVA or 20% up to 50 kVA –see chart over
Load	50 kVA maximum
Number of digital inputs	2 rated at 24 V DC < 10 mA (1 dedicate to initiation)
Number of digital outputs	2 rated at 24 V DC < 500 mA (1 dedicated to WAV)
Max ambient air temperature where applicable (with air cooled SCR)	35°C (95°F)
Max inlet water temperature where applicable (with water cooled SCR)	35°C (95°F)

**Note: these parameters will only appear if the mode is set to repeat.



Note: Duty cycle definition

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

Duty cycle% = (Total milliseconds of weld / 2000) * 100

Dimensions:

