

The time for heat up with full power and the time for hold the temperature with the pulse-pause proportion, can be programmed in the SPC of the machine control unit. The control signal from the SPC to the TSRLF is a logic signal. The pulse-pause proportion can be variate until the end of the welding cycle.

_____ one welding cycle _____

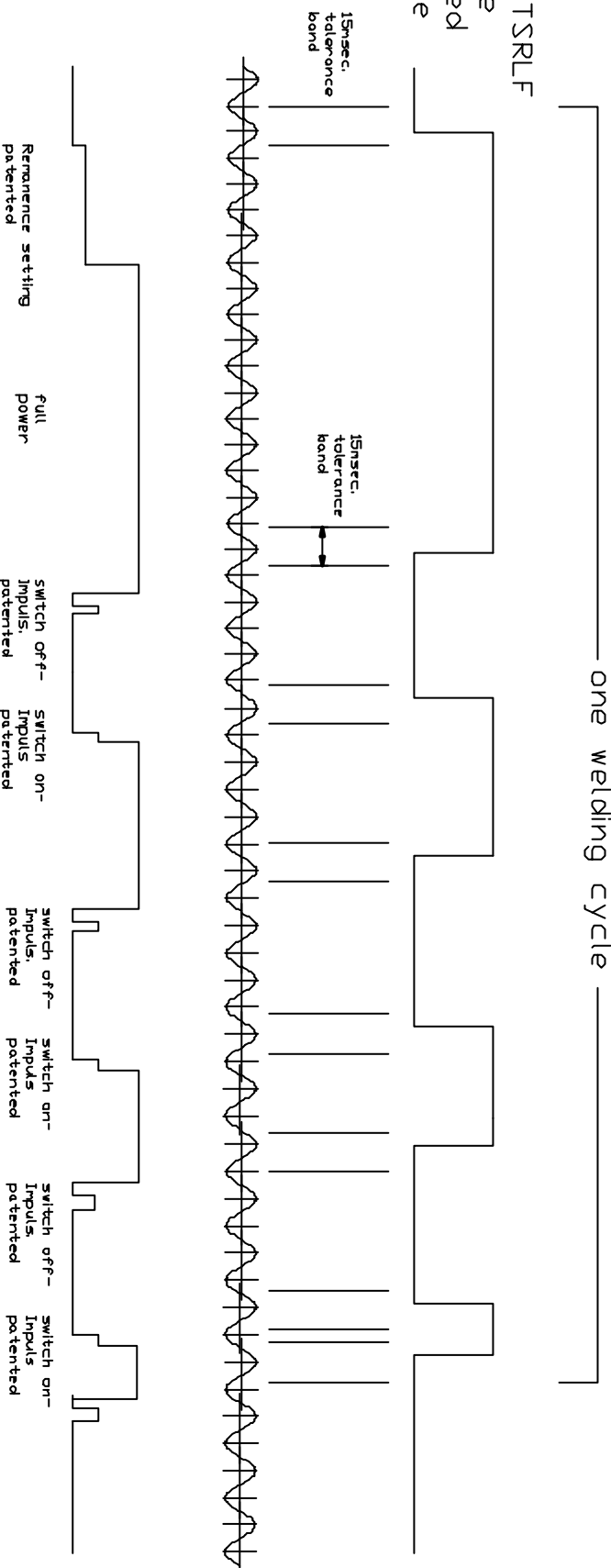
Signal to TSRLF should be synchronized to the line voltage

Line-voltage

el. power of heat wire.

State

Transformer Voltage and current at primary Side, = Power



Impswl1e.dwg Impulswelding with TSRLF with "sonderprogramm" for fast stryke of a Transformer. Drawed from EMEKD Ing. Büro Freiburg 20.05.02