

SOLUTION CONTROL TECHNICAL DATA SHEET #3 CONSTANT CURRENT AND PROGRAMMED CURRENT MONITOR/WINDOW OPTION #9181-22A AND #9181-22B

For SOLUTION controls (available for SOLUTION-2 controls on request *)

This option provides an easy to use and very accurate closed loop CONSTANT CURRENT function to SOLUTION controls. You can now set the required welding heat in **direct AMPS from a welding chart** and start production. The unique features of this system include:

- Works with up to **9 TRANSFORMER TAP POSITIONS** without the need to go through the setup procedure each time.
- Uses **AVC** (Automatic Voltage Compensation) even when in CONSTANT CURRENT mode to reach selected welding current within 2 line cycles.
- Value of current is entered **DIRECTLY** in actual AMPS on the 32 character display
- Can be switched from **CONSTANT CURRENT** mode to **CONSTANT VOLTAGE** mode (set in percent heat) with a few keystrokes on the keypad.
- **COMPARES** RMS current during entire weld against customer set windows for continuous quality control check of the weld, and displays the results for every weld. If the weld current is outside the customer set window, the SOLUTION tells you why, and in plain English - not codes.
- **SETUP** of system when first installed can be done in a few minutes using simple English language display prompts.
- **HOLDS** RMS current value to +/-1% of system range or better.
- Can be supplied with **PRIMARY** or **SECONDARY** current coils.

With UNITROL, all instructions on the display are in plain English. You can navigate through most set-ups and commands without looking at the direction book. It even tells you when to go to a higher or lower transformer tap switch position.

For SOLUTION and SOLUTION-2 controls:

This option allows the setting of upper and lower limits for current measurement on each weld. If the average RMS current measured during any weld is either **ABOVE** or **BELOW** the customer set window, the SOLUTION control will keep the electrodes closed, and the display will show the average RMS current measured during the weld. Measurements can be made on either weld transformer primary or secondary (order desired current pick-up coil). On SOLUTION-2 the fault can be assigned to one of three fault relays to signal an outside system of the problem.

*The HEAT STEPPER option #9281-15 is not available on SOLUTION-2 controls when this function is included.