

PLC-BASED Oscillator CONTROL

Features

- PLC based control for weld sequence and mechanical oscillation control in one box.
- Can be used as a "Stand-Alone" Oscillator control
- Easy-to-read 5.7" VGA TFT Color, 640x480 touch screen display
- User-friendly front panel layout
- Heavy-duty industrial pushbuttons
- Oscillator schedule or width change "on-the-fly"
- Programmable oscillator start delay time
- Joystick control for cross-seam adjustment with or without oscillation
- "Arc Start" outputs (maintained and momentary) for starting and stopping external welding equipment
- Can be integrated into a travel axis for controlling motion
- Weld Start/Stop

Programmed Sequence Functions

- Travel Speed
- Oscillator Screens
- Diameter
- Weld Timer On/Off
- Weld Counter on/off
- Weld Time
- Weld Distance
- Travel Start Delay
- Travel Stop Delay
- Pass Counter (For rotary applications only, Requires Limit Switch)
- Diameter (Positioners and Headstocks)
- Auto Torch Lift On/Off
- Torch Lower Time
- Torch Lift Time and Delay Time
- Return Home On/Off
- Home Delay Time
- Rapid Speed %
- Jog Speed %

Pandjiris' EZ Link[®] Series Delta Oscillator Controller is a user-friendly, PLC-based controller designed to provide flexibility for the operator. The EZ Link[®] Controllers put automated equipment control functions at your fingertips. Welding and motion functions are coordinated in an easy-to-use package.

EZ Link[®] Series Delta Oscillator Controller is similar to our EZ Link[®] Series controller except it has the additional capability to control our oscillator with a built-in Oscillator drive. The front panel layout includes a 5.7" VGA TFT Color (640x480 resolution) touch screen display. Custom-designed PLC program permits a wide range of programmed sequence configurations.

APPLICATIONS

The EZ Link[®] Series Delta Oscillator controller can be used for controlling a mechanical oscillator as a "Stand Alone" Mechanical Oscillator or for a dual purpose weld sequence controller / Mechanical Oscillator. A preset sequence setup menu allows for oscillator set-up screens and various other welding sequence features to be preset. The I/O is interconnected through internal isolated relays.

The EZ Link[®] Series Delta Oscillator Control provides almost all of the features of the Pandjiris EZ Link[®] Series controller, with additional oscillator control features.

Contact your local Pandjiris representative or our St. Louis office to find out how the EZ Link[®] Series Controller will make your life EZ'er!

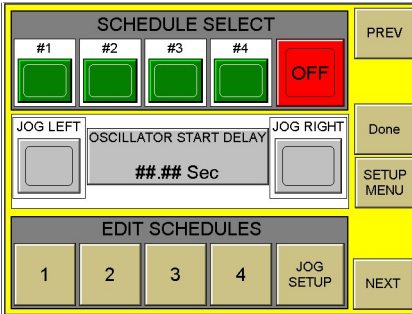


Specifications:

- PLC Based Control
- 115 VAC, 10 Amp Input
- Color Touch display, 640x480 pixels
- 16 Discrete Inputs (Internal PLC)
- 12 Discrete Outputs (Internal PLC)
- 1 Analog Output (Internal PLC)
- 2 Analog Inputs (Internal PLC)

Dimensions: 15-1/2" T x 13" W x 8-5/8" D

Delta Oscillator Control



Oscillator Setup Screen: Allows the operator to setup all and edit 4 oscillator sequence programs. F1-F4 keys allow the operator to switch to a different Oscillation Sequence “on-the-fly”. The “Oscillator Start Delay” parameter allows the operator to set a preset delay time from the arc start to the start of oscillation. Oscillator slide jog can be done with the joystick operator on the front of the control. If the “off” button is pressed, no oscillation will occur during the weld cycle.



Oscillator Schedule Setup: There are 4 Schedule Setup Screens. The one displayed is “Oscillator Schedule 1”. This screen allows the operator to set

Oscillation width .01" to 4.00"

Right and Left Dwell Time .02 - 9.99 sec

Speed 1.00 IPM to 120 IPM

Oscillator Slide Specifications:

Standard Duty Slide (GMAW, FCAW)

1. 51# @ 6" from face
2. Travel 3.937"
3. Slide Weight = 3#

HD Slide (SAW)

- 160# @ 6" from face
- Travel = 3.937"
- Slide Weight = 9 #

