

Technitron T6500 Series

Variable Frequency DC Inverter



300 and 2000 Amp Medium Frequency DC Welding System

The T6500 Series Variable Frequency DC Inverter is among a family of weld controls designed for the industrial market. The technology was developed and has been proven in the automotive industry where millions of welds have been made in a highly automated environment. The technology and reliability has now been designed and packaged for the industrial market.



Key Features

- Less power required over conventional AC weld controls
- Improves electrode life and secondary components
- Reduces primary energy cost
- Shorter weld times
- Closed loop, constant current control
- User friendly data entry panel
 - Weld schedule windows
 - Weld monitor windows
 - Upload/download windows
 - Fault windows
- Network Ready

Technitron T6500 Series

Variable Frequency DC Inverter



Specifications

Model	T6503	T6520
Line Voltage	480VAC 3 Phase +/- 15% 50/60Hz	480VAC 3 Phase +/- 15% 50/60Hz
Control Frequency	400 to 1200Hz Variable	400 to 1200Hz Variable
Primary Current Range	50 to 300A	50 to 2000A
Schedules	31	31
Pre-Squeeze Time	0.0 to 99.9 cycles	0.0 to 99.9 cycles
Squeeze Time	1.0 to 99.9 cycles	1.0 to 99.9 cycles
Up Slope Time	0.0 to 30.0 cycles	0.0 to 30.0 cycles
Weld 1 Time	0.0 to 99.9 cycles	0.0 to 99.9 cycles
Weld 1 Current	2.0 to 25.5 kA	2.0 to 200.0 kA
Down Slope 1 Time	0.0 to 30.0 cycles	0.0 to 30.0 cycles
Cool Time	0.0 to 99.9 cycles	0.0 to 99.9 cycles
Weld 2 Time	0.0 to 99.9	0.0 to 99.9
Weld 2 Current	2.0 to 25.5 kA	2.0 to 200.0 kA
Down Slope 2 Time	0.0 to 30.0 cycles	0.0 to 30.0 cycles
Hold Time	0.0 to 99.9 cycles	0.0 to 99.9 cycles
Off Time	1.0 to 99.9 cycles	1.0 to 99.9 cycles
Pulsation	1 to 9 times	1 to 9 times
Turns Ratio	4.0 to 200.0	4.0 to 200.0
Steppers	4 with 10 Steps	4 with 10 Steps
Current Rate	50% to 200%	50% to 200%
Count	0 to 9999 times	0 to 9999 times
I/O		
Inputs	11 (24VDC 10ma)	11 (24VDC 10ma)
Outputs	6 (24VDC 100ma)	6 (24VDC 100ma)
Valves	2 (24VDC 100ma)	2 (24VDC 100ma)
Monitors		
Current	0 to 25.5 kA	0 to 200.0 kA
Line Voltage	0 to 600 V	0 to 600 V
Fault / Alarm Codes	24	24
Operating Temperatures	23° to 113° F	23° to 113° F
Cooling Requirements	1.3 gallons/min at 86° or lower	1.3 gallons/min at 86° or lower
Dimensions (H" x W" x D")	28 x 28 x 13	53.25 x 29.50 x 18.25

Specifications subject to change without notification

Options

Model	T6503	T6520
Circuit Breaker	100 Amp	400 Amp
Isolation Contactor	Size 3	Size 5

Effective Date: July 2002
Data Sheet #: ML-00224 R1.2