



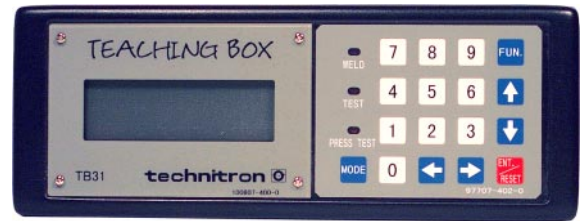
# Technitron T6804

## AC Inverter



### 400 Amp Medium Frequency AC/DC Welding System Uses Standard AC or DC Welding Transformer

Traditionally, if you wanted to go from AC welding to inverter technology, you had to rebuild the entire secondary to incorporate the small inverter transformer. Now with the T6804, there is no need to rebuild the machine. By changing only the control, you get all the benefits of an inverter with a conventional AC transformer.



#### Key Features

- Less power required over conventional AC weld controls
- Uses standard AC transformer
- Reduces primary energy cost
- Shorter weld times
- Closed loop constant current control
- User friendly Data Entry Panel
  - Weld schedule screen
  - Weld monitor screen

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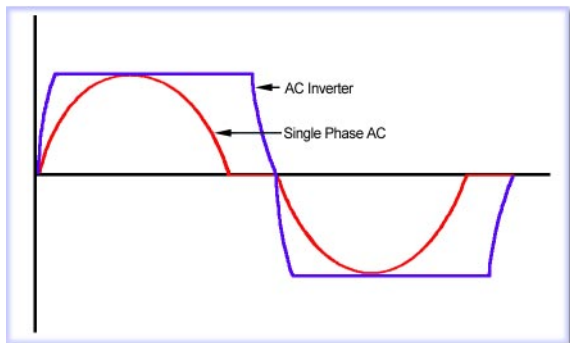
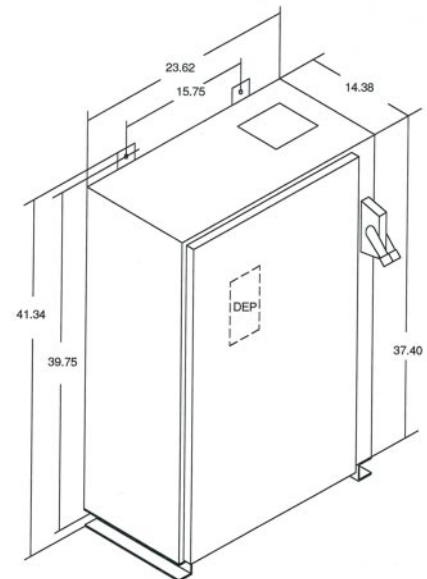
### Specifications

Line Voltage	480VAC 3-phase 60Hz
Control Frequency	400 to 1200Hz
Control Modes	AC or DC Inverter
Max. Primary Current	400 Amps
Schedules	15
Pre-Squeeze Time	0 to 99 cycles
Squeeze Time	0 to 99 cycles
Pressure Stable Time	0 to 30 cycles
Up Slope Time	0 to 30 cycles
Weld 1 Time	0 to 99 cycles
Weld 1 Current	2.0 to 25.5kA
Cool Time	0 to 99 cycles
Weld 2 Time	0 to 99 cycles
Weld 2 Current	2.0 to 25.5kA
Down Slope Time	0 to 30 cycles
Hold Time	0 to 99 cycles
Off Time	0 to 99 cycles
Pulsation	1 to 9 times
Turns Ratio	4.0 to 200.0 turns
Squeeze Pressure (Optional)	100 to 800kPa
Weld Pressure (Optional)	100 to 800kPa
Steppers	15 steppers with 5 steps each
Current Rate	50 to 200%
Count	1 to 9999
I/O	
Inputs	9 (24VDC 10mA)
Outputs	4 (110VAC/170VDC .1A)
Valves	2 (24VDC .2A)
Monitor	Current and line voltage of last weld
Operating Temperatures	23° to 113° F
Cooling Requirements	1.3 gallons/minute at 86° F or lower

Specification subject to change without notification.

### Options

- 100 Amp circuit breaker
- Size 3 isolation contactor
- 120VAC valve output
- Network Software Package



The comparison to the left shows the difference in the secondary current of an AC Inverter and conventional single phase AC. Because the AC inverter waveform does not cycle on and off through the cycle the AC inverter supplies more power in the same time allowing welds to be done with shorter weld times and even lower pressure. This gives better cosmetic welds and helps reduce tooling wear.

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