Computer Weld Technology, Inc.

MWC™
MODULAR WELD CONTROL

MWC™

The microprocessor based Modular Weld Controller is the main control module and provides all control and communication functions and can program external motion control axis via the Local Area network (LAN) port. The controller can support up to four stepper motor controlled axis, using the MSC-1000™ Micro-Step Controller, and four DC servo controls, using the DMC-1000™ DC Servo Controller. The MWC™ provides all external Input / Output control interface and electrical connections to user supplied components. The MWC™ consists of two major control systems. The first is a Programmable Logic Controller (PLC) and the second is the Modular Weld Control (MWC™). The PLC is the main controlling element and provides the interface between the MWC™ and the external I/O functions. The PLC is configured by using the terminal serial port. The user can define up to 150 sequences that will be executed by the specified switch inputs. The MWC™ control provides all of the weld control functions and can be programmed for up to 40 weld schedules via the terminal serial port or remote pendant port.

The following parameters are programmable:

- Prepurge Gas Flow Time
- Arc Start Parameter Time
- Arc Active Delay Time
- Ramp Up Time
- Weld Time (spot or manual)
- Ramp Down Time
- Crater Fill Time
- Wire Retract Time
- Burn Back Time
- Post Purge Time
- Pulse On Time*
- Pulse Off Time*
- Background Wire Feed Speed*

* For Pulse TIG Applications

FEATURES

- User definable configuration
- RS-232 Serial Port
- Flexibility to adapt to most solid state equipment
- Ease of set up

BENEFITS

- 40 Weld Schedules and 150 PLC Sequences are user programmable
- Permits off-line programming, system configuration and remote control
- Permits user to employ existing equipment in many cases
- Welding Parameters displayed while welding
- Automatically recognizes installed peripheral devices

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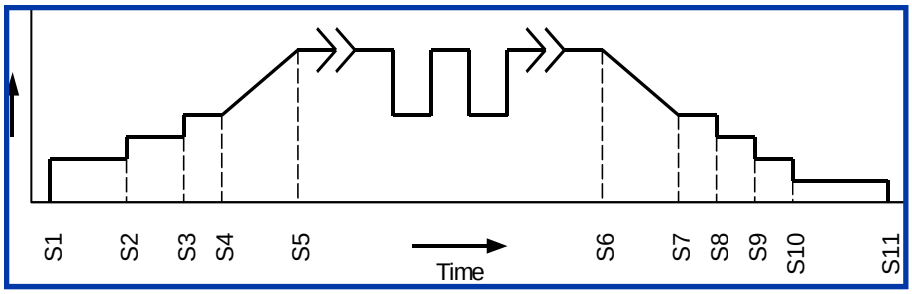
MWC™ SPECIFICATIONS

Weld Sequence Timed Events



Weld Sequence Events:

S1 = Cycle Start

S1 - S2 = Prepurge Gas Flow Time

S2 - S3 = Arc Start Parameter Time

S3 - S4 = Arc Active Delay Time

S4 - S5 = Ramp Time

S5 - S6 = Weld Time (spot or manual)

S6 - S7 = Ramp Down Time

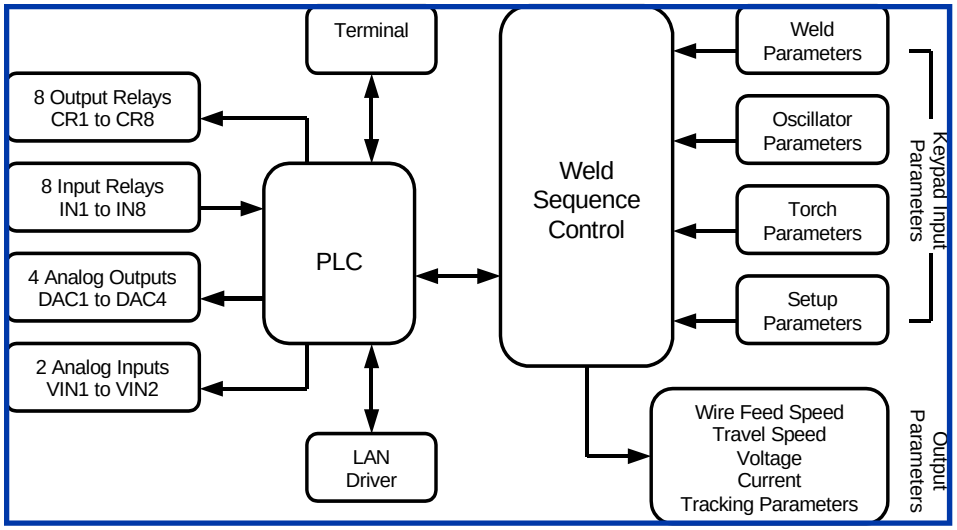
S7 - S8 = Crater Fill Parameter Time

S8 - S9 = Wire Retract Time

S9 - S10 = Burn Back Time

S10 - S11 = Post Purge Time

MWC™ Control System Diagram



MECHANICAL SPECIFICATIONS

Dimensions:	3.25” H x 13.25” W x 8.75” L (83mm x 337mm x 222mm)
Weight:	4.0 lbs. (1.8kg)
Power Input:	110 / 240 vac 50 / 60 Hz @ 8 amp
Operating Temperature:	-10°F to +140°F (-23°C to +60°C)

Note: Specifications subject to change without notice.

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