



- 127 welding programs
- Integrated programming unit
- Proportional valve control
- Sequence with 3 weld times
- Electrode wear compensation
- Electrode tip dressing control
- Ethernet connectivity
- Wide weld sequences:  
**CHAINED MODE, SUCCESIVE...**

### Working Modes

2

### Physical Characteristics

Hanging stations (number of weld programs)	MAN (127)	Dimensions (H x W x D)	202 x 134 x 49 mm
Pedestal welders (number of weld programs)	STA (127)	Weight	1,0 Kg
Robots (number of weld programs)	STA (127)	Working temperature	-5° to 60°

### Basic Functions

Max. number of power units	1
Communication network	Ethernet + TCP/IP
Control modes: constant current, current monitoring, firing angle	•
Electrode wear compensation through editabe curves	•
Sequence of 3 weld times	•
Log of the latest welds / Log of the latest error messages	512
Parameter storage without the need of battery back up	•

### Electrical Characteristics

Synchronisation	20 VCA
Frequency (automatic detection)	50/60 Hz
Power supply	24 VA +15%/-20%
Power rating	12 W

### Inputs - Outputs

Digital inputs (18...28V/10 mA)	18
Current measuring input (20÷2300 mV / kA)	1
Firing outputs (24 VDC / 1A, 5kHz pulses)	1
Digital outputs (24 VDC / 1A)	8

### Optionals

CPC-connect	Central programing software via Ethernet
SERRAstick	Memory stick for data log