



Transtig AC/DC 250 HF

Technical Notes

Specification

Transtig AC/DC 250 HF

Input

Voltage	220/380/415/440 VAC
Frequency	50/60 Hz
Phase	1 (2)
KVA	20 KVA
Rated Load Amps (415V)	41A
Recommended Fuse (415V)	60A

Output

Range AC/DC	8 - 320A
Duty 40%	250 - 30V
Duty 60%	200 - 28V
Duty 100%	160 - 26V
OCV AC	79V
OCV DC	72V

Controls

Post Flow	5 - 45 secs
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Dimensions (excl. undergear)

Length	762mm
Height	559mm
Width	406mm
Weight (net)	179 Kg

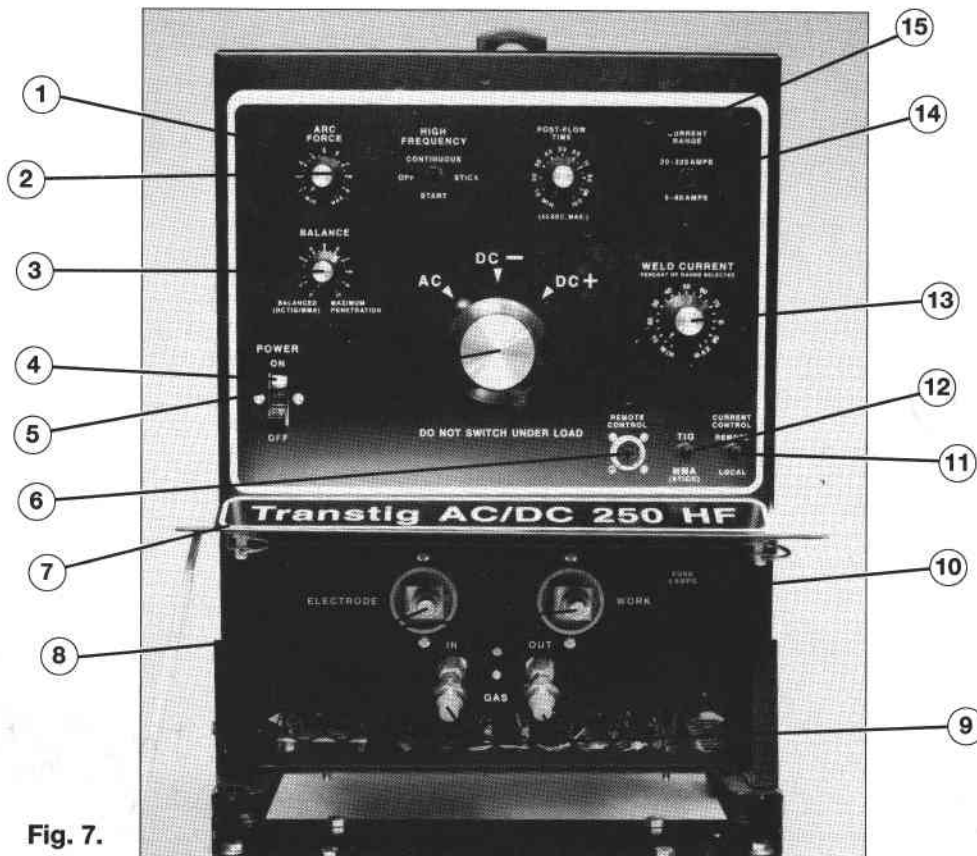


Fig. 7.

ITEM NO.	QTY	ELECTRICAL SYMBOL	PART NO.	DESCRIPTION
1	1	HFS	1415081	High Frequency Switch (on logic P.C.B)
2	1	AFP	1415080	Arc Force Potentiometer 10K 2w
3	1	BP	1415079	Balance Control Potentiometer 100K 2w
3a	1	R102	-	Resistor 1M ohm 1%
4	1	ROS	1415078	On/Off Switch DPST
5	1	CSS	1415076	Mode Selection Switch
5a	1	-	1415077	Switch Knob
6	1	P17	1413795	Remote Control Socket (12 Pin)
-	6	-	367972004	Control Plug Pins
-	1	-	368541003	Remote Control Plug
7	1	-	-	Terminal Cover
8	2	-	1415074	Output Terminal
9	2	-	1415072	Gas outlet 90°
9a	2	-	1415073	Gas outlet Adaptor 1/4" BSP
10	1	F1	1411873	Fuseholder 1 1/4" x 1/4"
10a	1	-	-	Fuse 5A 1 1/4" x 1/4"
11	1	PRS	1415071	Local/Remote Switch DPST
12	1	TSS	1415071	Process Selection Switch DPST
13	1	CCP	1415069	Weld Current Potentiometer 10K (on SCR P.C.B)
13a	1	-	1415070	Potentiometer Knob (Large)
14	1	SWI	1415068	Weld Current Range Switch DPST (on SCR P.C.B)
15	1	PFP	1415067	Post Flow Potentiometer (on logic P.C.B)
15a	3	-	1414954	Potentiometer Knob (Small)

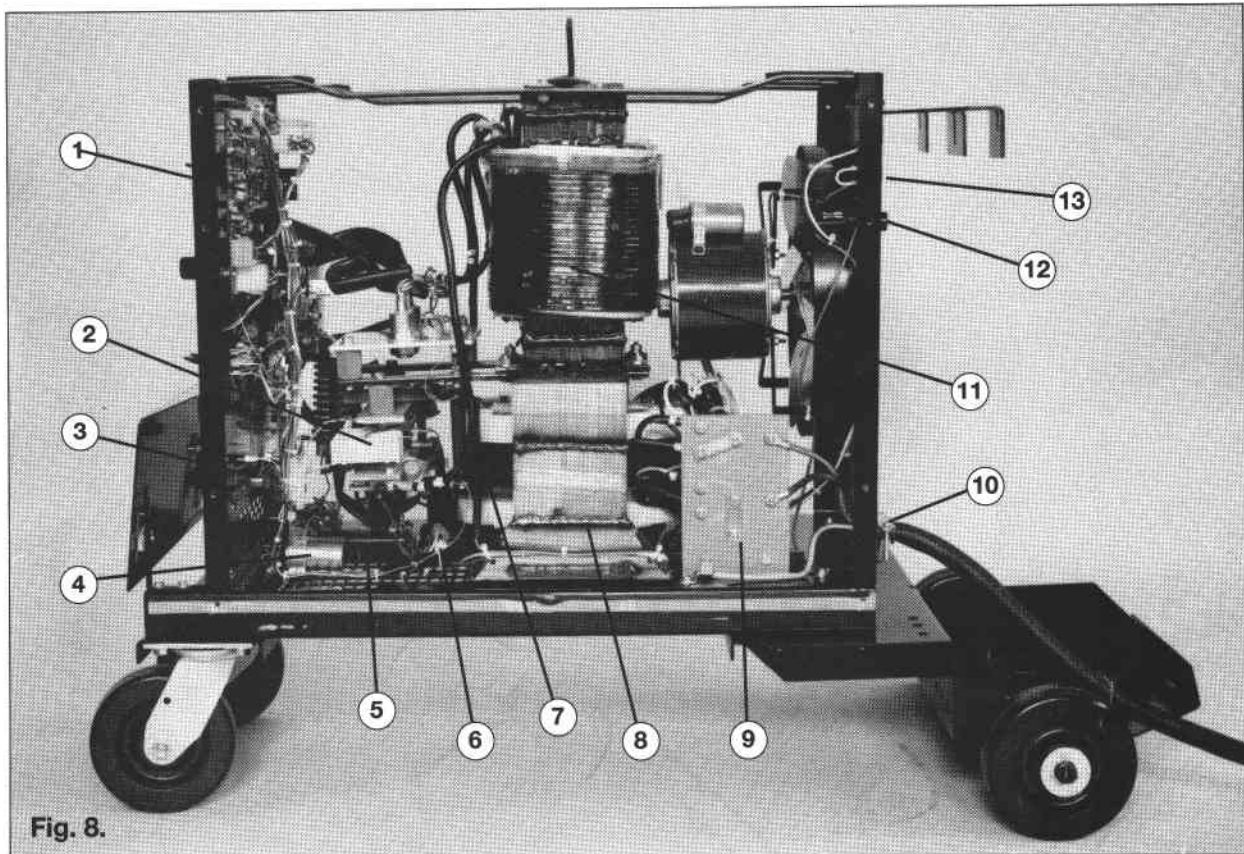


Fig. 8.

ITEM NO.	QTY	ELECTRICAL SYMBOL	PART NO.	DESCRIPTION
1	1	-	1415083	SCR Control P.C.B.
2	1	-	1415084	SCR Bridge Assy. (includes Items 2a, b, c, d)
2a	1	C1	-	Capacitor .02 mf, 1kv
2b	2	SCR-1 & 2	1414851	SCR Thyristor
2c	2	-	1415085	Filter Network
2d	1	TS3	1414888	Thermal Switch (SCR Bridge)
3	1	GSV	1414641	Solenoid valve 24v AC
-	1	R5	-	Resistor 470 ohm 2w
4	1	C8	1414637	Capacitor 10mf, 370v DC
5	1	R4	1415086	Resistor 10 ohm 50w (near side)
5a	1	R3	1415095	Resistor 150 ohm 50w (far side)
6	1	FN2	1415087	Filter Network
7	1	R6	1415093	Resistor 100 ohm 50w
8	1	MTR	1415091	Main Transformer
9	1	TB	1415092	Input Terminal Board
10	1	-	-	Input Cable Gland
11	1	HRTR	1415090	Reactor
-	2	TS1, TS2	1414610	Thermal Switch (included in item 8 and 11)
12	1	CB	1415089	Circuit Breaker 15 amp
13	1	J3	1415088	Auxiliary Power Socket (115v AC) - 1414987 Plug

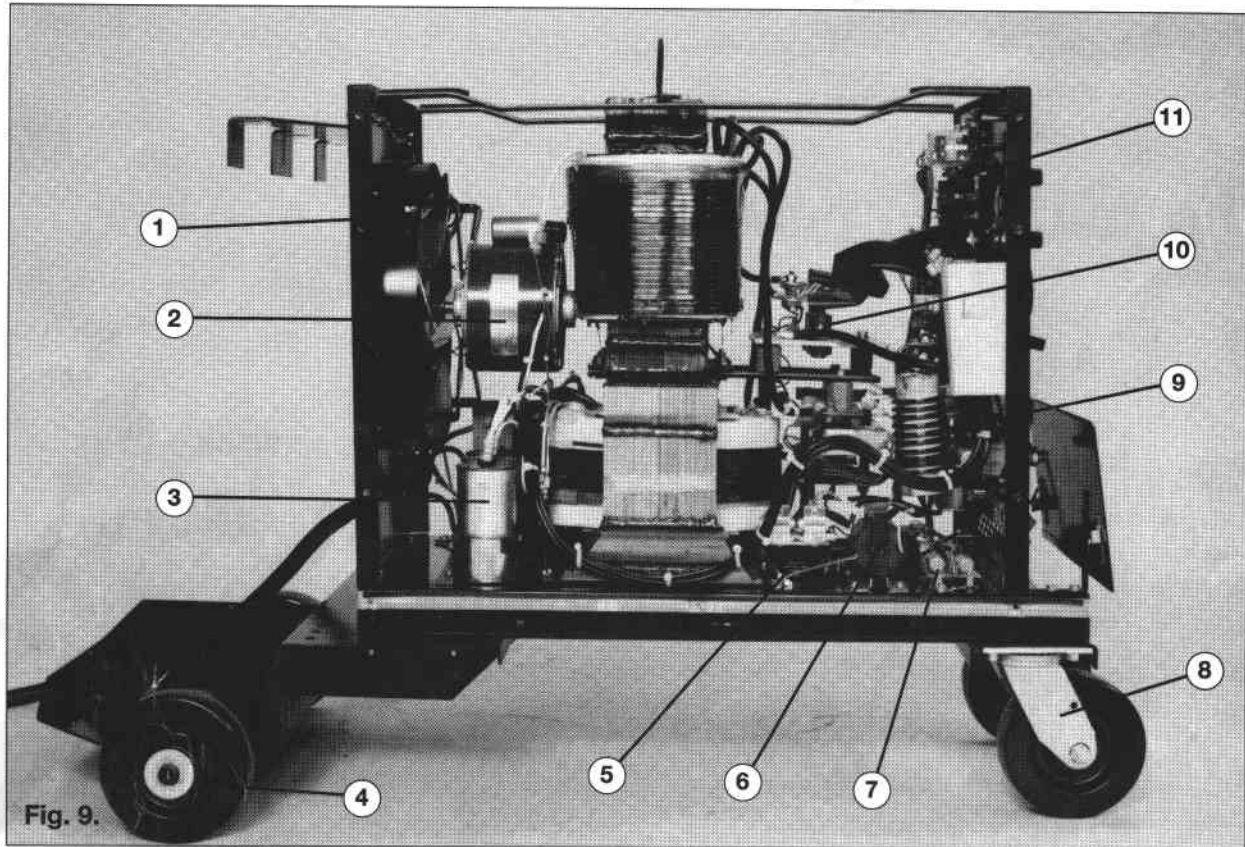


Fig. 9.

ITEM NO.	QTY	ELECTRICAL SYMBOL	PART NO.	DESCRIPTION
1	1	-	1415096	Fan Blade
2	1	FM	1414614	Fan Motor
3	3	C17, C18, C19	1415110	Capacitor 60mf, 440v
4	2	-	1415108	Rear Wheel
5	1	SG	1415101	Spark Gap Assy. (Includes Items 5a, b, c, d)
5a	1	-	1415102	Spark Gap P.C.B.
5b	2	-	-	Spark Gap Heat Sink
5c	2	-	1415104	Spark Gap Contacts
5d	1	-	1414670	Spark Gap Capacitor
6	1	HFTR	1414668	High Frequency Transformer
7	1	FN1	1415105	Filter P.C.B. Assy.
8	2	-	1415109	Front Castor Assy
9	1	ACT	1415100	Air Core Transformer
10	1	-	1415097	Diode Bridge Assy (includes Items 10a, b, c, d)
10a	2	C9, C10	-	Capacitor .02 mf, 1kv
10b	1	D1	1415098	Reverse Diode
10c	1	D2	1415099	Forward Diode
10d	2	-	-	Insulated Stand-Off
11	1	-	1415106	Logic P.C.B.
11a	1	-	1415107	HF Relay