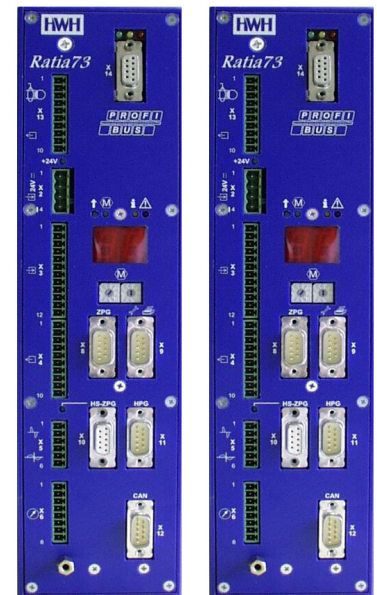# Harms und Wende Weld timers

Networking weld timers series Ratia 73

Standard Functions Ratia 73:

Multi functional weld timers for mounting in distributed systems. The modules can be placed in a central place or be distributed over the production
- ✓ 128 programs
- ✓ 128 counter groups
- ✓ Current- and pressure program
- ✓ Stepper function
  with linear stepper (10 steps)
- ✓ Electrode management
- ✓ Log book and diagnosis functions
- ✓ proportional valve output
- ✓ Automatic 50 / 60 Hz detection
- ✓ Bus- and local programming port
- ✓ 2 start function, (1 Start with field bus)
- ✓ 2 solenoid value- and pre-stroke outputs
- ✓ Spot repetition- and tip dressing function
- ✓ 24V I/Os

Extra functions Ratia 73 IQ1

- ✓ Secondary current regulation (AC)
- ✓ Current monitoring with spot repetition

Extra functions Ratia 73 IQ2

- ✓ Secondary current regulation for three phase DC
- ✓ Current monitoring with spot repetition

Bus interfaces Ratia 73

- ✓ Ethernet
- ✓ RS 422

- ✓ I/O over Profibus DP
- ✓ Interbus-S optical /electrical

Special functions Ratia 73

- ✓ Programming over user panel Mundus or
  hand programming device (HPG-E)
- ✓ Large distributed systems over **Pegasus** programming
  software
- ✓ Power supply 24V=