

MAXsa[®] 10 Controller

ArcLink[®]-enabled Controller for Power Wave[®] AC/DC 1000[®] SD Systems

The MAXsa[®] 10 controller offers a single monitoring and control point for the entire hard automation welding system. Operators have full control over AC and DC welding parameters and easy PLC interfacing to control fixture travel, timers and other system commands.

Processes
Submerged Arc



Output

40
VDC

Input

40
VDC



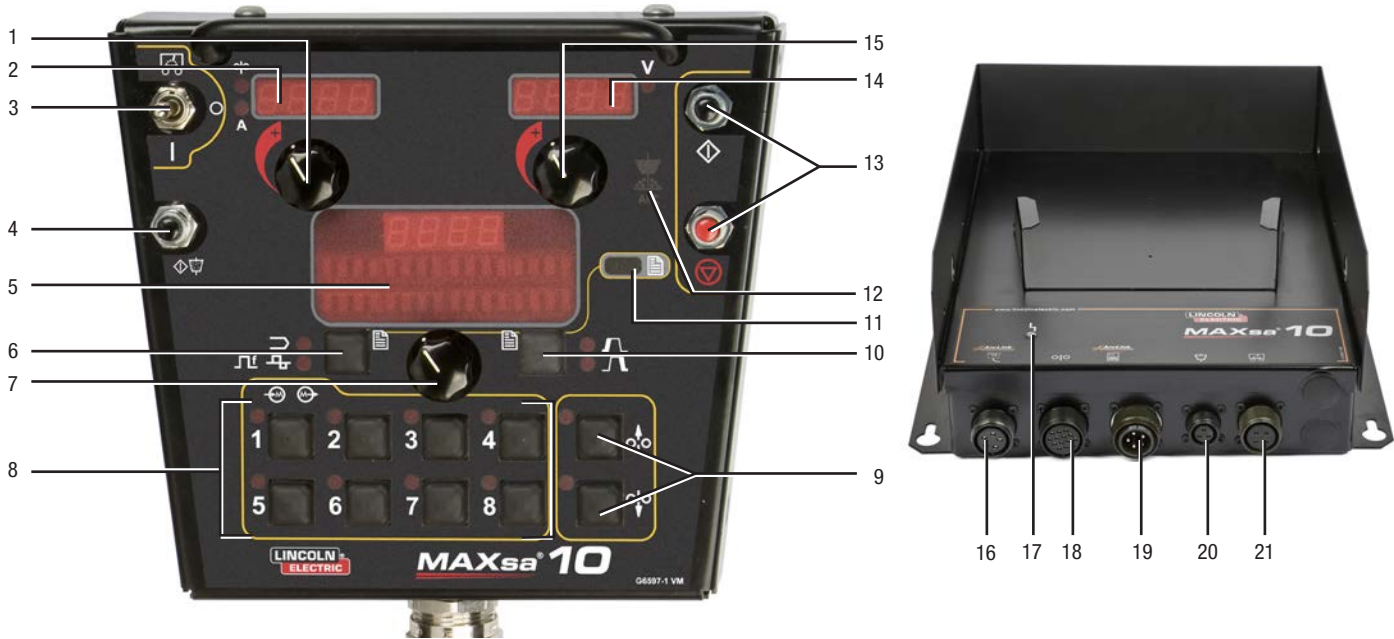
Key Features

- **Severe Duty Ready** – The controller is IP23 rated and ready for operation in harsh environments.
- **Pendant Box** – Mount the controller in the standard protective box or remove the pendant for hand-held operation. Extend hand-held operation from 4 feet (1.2 m) up to 100 feet (30.5 m) with an ArcLink[®] extension cable.
- **Eight Procedure Memories** – Pre-set and save your optimal welding parameters for repeating applications and recall later for fast changeovers.
- **User-Friendly Controls** – Clear digital display and controls make it easy to set weld modes, AC operation, strike/start/end options, travel stop/start, timers and other parameters.
- **Limit Control** – Apply operator procedure limits or lockout on any or all parameters.
- **Waveform Control Technology[®]** – Allows the user to choose from a library of pre-programmed weld modes. Parameters for each mode can be adjusted within a limited range to achieve optimal balance between deposition rate and penetration.

Technical Specifications

Product Name	Product Number	Input Power	Dimensions H x W x D in. (mm)	Net Weight lbs. (kg)
MAXsa [®] 10 Controller	K2814-3	40 VDC	15 x 13 x 4 (381 x 259 x 102)	25 (11.3)

KEY CONTROLS



- | | | | |
|---|---|---|---|
| <p>1. AMPS/WFS Control</p> <p>2. AMPS/WFS Display</p> <ul style="list-style-type: none"> • AMPS Indicator Light • WFS Indicator Light <p>3. Travel Switch</p> <ul style="list-style-type: none"> • Auto/Off/Manual <p>4. Flux Hopper Switch</p> <p>5. Mode Select Panel (MSP) Display</p> | <p>6. Weld Mode Selector</p> <ul style="list-style-type: none"> • Weld Mode Indicator Light • Frequency/Balance Indicator Light <p>7. Mode Select Panel Control Knob</p> <p>8. Eight Memory Buttons:</p> <ul style="list-style-type: none"> • Save common procedures • Apply operator range or limits • Lockout changes for procedure control | <p>9. Feed Reverse/Feed Forward Buttons</p> <p>10. Arc Start/End Options Selector</p> <ul style="list-style-type: none"> • Start Options Indicator Light • End Options Indicator Light <p>11. Set-Up Menu Indicator</p> <p>12. Arc Established Indicator</p> <p>13. Stop/Start Buttons</p> <p>14. Volts Display</p> <ul style="list-style-type: none"> • Volts Indicator Light | <p>15. Volts Control</p> <p>16. User Interface/Pendant Connector</p> <p>17. Status LED</p> <p>18. Wire Drive Connector</p> <p>19. Power Source Connector</p> <p>20. Flux Hopper Connector</p> <p>21. Travel Carriage Connector</p> |
|---|---|---|---|

RUGGED DESIGN, FLEXIBLE CONNECTION

- 1. IP23 Rated** – Tested and approved to withstand rain, humidity, dust and other environmental conditions. When placed vertically, the unit can be stored outdoors.
- 2. Hard Automation Connection** – Motion control, limit switches, PLC inputs and other auxiliary equipment are easily added to control device starting, stopping and other functions.
- 3. Hand-held Options** – The protective base unit shell facilitates fixed mounting and protects the controller. To get closer to the work, detach the controller for hand-held operation.

