

# PurgeNet™ Machine Interface

for PPM Readings to Welding Power Sources



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## DESCRIPTION

The PurgeNet™ Machine Interface is used for communicating the current oxygen reading from your PurgEye® Weld Purge Monitor® to another piece of equipment, such as a Welding Power Source.

All of the HFT® PurgEye® Weld Purge Monitors® reading down to 1 ppm (with the exception of the PurgEye® Nano) can control the start/stop function on a Welding Power Source. This is facilitated using the PurgeNet™ Machine Interface Lead.

A minimum PPM level is set on the Weld Purge Monitor® by the user, in accordance with the welding parameter, and if during the weld, the oxygen content in the purge gas falls to this, the welding power source automatically switches off, pausing the welding process until the PPM level has risen again.

For critical welds this is an essential feature to ensure consistent weld quality every time.

The lead connects to the port on the Weld Purge Monitor®. Charging can also be facilitated from this lead as can the use of other PurgeNet™ accessories.

Oxygen readings are communicated through industry standard 4020A current loop and relay signals.

The interface also includes a power supply to charge / power your PurgEye® from a standard 12-24V supply found in most industrial machines.

## OUTPUT

For PurgEye® Weld Purge Monitors® with 1 to 1000 ppm range (accurate to 10 ppm), the current output from the interface is linear, with 4mA representing 0 ppm and 20mA representing 1,000 ppm, with a resolution better than 1 ppm.

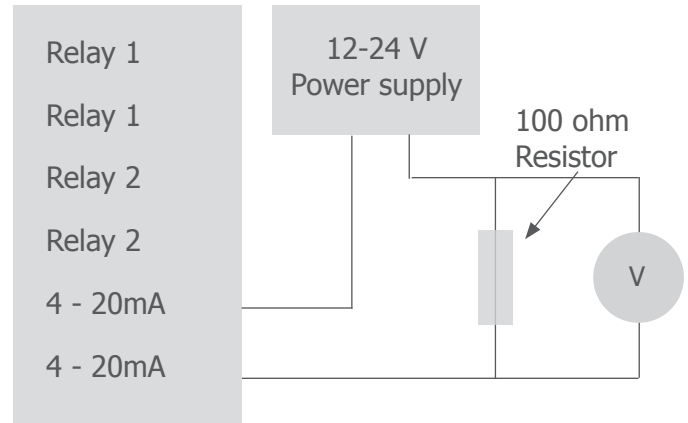
For the PurgEye® 600 Touch, with a measuring range of 10 to 250, 000 ppm, the current output is split into two linear output ranges, as follow:

PurgEye® 600 Touch	Current Output	Resolution
0 - 1000 ppm	4mA - 12mA	< 1 ppm
1000 - 250000 ppm	12mA - 20mA	~ 100 ppm

## STATUS LIGHT

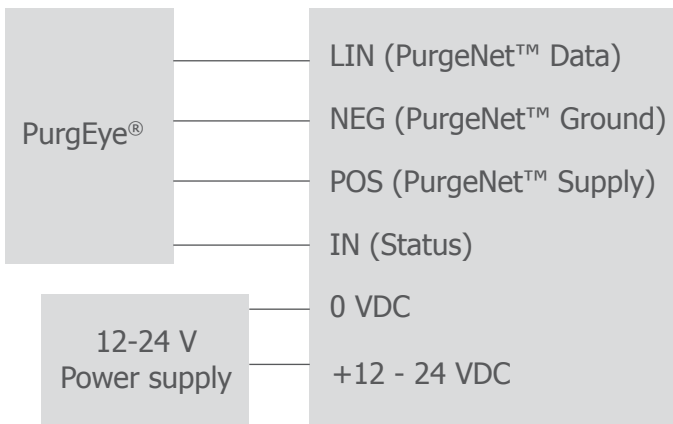
Slow flash	PNA-01 is correctly powered and receiving valid data from your PurgEye®.
On	PNA-01 is correctly powered but no data is being received from your PurgEye®.
Off	The PNA-01 is not powered, ensure the current loop and supply connections are correctly configured, see 'Connections' below.

For voltage output using the 4-20mA output, connect as below;



## CONNECTIONS

The basic connections required to get the module working are shown below (the power supply is optional for battery powered models). The status input can be used to control the sample pump in your PurgEye®, use a volt-free contact to connect the 'IN' terminal to the '0 VDC' terminal to activate the input.



## HUNTINGDON FUSION TECHNIQUES ■ HFT

### Other HFT® Weld Purging Products

Argweld® Inflatable Tube Pipe & Pipeline Weld Purging Systems  
 Argweld® PurgEye® Weld Purge Monitors®  
 Argweld® Weld Purge Film® & Weld Purge Super Adhesive®  
 Argweld® Weld Backing Tape™ & Weld Purge Tape™  
 Argweld® Weld Trailing Shields®  
 Argweld® Flexible Welding Enclosures®  
 Argweld® Weld Purge Plugs™ & Orbital Welding Plugs  
 Techweld® MultiStrike® Tungsten Electrodes

### Our HFT Pipestoppers® Division

Nylon, Aluminium, Steel and Rubber Pipe Plugs and Inflatable Stoppers

Machine Interface PNA-01 LFT A4 18-01-2021 ME

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