Model 105
Single Phase Resistance Welding Controller

FEATURES

- Spot Weld - Seam Weld - Roll Spot Weld - Butt Weld
- Cascade 3 Guns with Clamp Output
- Cascade 3 Welding Transformers
- Fully Programmable Triple Weld Schedules
- Single - Dual - Triple Foot Switch Control
- 87 Degree Fire Limit Control First Cycle
- Automatic Power Factor Control
- Water Cooled Contactor Over Temperature Shut Down
- Pulsating Heat Control
- One Time Squeeze Delay in Repeat
- Upslope Heat Control
- Temper Heat Control
- Intermittent Drive Motor On/Off Control
- Conversion to Model 106 Stepper Heat Control
Intertron Industries Inc: Model 105

- **105F** Controller with **Forge Delay Start**
- **105AP** Controller with 1/2 Cycle Alternate Polarity

**PERFORMANCE**

- Absolute Repeatability
- Quartz Crystal Accuracy
- Space Age Design and Rugged Construction

**SPECIFICATIONS**

- INPUT POWER: 200 VAC to 480 VAC 60 HZ.
- AC OUTPUT TO VALVES: 115 VAC 20 VA. EA.
- Solid State Contactors Available in Ranges from 300 Amps to 3000 Amps
- Ignitron Firing Module to Fire Ignitrons Size A through E
- Solid State Relays to Operate Clamp, Retraction, Tip Dress, Upset Valves
- Solid State Relay to Turn on Motor or Air Brake in Seam or Rollspot Mode
- Foot Switch Output to Cascade Next Controller
- Model **105AB** 3 of 6 Weld Schedule Select (Special Order)

**TIMING FUNCTIONS**

WELD SCHEDULE 1 - WELD SCHEDULE 2 - WELD SCHEDULE 3

<table>
<thead>
<tr>
<th>Function</th>
<th>Range</th>
</tr>
</thead>
<tbody>
<tr>
<td>squeeze delay time</td>
<td>00-99</td>
</tr>
<tr>
<td>squeeze time</td>
<td>00-99</td>
</tr>
<tr>
<td>impulses</td>
<td>00-99</td>
</tr>
<tr>
<td>cool time</td>
<td>00-99</td>
</tr>
<tr>
<td>heat time</td>
<td>00-99</td>
</tr>
<tr>
<td>heat %</td>
<td>00-99</td>
</tr>
<tr>
<td>quench time</td>
<td>00-99</td>
</tr>
<tr>
<td>temper time</td>
<td>00-99</td>
</tr>
<tr>
<td>temper %</td>
<td>00-99</td>
</tr>
<tr>
<td>hold time</td>
<td>01-99</td>
</tr>
<tr>
<td>off time</td>
<td>00-99</td>
</tr>
<tr>
<td>upslope steps</td>
<td>00-99</td>
</tr>
<tr>
<td>upslope % heat per step</td>
<td>0.0-9.9</td>
</tr>
</tbody>
</table>
- Operating Temperature: 0-50 Degrees Centigrade
- Cabinet Dimensions: 16"h x 20"w x 11"d
- Consult Factory for Custom Weld Schedule Requirements