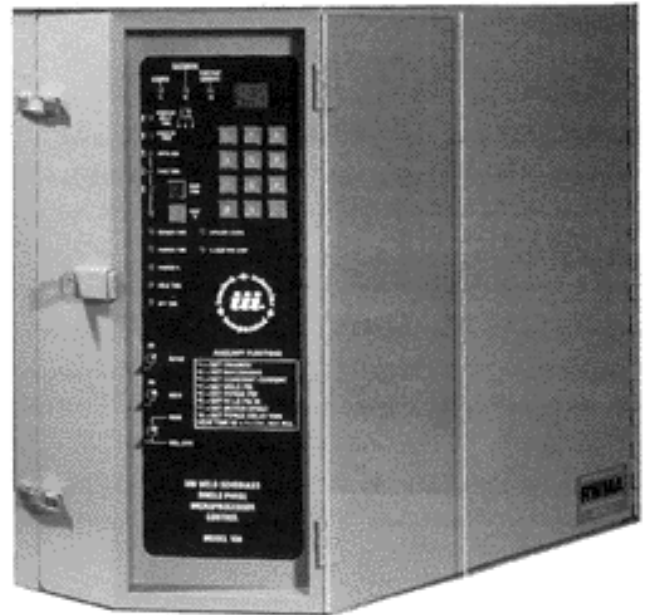




Model 108

Single Phase Resistance Welding Controller

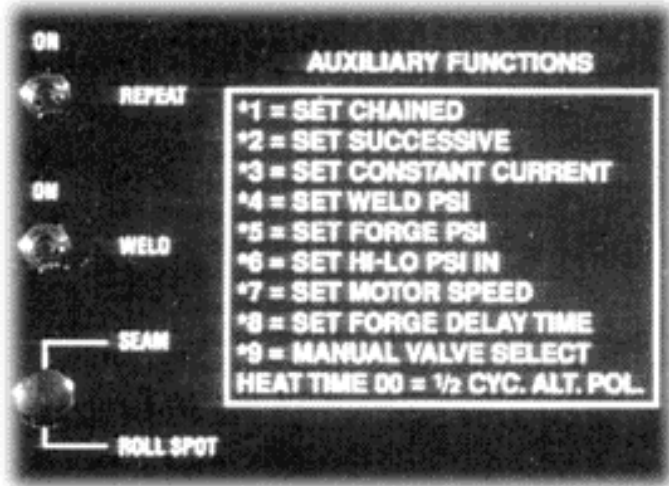
300 Weld Schedules in Memory



FEATURES

- Spot Weld - Seam Weld - Roll Spot Weld - Butt Weld
- Cascade 6 Guns with Clamp Output, Chained or Successive
- Cascade 24 Guns successively, one per Weld Schedule
- Cascade 6 Welding Transformers, Chained or Successive
- Manual Valve Select Program
- Fully Programmable 300 Weld Schedules
- Single - Dual - Triple Foot Switch Control
- 87 Degree Fire Limit Control First Cycle
- 1/2 Cycle Alternate Polarity Firing
- Water Cooled Contactor with 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
- Forge Delay Start
- Dual Mode Anti-Tie Down Initiation (momentary or push-and-hold)



OPTIONAL FEATURES

- Constant current Control or A.V.C.
- Built-in Weld Current Checker with 1% to 20% Allowable Deviation Error with Deviation Error Display and Constant Current or AVC Mode
- Conversion to Model 108A Stepper Heat

Control

- Weld/Forge Pressure Control Regulator
- Cylinder Pressure Hi-Low Limit
- Motor Speed Control
- RS 232 Upload/Download Weld Schedules to PC
- RS 232 PLC Control Interface
- Edit Weld Schedule Key Lock
- 108LD Load Distribution over 3 Phase Line with 16 Valve/12 Transformers Manual Valve and Transformer Selection
- 8 Limit Switches Allow Part in Position, Guns Up Detection and Weld Schedule Selection

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 3200 Amps

- Ignitron Firing Module to Fire Ignitrons Size A through E
- Solid State Relays to Operate Squeeze Valve in Spot - Seam - Rollspot - Cascade - Butt Weld
- End of Sequence Output
- Optional Solid State Relays to Operate Clamp, Retraction, Tip Dress, Upset Valves
- Optional Solid State Relay to Turn on Motor or Air Brake in Seam or Rollspot Mode

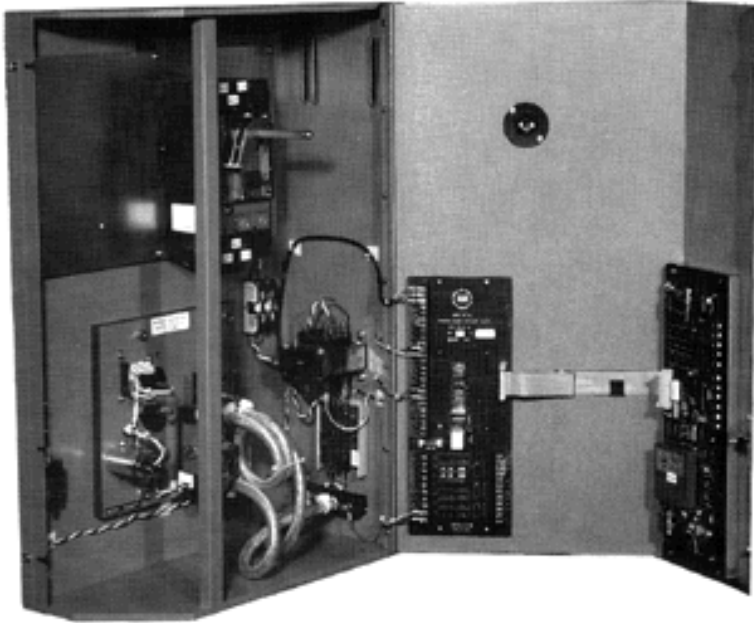
TIMING FUNCTIONS

Group A 00-99 Weld Schedules Group B 00-99 Weld Schedules Group C 00-99 Weld Schedules

squeeze delay time	00-99
squeeze time	00-99
impulses	00-99
cool time	00-99
heat time	00-99
heat %	00-99
quench time	00-99
temper time	00-99
temper %	00-99
hold time	01-99
off time	00-99
upslope steps	00-99
upslope % heat per step	0.0-9.9

- Operating Temperature: 0-50 Degrees Centigrade
- Cabinet Dimensions: 16 5/8"h x 20"w x 11"d
- Consult Factory for Custom Weld Schedule Requirements

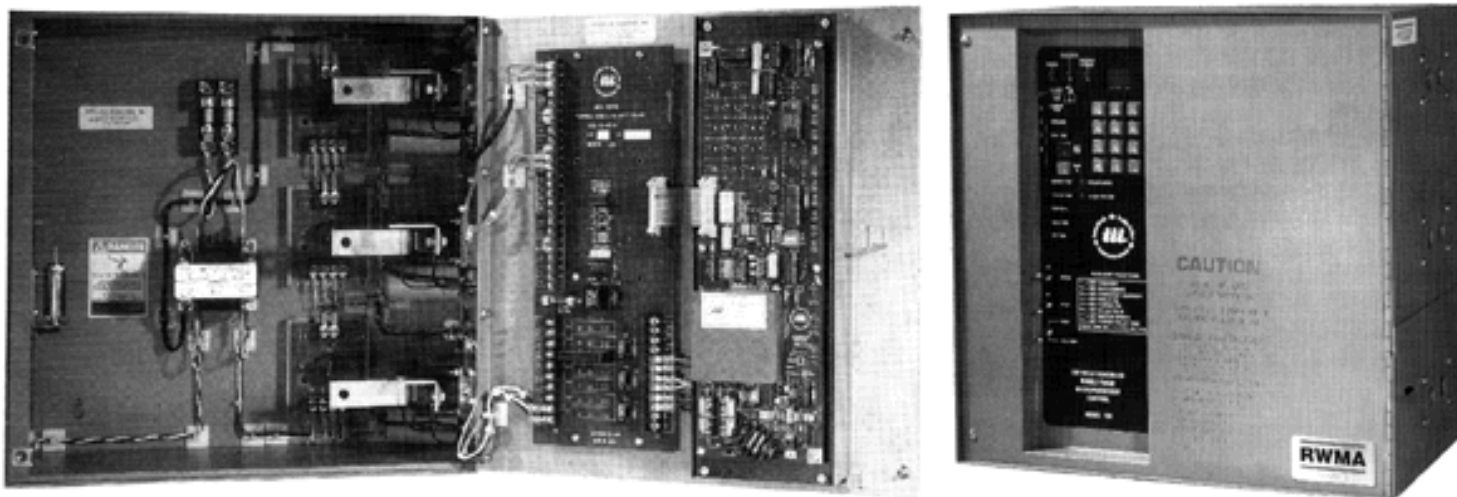
BREAKER SIZE: 100 AMPS, 400 AMPS, 600 AMPS



- Cabinet Dimensions: 30"h x 20"w x 11"d
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108SL STYLE CABINET

CASCADE 3 INDIRECT COOLED CONTACTORS



- Cabinet Dimensions: 16 5/8"h x 16 3/4"w x 9"d
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