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
Intertron Industries Inc: Model 108

- 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**

<table>
<thead>
<tr>
<th>Group A</th>
<th>00-99 Weld Schedules</th>
<th>Group B</th>
<th>00-99 Weld Schedules</th>
<th>Group C</th>
<th>00-99 Weld Schedules</th>
</tr>
</thead>
<tbody>
<tr>
<td>squeeze delay time</td>
<td>00-99</td>
<td>squeeze time</td>
<td>00-99</td>
<td>impulses</td>
<td>00-99</td>
</tr>
<tr>
<td>cool time</td>
<td>00-99</td>
<td>heat time</td>
<td>00-99</td>
<td>heat %</td>
<td>00-99</td>
</tr>
<tr>
<td>quench time</td>
<td>00-99</td>
<td>temper time</td>
<td>00-99</td>
<td>temper %</td>
<td>00-99</td>
</tr>
<tr>
<td>hold time</td>
<td>01-99</td>
<td>off time</td>
<td>00-99</td>
<td>upslope steps</td>
<td>00-99</td>
</tr>
<tr>
<td>upslope % heat per step</td>
<td>0.0-9.9</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

- 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

108HL STYLE CABINET WITH 2 POLE MAGNETIC BREAKER
BREAKER SIZE: 100 AMPS, 400 AMPS, 600 AMPS

- Cabinet Dimensions: 30"h x 20"w x 11"d

108SL STYLE CABINET

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