



Model 302C

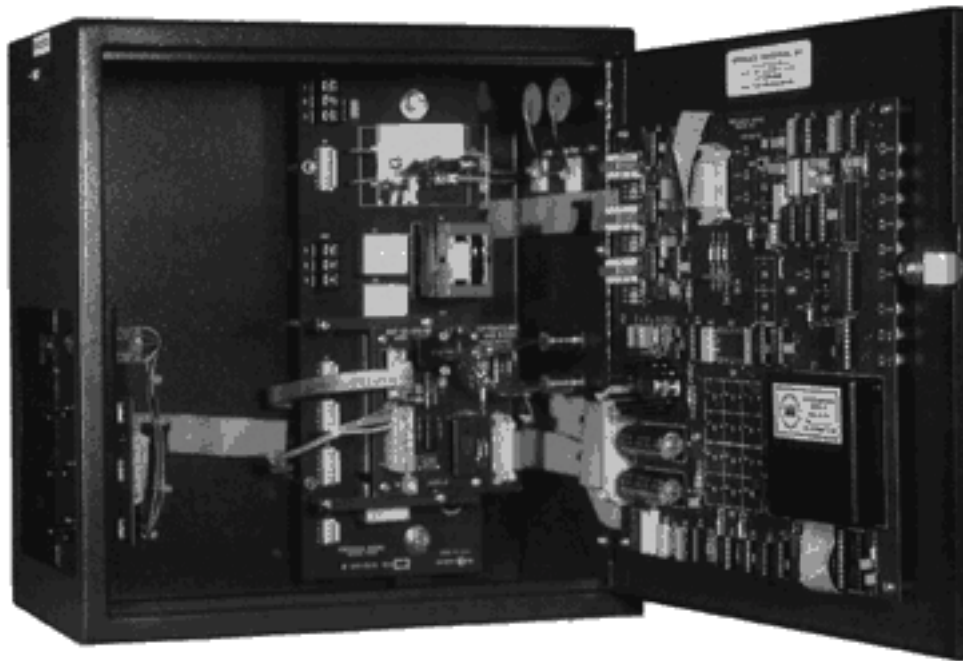
3 Phase Resistance Welding Controller



FEATURES

- 3 Phase Frequency Converter &
- 3 Phase Rectified D.C.
- Spot Weld - Seam Weld - Rollspot Weld
- Fully Programmable 16 Weld Schedules
- Pulsating Heat Control
- Programmable Forge Control
- Programmable Weld PSI
- Programmable Forge PSI
- Programmable Hi-Low Limit Weld PSI
- Programmable Hi-Low Limit Forge PSI
- Programmable Motor Speed
- Programmable First Spot Heat % In Seam
- Intermittent Drive Motor On/Off Control
- 5 Years Memory Retention Without Power

- Scanner Interlock
- RS232 Interface



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 150 VA
- Solid State Contactors Available in Ranges from 300 Amps to 3200 Amps
- Ignition Firing Module to Fire Ignitrons Size A through E
- Solid State Relay to Operate Squeeze Valve in Spot - Seam - Rollspot Mode
- Solid State Relay to Turn On Motor or Air Brake in Seam or Rollspot Mode
- Dual Pilot Air Pressure Regulator
- Dual Air Volume Booster 150 CFM
- DC Motor Controller 0 - 90 V or 0 - 180 V .5 HP to 2 HP
- Retraction and Two Stage Foot Switch Input
- Floating Input/Output to Central Interlock Scanner
- Visual Peripheral Diagnostics
- RS232 Connector to Upload and Download Weld Schedules to Laptop
- Remote Control Box Model 325A with the following switches: Repeat, Weld, Tip Dress, Positive - Alternate - Negative Polarity, Seam - Spot - Roll, Next Weld Schedule (quick selection between two weld schedules), Program Lock Key, One of Sixteen Weld

Schedule Selector Switch

TIMING FUNCTIONS

tip travel time	00-99
precompression time	00-99
squeeze time	00-99
impulses	00-99
cool time	00-99
forge delay time	00-99
heat time	00-99
heat %	00-99
heat decay time	00-99
heat decay %	00-99
hold time	00-99
off time	00-99
weld PSI	00-99
forge PSI	00-99
motor speed	00-99
first spot in seam	00-99



**MODEL 325A
REMOTE CONTROL BOX**

- Operating Temperature: 0-50 Degrees Centigrade
 - Cabinet Dimensions: 14"h x 14"w x 6"d
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