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
Intertron Industries Inc: Model 302C

- 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
### TIMING FUNCTIONS

<table>
<thead>
<tr>
<th>Function</th>
<th>Range</th>
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<tbody>
<tr>
<td>tip travel time</td>
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<tr>
<td>precompression time</td>
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<tr>
<td>squeeze time</td>
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<td>impulses</td>
<td>00-99</td>
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<td>cool time</td>
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<tr>
<td>forge delay time</td>
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<tr>
<td>heat time</td>
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<td>heat %</td>
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<tr>
<td>hold time</td>
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<tr>
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<tr>
<td>forge PSI</td>
<td>00-99</td>
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<tr>
<td>motor speed</td>
<td>00-99</td>
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<tr>
<td>first spot in seam</td>
<td>00-99</td>
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MODEL 325A
REMOTE CONTROL BOX

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