



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

- **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

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"h x 20"w x 11"d
 - Consult Factory for Custom Weld Schedule Requirements
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