

100/300/1000ADP

resistance welding New Generation CD Welders

New generation Advanced Dual Pulse CD welders with pulse monitoring, limits and unique process tools for improved weld quality

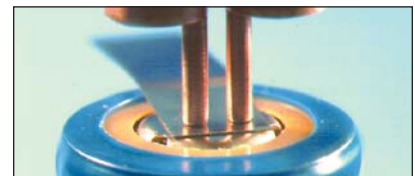
- Built-in current monitor
- Set pulse limits with second pulse inhibit
- Four pulse widths with fast rise times
- Automatic polarity switching
- Upslope function
- Quick view color screen



Key Features

- **Dual pulse function**
Overcomes surface inconsistencies
- **Built-in monitor**
Internal sensor measures peak current for both pulses for process monitoring
- **Process monitor**
Color coded bar graph on RUN screen provides instant weld history of In Limits/ Out of Limits percentages to assess process performance
- **Set test pulse and pulse limits with inhibit option**
Upper and lower limits can be set for both pulses, with option of inhibit Pulse 2 if Pulse 1 is out of limits to prevent weld blow out
- **Upslope function**
Gradual ramping of weld energy to alleviate weld splash – a first for CD welders
- **Polarity programming by pulse**
Automatic polarity switching between pulses provides even heating between electrodes and increases electrode life
- **Four selectable pulse widths**
Increases the range of welding applications and improves process optimization
- **High resolution 6.5 inch color display**
Large clear display with all weld information visible on RUN screen
- **High repetition rate**
Efficient power electronics provide improved repetition rates

TYPICAL APPLICATIONS



battery tab welding



Tack welding of carrier strip



Conductive terminal attachment

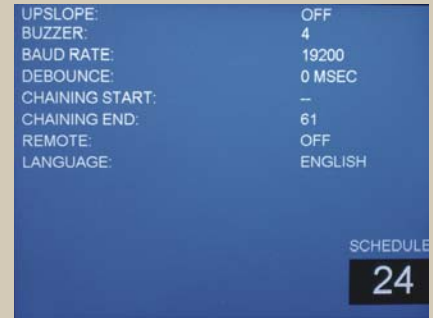
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RUN screen contains all information at a glance, with color coding. When Out of Limits occurs, box turns from green to red. Weld counter shows In Limits/ Out of Limits percentage.



LIMITS / COUNTER screen. Set limit settings with second pulse inhibit option if Out of Limit condition occurs on Pulse 1. Reset weld counter and set counter limit.



SETUP screen. Upslope, chaining and language select.



External Transformer

SPECIFICATIONS

Feature	100ADP / 300ADP / 1000ADP
Input Line Voltage	90-138 VAC, 50-60Hz 180-264 VAC, 50-60Hz
Dual Pulse	Yes
Air Head Driver Output	24V, DC or AC – 0.5A Max.
Weld Schedules	63
Chain Schedules (Automatic Step)	Yes
Programmable Squeeze Time	Programmable per schedule from 0-2.999 sec.
Programmable Hold Time	Programmable per schedule from 0-2.999 sec.
Remote Schedule Selection	Yes
Programmable Polarity	Positive/Negative/Alternating
End Cycle Buzzer	Yes
Output Relays	Weld Ready, Weld End, Counter Limit, Alarm, Out of Limits
Microprocessor Control	Yes
Weld Counter with User Programmable Limit	Yes
Languages	English, Spanish, German

OUTPUT PULSE CHARACTERISTICS

Model	Watt Second Adjustment Range	Dual Pulse	Single Pulse Welding Speed per Minute	Pulse Width Selection	Pulse Width (Max Energy into 1 Milliohm Load)		Rise Time (Max Energy into 1 Milliohm Load)		Maximum Pulse Height
					No Upslope	With Upslope	No Upslope	With Upslope	
100ADP	1-100 Ws	Yes	10Ws-240 25Ws-170 50Ws-110 100Ws-75	Very short	2.0ms	NA	0.6ms	NA	6.0 V
				Short	2.4ms	2.7ms	0.6ms	1.0ms	6.0 V
				Medium	2.9ms	3.4ms	0.8ms	2.1ms	5.6 V
				Long	4.0ms	5.2ms	1.2ms	3.3ms	4.1 V
300ADP	3-300 Ws	Yes	10Ws-520 50Ws-240 150Ws-140 300Ws-80	Very short	2.4ms	NA	0.9ms	NA	7.7 V
				Short	6.0ms	6.0ms	1.0ms	1.2ms	7.6 V
				Medium	8.0ms	8.2ms	1.5ms	2.8ms	5.8 V
				Long	11.2ms	12.2ms	1.6ms	3.3ms	4.6 V
1000ADP	1-999 Ws	Yes	10Ws-180 50Ws-125 250Ws-80 500Ws-60 750Ws-45 1000Ws-30	Very short	3.5ms	NA	1.0ms	NA	12.5 V
				Short	7.8ms	7.9ms	2.0ms	2.2ms	13.8 V
				Medium	8.4ms	8.9ms	2.7ms	3.2ms	12.2 V
				Long	11.7ms	14.4ms	3.7ms	4.7ms	8.8 V

PHYSICAL CHARACTERISTICS

	100ADP	300ADP	1000ADP*
H x W x D inches (mm)	11.5 x 9.9 x 13.8 (293 x 252 x 350)	11.5 x 9.9 x 13.8 (293 x 252 x 350)	11.5 x 9.9 x 13.8 (293 x 252 x 350)
Weight lbs (Kg)	37 (17)	66 (30)	29 (13)

*uses external transformer. 14.3x9.0x10.8 inches (364 x 229 x 275mm) HxWxD, 135lbs (61Kg) weight.

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