



Model 3000

Medium Frequency Inverter Resistance Welding Controller

FEATURES AND SPECIFICATIONS

- Spot Weld – Seam Weld – Roll Spot Weld – Butt Weld
- Fully Programmable 999 Weld Schedules
- Programmable Weld Counter for Each Weld Schedule
- Primary Weld Current Limit Built in Monitor
- Secondary Current Monitor with Auto Scaling 1K Amps to 99K Amps
- Welding Transformer/Rectifier Limits Monitor:
- Duty Cycle – Weld Time – K Amps
- Weld Controller Halts with Warning Message if limits are exceeded
- Weld Controller reads Transformer I.D. Code to verify limits
- +/- Limit K Amps
- Factory Preset Operating Frequency 0.5KC – 2 KC
- Copper Water-cooled IGBT Heat Sink with Temp. Sensor
- Pulsating Heat Time – Cool Time Control
- Upslope – Downslope – Quench – Temper Control
- One Time Squeeze Delay in Repeat Mode
- Weld Heat Stepper
- Weld Pressure Stepper
- Direct Interface to Intertron Interlock Scanner
- Edit Lock via 4 Digit Pass Code for Each Weld Schedule
- Edit Weld Schedule Key Lock for All Weld Schedules
- Intermittent and Continuous Drive Motor Speed Control
- Weld and Forge Air Pressure Regulators
- 00 – 99 PSI or 000 – 682 KPA
- Air Volume Booster 45 CFM or 150 CFM
- Weld Cylinder Pressure Hi – Low Limit Sensor
- Chain Weld Schedules for Special Application Requirements
- Switch Inputs:
- Retraction – 1st and 2nd Stage – Remote Weld – Tip Dress – E. Stop
- Head DN – Key In – Key out for Machines with Key Lock Cylinder
- Heat Time Override Limit Switch in Butt Weld Mode
- Dual Anti-Tie-Down Mode: Momentary – Push and Hold
- Valve Outputs Retractions – Weld – Forge – Water Saver – Key Lock Clutch/Brake
- RS232 Interface to P.C. prints out Weld Impulse Monitored Time and Current Upload/Download
- Weld Schedules to and from P.C.
- Secondary Weld Current Programming: K Amps or Heat %
- All Time Controls are Programmed in Milliseconds or Cycles
- Weld Schedule 000 allows setup of Initial Default Values and Units of Measure for All Weld Schedules





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Standard Cabinet Dimensions: 30" h x 24" w x 12" d

ELECTRICAL SPECIFICATIONS

- Input Power
- 3 Phase 220 VAC – 240 VAC – 380 VAC – 440 VAC – 480 VAC – 575 VAC
- 50/60 HZ
- Optional 3 Phase Breaker in Cabinet
- AC Output to Valves 120 VAC, 20 VA per Valve
- DC Output to Forge Valve 24 VDC 0.25 Amps
- Primary Current Driver 200 Amp to 800 Amp in Standard Cabinet
- 1000 Amp to 2000 Amp Driver in HL Cabinet, 12" taller than Standard

Your Local Representative



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