

125/300/1000ADP

Capacitive Discharge Welders

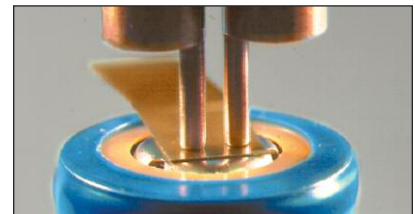


- Built-in current monitor
- Set pulse limits with second pulse inhibit
- Four pulse widths with fast rise times
- Automatic polarity switching
- Upslope function
- Quick view color screen

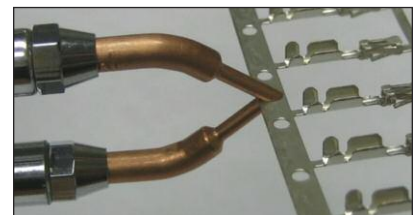
KEY FEATURES

- Dual pulse function helps overcome surface inconsistencies
- Built-in monitor measures peak current for both pulses for process monitoring
- Process monitor features a color coded bar graph on the RUN screen that provides instant weld history of In Limit/ Out of Limit percentages to assess process performance
- Upper and lower limits can be set for both pulses, with an option to inhibit Pulse 2 if Pulse 1 is out of limits. Prevents weld blow out
- Upslope function allows gradual ramping of weld energy to alleviate weld splash
- Automatic polarity switching between pulses provides even heating between electrodes and increases electrode life
- Up to four software selectable pulse widths increases the range of welding applications and improves process optimization.
- High resolution 6.5 in color display – large, clear 6.5 inch high resolution color display shows all weld information on the RUN screen
- Efficient power electronics provide high repetition rates

TYPICAL APPLICATIONS



Battery tab welding



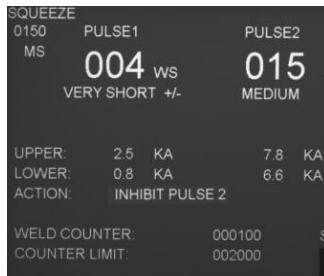
Tack welding of carrier strip



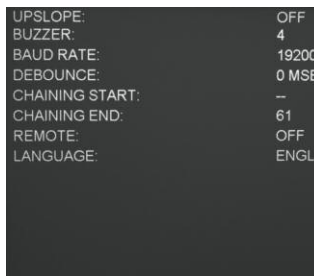
Conductive terminal attachment



RUN screen



LIMITS/ COUNTER screen



SETUP screen

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.

TECHNICAL SPECIFICATIONS

Feature	125ADP / 300ADP / 1000ADP
Input line voltage	90 - 138 VAC, 50 - 60 Hz 180 - 264 VAC, 50 - 60 Hz
Dual pulse	Yes
Air head driver output	24 V, DC or AC – 0.5 A 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 (125ADP, 300ADP only)
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	Single pulse welding speed per minute	Dual pulse	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	
125ADP	1 - 125 Ws	10 Ws - 140 35 Ws - 80 75 Ws - 55 125 Ws - 45	Yes	Very short	2.0 ms	NA	0.65 ms	NA	6.9 V
				Short	2.3 ms	2.4 ms	0.65 ms	0.9 ms	6.9 V
				Medium	2.5 ms	2.8 ms	0.85 ms	1.4 ms	6.3 V
				Long	3.9 ms	4.7 ms	1.2 ms	2.8 ms	4.5 V
300ADP	3 - 300 Ws	10 Ws - 520 50 Ws - 240 150 Ws - 140 300 Ws - 80	Yes	Very short	2.4 ms	NA	0.9 ms	NA	7.7 V
				Short	6.0 ms	6.0 ms	1.0 ms	1.2 ms	7.6 V
				Medium	8.0 ms	8.2 ms	1.5 ms	2.8 ms	5.8 V
				Long	11.2 ms	12.2 ms	1.6 ms	3.3 ms	4.6 V
1000ADP	10 - 999 Ws	10 Ws - 170 50 Ws - 130 250 Ws - 65 500 Ws - 35 750 Ws - 17 999 Ws - 10	Yes	Very short*	2.4 ms	NA	0.9 ms	NA	7.7 V
				Short*	7.8 ms	7.9 ms	2.0 ms	2.2 ms	13.8 V
				Medium*	8.4 ms	8.9 ms	2.7 ms	3.2 ms	12.2 V
				Long*	11.7 ms	14.4 ms	3.7 ms	4.7 ms	8.8 V

* settable on the 1000ADP by the factory prior to shipment. To be shipped in a short pulse width configuration unless otherwise specified on order.

WEIGHT & DIMENSIONS

	125ADP	300ADP	1000ADP**
Dimensions (L x W x H)	13.8 in x 9.9 in x 11.5 in (350 mm x 252 mm x 293 mm)	13.8 in x 9.9 in x 11.5 in (350 mm x 252 mm x 293 mm)	13.8 in x 9.9 in x 11.5 in (350 mm x 252 mm x 293 mm)
Weight	44 lbs (20 kg)	66 lbs (30 kg)	29 lbs (13 kg)

** uses external transformer. 10.8 in x 9.0 in x 14.3 in (275 mm x 229 mm x 364 mm) L x W x H, 135 lbs (61 kg) weight.



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