

3. Specifications

- (1) Weld power: 3-phase 220VAC, +10%, -20% 50/60Hz
- (2) Control power: same as weld power
- (3) Control unit output: 50A-peak value maximum, 2KHz, air cooling
- (4) Type of control: either constant current, constant voltage, or constant power
- (5) Timer setting ranges (7 schedules)
 - 1) RISE 1 : 0-49 MS (included in WELD 1)
 - 2) WELD 1 : 0-99 MS
 - 3) COOL : 0-99 MS
 - 4) RISE 2 : 0-49 MS (included in WELD 2)
 - 5) WELD 2 : 0-99 MS
- (6) HEAT 1 and HEAT 2 setting ranges (7 schedules)
 - 1) constant current control: 0.20-2.00KA
 - 2) Constant voltage control: 0.20-2.00V
 - 3) Constant power control: 0.04-4.00KW
- (7) Monitor setting ranges (7 schedules)
 - 1) Current monitor : \pm 0.00-9.99 KA
 - 2) Voltage monitor : \pm 0.00-9.99 V
 - 3) Power monitor : \pm 0.00-9.99 KW
- (8) Total count setting range (1 schedule):
00000-99999
- (9) Weld transformer selection channel number:
0-4
- (10) Weld transformer selection interval time:
10-990ms (in 10ms increments)
- (11) Mode selection (1 schedule)
(Items in parentheses indicate what will be shown on the LCD.)
 - 1) Current monitor (IM): OFF (0)/WELD 1(1)/WELD 2 (2)
 - 2) Voltage monitor (VM): OFF (0)/WELD 1(1)/WELD 2 (2)
 - 3) Power monitor (WM): OFF (0)/WELD 1(1)/WELD 2 (2)
 - 4) Start and end output mode (MR) : (0)/(1)
 - 5) 7-schedule start (7S) : (0)/(1)
 - 6) Panel schedule start (PS) : (0)/(1)
 - 7) Program lock (NP) : (0)/(1)
 - 8) Feedback gain adjustment(C-GAIN=): (0) - (9)
 - 9) Data output (D-OUT=) : (OFF)/(ON)
- (12) External input signals:
Start 1, start 2, start 3, start 4, trouble reset.
Supply normally open no voltage relay inputs or transistor inputs.

- (13) External output signals:
Weld end, trouble: relay contact output, relay
capacity 100VAC, 0.5A.
Counter: transistor output, capacity 24 VDC
50 mA
- (14) Compatible weld transformers: IT-500A and IT-501A
- (15) WELCARD (RAM Card)
- 1) Capacity: Schedule card -13 welders
Monitor 1 card -1686 welds
Monitor 2 card -7167 welds
 - 2) Monitor data items recorded
Monitor 1 card: start number, current 1,
current 2, voltage 1, voltage
2, power 1, power 2, average
pulse width 1, average pulse
width 2, time
Monitor 2 card: start number, deviation from
control value (%), time
 - 3) Memory protection battery:
BR2016 lithium battery: battery life is more than
5 years.
- (16) Data output (optional): RS-485
- (17) Memory protection battery:
- 1) Lithium battery: CR 2/3 8.L (Fuji
Electrochemical), or any reliable 3V 1500mAH
battery
 - 2) Battery life: 5 years from shipping date
- (18) Recommended temperature range for operation: 0-45
degrees C
- (19) Weight: 22 lb (10Kg)
- (20) Accessories: 1 power cable
1 output cable
1 sensor cable
1 I/O cable
1 operational manual