

welding power

HAC-1000

PROGRAMMABLE AC WELDING CONTROLLER

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The Model HAC-1000 is a programmable, highly versatile AC welding power supply. Intended for higher power applications or, when high repetition rates are required, this compact, microprocessor-based system is designed to control complex welding functions with simple walk-through programming.

Applications:

Ferrous Metals Welding
Seam/Roll/Spot Welding
Resistance Brazing

features

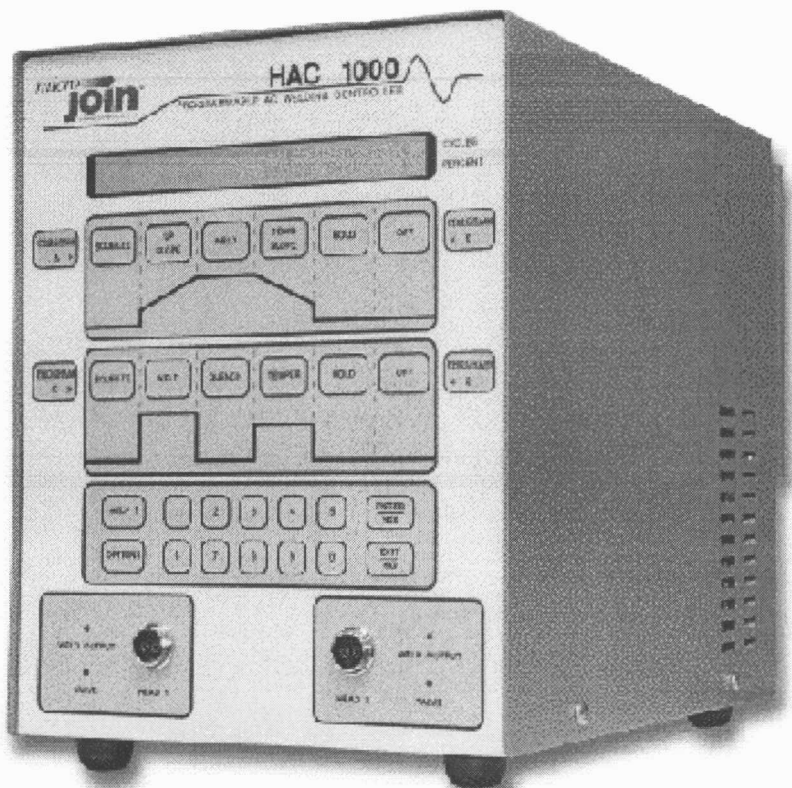
- Backlit LCD
- Intuitive easy-to-use interface
- Wide range of transformer options to meet application requirements
- Exceptional range of weld sequence programming options

Programmable Weld Schedules

Four different weld schedules may be pre-programmed. The schedule may be selected by pressing a membrane switch on the front panel. For applications that are automated, the programs may be selected or altered through an RS-232 port.

Built-in Operational Manual

The HAC-1000 power supply is designed for ease of use. A HELP key provides a built-in operation manual, and an OPTIONS key prompts the operator through a variety of functions. A backlit liquid crystal display (LCD) continuously sends the entire weld schedule for a selected program. When changes are necessary, the display shows simple instructions to take the operator through the changes step-by-step. For more experienced technicians, a shortened instruction set may be displayed.



Wide Range of Weld Sequences

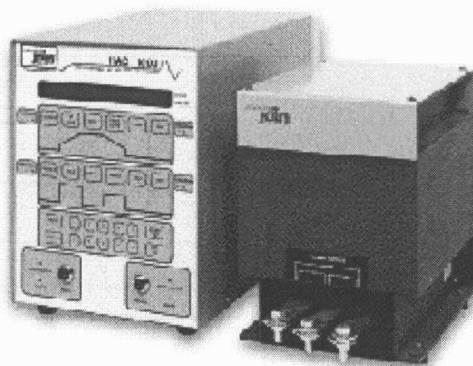
In addition, the HAC-1000 offers a variety of weld sequences including:

- Upslope - Weld - Downslope
- Squeeze - Weld - Hold - Off
- Weld - Quench - Temper
- Preheat - Weld - Postheat
- Roll - Spot

Power Flexibility

The HAC-1000 features automatic power factor correction and is designed to perform with a variety of transformers and weld heads. It also incorporates automatic line frequency adaptation (50 or 60 Hz), line voltage compensation and internal valve drivers for pneumatic weld heads.

Black



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A Polymer Technology Company

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specifications - model HAC-1000

Control type	Single phase, absolute count	
Input voltage	230 V \pm 15% (460 V optional)	
Input frequency	50 or 60 Hz (automatic detection)	
Weld sequence control		RS-232 Interface
Squeeze time	00 to 99 cycles	00 to 32000 cycles
Upslope time	00 to 99 cycles	00 to 32000 cycles
Weld time	1/2, 1 to 99 cycles	00 to 32000 cycles
Quench time	00 to 99 cycles	00 to 32000 cycles
Temper time	00 to 99 cycles	00 to 32000 cycles
Downslope time	00 to 99 cycles	00 to 32000 cycles
Hold time	00 to 99 cycles	00 to 32000 cycles
Off time	00 to 99 cycles	00 to 32000 cycles
Repeat	00 to 99 cycles	00 to 255 cycles
Percent current to weld time (top heat, bottom heat, temper time)	20-95% rms	
Automatic power factor correction	Standard	
Silicon control rectifier (SCR) rating	70 A at 50% duty cycle	
Dimensions (H x W X D)	12" x 9" x 16.5" (305 mm x 229 mm x 419 mm)	
Weight	30 lb (14 kg) installed, 40 lb (18 kg) shipping	
Power cord	5 ft (1.5 m) terminated with Huble No. 2321 connector	
Output cable	5 ft (1.5 m) 12 AWG cable terminated with MS-3106A-22-9S connector	
Power supply firing options	(2) Two pin female amphenol connectors on front panel for direct connection (2) Seven pin female amphenol connectors to heads (2 max.) for foot switch operation (SPDT)	

available transformers for use with the HAC-1000

Model	230 V 50/60 Hz	Output (V)
WD-9817-001	2.5 KVA	1.2, 2.3, 3.5
WD-9817-002	5.0 KVA	5.0
WD-9817-003	15.0 KVA	2.35, 4.7, 7.1
WD-9817-004	5.0 KVA	12.0
WD-9817-005	5.0 KVA	1.9, 5.6, 7.5
WD-9817-009	15.0 KVA	12.0

Model	460 V 50/60 Hz	Output (V)
WD-9817-006	5.0 KVA	12.0
WD-9817-007	5.0 KVA	1.9, 5.6, 7.5
WD-9817-008	15.0 KVA	12.0

Ordering Configuration and Options HAC-1000

High-capacity capacitor discharge welding power supply especially designed for high repetition rates and complex welding control. Unit features 100 weld schedules, programmable weld count limit alarm, weld lookout feature, external I/O for integration to automation systems and double pulse capability.

HAC1000-XXX

Input Voltage
230 230V, 1-phase, 60 Hz (std)
460 460V, 1-phase, 50/60 Hz

Model HAC0230 - Solid state weld controller is available for lighter duty applications.

Represented by:

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