

SPECIFICATIONS

POWER SUPPLY MODEL	Spot Weld				Seam/Roll Spot	
	IS-120B	IS-444B	ISA-500A	IS-471B	IS-443B	IS-470B
Power Source	3 phase 480VAC / 440VAC / 400VAC / 220VAC +10% -15% 50/60 Hz.					
Output Frequency	1 kHz / 800 Hz / 600Hz (selectable)					
Output Voltage	Single phase 650V, peak @ 480V input					
Rated Capacity	52kVA @ 480 VAC	182kVA @ 480 VAC	325kVA @ 480 VAC	182kVA @ 480 VAC	325kVA @ 480 VAC	
Max. Primary Output Current	200A (8% duty cycle)	500A (15% duty cycle)	1000A (12% duty cycle)	500A (15% duty cycle)	1000A (12% duty cycle)	
Control Systems	Secondary Constant Current Secondary Constant Power Primary Constant Current (RMS) Primary Constant Current (Peak) Fixed Pulse Secondary Constant Voltage	Secondary Constant Current Secondary Constant Power Primary Constant Current (RMS) Primary Constant Current (Peak) Fixed Pulse		Primary Constant Current (PWM RMS Value) Primary Constant Current (PWM Effective Peak) Fixed Pulse		
Control Modes	n/a	Forging, Chaining, Successive		n/a		
Weld Schedules	15 schedules		15 schedules		7 schedules	
Timer Settings	<i>ms Mode</i>	<i>Cycle Mode</i>	<i>ms Mode</i>	<i>Cycle Mode</i>	<i>ms Mode</i>	
Squeeze Delay	0000-9999ms	000-999cyc	0000-9999ms	000-999cyc	n/a	
Squeeze	0000-9999ms	000-999cyc	0000-9999ms	000-999cyc	0000-9999ms	
Delay	n/a	n/a	n/a	n/a	000-999ms	
Weld 1	000-600ms	00-30cyc	000-600ms	00-30cyc	000-600ms	
Upslope	000-400ms	00-20cyc	000-400ms	00-20cyc	000-400ms (included in Weld 1)	
Cool	000-999ms	00-99cyc	000-999ms	00-99cyc	000-999ms	
Weld 2	000-600ms	00-30cyc	000-600ms	00-30cyc	n/a	
Downslope	000-400ms	00-20cyc	000-400ms	00-20cyc	n/a	
Hold	000-999ms	00-99cyc	000-999ms	00-99cyc	000-999ms	
Off	0000-9990ms	00-99cyc	0000-9990ms	00-99cyc	n/a	
Pulses	1-9	1-9	1-9	1-9	1-9	
Max. Secondary Current Settings	0.1 - 20.0kA	2.0 - 40.0kA	4.0 - 80.0kA	1.0 - 20.0kA	2.0 - 40.0kA	
Weld Monitors						
Current	00.0-20.0kA	00.0-40.0kA	00.0-80.0kA	00.0-20.0kA	00.0-40.0kA	
Voltage	00.0-9.99V	0.00-9.99V	0.00-9.99V	n/a	n/a	
Power	00.0-20.0kW	00.0-40.0kW	00.0-80.0kW	n/a	n/a	
Pulse Width	10%-100%	10%-100%	10%-100%	10%-100%	10%-100%	
Program Unit	MA-627A (sold separately)					
Monitor Unit	MA-628A (sold separately)				n/a	
Physical Characteristics						
Dimensions Inches	11.0 x 7.00 x 25.0	27.0 x 12.0 x 20.0	27.0 x 12.0 x 26.0	27.0 x 12.0 x 20.0	27.0 x 12.0 x 26.0	
H x W x D (mm)	(279 x 178 x 635)	(686 x 305 x 508)	(686 x 305 x 660)	(686 x 305 x 508)	(686 x 305 x 660)	
Weight: lbs (kg)	33 (15)	99 (45)	139 (63)	99 (45)	139 (63)	
Transformer Model	IT-40	IT-85	IT-130	IT-250		
Rated Capacity	40kVA @ 50%	85kVA @ 50%	130kVA @ 50%	250kVA @ 50%		
Max. Input Voltage	650V	650V	650V	650V		
Input Frequency	1000 Hz	1000 Hz	1000 Hz	1000 Hz		
Unloaded Secondary Voltage/Turns Ratio	4.28V (152:1), 8.55V (76:1)	8.9V (73:1), 9.5V (68:1)	13.0V (50:1), 13.8V (41:1)	13.0V (50:1)		
Cooling Water	1 gal/per min.	2 gal/per min.	4 gal/per min.	4 gal/per min.		
Dimensions Inches (H x W x D) (mm)	6.75 x 5.00 x 14.9 (171 x 127 x 378)	6.75 x 6.00 x 11.9 (171 x 152 x 302)	10.3 x 6.00 x 15.5 (262 x 152 x 394)	10.3 x 7.75 x 19.0 (262 x 197 x 483)		
Weight lbs. (Kg)	60 (27)	60 (27)	110 (50)	130 (59)		

Your Local Representative



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