



IS Series - Mid-Frequency Inverter Weld Controls

The IS Series - Mid-Frequency Inverter Weld Controls feature closed-loop current, voltage, and power feedback, fast response times, and a wide range of output power - 0.050-80 kA in 4 ranges. This makes them ideal for small or large, single or mixed part manufacturing.

Six different weld control models allow the user to select the best mode for the application: primary limit, primary and secondary RMS, power RMS, voltage control or pulse percent.

Packaged in a NEMA enclosure, the new units come as standard with a rotary handle and internal circuit breaker. It has a "triple pulse" weld capability which provides flexible weld profiles and enables three pulses in each cycle. Each weld segment can be programmed with upslope and downslope and may contain up to 19 pulses.

Key features IS Series - Mid-Frequency Inverter Weld Controls

- > 800 A or 1400 A primary output
- > Six feedback modes
- > Built-in current, voltage, power, time and pulse monitor
- > Optional displacement monitoring and proportional regulator control
- > Primary short-circuit protection
- > Triple-pulse weld profile: W1, W2, W3, up to 19 pulsations per weld segment
- > Pre-weld check process tool
- > I/O check screen
- > Cascade option: 5 and 7-way cascade
- > RS232 or RS485 communications
- > NEMA style enclosures

Specifications IS Series - Mid-Frequency Inverter Weld Controls

.	IS800 AMY-Global Version	IS-1400 AMY-Global Version
Maximum primary output current (peak)	1400 amps @ 3%	4000 amps @ 12%
Settings - Constant current	0.05 - 80.0 kA	1.00-260 kA
Settings - Constant power	0.05-120 kW	0.50-390 kW
Settings - Constant voltage	0.20-9.99 V	0.20-9.99 V
Settings - Fixed pulse	10.0-99.9%	10.0-99.9%
Weld monitors - Current	0.0-99.9 kA	0.0-300.0 kA
Weld monitors - Power	000.0-999.9 kW	000.0-999.9 kW
Weld monitors - Voltage	0.00-9.99 V	0.00-9.99 V
Weld monitors - Pulse %	10.0 - 100.0%	10.0 - 100.0%
Power source	380 - 480 VAC, Three Phase, 50/60 Hz, +- 10%	380 - 480 VAC, Three Phase, 50/60 Hz, +- 10%
Output frequency	600 - 1000 HZ	600 - 100 HZ
Control modes	Primary constant current control, Primary limit control, Secondary RMS control, Power RMS control, Voltage control, Pulse % control	Primary constant current control, Primary limit control, Secondary RMS control, Power RMS control, Voltage control, Pulse % control
Number of schedules	255 (Selectable by pendant or external I/O)	255 (Selectable by pendant or external I/O)
Time settings: Squeeze delay	0000-9999 (ms) / 0000-9999 (CYC)	0000-9999 (ms) / 0000-9999 (CYC)
Time settings: Squeeze	0000-9999 (ms) / 0000-9999 (CYC)	0000-9999 (ms) / 0000-9999 (CYC)
Time settings: Upslope	000-999 (ms) / 00-50 (CYC)	000-999 (ms) / 00-50 (CYC)
Time settings: Weld	000-999 (ms) / 00-50 (CYC)	000-999 (ms) / 00-50 (CYC)
Time settings: Cool	0000-9999 (ms) / 0000-9999 (CYC)	0000-9999 (ms) / 0000-9999 (CYC)
Time settings: Down slope	000-999 (ms) / 00-50 (CYC)	000-999 (ms) / 00-50 (CYC)
Time settings: Hold	00000-20000 (ms) / 00000-00999 (CYC)	00000-20000 (ms) / 00000-00999 (CYC)
Time settings: Off time	0 or 0010 - 9990 (ms) / 0000 - 0099 (CYC)	00000-20000 (ms) / 00000-00999 (CYC)
Time settings: Pulsation setting	01-19 (settable for WELD 1 to WELD 3, respectively)	01-19 (settable for WELD 1 to WELD 3, respectively)
Transformer turns ration	1.0-199.9	01-19 (settable for WELD 1 to WELD 3, respectively)
Valve setting	Up to 6 valves - including proportional valve	Up to 6 valves - including proportional valve
Control gain (GAIN)	1-9	1-9
Step-up/-down (STEPPER COUNT)	STEP 1-9 (9 steps), UP (down) ratio (RATIO) 50-200%, Counter setting (COUNT) 0000-9999	STEP 1-9 (9 steps), UP (down) ratio (RATIO) 50-200%, Counter setting (COUNT) 0000-9999
Weld count monitor (PRESENT COUNT)	0000-9999	0000-9999
External communication	RS-232 (single or bi-directional)	RS-232 (single or bi-directional)
Program protect	Programming protected when active	Programming protected when active
EU Certification	CE compliant	CE compliant
WEIGHT & DIMENSIONS		
Dimensions L x W x H	800 x 800 x 2000 mm	800 x 800 x 2000 mm

Weight	250 kg	300 kg
Options	RS-485 communications (RS-232 standard), Isolation contactors, MG Weld monitors, Cable throughput top cabinet	

Product applications IS Series - Mid-Frequency Inverter Weld Controls



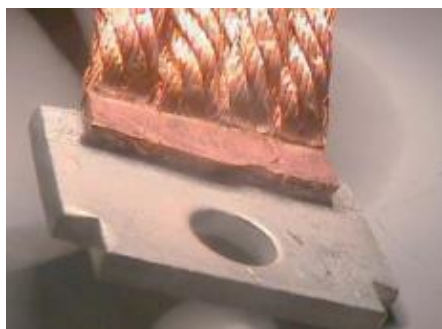
Commutator fusing



Wire termination



Sheet metal welding

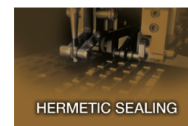


Braided cable termination

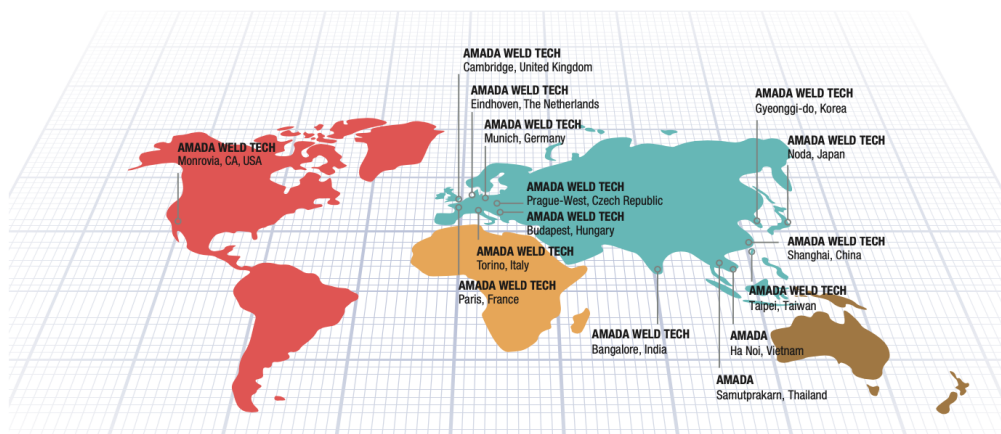
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