



IS-300A

Mid-Frequency Inverter Resistance Welding Control

- 300 amp primary output
- Six feedback modes
- Built-in current, voltage, power, time and pulse monitor
- Primary short circuit protection
- Triple pulse weld profile: W1, W2, W3, up to 19 pulsations per weld segment
- I/O check screen
- 5-way cascade option using MA-650A
- Pre-weld check process tool
- RS232 or RS485 communications
- Compact design

KEY FEATURES

Six Weld Control Modes

Six different weld control modes allows you to select the best control mode for your application: primary limit, primary and secondary RMS, power RMS, voltage control, or pulse percent.

Triple Pulse Weld Capability

Provides flexible weld profiles allowing for three pulses in each weld cycle. Each weld segment may be programmed with upslope and down-slope and can have up to 19 pulsations in each segment. You can also change the control mode for each weld segment.

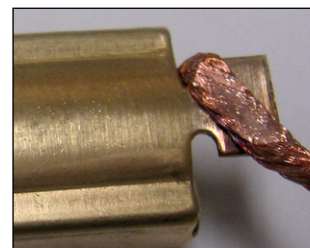
Wide Current Range

The **IS-300A** inverter spot welder has a current range of .050 A to 20 kA making it possible to weld a large range of parts – from small, electronic components to sheet metal and copper bus bars – with the same welding control.

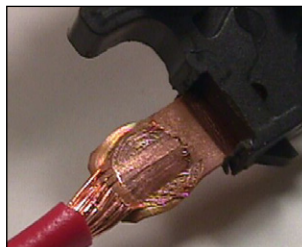
TYPICAL APPLICATIONS



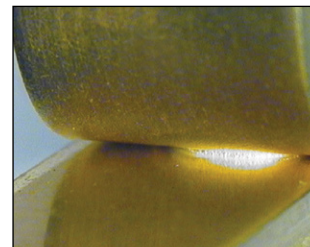
Commutator fusing



Brass terminal



Wire termination



Sheet metal welding

TECHNICAL SPECIFICATIONS

Model	IS-300A-00-00	IS-300A-00-01	
Power requirements (fixed at factory)	3-phase, 200–240 VAC±10% (50/60 Hz)	3-phase, 380–480 VAC±10% (50/60 Hz)	
Max. output current	300 A (peak value)		
Duty cycle	300 A @ 4.4%, 200 A @ 10%, 100 A @ 35%, 45 A @ 100%		
Number of schedules	255		
Output frequency	600 Hz~3 kHz (in 100 Hz increments)		
Control method	Primary constant-current RMS / Secondary constant-current RMS / Secondary constant-power RMS / Primary constant-current PEAK / Secondary constant-voltage RMS / Constant-phase control		
Timer setting range		Millisecond mode	Cycle mode
	SQUEEZE DELAY	0000~9999 ms	000~999 cyc
	SQUEEZE	0000~9999 ms	000~999 cyc
	UP-SLOPE 1,2,3	000~999 ms	00~50 cyc
	WELD 1,2,3	000~999 ms	00~50 cyc
	DOWN-SLOPE 1,2,3	000~999 ms	00~50 cyc
	COOL 1,2	000~999 ms	000~999 cyc
	HOLD	00000~20000 ms	000~999 cyc
	OFF	0 or 10~9990 ms	00~99 cyc
Transformer turns ratio	1.0~199.9		
Pulsation setting	01~19		
Valve setting	2		
Setting range	Constant current Constant power Constant voltage Constant phase	0.05~ 20.0 kA .05~20.0 kW 0.20~9.99 V 10.0~99.9%	
Current monitor	00.0~99.9 kA / 0.00~9.99 kA		
Power monitor	000.0~999.9 kW / 00.00~99.99 kW		
Voltage monitor	0.00~9.99 V		
Pulse width monitor	HIGH 10.0~100%		
Cooling method	Forced air cooling		
Data communication	RS-232C (one-way communication) / RS-485 (bidirectional communication)		
Corresponding transformer	IT-1040-3	(500 V) IT-4040-3 IT-4085-3, IT-4140-3 (650 V) IT-1040-3, IT-1085-3, IT-1140-3	

WEIGHT & DIMENSIONS

Dimensions (L x W x H)	22.6 in x 6.8 in x 10.6 in (574.0 mm x 172.7 mm x 269.2 mm)
Weight	36.4 lbs (16.5 kg)



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