

## The HCD features give you these benefits:

FEATURE	BENEFIT
■ Microprocessor controlled with program storage of 100 weld schedules and password protection	Precise control of all welding parameters; repeatable process setup and program storage security
■ Four easily selected pulse widths	Enables welding of a large variety of materials including conductive metals
■ Weld fire lockout	Ensures consistent energy output even during rapid firing
■ Double pulse	Improves the weldability of plated materials
■ Advanced electronics	Increased welding rates mean increased production rates; allows for compact design, increasing the available usable work bench area
■ Push-button programming and large LED display	Simplifies operation and reduces training time
■ Weld counter	Improves process control by alerting operator to inspect for electrode wear
■ External inputs/outputs	Simplifies integration into automated work cells; interfaces easily with a PC or PLC

## HCD-125



### SPECIFICATIONS • HCD-125

Input voltage	90–130 VAC; 180–260 VAC (add -CO1 suffix)
Input frequency	50 or 60 Hz, automatically selected
Standby current	less than 0.5 amp
Current limits	2 x 12 amp
Weld pulse width	0.9 ms (very short); 2.0 ms (short); 2.9 ms (medium); 4.7 ms (long)
Weld pulse rise time	0.3 ms (very short); 0.6 ms (short); 0.9 ms (medium); 1.5 ms (long)
Peak voltage (into 1-mΩ load)	6.0 V (very short); 5.5 V (short); 5.1 V (medium); 4.1 V (long)
Energy storage	0.1–125 Ws ± 5%; 1500 μf; 40–406 Vdc
Weld speed (continuous)	150/min (100% power)
Ventilation	forced air
Inputs	Firing switch . . . . . SPST actuator switch; contact usually open Program selection . . . . . 7 pins of 15 pin DB15-F; switch closure inputs; select from program 1–99
Outputs	Weld inhibit . . . . . 1 pin of 15 pin DB15-F; switch closure input open collector output or TTL (jumper selectable) Process complete . . . . . changes state during discharge Weld ready . . . . . changes state during discharge, capacitor bank recharge, and in No Weld position Counter alarm . . . . . changes state after current weld count exceeds preset weld count
RS-232 interface	3-wire connection, DB9-F
Blackout data retention	battery backed-up RAM
Installed size	12-in. (305-mm) high; 9-in. (229-mm) wide; 16-in. (407-mm) deep
Installed weight	36 lb (17 kg)
Shipping size and weight	one container; 2.5 total ft <sup>3</sup> (70 L); weight 46 lb (21 kg)

*Specifications subject to change without notice*