



CD SPM Welders

Single Pulse Capacitive Discharge Spot Welders



Applications:

- Cross wire welding
- Thermocouple welding
- Copper, Aluminum, Steel, and Brass wire and sheet welding
- Strain gauges

Features:

- 100 or 200 watt second capacity
- Single Pulse operation
- Weld energy displayed in 0.1ws increments below 10ws
- Simple, user-friendly interface
- Up to 120 welds/min

CD SPM Spot Welders

Sunstone's CD SPM microprocessor-controlled single pulse resistance spot welders are engineered to provide a wide range of welding flexibility for fine-spot resistance welding. The CD SPM welders can provide as little as 0.1 watt seconds of energy for welding microscopic wires and parts. For thicker welds, energy can be adjusted up to 100ws or 200ws depending on the unit model. These welders are versatile and easy-to-use for many fine-spot resistance welding applications.

The welder interface lets users quickly select weld settings for a wide variety of welding applications. New features and enhancements found on the CD SPM welders include:

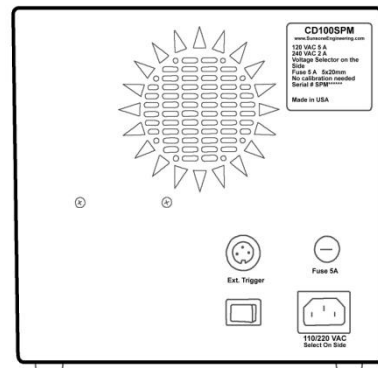
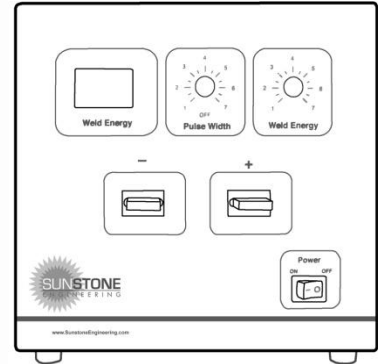
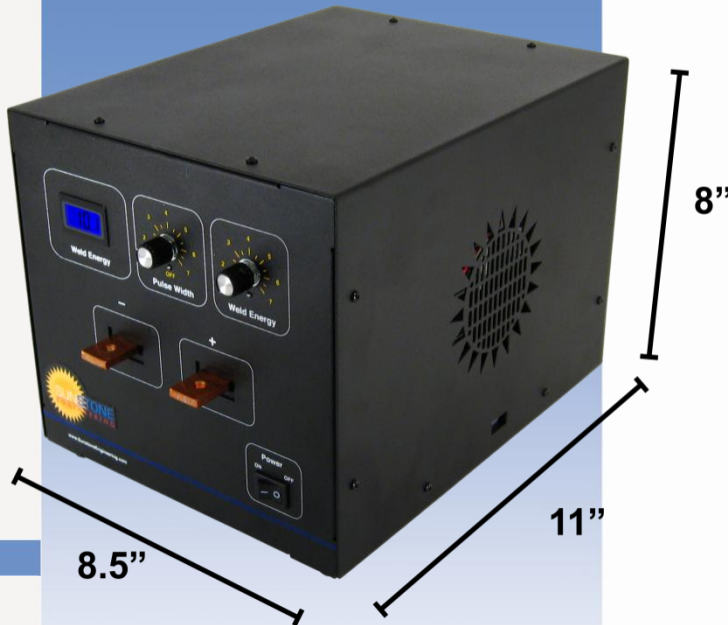
- Refined Control of Weld Energy
- LCD Display with Exact Energy Read-Out
- Audio Beeps – Indicating Weld Initiation Successful
- Thermal Protection Monitoring of Internal Power Supply Temperature

These enhancements to Sunstone's original CDSP welders allow for increased use and functionality at an affordable price.



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Specifications

Table 1: Peak weld current as a function of weld energy and external welding load

CD100 SPM				CD200 SPM			
Energy (ws)	1.0mΩ Load (Amps)	1.5mΩ Load (Amps)	4.0mΩ Load (Amps)	Energy (ws)	1.0mΩ Load (Amps)	1.5mΩ Load (Amps)	4.0mΩ Load (Amps)
0.1	250	200	100	0.2	250	200	100
25	3953	3162	1581	50	3953	3162	1581
50	5590	4472	2236	100	5590	4472	2236
75	6847	5477	2739	150	6847	5477	2739
100	7906	6325	3162	200	7906	6325	3162

Table 2: Weld speed in welds per minute

Pulse Width (% of maximum energy)	CD100 SPM welds/min (pulse energy)	CD200 SPM welds/min (pulse energy)
2.5%	120 (2.5ws)	120 (5ws)
25%	85 (25ws)	42 (50ws)
50%	60 (50ws)	30 (100ws)
75%	50 (75ws)	25 (150ws)
100%	40 (100ws)	20 (200ws)



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Table 3: Weld Pulse Characteristics

Model	Min and Max Output	Pulse Width		Min Pulse Height
		Min	Max	
CD100 SPM	0.1 ws - 100 ws	0.26 ms	5 ms	0.2 V
		0.47 ms	10 ms	
CD200 SPM	0.1 ws - 200 ws	0.26 ms	5 ms	0.2 V
		0.47 ms	10 ms	

Table 4: Physical Characteristics

	CD100 SPM		CD200 SPM	
	Inches	cm	Inches	cm
Height	8	20.3 cm	8	20.3 cm
Width	8.5	21.6 cm	8.5	21.6 cm
Depth	11	28 cm	11	28 cm
Weight	17 lbs	(8 kg)	19 lbs	(9 kg)



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