



Dual Pulse Capacitive Discharge

The Sunstone™ CDDP Welder

For Strong Weld Joints that Only a Sunstone Dual Pulse Welder Can Deliver

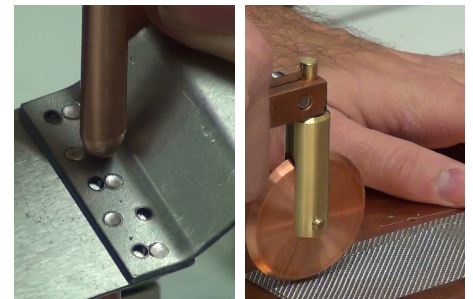
Capacitive discharge (CD) resistance welders have many advantages over other welder types. You'll appreciate a quick energy release concentrated into a small area, generating only a small heat signature or heat affected zone (HAZ). For more delicate projects, such as battery welding, the Sunstone's welding technology maintains the integrity of the cell's chemistry.

Sunstone's dual pulse feature is ideal for achieving strong weld joints. Dual pulse divides the energy into two pulses that occur within milliseconds of one another. Pulse 1 is a low energy pulse designed to pre-heat the work piece, helping to seat the electrodes, reduce weld splash, and burn away contaminants and oxides. Pulse 2 performs the actual weld by discharging the remaining stored energy.

The Sunstone CDDP welders are simple to use with an intuitive and user-friendly interface. Each can be adjusted and fine-tuned to match the requirements of countless applications. A digital screen displays total weld energy and individual pulse length settings, ensuring detail and precision. When combined with a Sunstone weld head or hand attachments, you'll enjoy strong and repeatable welds for high levels of consistency and quality control.

FEATURES

- Choose from 200, 400, 600, and 1000 Ws Models
- Single or Dual-Pulse Operation
- Roll Spot Capable (optional)
- Infinitely Adjustable Pulse Width
- Up to 275 Welds/Min (depending on model and energy)
- 1 Year Warranty Backed by Sunstone's Reputation for Quality and Customer Service



TYPICAL APPLICATIONS

- Battery Pack Assembly
- Thermocouples & RTD's
- Strain gauges
- Flat Heating Elements
- Mesh
- Cross Wire Welding
- Foils & Small Wires
- Temperature Sensors
- Honeycomb & Aerospace
- Terminals & Relays

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sunstone
The Micro Welder Experts

Weld Pulse Specifications

	CD200DP	CD400DP	CD600DP	CD1000DP
Min/Max Output	5-200 Ws	5-400 Ws	5-600 Ws	30-1000 Ws
Pulse Width Min/Max	0.53/43.2 ms	0.37/48.1 ms	0.29/51.1 ms	0.23-54.7 ms
Rise Time to Max Voltage	0.2 ms	0.2 ms	0.2 ms	0.2 ms
Min Pulse Height	2.5 V	2.04 V	2.04 V	2.2 V
Max Pulse Height	15.8 V	18.3 V	22.4 V	20.5 V

Technical Specifications

FEATURE	ALL MODELS
Single and Dual Pulse	Yes
Pulse 1 Energy Adjustment (% of setpoint energy)	0% to 30%
Pulse 2 Energy Adjustment (% of setpoint energy)	0% to 99%
Peak Current	7905-11,180 Amps

Weld Speeds (weld per minute)

PG2 Copper Wheel or Weld Head (1AWG @ 1.8mΩ)			
Ws	CD200DP	CD400DP	CD600DP
10	185	167	149
20	150	135	125
40	118	105	96
100	84	73	68
200	62	54	51
400	-	38	36
600	-	-	29

DPHP-MP (4AWG @ 4.2mΩ)			
Ws	CD200DP	CD400DP	CD600DP
10	188	182	164
20	158	145	134
40	122	111	102
100	88	76	71
200	66	56	51
400	-	39	36
600	-	-	30

DPHP-LP (8AWG @ 8.8mΩ)			
Ws	CD200DP	CD400DP	CD600DP
10	215	196	177
20	177	170	148
40	132	121	117
100	93	81	76
200	69	60	56
400	-	30	39
600	-	-	30

Physical Characteristics

	CD200DP		CD400DP		CD600DP		CD1000DP	
	Inches	cm	Inches	cm	Inches	cm	Inches	cm
Height	10.5	26.7	10.5	26.7	10.5	26.7	11	28
Width	12	30.5	12	30.5	12	30.5	18.75	47.6
Depth	13.5	34.3	13.5	34.3	13.5	34.3	14	35.6
Weight	34 lbs	16 kg	39 lbs	18kg	39 lbs	18 kg	55 lbs	26kg

Power Specifications

	CD200DP	CD400DP	CD600DP	CD1000DP
Input Voltage	85 - 260 VAC	85 - 260 VAC	85 - 260 VAC	85 - 260 VAC
Frequency Range	47-63Hz	47-63Hz	47-63Hz	47-63Hz
Power Factor (typ.)	PF>0.94/230VAC PF>0.99/115VAC	PF>0.94/230VAC PF>0.99/115VAC	PF>0.94/230VAC PF>0.99/115VAC	PF>0.94/230VAC PF>0.99/115VAC
AC Current (typ.)	8.5A/115VAC 5A/230VAC	8.5A/115VAC 5A/230VAC	8.5A/115VAC 5A/230VAC	8.5A/115VAC 5A/230VAC

Peak Weld

	CD200DP	CD400DP	CD600DP	CD1000DP
1AWG 4ft	7905	9130	11180	10250
4AWG 6ft	6081	7023	8600	7885
8AWG 6ft	3162	3632	4472	4100
Minimum Load=1m0hm. Using a smaller load may damage the welder.				

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MADE IN THE USA  **EWI** STRATEGIC TECHNOLOGY PARTNER

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