



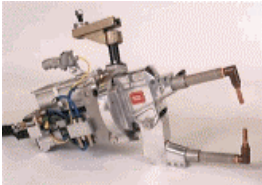
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### typical applications

#### projection welders



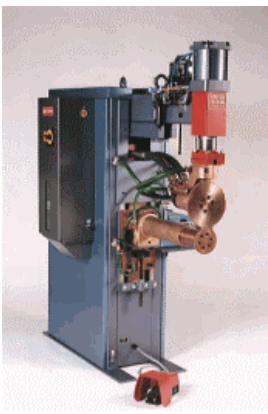
#### manual stations



#### robot stations



#### seam welders



# WS700 welding control

data sheet



## Value-priced features and flexibility

The WS700 has been designed as an easy to use welding control timer intended for the customer who requires monitoring and quality welds. This timer has spot/pulsation/seam and roll-spot sequences with selectable phase angle or constant current control. A simple to use 4-line LCD and keypad allows up to 64 programs of weld settings to be entered. The timer can be supplied in a combination cabinet with circuit breaker and SCR to suit all machine kVA sizes.

features	benefits
easy to use	ready to go
phase angle/constant current	quality welds
integral programmer	always available
50 or 60 Hz operation	international
64 user-defined programs	store settings for different material and thicknesses
retract control	suitable for most types of gun operation
counter function	can be used for electrode maintenance
weld current monitoring	quality welds
proportional valve control	control the welding force
pressure monitoring	quality welds
printer output	record weld quality

### options

- WS98-700 PC software for programming and monitoring
- ELR/1 earth-leakage relay
- 2-hand start unit
- 3PA/2 3-phase adapter

### configurations

WS700, cabinet and SCR combinations are shown in document 91-10-00-00-16

# WS700 welding control

data sheet

## program parameters x 64

presqueeze	0..99 cycles
squeeze	0..99 cycles
weld1	0..99 cycles
cool1	0..99 cycles
weld2	0..99 cycles
cool2	0..99 cycles
pulses	0..9
hold	0..99 cycles
off	0..99 cycles
pressure	0..10 V
heat1	0..99 %
heat2	0..99 %
current1	0..60 kA
current2	0..60 kA

## monitoring parameters x 64

current monitor	on/off
weld1 high/pre/low limit	0..99 %
weld2 high/pre/low limit	0..99 %
pre-limit count	0..99
pressure monitor	on/off
pressure high/low limit	0..99 %

## configuration parameters

sequence	spot/roll-spot/seam
retract	standard/hilift+/hilift-
frequency	50/60 Hz
contactor time	0..200 s
blanking	on/off
await pressure	on/off
toroid test	on/off
sensor	toroid/CT
heat range	high/low

## calibration parameters

toroid sensitivity	100..2000 mV/kA
CT sec:pri ratio	1:1..199:1
CT sec:pri offset	-1 kA..+1 kA
pressure	2 points, kN/V

## counter

actual count	0..9999
end count	0..9999
at end of count	stop/continue

## environmental

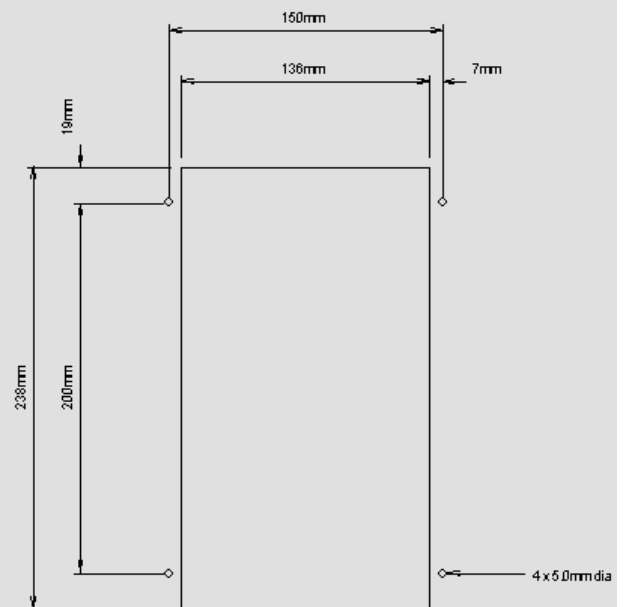
temperature	
- operating	0° to +50°C
- storage	-25° to +70°C
humidity	
- operating	up to 80% (relative)
- storage	10% to 90%

## dimensions

height	292 mm
width	172 mm
depth	38 mm

## mounting

cut-out dimensions



## power/synchronisation requirements

maximum input current	1 A @ 24 V dc ±20%
line frequency	50/60 Hz ±1Hz

## i/o ratings

2 outputs	500 mA @ 24 V dc each
6 outputs	100 mA @ 24 V dc each
12 inputs	10 mA @ 24 V dc each (max)

Information in the document is subject to change without notice.

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