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**typical applications**

brakeshoe welders



# WS700B welding control

data sheet



## Specialised sequence for brakeshoes

The WS700B is intended for brakeshoe welding applications requiring high quality welding and monitoring. This timer has a specific brakeshoe weld sequence with up to 16 spots per program/shoe. Each spot has selectable phase angle/constant current modes. 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
specific brakeshoe sequence	allows easy positioning of each spot
phase angle/constant current	quality welds
integral programmer	always available
50 or 60 Hz operation	international
64 user-defined programs	store settings for different types of brakeshoe
counter function	can be used for electrode maintenance
weld current monitoring	quality welds
pressure monitoring	quality welds
proportional valve control	control the welding force
printer output	record weld quality

### options

WS98-700B PC software for programming and monitoring  
 3PA/2 3-phase adapter  
 PM150W/300W/500W

### configurations

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

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# WS700B welding control

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### program parameters x 64

squeeze	0..99 cycles
spots	1..16
for each spot	
cool	0..99 cycles
weld	0..99 cycles
heat	0..99.9%
current	0..60 kA
mode	PHA/CCR
hold	0..99 cycles
pressure	0..10V

### monitoring parameters x 64

current monitor	on/off
current low limit	0..99%
current high limit	0..99%
pressure monitor	on/off
pressure low limit	0..99%
pressure high limit	0..99%

### configuration parameters

sequence	spot/roll-spot/seam
retract	standard/hilift+/hilift-
frequency	50/60 Hz
contactor time	0..200s
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	-1kA..+1kA
pressure	2 points, kN/V

### counter

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

### environmental

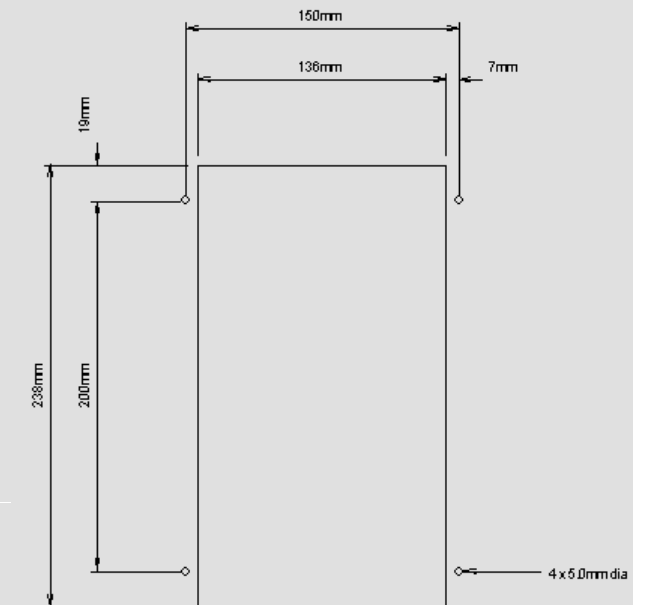
temperature	
- operating	+10° to +50°C
- storage	-25° to +70°C
humidity	
- operating	up to 80% (relative)
- storage	10% to 90%

### dimensions

height	292mm
width	172mm
depth	38mm

### mounting

cut-out dimensions



### power/synchronisation requirements

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

### 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)

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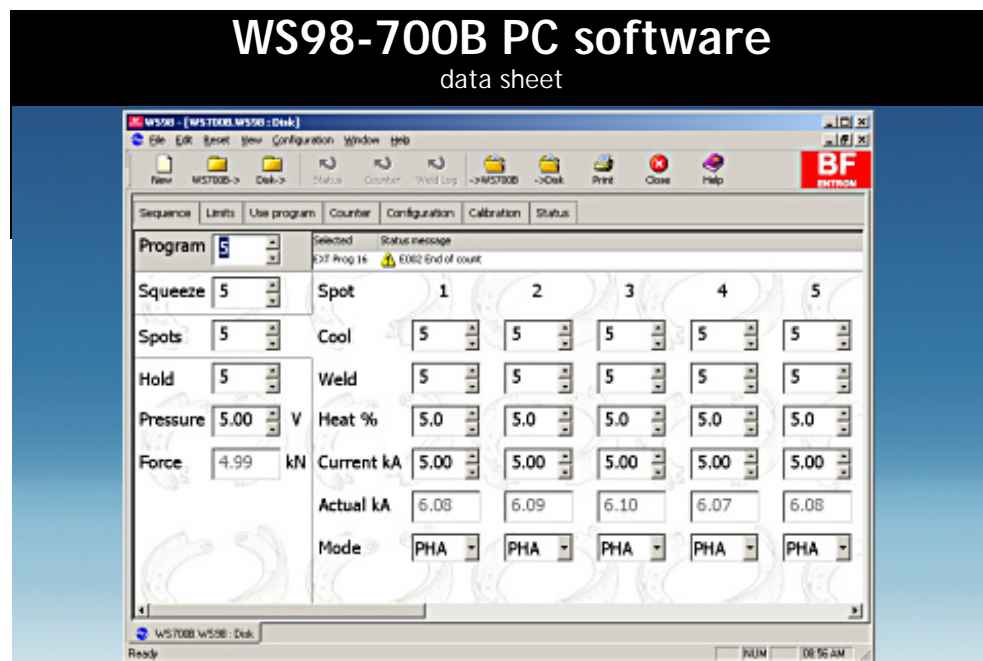
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Take control of your welding data

Using all the features of Microsoft® Windows®, WS98-700B allows you to program, monitor and archive the data in your WS700B welding control. Connection to the timer is via a fast but simple RS-232 link (cable supplied) and the settings are displayed in tabbed windows, with each window showing only the parameters relevant to your application. For the WS700B, WS98 is an essential partner.

features	benefits
easy to use	helps you get your work done
programming, configuration and status windows	parameters arranged in functional groups
enhanced tooltips	detailed explanation of all parameters
built-in printing and archiving	record and store all of your settings
multi-document interface	check the settings from disk or WS700B
context-sensitive HTML help	explains all features
detailed sequence log	record current, heat and force for every weld

options

none

configurations

none

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WS98-700B PC software data sheet

**program and limits display**

status information	✓
selected program	✓
sequence parameters	✓
monitoring parameters	✓
printing	✓
disk access	✓
status/counter reset	✓
context-sensitive help	✓

**use program display**

status information	✗
selected program	✓
printing	✓
disk access	✓
status/counter reset	✓
context-sensitive help	✓

**counter display**

status information	✗
selected program	✓
printing	✓
disk access	✓
status/counter reset	✓
context-sensitive help	✓

**configuration display**

status information	✗
selected program	✗
application-specific parameters	✓
printing	✓
disk access	✓
status/counter reset	✓
context-sensitive help	✓

**calibration display**

status information	✗
selected program	✗
CT, toroid and pressure calibration parameters	✓
printing	✓
disk access	✓
status/counter reset	✓
context-sensitive help	✓

**status display**

status information	✓
selected program	✓
results of the last weld	✓
force output and force feedback	✓
counter status	✓
i/o status	✓
printing	✓
disk access	✓
status/counter/log reset	✓
context-sensitive help	✓

**system requirements**

PC with a 486DX or higher running Microsoft Windows 98, 2000, XP or NT4 build 1381:service pack #4. Microsoft Internet Explorer 3 is required for HTML help functions.

5 MB of available hard-disk space

800x600 16-bit colour display

Microsoft mouse or compatible pointing device

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