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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 4line 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

WS700B welding control

data sheet

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

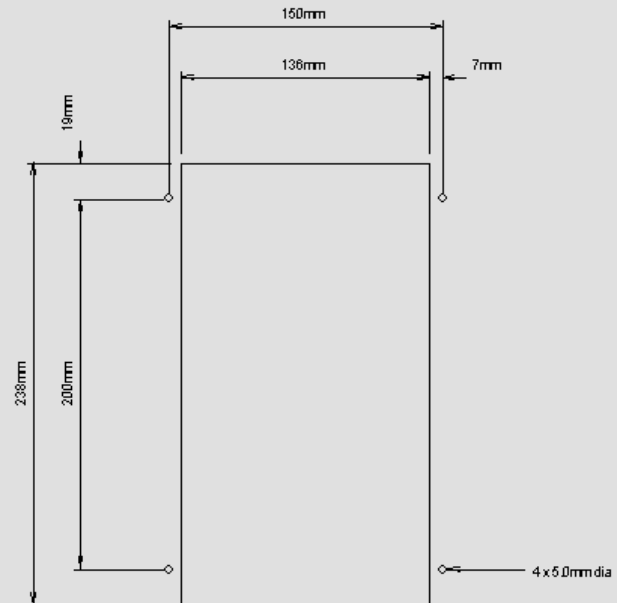
temperature	
- operating	+10° to +50°C
- storage	-25° to +70°C
humidity	
- operating	up to 80% (relative)
- storage	10% to 90%

dimensions

height	292mm
width	172mm
depth	38mm

mounting

cut-out dimensions



power/synchronisation requirements

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

Information in the document is subject to change without notice.

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