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typical applications

mf pedestal



mf robot stations



WS700ms welding control

data sheet



Medium-frequency features and flexibility

The WS700 has been designed as an easy to use medium-frequency 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 constant current.

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
constant current	quality welds
integral programmer	always available
inverter diagnostics	user-friendly
64 user-defined programs	store settings for different material and thicknesses
programmed in milliseconds	accuracy
retract control	suitable for most types of gun operation
counter function	can be used to stop welding
current/pressure monitoring	quality welds
proportional valve control	control the welding force
printer output	record weld quality

options

- WS98-700ms PC software for programming and monitoring
- ELR/1 earth-leakage relay
- 2-hand start unit

configurations

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

WS700ms welding control

data sheet

program parameters x 64

presqueeze	0..1999 ms
squeeze	0..1999 ms
weld1	0..999 ms
cool1	0..999 ms
weld2	0..999 ms
cool2	0..999 ms
pulses	0..9
hold	0..999 ms
off	0..999 ms
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
inverter	2 points, kA/% heat
pressure	2 points, kN/V

counter

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

environmental

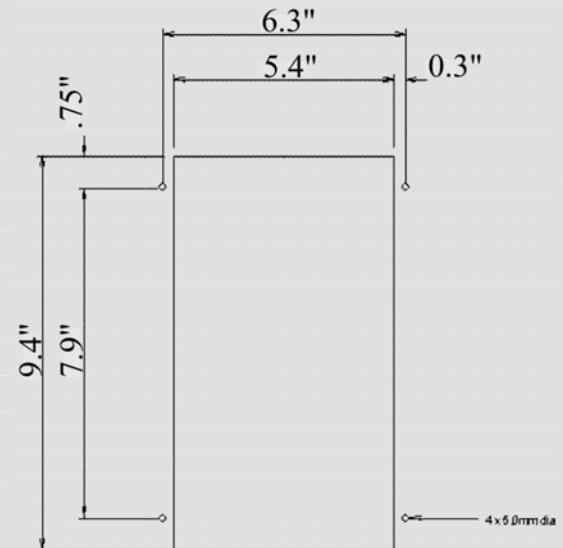
temperature	
- operating	32 to 122° F
- storage	-13 to 158° F
humidity	
- operating	20% to 80% (relative)
- storage	10% to 90%

dimensions

height	11.5"
width	6.75"
depth	1.5"

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	10mA @ 24 V dc each (max)

Information in the document is subject to change without notice.

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