

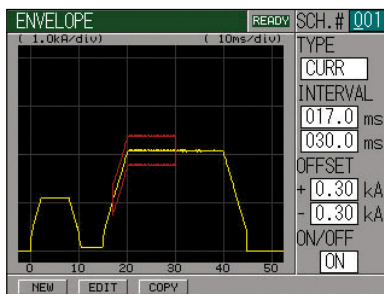


Fine Spot Welder IPB-5000B-MU DC Inverter Welding Power Supply

- Four control modes for process optimization for part manufacturing tolerances
- GOOD / NO GOOD determination signals if weld was successful providing instant feedback
- Displacement measurement indicates the amount of collapse the material exhibits during the weld.
- Envelope feature - allows users to set dynamic profile of limits around a setting.

KEY FEATURES

- **Control Modes** - Optimum control modes for obtaining ideal weld quality and consistency can be chosen from; constant current control, constant voltage control, combination of constant current and constant voltage control, and constant power control.
- **GOOD/NO GOOD determination** - The comparator feature allows to set upper and lower limits around the measured value of up to four parameters; which are current, voltage, power and resistance. When those values reach out of the limits, an error signal or a caution signal alarms.
- **Displacement Measurement** - Measures how much an electrode moves down because of material collapse during weld. Weld to displacement - stops welding when displacement value reaches the set value. Requires displacement sensor sold separately.
- **Envelope** - The envelope feature allows dynamic limits to be set around a monitored waveform to ensure the same resistance change occurs at the same rate for every weld.

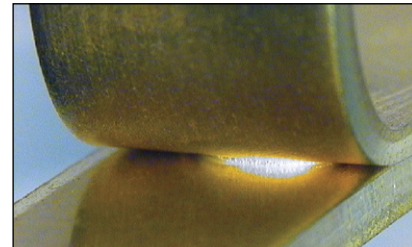


Red: envelope Yellow: current

TYPICAL APPLICATIONS



Automotive sensor



Electrical busbar



Motor armature

TECHNICAL SPECIFICATIONS

Model	IPB-5000B-MU	
Power requirements	Three phase, 200-240 VAC or 380-480 VAC, 50/60 Hz	
Primary frequency	5 kHz	
Primary current	200 A	
Feedback modes (Secondary supply)	Constant current, constant voltage, Combination of constant current and constant voltage control, constant power	
Time setting	Number of weld schedules	127
	Squeeze delay	0000 – 9999 ms (1 ms increments)
	Squeeze	0000 – 9999 ms (1 ms increments)
	Pre-check weld	00.0 – 10.0 ms (0.2 ms increments)
	Pre-check	1 ms (fixed)
	Upslope	000.0 – 500.0 ms (0.2 ms increments)
	Weld 1	000.0 – 500.0 ms (0.2 ms increments)
	Downslope	000.0 – 500.0 ms (0.2 ms increments)
	Pause	00.0 – 99.8 ms (0.2 ms increments)
	Upslope	000.0 – 500.0 ms (0.2 ms increments)
	Weld 2	000.0 – 500.0 ms (0.2 ms increments)
	Downslope	000.0 – 500.0 ms (0.2 ms increments)
Hold	000 – 999 ms (1ms increments)	
Current setting range	0.40 – 6.00 kA	
Current monitor	0.00 – 9.99 kA	
Displacement monitor	-29.999 mm to 29.999 mm	

TECHNICAL SPECIFICATIONS - TRANSFORMERS

Model	ITB-780B6
Rated capacity	17.4 kVA
Rated primary voltage	600/300 V (Rear Panel Jumper selection) See user Manual
Secondary voltage, no load	13 V
Maximum secondary current (Maximum duty cycle)	6000 A (2.5%) @480 VAC * 4000 A (2.5%) @240 VAC *
Cooling method	Forced air cooling
Frequency	5 kHz
Turns ratio of transformers	46:1 @480 VAC 23:1 @240 VAC

* Max secondary current dependent on secondary impedance.

WEIGHT & DIMENSIONS

	IPB-5000B-MU	ITB-780B6
Dimensions (W x D x H)	6.77 in x 15.35 in x 10.59 in (172 mm x 390 mm x 269 mm)	7.48 in x 14.80 in x 7.20 in (190 mm x 376 mm x 183 mm)
Weight	33 lb (15 kg)	28 lb (13 kg)



USA Headquarters and Western Technical Center

AMADA WELD TECH
1820 S. Myrtle Ave. • Monrovia, CA 91016 US • T: (626) 303-5676
info@amadaweldtech.com • www.amadaweldtech.com
ISO 9001 Certified Company • 24/7 Repair Service: 1-866-751-7378

AMERICAS

AMADA WELD TECH
(Eastern Technical Center)
High Point, North Carolina
T: (941) 544-5762
southsales@amadaweldtech.com

AMADA WELD TECH
(Midwest Technical Center)
Detroit, Michigan
T: (248) 313-3078
midwestsales@amadaweldtech.com

AMADA WELD TECH
(Mexico Office)
El Paso, Texas
T: (915) 881-8765
mxsales@amadaweldtech.com

EUROPE
AMADA WELD TECH
GmbH
Munich, Germany
T: +49-89-839403-0
infode@amadaweldtech.eu

ASIA

AMADA CO., LTD.
Isehara, Japan
T: +81-463-96-3268
sales@miyachi.co.jp

AMADA WELD TECH
SHANGHAI CO., LTD.
Shanghai, China
T: +86-21-6448-6000
jwu@amadaweldtech.com.cn

AMADA WELD TECH KOREA CO., LTD.
Seoul, Korea
T: +82-31-8015-6810
amadasales@amadaweldtech.co.kr
sales2@amadaweldtech.co.kr

AMADA WELD TECH TAIWAN CO., LTD.
Taipei, Taiwan
T: +886-3-328-3511

AMADA (THAILAND) CO., LTD.
Bangkok, Thailand
T: +66-2170-5900
info@amada.co.th

AMADA VIETNAM CO., LTD.
Ha Noi, Vietnam
T: +84-4-6261-4583
thuyet@amada.co.jp

AMADA WELD TECH
INDIA PVT., LTD.
Bangalore, India
T: +91-80-4092-1749
info@amadaweldtech.in

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