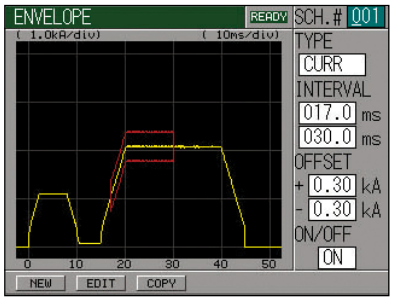


Fine Spot Welder
IPB-5000B-MU
DC Inverter Welding Power Supply

- 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.

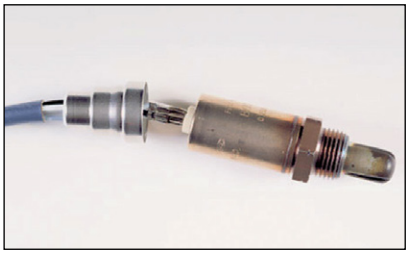
KEY FEATURES

- ***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.
- ***Diplacement 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.

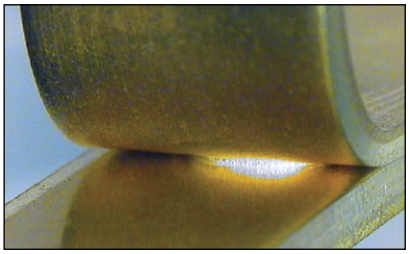


Red: envelope Yellow: current

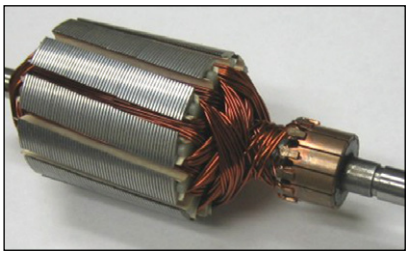
TYPICAL APPLICATIONS



Automotive sensor



Electrical bussbar



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)

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