

DATAPAK 700S Seam Welding Process Monitor

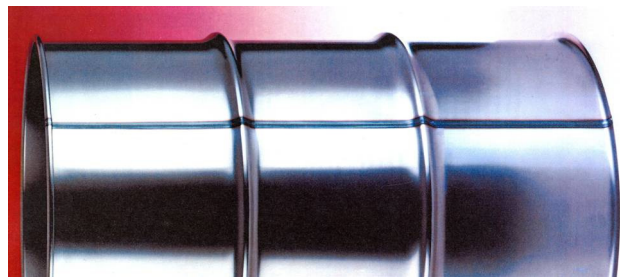
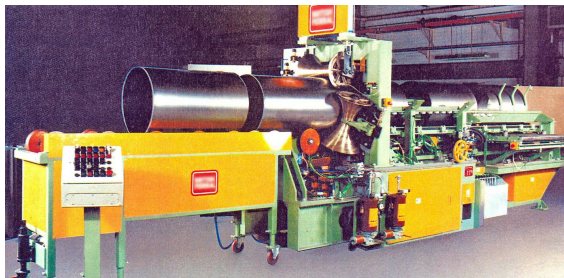


**Versatile resistance weld monitor
and data logger/recorder**

Advanced monitoring for the seam welding professional

The Datapak 700S can be used as a specialist seam weld meter or as a machine process monitor. By measuring current, time and force and having the capability to interface with individual welding stations, it can supplement and enhance legacy installations or replace existing meters. One of the important advantages of the Datapak is the provision of independent weld monitoring which is not affected by possible malfunctions within welding controls that may otherwise result in undetected welding errors. Up to 64 selectable monitoring programs and a teach facility allow easy set-up. Flexible inputs and outputs allow connection to a wide range of welding control systems. Data can be exported via the RS-232 port.

Datapak 700S is suitable for the following Applications:



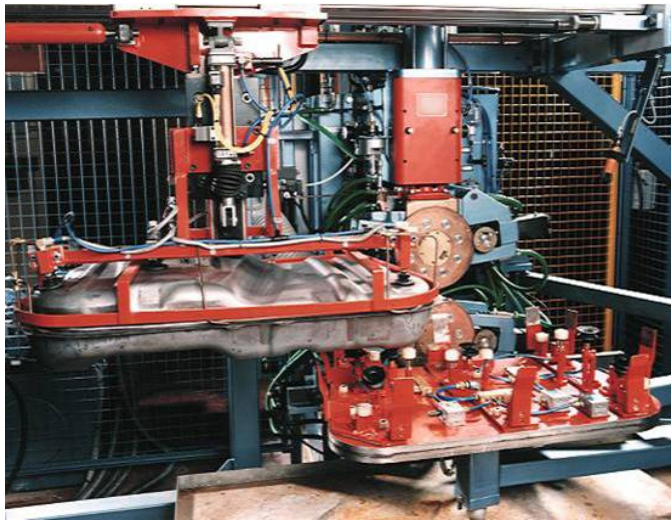
Drum and continuous seam welding

Headline Features:

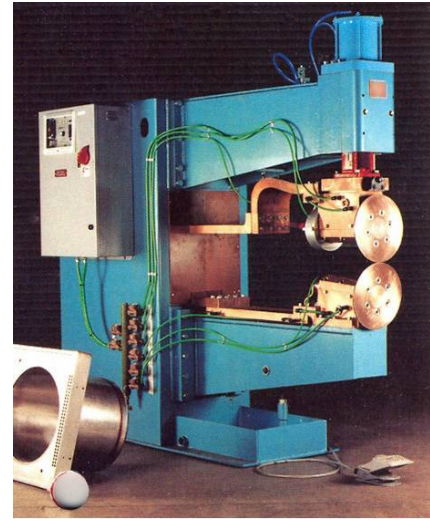
- ◆ Unique weld current/time profile monitoring with easy set up
- ◆ Records seam welds of up to 80 seconds long
- ◆ Recorded data can be sent via a built in RS232 port to a printer or PC
- ◆ Measures two key process parameters—Current and Time
- ◆ Integral Weld counter
- ◆ 60 programmes
- ◆ Real-time clock records time and date of each weld
- ◆ Current monitoring with high, low and pre-limits
- ◆ Time monitoring in increments of 1/2 cycle, 1 cycle and 1ms at frequencies of 50/60 Hertz or 1 kHz
- ◆ Program teach facility for easy set-up
- ◆ Primary or secondary current measurement using toroid or CT
- ◆ Toroid and CT sensor calibration function
- ◆ Toroid test function
- ◆ Machine interlock contact
- ◆ Analogue output of current level
- ◆ Large bright 4x20 character electro-fluorescent display
- ◆ RS232 port, for PC communications and print-out of weld data
- ◆ Key-switch security.
- ◆ Measures AC or DC current

DATAPAK 700S Seam Weld Monitor — Feature Table

Other seam welding monitor applications:



Fuel/Gas tank seam welding



Modulated and continuous seam welding

Standard Features

Display: 4 x 20 character VFD

Indicators:

Fault
Warn
Pass
Count

Touch sensitive membrane keypad:

8 keys and 3 indicators

Key switch:

Position 1 - Bypass
Position 2 - Normal
Position 3 - Reset/Edit

Weld on/off optional—24VDC

Primary or Secondary monitoring

Program selection:

Internal default
External binary

Toroid sensitivity: 100 to 2,000 mV/kA

CT ratio: 800:1

Communications Port: RS232

Real time clock: h:m:s dd:mm:yyyy

Global Parameters

Configuration:

Mode (AC/DC)
Trigger threshold 0...60kA
Sensor (Toroid/CT)
Toroid test (On/Off)

Calibration:

Toroid (100-2000mV/kA)
CT S/P ratio (1:1...199:1)
CT S/P offset (-1kA...+1kA)
Analogue output (10V=0...60kA)

Printer:

Lines per page
Format (Table/CSV)
Print condition (All/Pass/Fail/Off)

Clock:

Date
Time

Monitor Programs x 64

Monitor/Teach

Recorded Current 0...60kA

Recorded Time 0...4000 cycles

Sample size (1/2 or 1 cycle / 10—20ms)

Time/Date recording

Current monitor On/Off

Time monitor On/Off

Current low limit 0...99%

Current pre-limit 0...99%

Current high limit 0...99%

Pre-limit count (0...9999)

Continue/Stop at end

Inputs

Weld On/Off monitor input

Toroid 100-2000mV/kA

CT 800:1

Program 1 select

Program 2 select

Program 4 select

Program 8 select

Program 16 select

Program 32 select

Current Trigger via CT or Toroid

Outputs

Machine interlock voltage free contact

Analogue output of current

Printer (RS232)

