



*Tipaloy*



## Medium Frequency DC Inverter Controls

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iPAK is an integrated timer/controller/inverter system for MF resistance welding. The control section is housed in a cassette-type casing, which simply mounts onto the power pack for ease of maintenance. Millisecond precision, constant current and constant power operation, with comprehensive monitoring, assures weld quality.

### **CAPABILITIES**

- Current/Power Monitoring: High/Low limits and Pre-limit
- Proportional valve controller (0-10 V or 4-20 mA)
- Pressure Monitoring: High/Low limits
- Up to 3 analog inputs (2 x 0-10 V, plus 1 x 0-10 V or 4-20 mA)
- High Current Output configurations – up to 300 kA weld current capability, higher on special applications

### **OPTIONS**

- Constant Voltage regulation / Constant Power
- Isolation Contactors
- Fieldbus Interfaces – InterBus-S, Profibus DP and DeviceNet
- Plug-in option board provides 10/100Base-T Ethernet connection
- ELR/1 Earth-leakage Relay
- ELCR/1 Machine Protection Device
- I/O Expansion
- WSP3 hand-held Programming Pendant

### **FEATURES**

- Spot / Repeat / Roll-spot / Seam (dual heat) / Seam (preheat)
- Pulsation, Upslope and Downslope
- Dual weld intervals per program (Preheat and Weld)

- 64 programs (internal or external selection)
- Constant Current regulation
- Programmable blocking on fault
- Weld Log keeps history of recent welds
- Programmable outputs (events)
- Retract/High-lift control
- Single or dual gun operation
- OHMA (Air over Oil) gun operation
- Machine Sequencer Logic
- Linked weld programs for multiple spot sequences

## **SOFTWARE**

- WS98-iPAK PC Programming Software – networking, calibration, monitoring, data logging

Tipaloy, Inc. 1435 East Milwaukee Ave. Detroit, MI 48211 Phone: 313-875-5145

Email: [Tipaloy@Tipaloy.com](mailto:Tipaloy@Tipaloy.com) Web: [www.Tipaloy.com](http://www.Tipaloy.com)