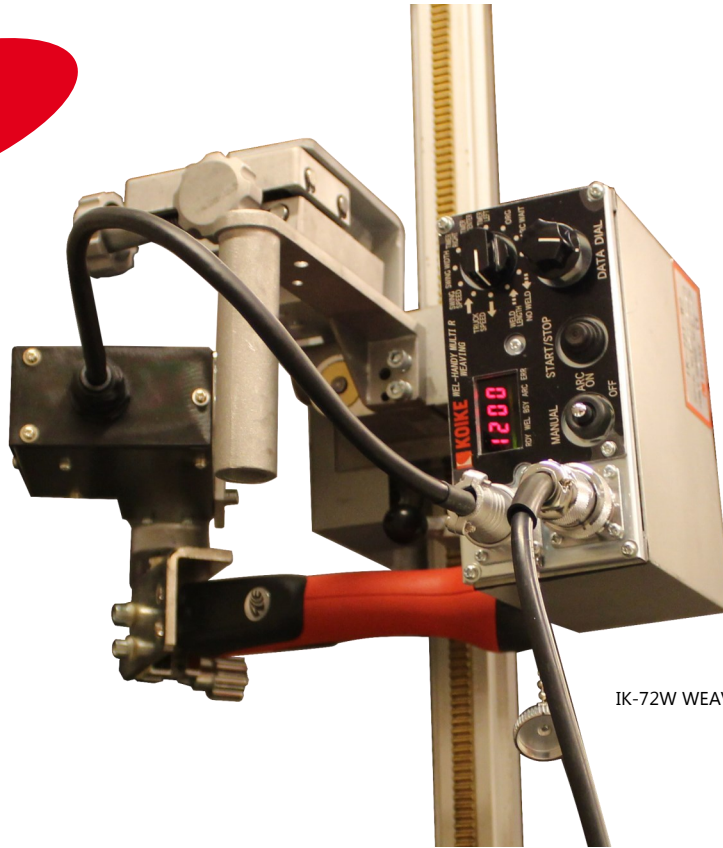


NEW



IK-72W WEAVING

# IK-72W Series

Rail traveling carriage for all position welding

## Features and Benefits

- Light weight at 5.5 kg (W) / 7.6 kg (WEAVING)
- Two models:
  - IK-72W: Tack welding
  - IK-72W WEAVING: Tack and weaving welding
- Carriage positioning by limit switch
- Advanced tack welding functions
- Digitally controlled weaving and tack welding (Weaving model)
- Shares same rail system as the cutting machine IK-72T; making it possible to weld after cut.

The **IK-72W series** is used for straight welding in horizontal and vertical positions using 1 dimensional rail and curved and twisted plane welding using 2 and 3 dimensional rails.

By using same rail system as the cutting machine IK-72T, cutting and welding can be done with IK-72 system in convenient and lightweight package.

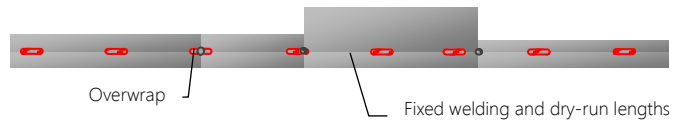


# The NEW Advanced tack controller

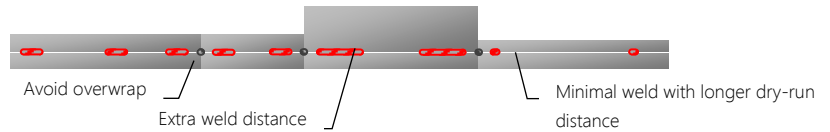
## Controllable tack welding distance

- Tack and dry-run distance can be controlled during welding just by simple click on a toggle switch.
- Equipped with encoder motor. WELIK-72W calculates travel distance by counting motor rotation, enabling accurate distance control.
- All parameter values are shown on the digital display for easier parameter management and repeatability.

**Previous model** - Tack and dry-run distances are fixed



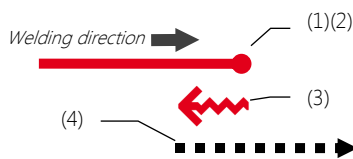
**IK-72W control** - Controllable tack distance



## Crater filling function<sup>(\*)</sup>

<sup>(\*)</sup> requires welding machine with crater function with matching control.

- Automatically switches to crater amperage at the end of each weld for crater fill sequence.

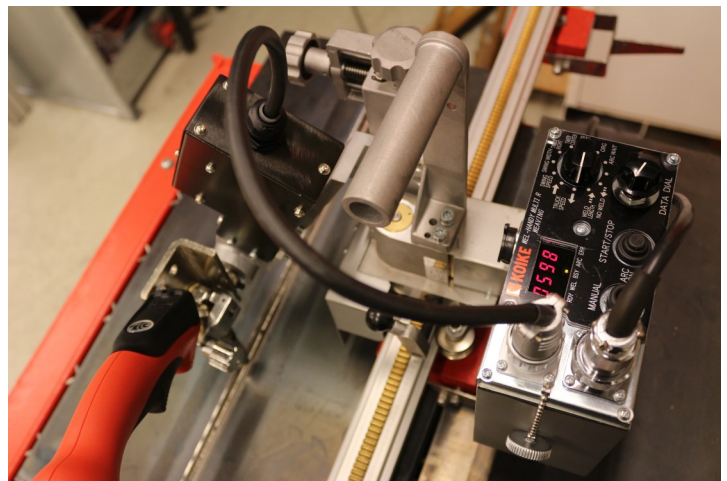


- 1) At end of each weld, carriage gives signal to welding power source to switch to crater amperage.
- 2) Carriage stops for a set period of time
- 3) With crater amperage, carriage welds backwards at a set speed for a set distance
- 4) After crater sequence, carriage dry-runs to starting point of next tack weld (in tack welding mode)

## WU-5R Weaving Unit (Option for IK-72W Standard with IK-72W WEAVING model)

A Option for IK-72W to perform weaving welding. Includes mounting bracket. Weaving is controlled by encoder motor.

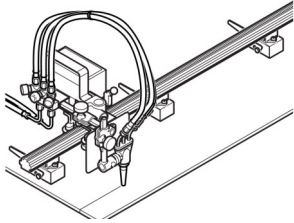
- Weaving speed (\*): 400 - 1500 mm/min
- Weaving widths(\*): 0 - 100.0 mm/min
- Stop timer (left/center/right): 0.0 - 10.0 seconds



## Accessories

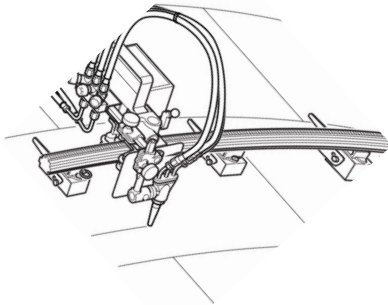
### Rail selections

Accessory	Stock #
IK-72T 1D-RAIL 1500MM	TBPJ64025
IK-72T 2D-RAIL 1000MM	90154
IK-72T 3D-RAIL 1000MM	TBPJ64026



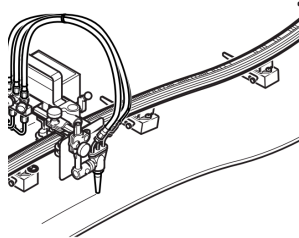
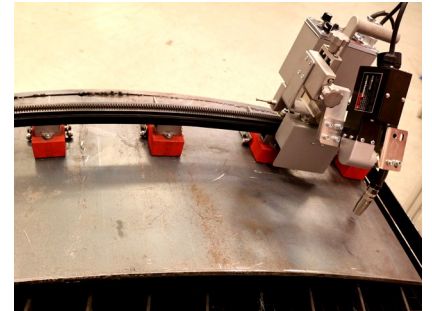
#### 1D Rail 1500mm

- For flat plate
- Extendable aluminium made straight rail
- Ideal for straight welding applications
- 4 permanent magnets



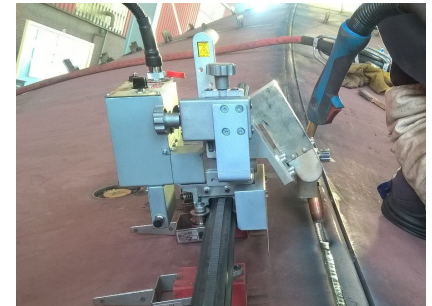
#### 2D Rail 1000mm

- For bended plane
- Extendable flexible rubber rail with steel plate liner; Maximum bending radius 2500 mm
- 5 permanent magnets
- Upto 30° slope from horizontal position



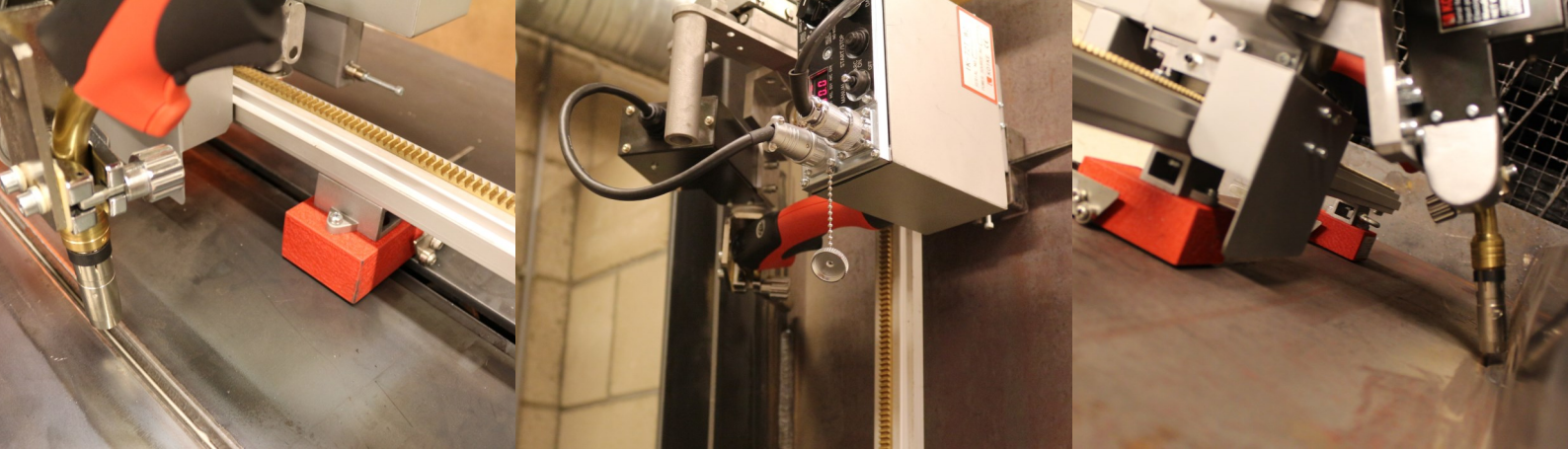
#### 3D Rail 1000mm

- For bended and twisted planes
- Extendable flexible rubber rail; bends in any directions
- Maximum bending radius 2000 mm
- 5 permanent magnets
- Upto 30° slope from horizontal position



### Other optional accessories

Accessory	Stock #	Description
Rail connector	33107	Parts to connect 1D rail to 2D / 3D rail.
Longer vertical bar 350L	31697	Extends torch positioning by 350 mm
Transformer PR 100-240V-SEC 24V 65W	222.002.256	Primary 100-240V / Secondary DC 24 V
Weaving unit WU-5R	90255	



## Type and Specification

### Specification

	IK-72W	IK-72W WEAVING
Machine weight	5.5 kg	7.6 kg
Travel speed	20 ~ 600 mm/min	
Guiding method	IK-72 rail system	
Driving method	Rack and pinion	
Torch adjustment	Up/down	45 mm
	Forward/backward	45 mm
Torch holder diameter	16 ~ 20 mm	
Automatic stop function	Limit switch on each end of carriage	
Weaving unit WU-5R	-	Included
Welding method	Continuous	Yes
	Tack / Stitch	Yes
	Weaving / Oscillation	Optional
Power & signal cable	Power and Signal integrated Y-branch cable (Carriage-branch: 6 m, Branch-Power: 10 m, Branch-feeder:0.5 m)	
Torch holder diameter	16 ~ 20 mm	
Position adjustment by limit switch	Yes	
Encoder motor for precise speed control	Yes	
Digital display	Yes	
Crater fill function	Yes	
Input power	DC 24V	

### Types

Model	Stock #
IK-72W	90250
IK-72W WEAVING	90251

### Scope of delivery

Scope of delivery
Machine body
Power & signal cable
Rail mounting bracket for limit switch (2 pcs)
Allen keys (2pcs)
Operation manual



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## Headquarter:

### Koike Europe B.V.

Grote Tocht 19  
1507 CG Zaandam  
The Netherlands

Tel +31-(0)75 - 612 - 7227  
Fax +31-(0)75 - 670 - 2271  
info@koike-europe.com  
www.koike-europe.com

### Koike Europe B.V.

#### Germany Branch Office

Im Löchel 2  
35423 Lich-Eberstadt  
Deutschland

Tel +49-(0)6004 - 91 - 6930  
Fax +49-(0)6004 - 91 - 6931- 01  
info.germany@koike-europe.com  
www.koike-europe.com

### Koike France S.a.r.l.

Espace Mercure  
Z.A.E. Les Dix Muids  
59770 Marly  
France

Tel +33-32730-4343  
Fax +33-32730-1250  
info@koike-europe.com  
www.koike-europe.com

### Koike Italia Srl

Via Papa Giovanni XXIII, n 45  
20090 - RODANO (MILANO)  
Italy

Tel +39-02953 - 28 - 717  
Fax +39-02739 - 60 - 447  
info@koike-europe.com  
www.koike-europe.com

### Koike Middle East FZE

SAIF Zone Sharjah-UAE  
P.O. Box 122978  
United Arab Emirates

Mobile +971561177615 /  
+971566453803  
Fax +9716-5312805  
b.pandey@koike-europe.com  
www.koike-europe.com