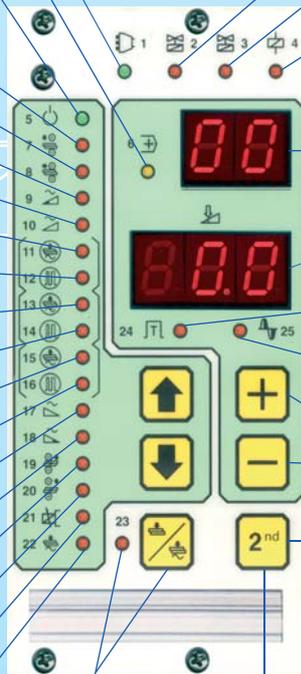


CS-279R

- PROGRAMMING**
Selection of program to be modified or to run.
- UNIT READY**
- STAND BY UNIT READY**
- ROLL SQUEEZE**
- WELD DELAY**
- SLOPE INITIAL CURRENT UP**
- SLOPE UP**
- WELD 1**
- PAUSE 1**
- WELD 2**
- PAUSE 2**
- WELD 3**
- PAUSE 3**
- SLOPE DOWN**
- SLOPE FINAL CURRENT DOWN**
- HOLD TIME**
- ROLLER OPEN OFF TIME**
- PROPORTIONAL VALVE**
- WELD - NO WELD FROM PROGRAM**

POWER SUPPLY



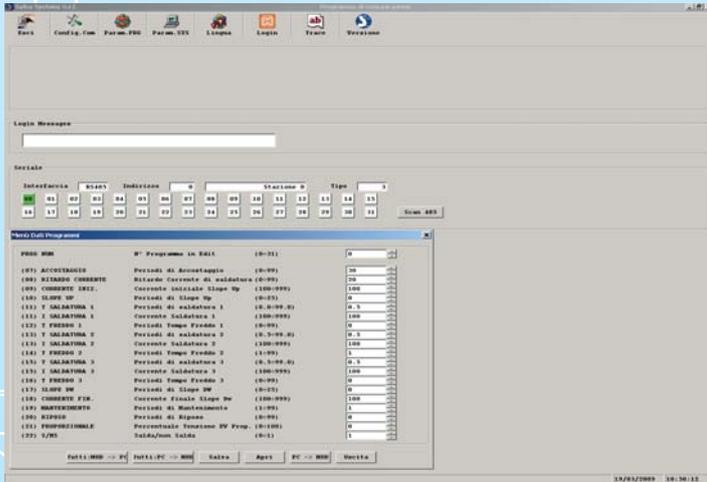
- EV - PRE-STROKE**
- EV - ROLLER SQUEEZE**
- TL - MOTOR START**
- ACTIVE PROGRAM DISPLAY**
- CYCLES - WARNING - PARAMETERS DISPLAY**
- TIMES**
- CURRENTS**
- PARAMETERS SETTING**
- SYSTEM PARAMETERS ACCESS**

WELD - NO WELD INTERNAL - EXTERNAL

- ADD = UNIT NETWORK ADDRESS ON - OFF**
- TAB = COS f TABLE**
- LCO = NET COMPENSATION ON - OFF**
- DLY = FIRST 1/2 CYCLE INSERTION DELAY**
- CP = PRESSURE CONTACT BEFORE - AFTER SQUEEZE**
- FC = END CYCLE TYPE**
- FCT = END CYCLE CONTACT CLOSURE TIME**
- PFS = PROPORTIONAL VALVE END RANGE**
- AuT = SQUEEZE TIME AUTO HOLD**
- AoP = PRE STROKE VALVE OPENING AT CYCLE END**
- COP = COPY PROGRAM '0' ON ALL PROGRAMS**
- RES = SYSTEM PROGRAM PARAMETER RESET**



CS-2793



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Main Features:

- Synchronous control for SCR with phase cut off weld current regulation.
 - Working cycle specially designed for Roll welding machines.
- Three different hot cycles in each program, that can be recalled during program running.
 - Initial current slope up and final current slope down independently adjustable.
- Weld time setting: up to 10 with a resolution of ½ period; above 10 with a resolution of 1 period.
 - Weld current setting in thousands of half wave phase cut off.
 - All outlets and inlets are galvanic insulated.
- Setting and running capability of 32 programs selected from internal or external.
- Copy function to overwrite automatically the program 0 on all other programs.
- Line voltage compensation with activation / deactivation by system parameter.
 - Network serial interface RS485.
- Cycle start with concomitance (dual inlet) or via foot switch.
- Setting of the first insertion delay with a system parameter.
 - Separate proportional valve outlet galvanic insulated.
- Setting of the proportional valve full opening range (100%) from 5 to 10 volt with a system parameter.
 - Three different Cycle Ends with correspondent time setting by system parameters.
 - 16 current tables for different machine's power factor.
- Pre stroke solenoid valve acting as pre stroke with manual opening or opening at cycle end selectable with a system parameter.
 - Automatic power line frequency recognition.
 - Dedicated signals for PLC drive.
- Fully adjustable from a PC program.

