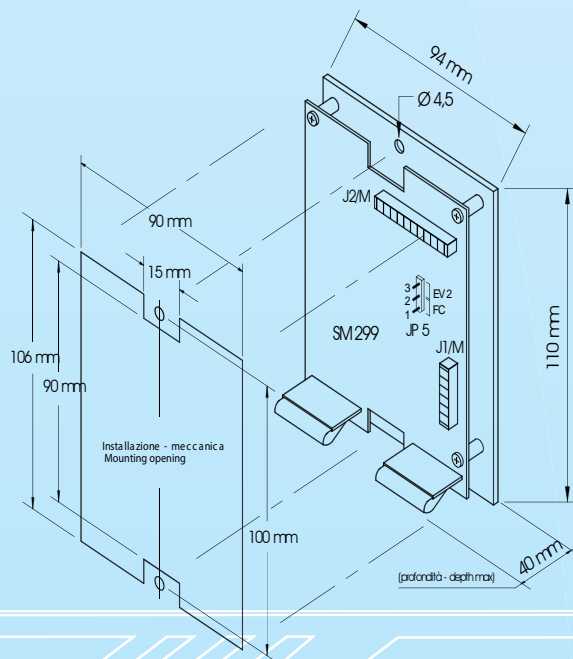


- 1 Power Line Led
- 2 Start Cycle 1 Led
- 3 Start Cycle 2 Led
- 4 Pressure Contact Led
- 5 End Cycle Input Led (Continued Weld Mode)
- 6 Solenoid Valve Led
- 7 Stand-by Led
- 8 Squeeze Led
- 9 Slope Up Led
- 10 Weld Time Led 1
- 11 Weld Current Led 1
- 12 Weld Time Led 2
- 13 Weld Current Led 2
- 14 Cool Time Led
- 15 Pulsed Weld Led
- 16 Hold Time Led
- 17 Off Time Led
- 18 Automatic Cycle Enable Led
- 19 Weld Enable Led
- 20 Display



Main features

General

- Automatic Compensation of the network voltage fluctuation.
- EMERGENCY Input for cutting power to the control and valves.
- Two cycle start inputs for execution of two separate programs 1 and 2, in association at the same valve or different one
- Short circuit protected output for drive second solenoid valve or End Cycle signal, output for synchronous ignition of the SCR.
- Management double head machine.
- Setting and internal call of sixteen welding programs, 1-16.
- Selectable times in ½ Cycles steps up to 10 and complete Cycle over 10.
- Direct set of welding / non-welding by keys "+" and "-".
- Malfunctions Control.
- Outputs voltage 24 V D.C. 5W max, the outputs is protected from the short circuit.
- Grid Supply voltage can be set to 230 or 400 V +/- 20%.
- Automatic detection of the grid frequency: 50/60 Hz.

Program Parameters:

- Squeeze adjusting time from 0 to 99 Cycles.
- Slope up adjusting time from 0 to 20 Cycles.
- Adjustment of two- hot stroke, one of which is settable in preheating or post heating the other as welding, from 0.5 to 99 cycles or continuous welding (function Co.) with interruption by separate inlet.
- Welding pulse setting from 1 to 9
- Cold time setting from 0 to 99 Cycles.
- Hold time setting from 0.5 to 99 Cycles.
- Off Time setting from 0 to 99 Cycles.
- Program cycle Repeat Setting.

System Parameters:

- Setting the aperture of the first half cycle of welding
- Set of 16 tables of cos (φ).
- Setting time auxiliary heat before or after welding.
- Setting the working single or cascade / contemporary.
- Setting of the trigger point for the end weld signal before or after Hold Time
- Set function for pivoting machine
- Set the machine for double head / point with or without overlap.
- Association Start of cycle 1 to program 1 and start cycle 2 S to program 2 at one valve or two.

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