

CS-279m

PROGRAMMING
Selection of program to be modified or to run.

UNIT READY

**STAND BY
UNIT READY**

**PRESQUEEZE
TIME**

**SQUEEZE
TIME**

SLOPE UP

WELD TIME

WELD CURRENT

HOLD TIME

OFF TIME

**POWER
SUPPLY**

EV - PRESQUEEZE

EV - SQUEEZE

**ACTIVE PROGRAM
DISPLAY**

**CYCLES - WARNING -
PARAMETERS DISPLAY**

PARAMETERS SETTING

**SYSTEM PARAMETERS
ACCESS**

**WELD - NO WELD
FROM PROGRAM**

**WELD - NO WELD
INTERNAL - EXTERNAL**

ADD = UNIT NETWORK ADDRESS

TAB = COS ϕ TABLE

**LCO = NET COMPENSATION
ON - OFF**

**DLY = FIRST 1/2 CYCLE INSERTION
DELAY**

FC = END CYCLE TYPE

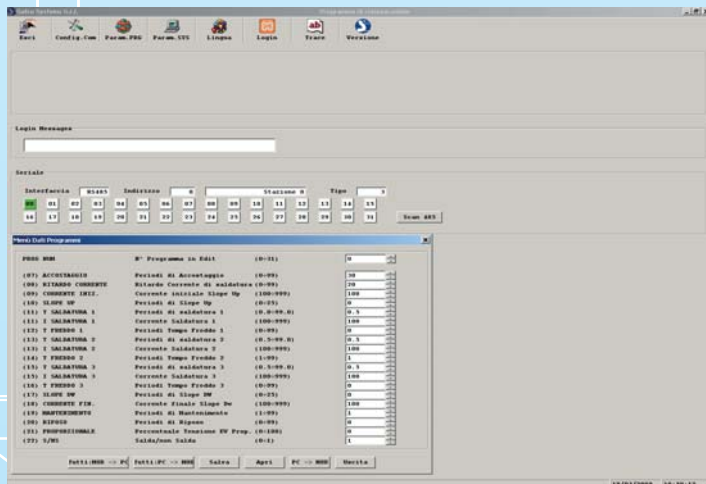
**FCT = END CYCLE CONTACT
CLOSURE TIME**

**COP = COPIES PROGRAM '0'
ON ALL PROGRAM**

**RES = SYSTEM - PROGRAM
PARAMETER RESET**



CS-279M



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Main Features:

- Synchronous welding control driving thyristors assemblies with phase cut off procedure for weld current regulation.
- Especially designed to control multiple spot welders Master (CS 279 M) - Slave (CS 279 S) with contemporary, sequence mode.
 - Weld time setting in half periods up to 10 and then in periods.
 - Weld current setting in thousandths of half wave cut off.
 - All outlets and inlets are galvanic insulated.
- Setting and running capability of 32 programs remote or locally selected.
 - Automatic copy functions of program 0 over 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.
- The first current switch on delay can be set by a system parameter.
- Management of three different cycles ends modes. The correspondent times can be set by mean of system parameters.
- Formulation of 16 charts for different machine's power factors.
 - Automatic line frequency recognition.
 - Dedicated signals for PLC drive.
 - Fully adjustable from a PC program.

