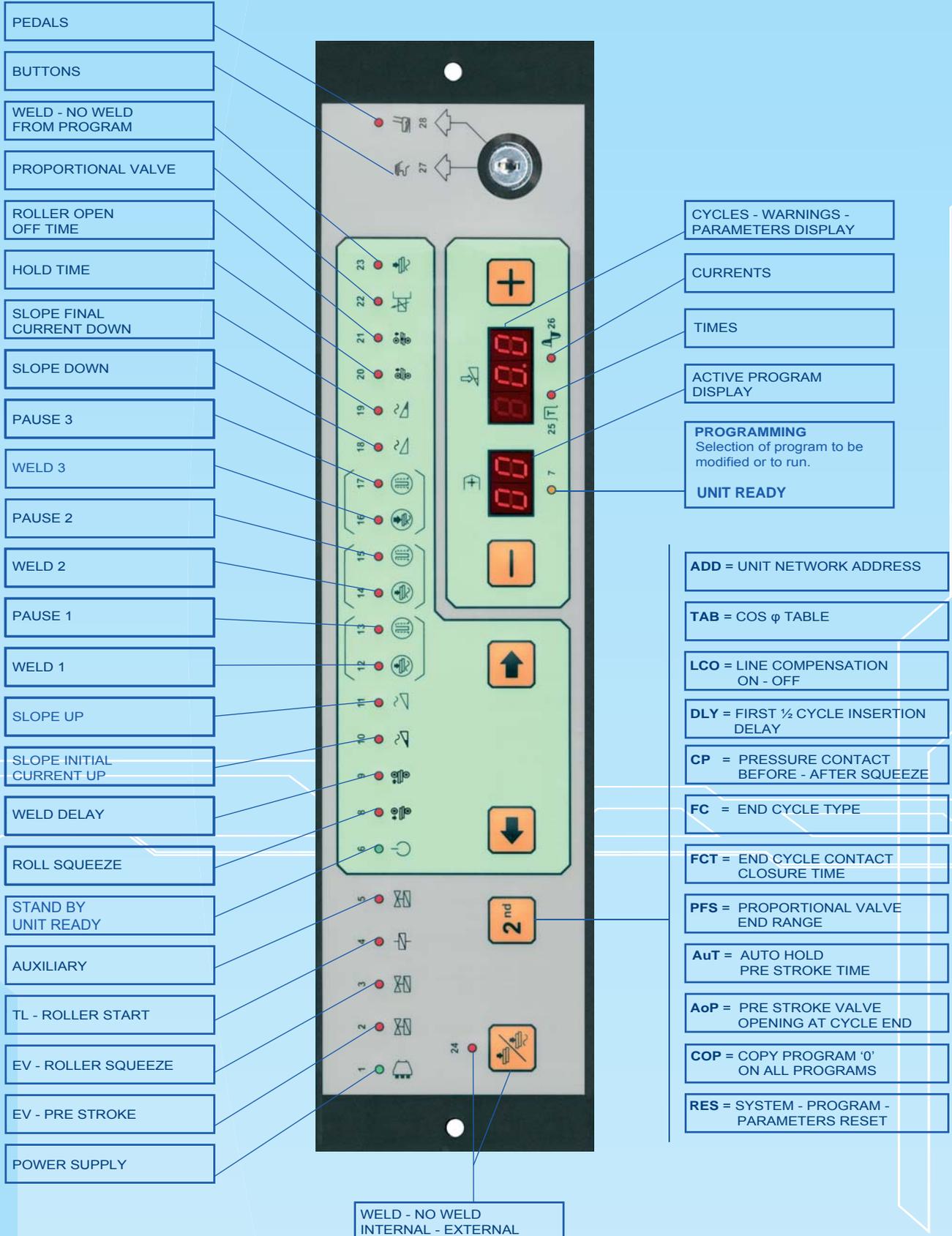


# CS-2903



- PEDALS
- BUTTONS
- WELD - NO WELD FROM PROGRAM
- PROPORTIONAL VALVE
- ROLLER OPEN OFF TIME
- HOLD TIME
- SLOPE FINAL CURRENT DOWN
- SLOPE DOWN
- PAUSE 3
- WELD 3
- PAUSE 2
- WELD 2
- PAUSE 1
- WELD 1
- SLOPE UP
- SLOPE INITIAL CURRENT UP
- WELD DELAY
- ROLL SQUEEZE
- STAND BY UNIT READY
- AUXILIARY
- TL - ROLLER START
- EV - ROLLER SQUEEZE
- EV - PRE STROKE
- POWER SUPPLY

- CYCLES - WARNINGS - PARAMETERS DISPLAY
- CURRENTS
- TIMES
- ACTIVE PROGRAM DISPLAY
- PROGRAMMING**  
Selection of program to be modified or to run.
- UNIT READY

- ADD = UNIT NETWORK ADDRESS
- TAB = COS φ TABLE
- LCO = LINE 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 = AUTO HOLD PRE STROKE TIME
- AoP = PRE STROKE VALVE OPENING AT CYCLE END
- COP = COPY PROGRAM '0' ON ALL PROGRAMS
- RES = SYSTEM - PROGRAM - PARAMETERS RESET

WELD - NO WELD  
INTERNAL - EXTERNAL

# CS-2903

**SAFCO** Systems s.r.l.

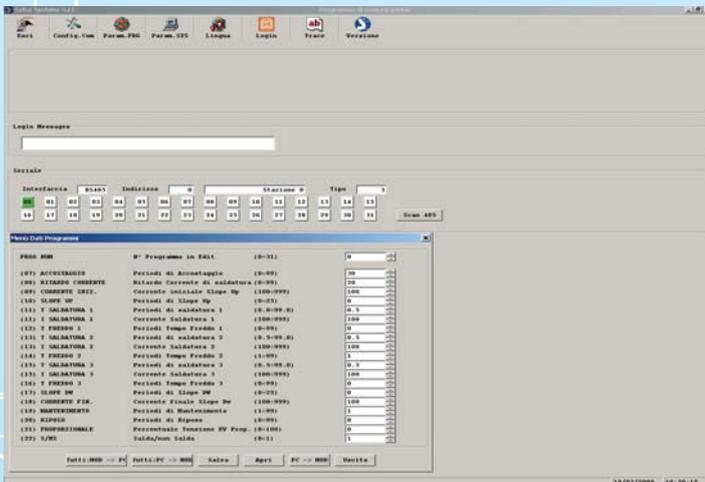
Via Isonzo, 17/b - 20090 Cesano Boscone (MI) - ITALY

Phone +39 02 4504433 - +39 02 4504435

Fax +39 02 4504321

E-mail: info@safcosys.it

Web Site: www.safcosys.it



## Main Features:

- Synchronous control for SCR with phase cut off welding 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  $\frac{1}{2}$  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 remote or locally selected.
- 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.
- Interchangeable with previous versions ( IR3/S 1220 - IR3/S 1350 ).

