

# AK-32 Micro-computer based 3 Phase DC welding controls



**FORWEL**

## Ratings and Specifications

ITEM		AK-32
<b>Weld Power</b>		3 Phase, 200~240VAC/380~440VAC (It is decisive when forwarding from the plants.)
<b>Control Power</b>		100~240VAC (Free Voltage)
<b>Frequency</b>		50/60Hz
<b>Indication</b>		7-Segment LED Display
<b>Operation Mode</b>		Spot, Twin Head Spot, Seam
<b>Weld Counter</b>		9999 counts at each Weld Schedule (Schedule 1~9)
<b>Program Parameters</b>	<b>SCHEDULE</b>	7 or 9 schedules
	<b>SQUEEZE</b>	0 ~ 99 cycles
	<b>SLOPE 1 (UP)</b>	0 ~ 9 cycles
	<b>WELD 1</b>	0 ~ 99 cycles
	<b>COOL 1</b>	0 ~ 9 cycles
	<b>WELD 2</b>	0 ~ 99 cycles
	<b>SLOPE 2 (DOWN)</b>	0 ~ 9 cycles
	<b>COOL 2</b>	0 ~ 99 cycles
	<b>OFF</b>	0 ~ 99 cycles
	<b>CURRENT 1</b>	0.0 ~ 99.9%
	<b>CURRENT 2</b>	
<b>Control Method</b>		Thyristor(SCR) Phase Control method by 3 Phase delta connections
<b>External Input</b> (Dry contact or open collector)		Start 1, 2, 4 Switch
		Weld ON/OFF Switch
		Program Lock Switch
		Thyristor Thermo Switches
<b>External Output</b> (250V 0.5A)		Hold End Output
		Valve 1, Valve 2 Control Voltage Output (100 ~ 240VAC)
<b>Memory Retention</b>		More than 10 years after power failure
<b>Ambient Temperature</b>		-10 ~ 55°C (with no icing)
<b>Storage Temperature</b>		-25 ~ 85°C (with no icing)
<b>Ambient Humidity</b>		35% ~ 85% RH (with no condensation)
<b>Dimensions</b>		320mm(W) x 129mm(H) x 260mm(D) 12.6"(W) x 5.0"(H) x 10.2"(D)



## Selection Table :

**AK32 - 440**

**3 Phase Weld power**

220 : 200~240VAC

440 : 380~480VAC

**Product name**

- Control power : 100~240VAC

- Pressure Valve output : Control voltage output

**FORWEL**

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