

SM-24 Panel mounted Standard welding controls

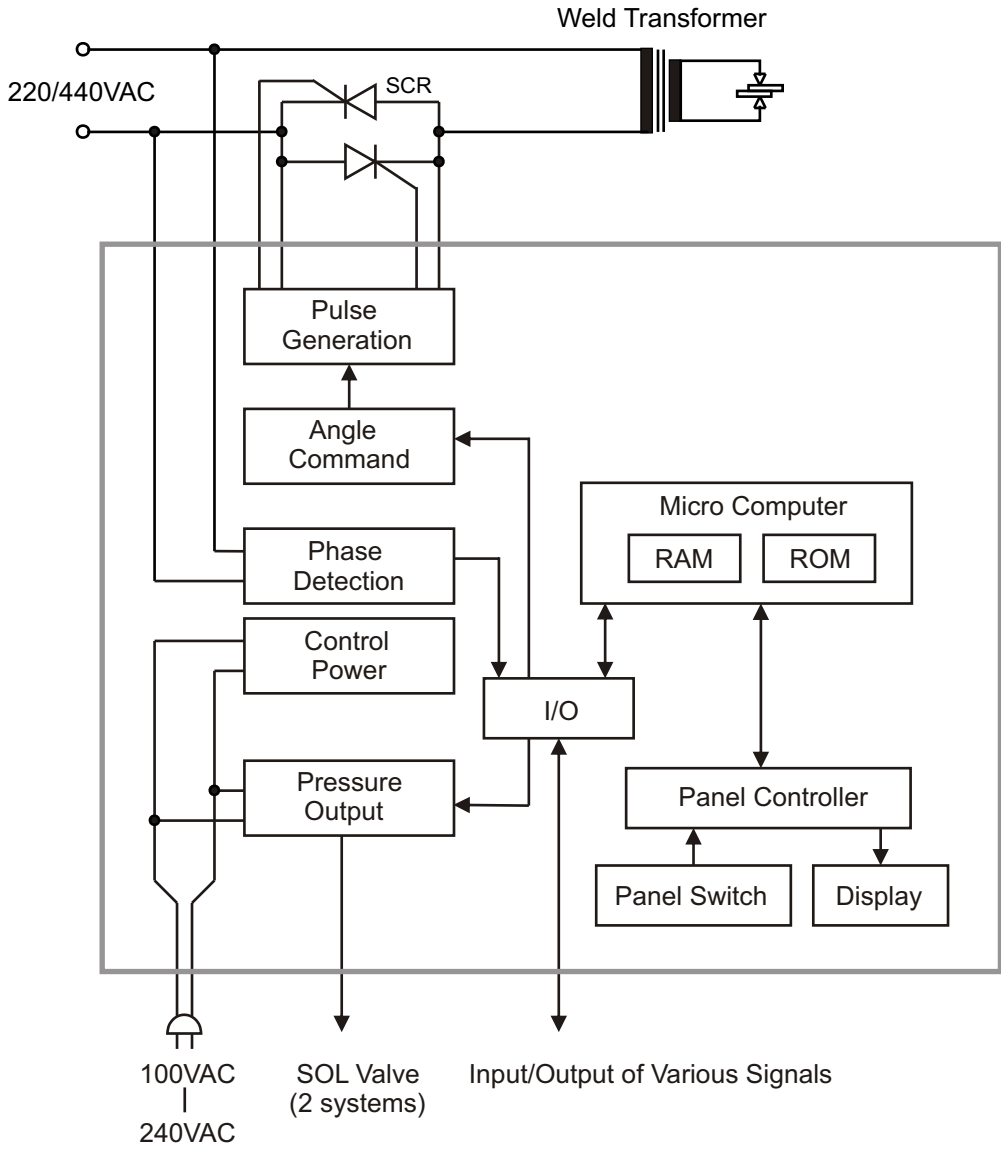


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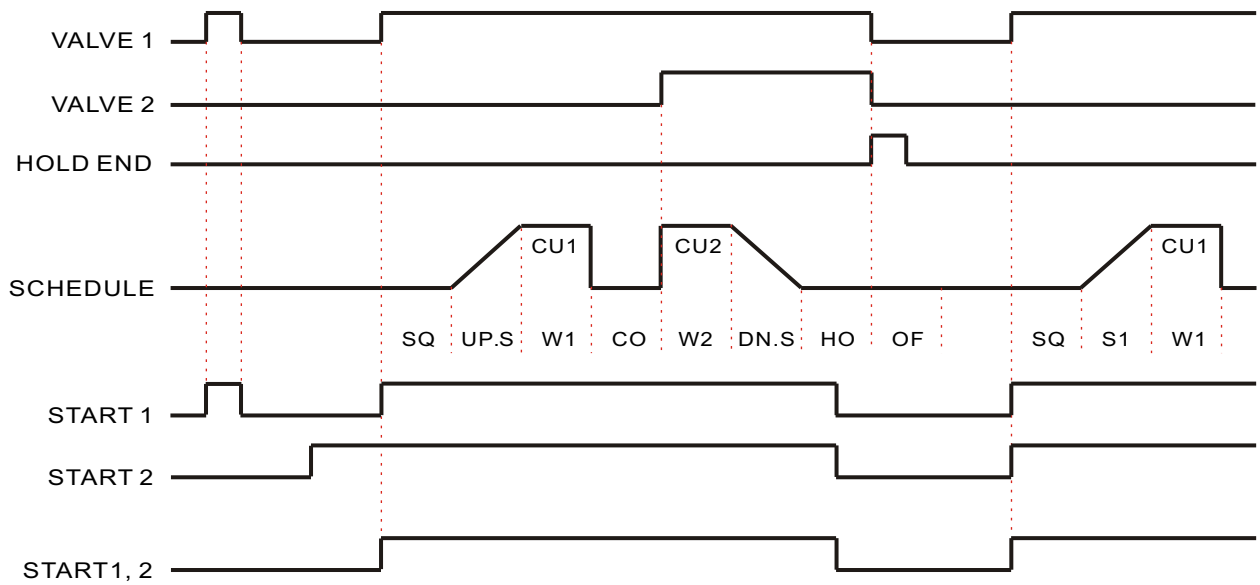
Ratings and Specifications

ITEM		SM-24V	SM-24H
Weld Power		200~240VAC/380~480VAC, 50/60Hz	
Control Power		100~240VAC (Free Voltage), 50/60Hz	
Indication		7-Segment LED Display	
Operation Mode		Spot, Twin Head Spot, Butt, Seam & Brazing	
Weld Counter		0 ~ 9999 counts	
Program Parameters	SCHEDULE	0 ~ 9 schedules	
	SQUEEZE	0 ~ 99 cycles	
	SLOPE 1 (UP)	0 ~ 9 cycles	
	WELD 1	0 ~ 99 cycles	
	COOL 1	0 ~ 9 cycles	
	WELD 2	0 ~ 99 cycles	
	SLOPE 2 (DOWN)	0 ~ 9 cycles	
	COOL 2	0 ~ 99 cycles	
	OFF	0 ~ 99 cycles	
	CURRENT 1	0.0 ~ 99.9%	
CURRENT 2	0.0 ~ 99.9%		
Control Method		Phase Control by Thyristor	
Operation Mode Input		Mode 1, Mode 2	
Start Input		Start 1, Start 2	
Thermo Input		SCR & Transformer Thermo Switch	
Hold End Output		Relay Contact Output, One Short (0.2 sec)	
Pressure Valve Output		Valve 1, Valve 2 Control Voltage Output (100 ~ 240VAC)	
Memory Retention		More than 10 years after power failure	
Ambient Temperature		-10 ~ 55°C (with no icing)	
Storage Temperature		-25 ~ 85°C (with no icing)	
Ambient Humidity		35% ~ 85% RH (with no condensation)	
Dimensions	Control Box	180mm(W) x 53mm(H) x 260mm(D) 7.1"(W) x 2.1"(H) x 10.2"(D)	
	Teaching Panel	81(W) x 15(H) x 255mm(D) 3.2"(W) x 0.6"(H) x 10.0"(D)	255(W) x 15(H) x 81mm(D) 10.0"(W) x 0.6"(H) x 3.2"(D)

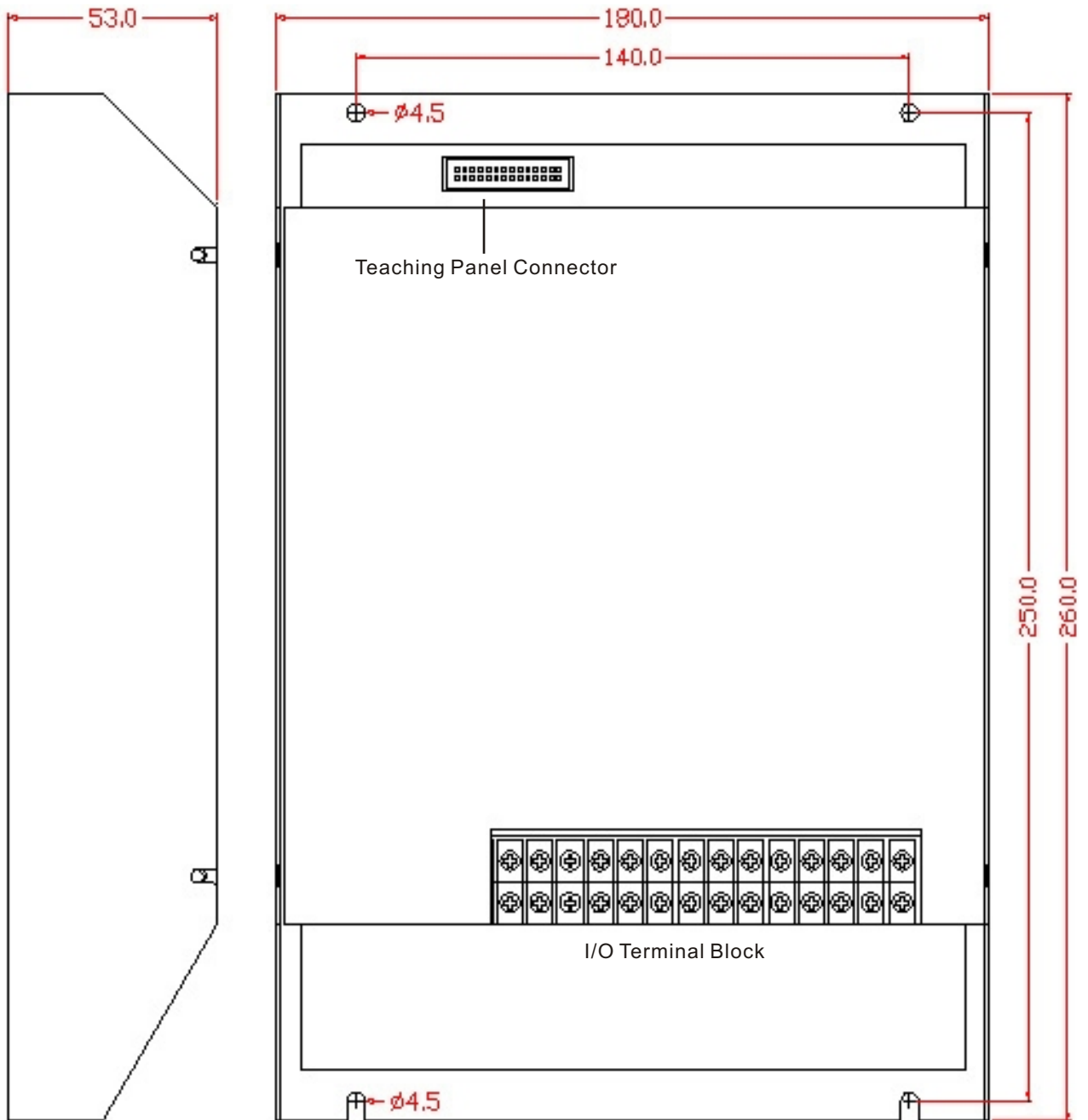
Block Diagram



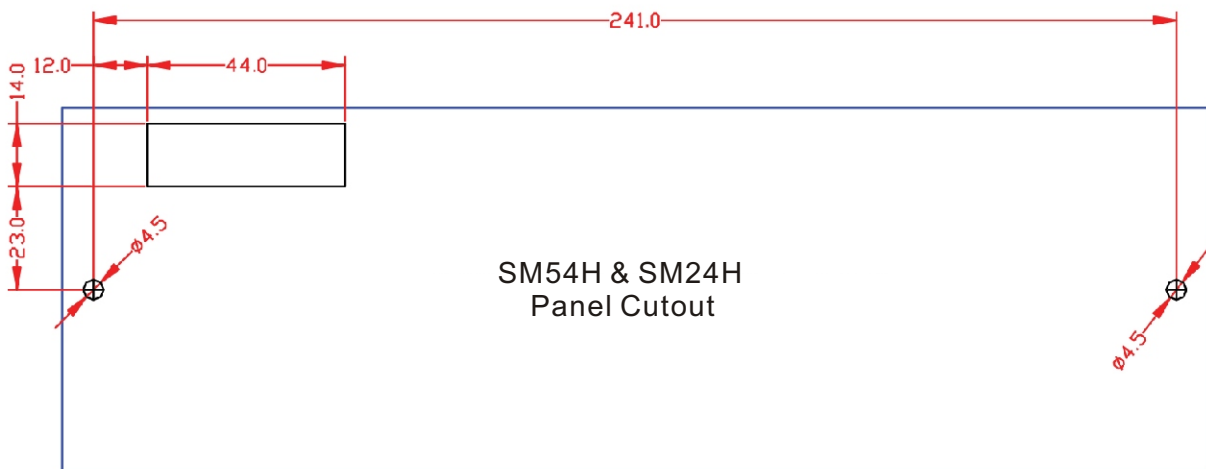
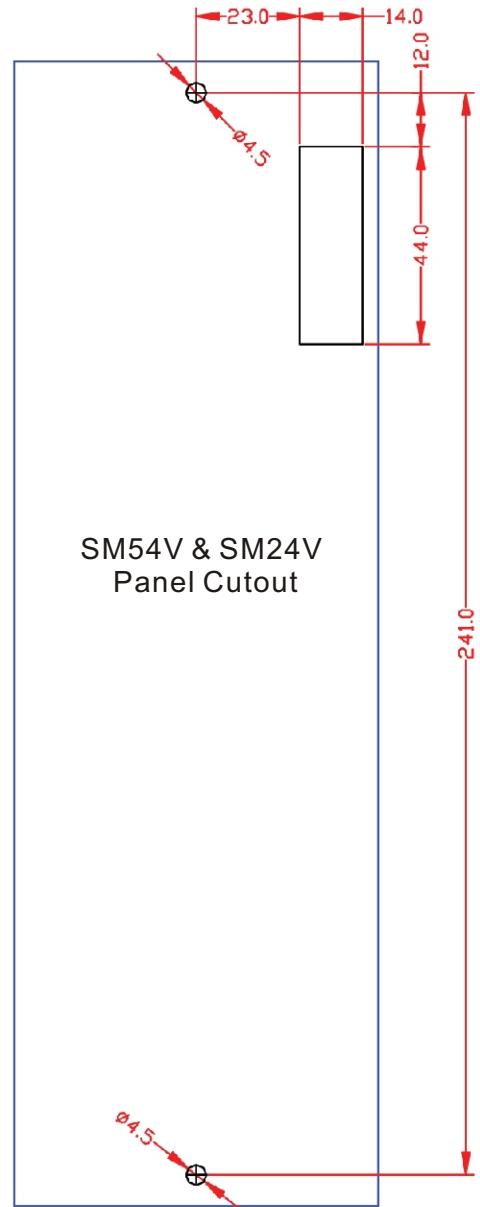
Basic Time Chart



Control Box Dimensions



Teaching Panel Mounting





Selection Table :

SM24V

Product name

SM24V : Vertical type

SM24H : Horizontal type

- Control power : 100~240VAC
- Welding power : 200~240VAC and 380~480VAC
- Pressure Valve output : Control voltage output