

# **SM-24** Applicable for Spot, Twin head spot, Seam welders **Resistance Welding Controls**

- Versatile, easy-to-operate, microcomputer controls
- 10 Weld schedules
- 2 Impulse weld schedules
- Up and Down slope
- 9999 Weld counter
- 2 Pressure valve output
- 2 Start input
- 4 Operations
  - Spot welder
  - Twin head spot welder
  - Seam welder & Brazing welder
  - Flash butt welder



**FORWEL**

## Specifications

MODEL		SM-24V	SM-24H
Welding power source		200~240VAC and 380~480VAC	
Control power source		100~240VAC	
Frequency		50/60Hz	
Indication		7-Segment LED Display	
Operation mode		Spot, 2 Head Spot, Seam & Brazing, Flash butt	
Weld counter		0..9999 counts	
Program parameters	Schedule	0..9 schedules	
	Squeeze	0..99 cycles	
	Up slope	0..9 cycles	
	Weld 1	0..99 cycles	
	Cool 1	0..9 cycles	
	Weld 2	0..99 cycles	
	Down slope	0..9 cycles	
	Cool 2	0..99 cycles	
	Off	0..99 cycles	
	Current 1	0.0 to 99.9%	
	Current 2	0.0 to 99.9%	
Control Method		Phase control by thyristor	
Operation mode input		Mode switch 1, Mode switch 2	
Start input		Start 1, Start 2	
Thermo switch input		Thyristor & Transformer thermo switch	
Hold end output		Relay contact output	
Pressure valve output		Solenoid Valve 1, Valve 2 Output Control Voltage Output (100 to 240VAC)	
Memory retention		More than 10 years after power failure	
Ambient temperature		-10 to 55 °C	
Storage temperature		-25 to 65 °C	
Ambient humidity		35% to 85% RH	
Dimensions	Control Box	180mm(W) x 260mm(D) x 53mm(H), 7.1"(W) x 10.2"(D) x 2.1"(H)	
	Teaching Panel	81mm(W)x255mm(D)x15mm(H) 3.2"(W)x10.0"(D)x0.6"(H)	255mm(W)x81mm(D)x15mm(H) 10.0"(W)x3.2"(D)x0.6"(H)

# Teaching Panel



1. SCHEDULE : 0..9 schedule

2. SQUEEZE : 0..99 cycle

3. SLOPE1 : 0..9 cycle \*\*

4. WELD1 : 0..99 cycle

5. COOL1 : 0..9 cycle

6. WELD2 : 0..99 cycle

7. SLOPE2 : 0..9 cycle \*\*\*

8. COOL2 : 0..99.cycle

9. OFF : 0..99 cycle

10. CURRENT1 : 0.0 to 99.9%

11. CURRENT2 : 0.0 to 99.9%

12. WELD COUNT : 0..9999 count

13. WELD POWER lamp

14. THERMO lamp

15. START lamp

16. READY lamp

17. AUTO (Auto/ Manual) button

18. WELD (Weld / Test) button

19. Weld count clear button

20. Operation / Program button

21. ► Button : Preset position to right

22. ◀ Button : Preset position to left

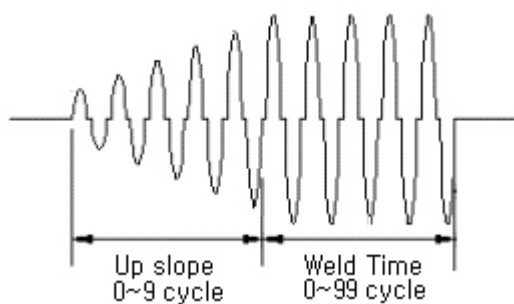
23. + Button : Data increment

24. - Button : Data decrement

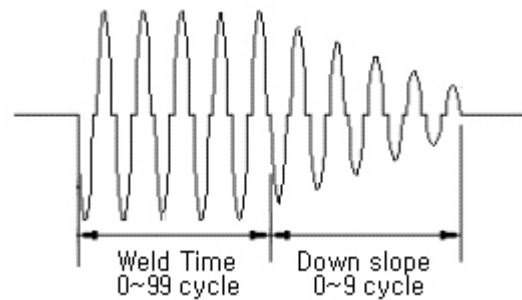
& Control power OFF/ON button

25. SCHEDULE (Weld schedule) button

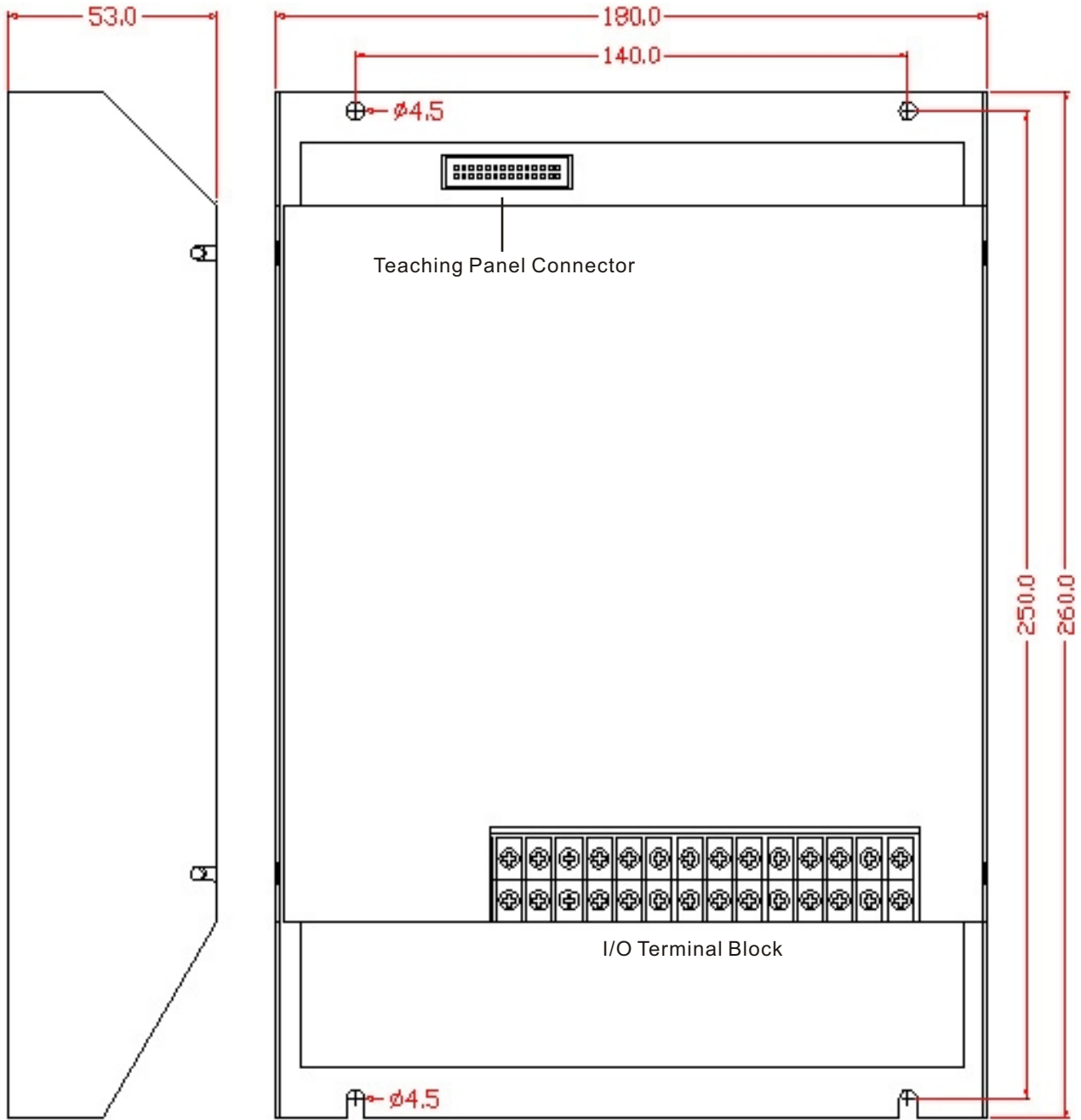
\*\*Slope1



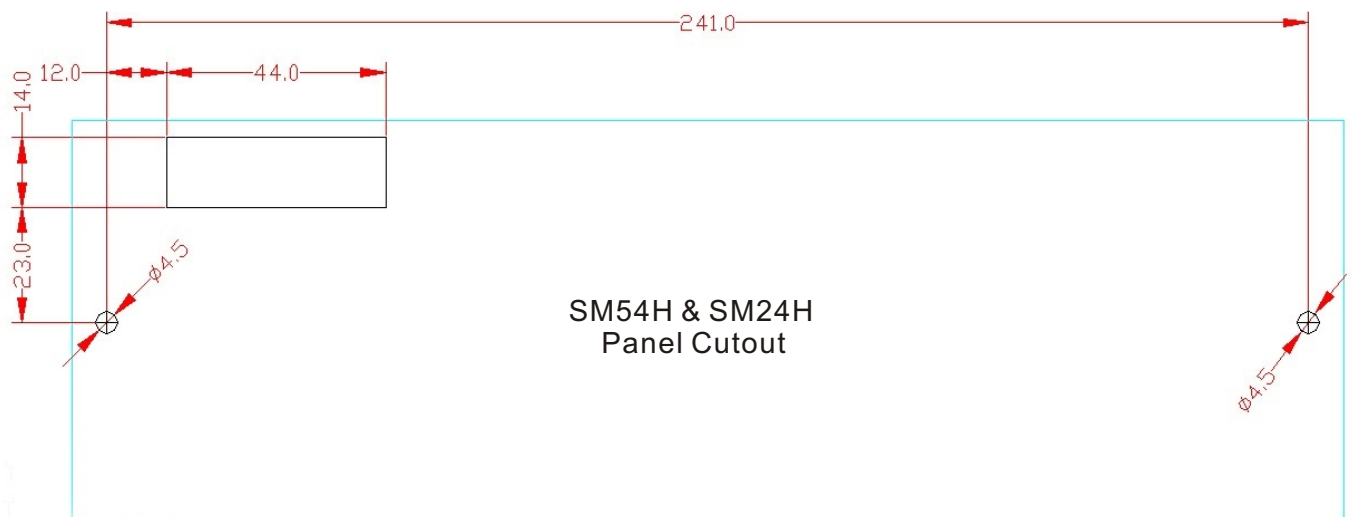
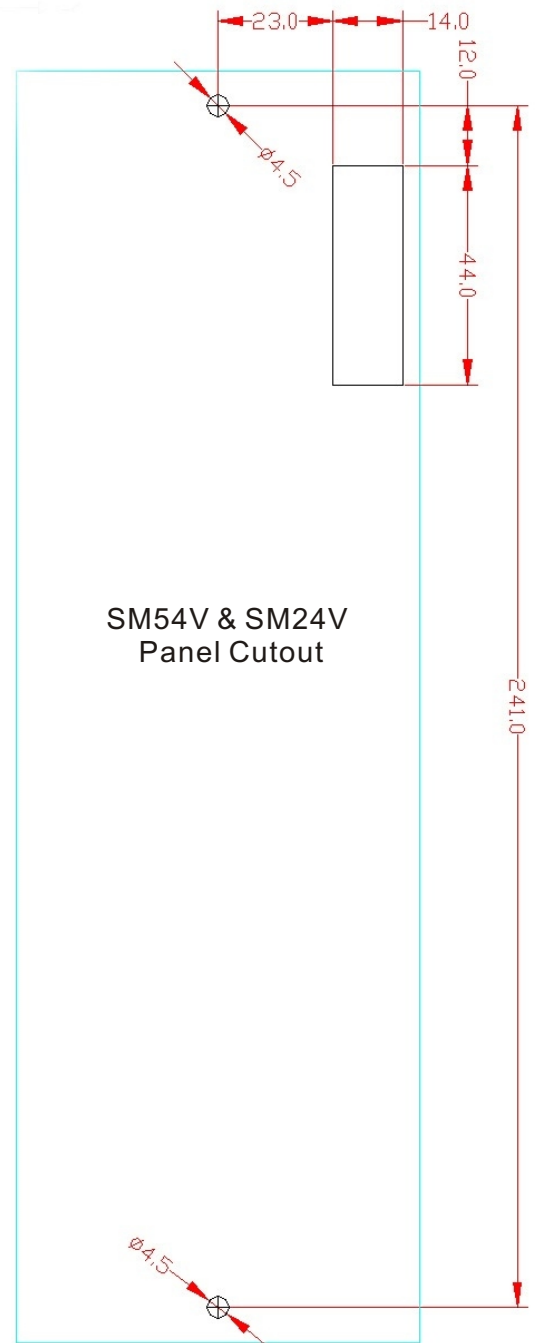
\*\*\*Slope2



# 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