

AK-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

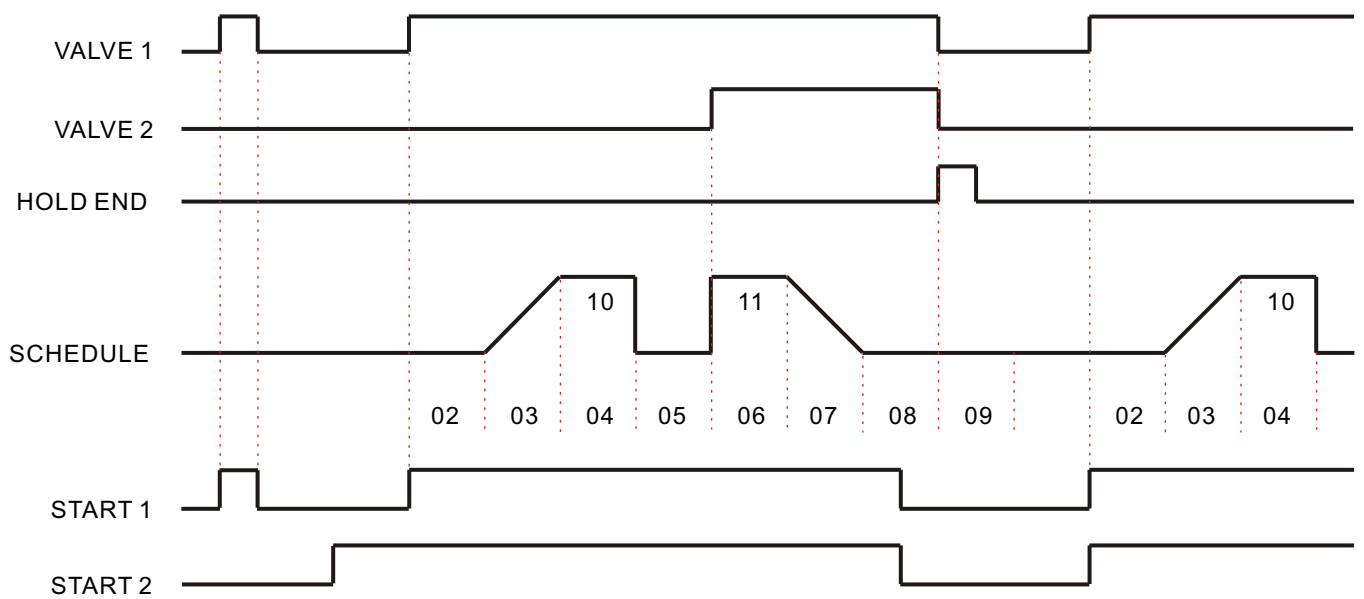
SPECIFICATIONS

MODEL		AK-24V/H
Welding power		220VAC and 380/440VAC
Control power		100 to 240VAC
Frequency		50/60Hz
Power consumption		15W Max.
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	
	Current 1	0.0 to 99.9%
	Current 2	
Weld current	Control method	Phase control by thyristor
	Control angle	20 to 160
	Maximum analyze	0.1%
Number of mode input		Mode switch 1, Mode switch 2 Dry contact or open collector
Number of start input		Start 1, Start 2, Dry contact or open collector
Thermo switch input		Thyristor thermo switch, Dry contact or open collector
Hold end output		Relay contact output, One short(0.2 sec)
Number of solenoid valve		Solenoid Valve 1, Valve 2 Output Control Voltage Output (90 to 250VAC)
Memory retention		10 years and over after power failure
Ambient temperature		-10 to 55 °C (at non-freezing status)
Storage temperature		-25 to 65 °C (at non-freezing status)
Ambient humidity		35% to 85% RH
Dimensions	AK-24V	85mm(W) x 260mm(H) x 207mm(D), 3.3"(W) x 10.2"(H) x 8.1"(D)
	AK-24H	260mm(W) x 85mm(H) x 207mm(D), 10.2"(W) x 3.3"(H) x 8.1"(D)
Weight		1.3Kg (2.9Lb)

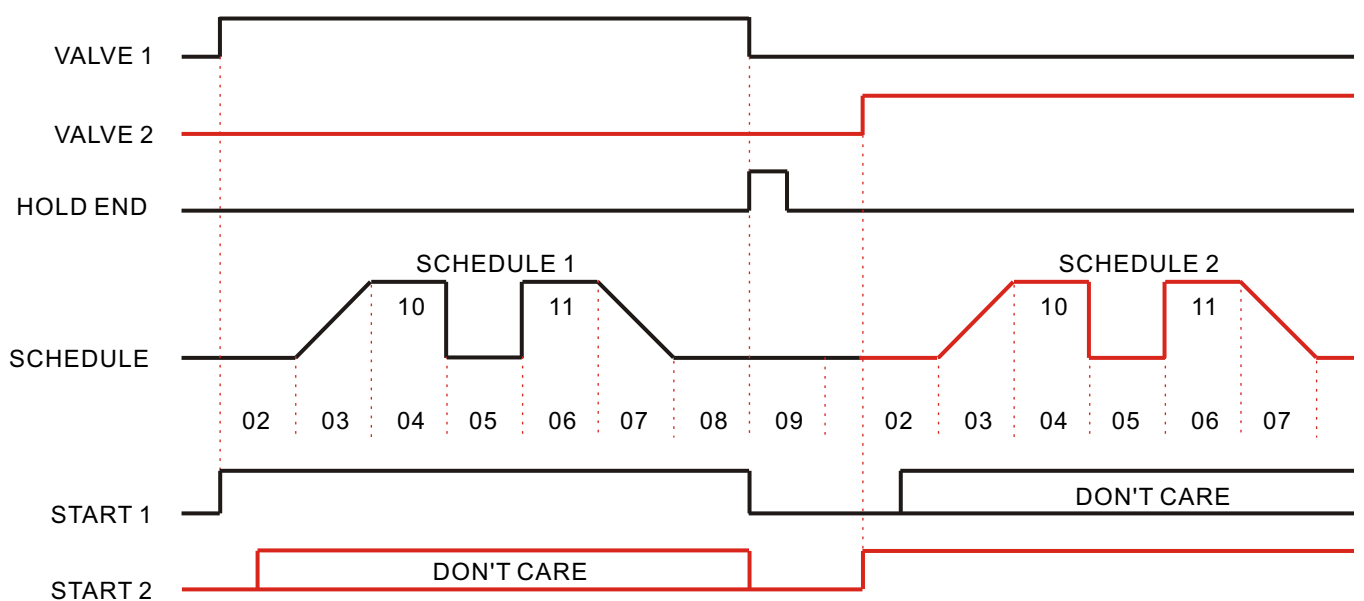
Operation / Timing charts

Operation	Mode switch		Schedule	Remarks
	Mode1	Mode2		
Spot welder	OFF	OFF	0 ~ 9	
Twin head spot welder	ON	OFF	1	START1
			2	START 2
Seam welder	OFF	ON	0 ~ 9	Slope 2 = 0
Brazing welder				Slope 2 = 1~9 Slope 2 is pulsation
Flash butt welder	ON	ON	0 ~ 9	

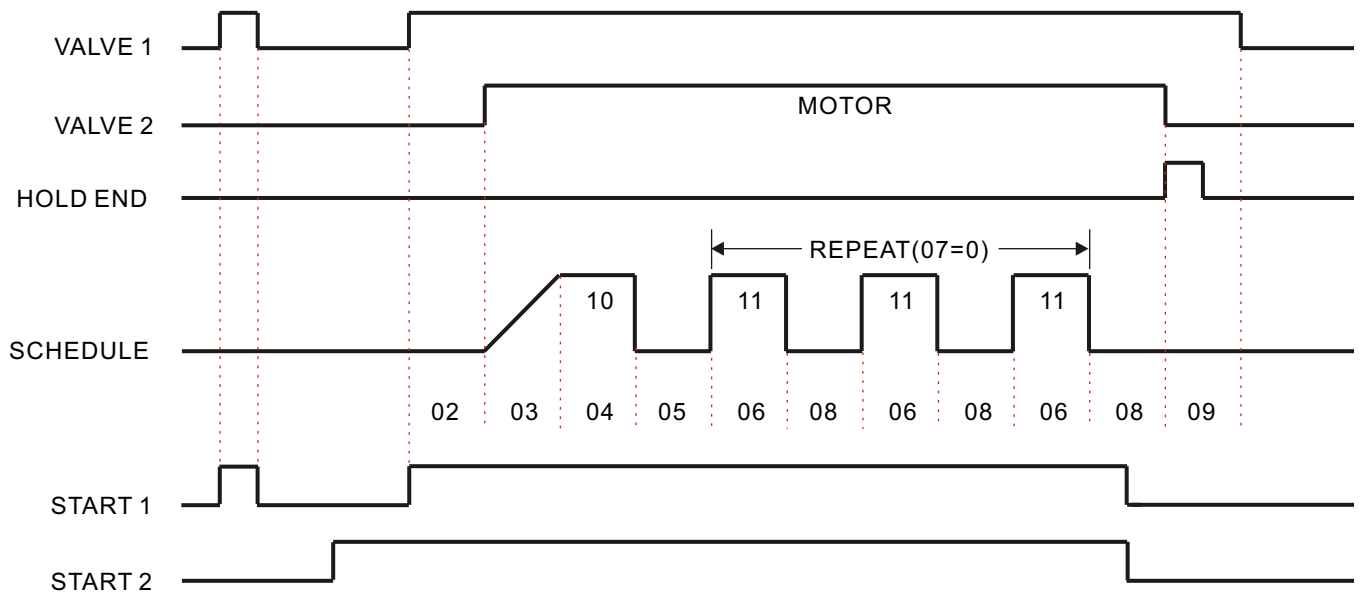
- Spot welder



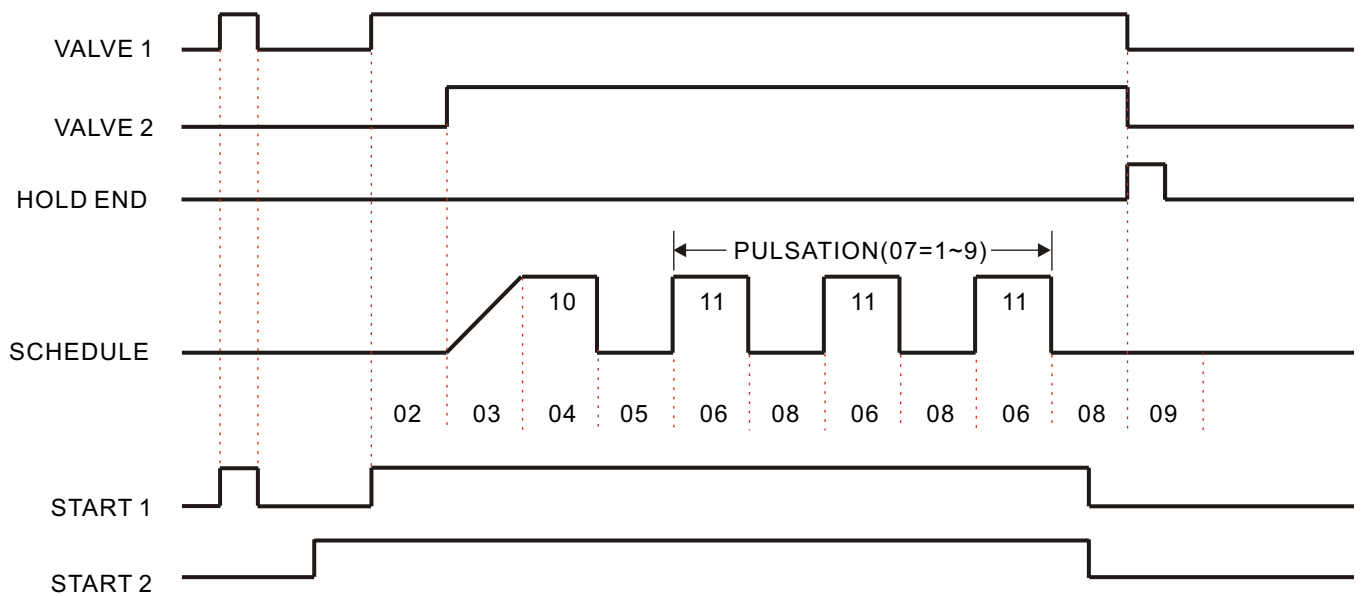
- Twin head spot welder



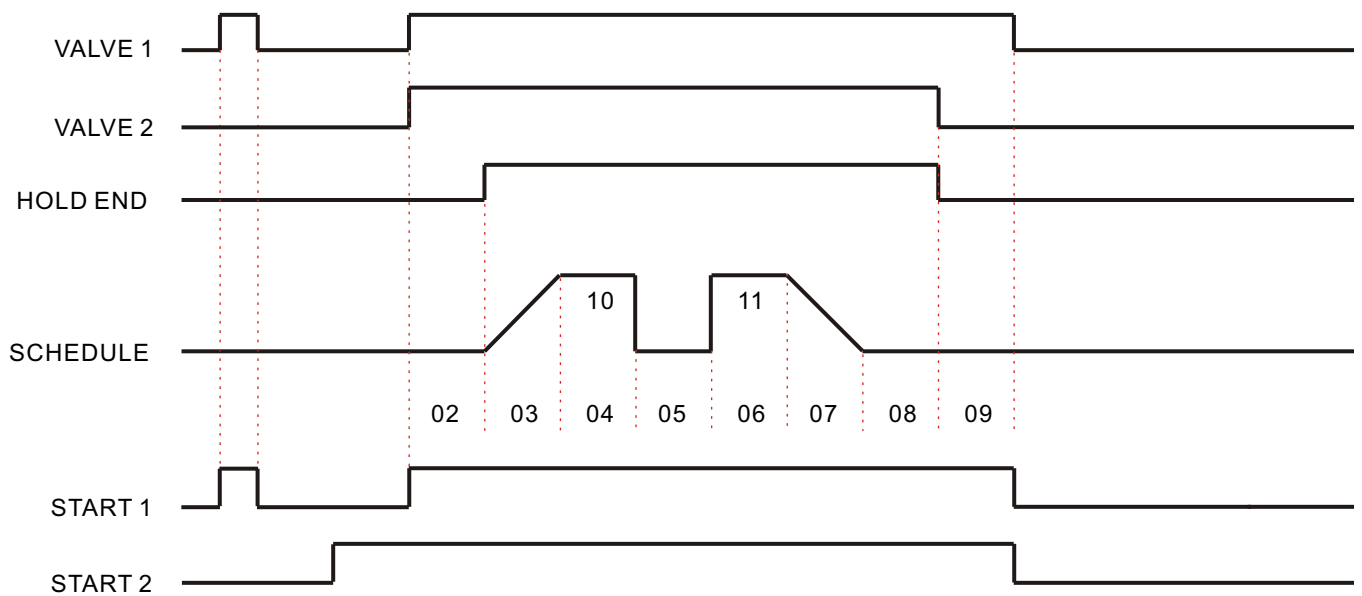
- Seam welder



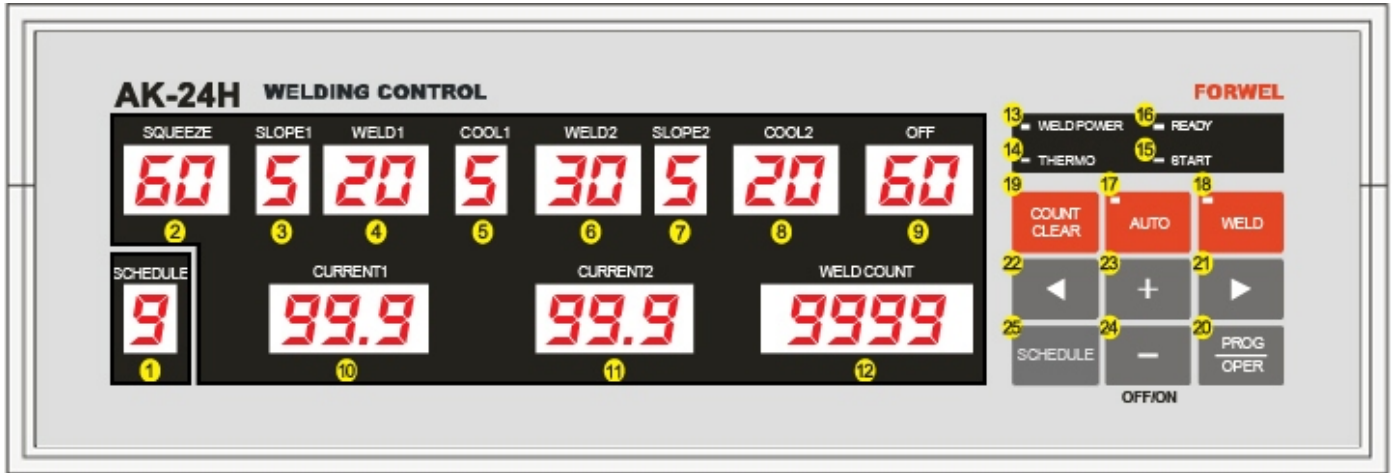
- Brazing welder



- Flash butt welder

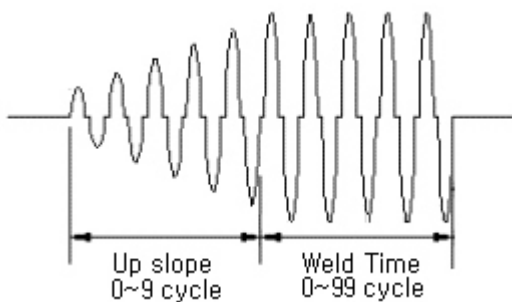


FRONT VIEW



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

