

AK-32 3 Phase Welding Control

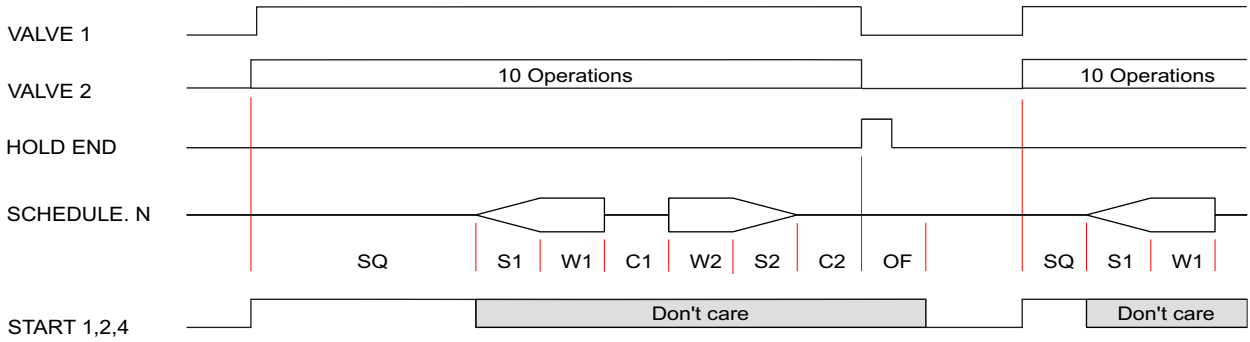


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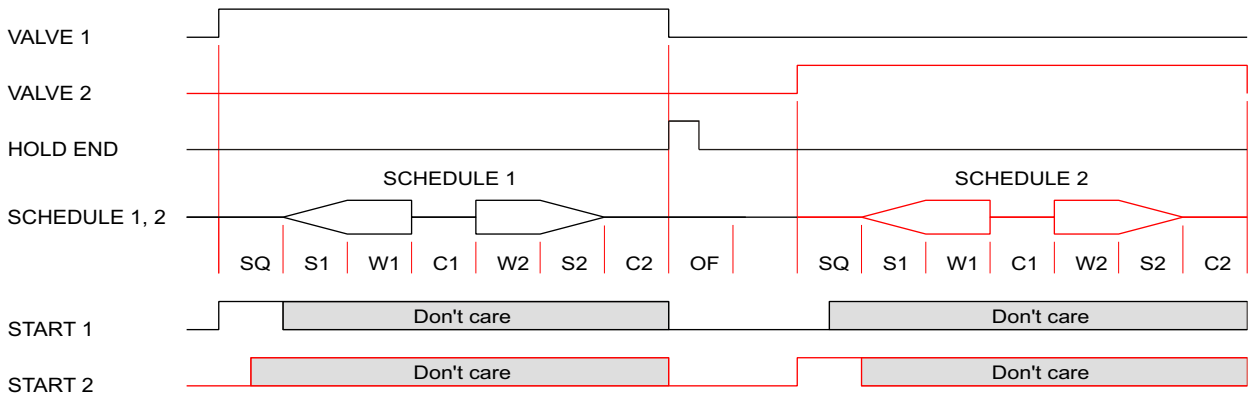
SPECIFICATIONS

MODEL		AK-32
Welding Power Source		3 Phase, 220VAC or 380/440VAC (It is decisive when forwarding from the plants.)
Control Power Source		90~250VAC
Frequency		50/60Hz
Power Consumption		15W Max. (Excluding Valve1, Valve2 output)
Indication		7-segment LED Display
Operation Mode		Spot, 2 Head Spot, Seam
Weld Counter		9999 counts at each Weld Schedule(Schedule 1~9)
Program Parameters	Schedule	7 or 9 schedules
	Squeeze	0~99 cycles
	Slope 1(Up Slope)	0~9 cycles
	Weld 1	0~99 cycles
	Cool 1	0~9 cycles
	Weld 2	0~99 cycles
	Slope 2(Down Slope)	0~9 cycles
	Cool 2	0~99 cycles
	Off	0~99 cycles
	Current 1	0.0~99.9%
	Current 2	
Weld Current	Control Method	Thyristor(SCR) phase control method by 3 Phase delta connections
	Control Angle	20~160
	Maximum Analyze	0.1%
External Input (Dry contact or open collector)		Start 1, 2, 4 Switch
		Weld ON/OFF Switch
		Program Lock Switch
		Weld Trans or Thyristor Thermo Switches
External Contact Output (250V 0.5A)		Hold End Output (Relay Contact Output), 0.2 sec
		Solenoid Valve 1, Valve 2 Output Control Voltage Output (90~250VAC)
Memory Retention		10 years (EEPROM)
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		320mm(W) x 129mm(H) x 260mm(D) 12.6"(W) x 5.0"(H) x 10.2"(D)
Weight		2.4Kg (5.3Lb)

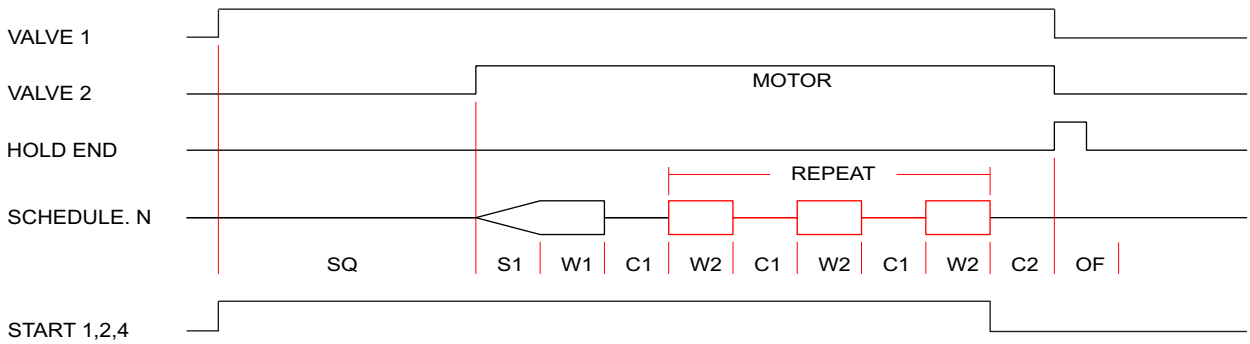
Spot & Projection Mode



2 Head Spot Mode

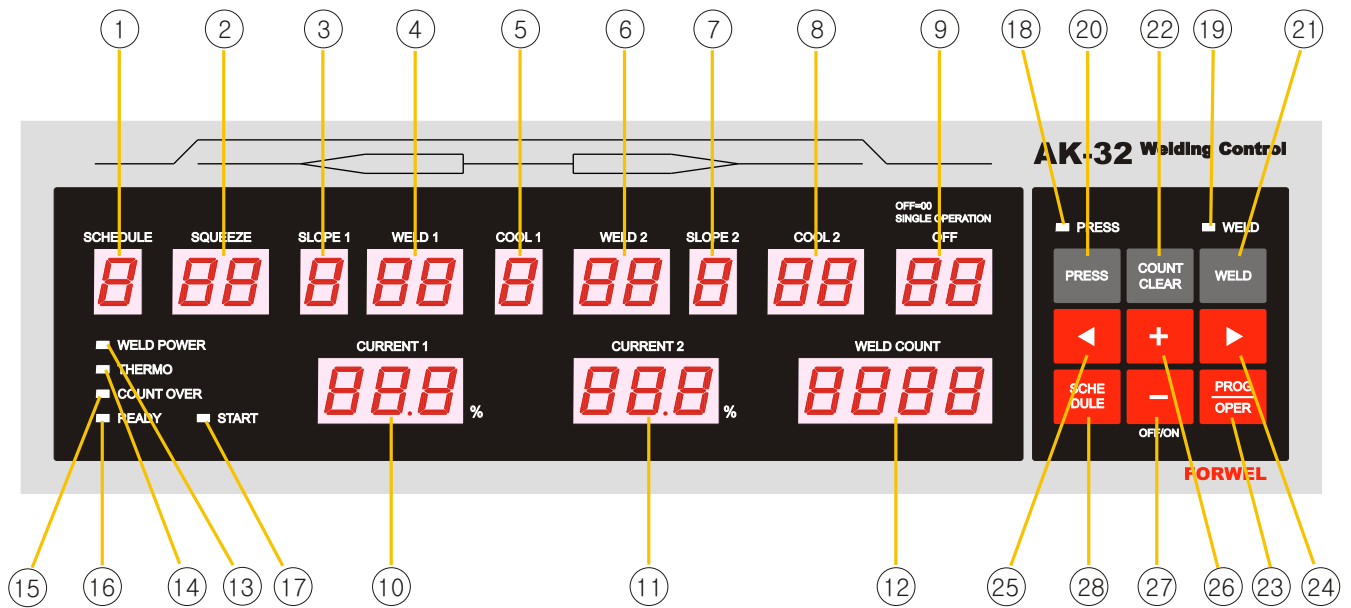


Seam & Roll-Spot Mode



SQ_Squeeze S1_Up Slope W1_Weld 1 C1_Cool 1 W2_Weld 2 S2_Down Slope C2_Cool 2 OF_Off

Descriptions of Display and Preset value



- | | |
|------------------------------------|---------------------------------------------------------------------------------|
| 1 SCHEDULE : 1~9 schedules | 20 PRESS Button (Valve1 ON/OFF) |
| 2 SQUEEZE : 0~99 cycles | 21 WELD ON/OFF Button |
| 3 SLOPE 1(Up Slope) : 0~9 cycles | 22 WELD COUNT CLEAR Button |
| 4 WELD 1 : 0~99 cycles | 23 PROGRAM/OPERATION Button |
| 5 COOL 1 : 0~9 cycles | 24 ► Button : Preset position to right. |
| 6 WELD 2 : 0~99 cycles | 25 ◀ Button : Preset position to left. |
| 7 SLOPE 2(Down Slope) : 0~9 cycles | 26 + Button : Data increase |
| 8 COOL 2 : 0~99 cycles | 27 - Button : Data decrease
and Display OFF/ON Button |
| 9 OFF : 0~99 cycles | 28 SCHEDULE(Weld Schedule) Button
: Press to increase the schedule No. by 1. |
| 10 CURRENT 1 : 0.0~99.9% | |
| 11 CURRENT 2 : 0.0~99.9% | |
| 12 WELD COUNT : 0~9999 Counts | |
| 13 [WELD POWER] LED | |
| 14 [THERMO] LED | |
| 15 [COUNTER OVER] LED | |
| 16 [READY] LED | |
| 17 [START] LED | |
| 18 [PRESS] LED | |
| 19 [WELD] LED | |