

# SK-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

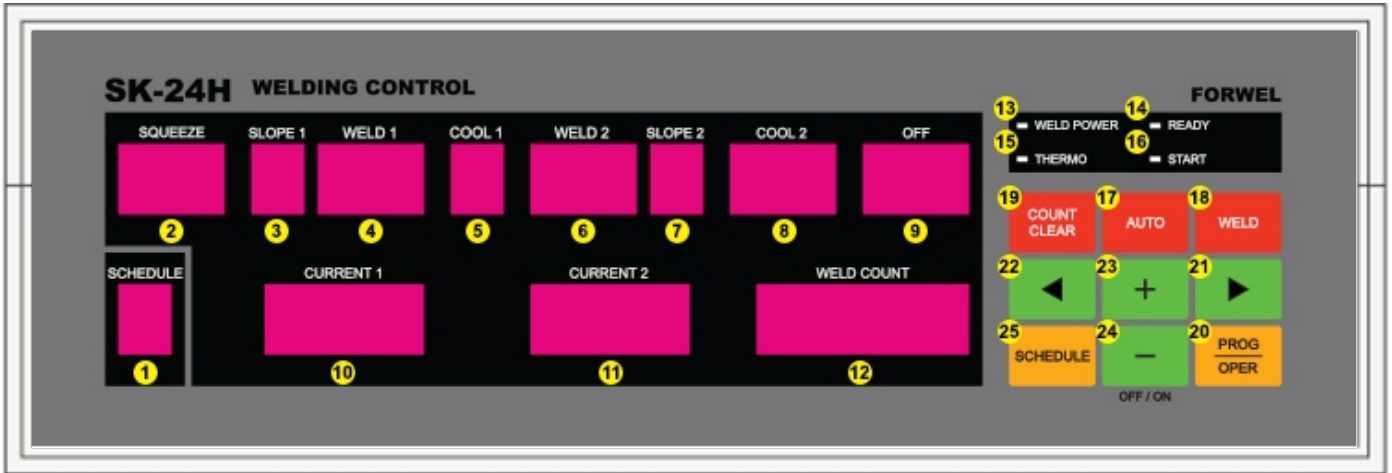


**FORWEL**

## SPECIFICATIONS

MODEL		SK-24V, SK-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	
	Current 1	0.0 to 99.9%
	Current 2	
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	SK-24V	85mm(W) x 260mm(H) x 207mm(D), 3.3"(W) x 10.2"(H) x 8.1"(D)
	SK-24H	260mm(W) x 85mm(H) x 207mm(D), 10.2"(W) x 3.3"(H) x 8.1"(D)

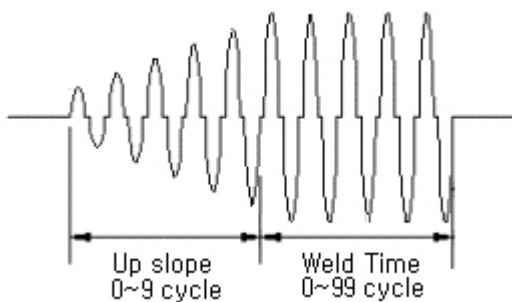
## FRONT VIEW



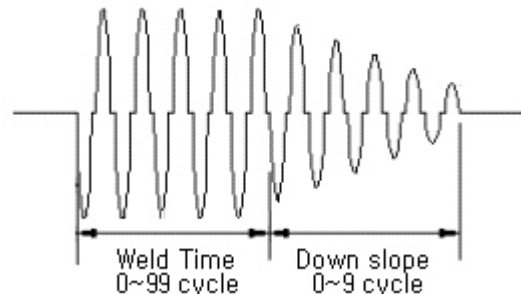
1. SCHEDULE : 0..9 schedule
2. SQUEEZE : 0..99 cycle
3. SLOPE1 : 0..9 cycle \*\*
4. WELD1 : 0..99 cycle
5. COOL1 : 0..9 cycle
6. WELD2 : 0..99 cycle
7. SLOPE2 : 0..9 cycle \*\*\*
8. COOL2 : 0..99.cycle
9. OFF : 0..99 cycle
10. CURRENT1 : 0.0 to 99.9%
11. CURRENT2 : 0.0 to 99.9%
12. WELD COUNT : 0..9999 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





## Selection Table :

### SK24V

**Product name**

SK24V : Vertical type

SK24H : Horizontal type

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