

CS-279P

PROGRAMMING
Selection of program to be modified or to run.

UNIT READY

STAND BY UNIT READY

PRESQUEEZE TIME

SQUEEZE TIME

PREHEAT TIME

COOL TIME 1

SLOPE UP

WELD TIME

COOL TIME 2 (PAUSE)

NUMBER OF PULSES

COOL TIME 3

RELIVE TIME

HOLD TIME

OFF TIME

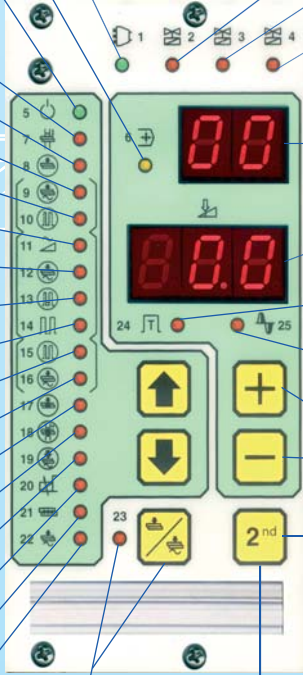
FORGE TIME DELAY

PROPORTIONAL VALVE

SINGLE CYCLE REPETED CYCLE

WELD - NO WELD FROM PROGRAM

POWER SUPPLY



EV - PRESQUEEZE

EV - SQUEEZE

EV - FORGE

ACTIVE PROGRAM DISPLAY

CYCLES - WARNIG - PARAMETERS DISPLAY

TIMES

CURRENTS

PARAMETERS SETTING

SYSTEM PARAMETERS ACCESS

WELD - NO WELD INTERNAL - EXTERNAL

ADD = UNIT NETWORK ADDRESS

TAB = COS f TABLE

LCO = NET COMPENSATION ON - OFF

DLY = FIRST 1/2 CYCLE INSERTION DELAY

CP = PRESSURE CONTACT BEFORE - AFTER SQUEEZE

FC = END CYCLE TYPE

FCT = END CYCLE CONTACT CLOSURE TIME

JP = PRESQUEEZE JUMP OR SQUEEZE IN REPEATED

PFS = PROPORTIONAL VALVE END RANGE

COP = COPIES PROGRAM '0' ON ALL PROGRAMS

RES = SYSTEM - PROGRAM - PARAMETERS RESET



CS-279P

SAFCO Systems s.r.l.

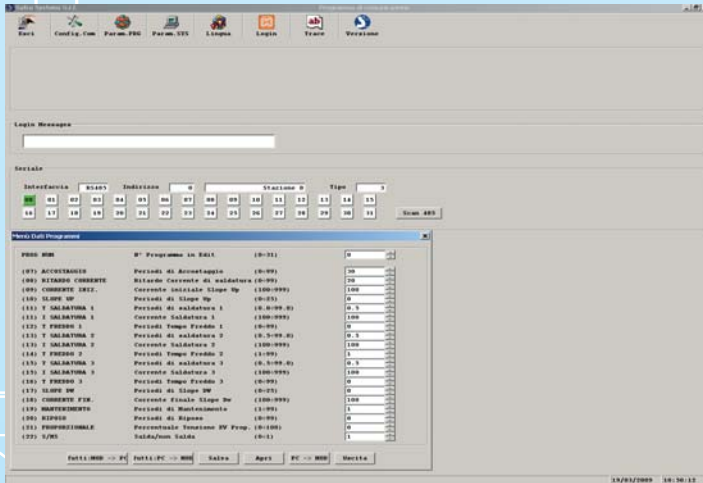
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Main Features:

- Synchronous control for SCR with phase cut off weld current regulation.
 - Working cycle specially designed for Spot weld machines.
 - Three different hot cycles: preheat, weld, after heat.
- Weld time setting up to 10 with a resolution of $\frac{1}{2}$ period; above 10 with a resolution of 1 period.
 - Weld current setting in thousands of half wave phase cut off.
 - All outlets and inlets are galvanic insulated.
- Setting and running capability of 32 programs remote or locally selected.
- Copy function to overwrite automatically the program 0 on all other programs.
- Line voltage compensation with activation / deactivation by system parameter.
 - Network serial interface RS485.
- Cycle start with concomitance (dual inlet) or via foot switch.
 - First insertion delay setting with a system parameter.
 - Separate proportional valve outlet galvanic insulated.
- Setting of the proportional valve full range (100%) from 5 to 10 volt with a system parameter.
 - Three different Cycle Ends with correspondent time setting by system parameters.
 - 16 current tables for different machine's power factor.
- Pre stroke solenoid valve acting as pre stroke with manual opening or opening at cycle end selectable with a system parameter.
 - Automatic power line frequency recognition.
 - Dedicated signals for PLC drive.
- Fully adjustable from a PC program.

