

# Applicable for **AK-24** Spot, 2 Head Spot, Seam Welders Resistance Welding Control

- 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
  - 2 Head Spot Welder
  - Seam Welder & Brazing Welder
  - Flash butt Welder



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## SPECIFICATIONS

MODEL		AK-24V/H
Welding Power Source		220VAC and 440VAC +10%, -25%
Control Power Source		100~240VAC(Free Voltage)
Frequency		50/60Hz
Power Consumption		15W Max.
Indication		7-segment LED, 6.5mm(W) x 10.0mm(H)
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	0.0~99.9%
	Current 2	
Weld Current	Control Method	Phase control by thyristor
	Control Angle	20~160
	Maximum Analyze	0.1% to 140 (0.14)
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
Weld End Signal		Relay Contact Output, One short(0.2 sec)
Number of Solenoid Valve		Valve 1, Valve 2 Control power output
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
Insulation Resistance		Min. 100M $\Omega$ (at 500VDC)
Dielectric Strength		2000VAC 50/60Hz for 1minute
Noise Strength		$\pm$ 2kV the square wave noise (Pulse width: 1 $\mu$ s by the noise simulator)
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)