

Welboy 22

Versatile, easy-to-operate, micro-computer control unit

Model : WELBOY-22V

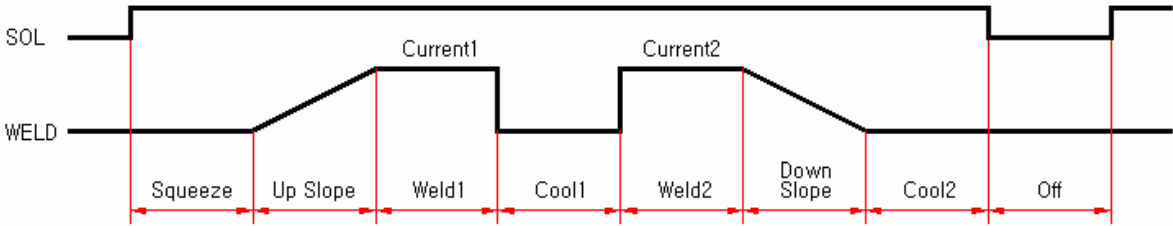


Model : WELBOY-22H



Programmable parameters

Weld Schedule	Squeeze time	Up slope time	Weld1 time	Cool1 time	Weld2 time	Down slope	Cool2 time	Off time	Weld Current1	Weld Current2	Weld Count
0~9	0~99 cycle	0~9 cycle	0~99 cycle	0~99 cycle	0~99 cycle	0~9 cycle	0~99 cycle	0~99 cycle	0.0~99.9 %	0.0~99.9 %	0~9999



Specification

MODEL		AK-20V, AK-20H	WELBOY-22V, WELBOY-22H
Weld power	VAC	220/380/440VAC +10%, -25%	
Control and solenoid power	VAC	110VAC ±15% or 220VAC ±15% [not changeover]	
Frequency	Hz	50/60	
Memory backup	-	10 years and over after power failure	
Indication	-	7-segment LED, 6.5(W) x 10.0(H)mm	
Number of mode input	In	Mode switch1(MS1), Mode switch2(MS2), Dry contact or open collector	
Number of start input	In	Start1(FS1), Start2(FS2), Dry contact or open collector	
Thermo switch input	In	Thyristor thermo switch, Dry contact or open collector	
Number of solenoid valve	Out	Solenoid valve1(SOL1), Solenoid valve2(SOL2), 110VAC and 220VAC	
Weld end signal	Out	Relay contact output (1a1b), One short(0.3sec)	
Weld current	-	Control method : Phase control by thyristor	
		Control angle : 20~160	
		Maximum analyze : 0.1% (0.0~99.9%)	
Weld counter	Count	0~3999	0~9999
Setting range	-	Weld Schedule :0~9 schedules	Weld Schedule :0~9 schedules
		Squeeze time :0~99 cycle Up slope time :0~9 cycle Weld time :0~99 cycle Cool time :0~99 cycle Off time :0~99 cycle Weld Current :0.0~99.9%	Squeeze time :0~99 cycle Up slope time :0~9 cycle Weld1 time :0~99 cycle Cool1 time :0~9 cycle Weld2 time :0~99 cycle Down slope time :0~9 cycle Cool2 time :0~99 cycle Off time :0~99 cycle Weld Current1 :0.0~99.9% Weld Current2 :0.0~99.9%
Ambient temperature	°C	-10 to 55jÉ (at non-freezing status)	
Storage temperature	°C	-25 to 65jÉ (at non-freezing status)	
Ambient humidity	%	35 to 85%RH	
Insulation resistance	-	Min. 100MjΩ (at500VDC)	
Dielectric strength	-	2000VAC 50/60Hz for 1 minute	
Noise strength	-	±2kV the square wave noise(pulse width:1jÁ by the noise simulator)	
Vibration	Mechanical	0.75mm amplitude at frequency of 10 to 55Hz in each of X, Y, Z directions for 1 hours	
	Malfunction	0.5mm amplitude at frequency of 10 to 55Hz in each of X, Y, Z directions for 10 minutes	
Size	mm	194(W) x 76(H) x 190(D)	318(W) x 93(H) x 240(D)
Weight	Kg	2.0Kg Max.	4.0Kg Max.

Operation mode /

Operation mode	External mode switch		Schedule	Remarks
	MS1	MS2		
Spot /Projection mode	OFF	OFF	0 ~ 9	
2Head Spot /Portable mode	ON	OFF	1	Start switch1 (FS1)
			2	Start switch2 (FS2)
Seam mode	OFF	ON	0 ~ 9	Down slope = 0
Brazing mode				Down slope = 1~9
Flash butt mode				Down slope is pulsation

