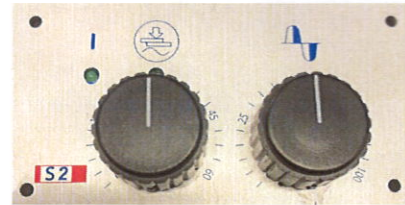


S2 Welding Control



S2 Welding control for PN4-PN6


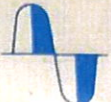
DESCRIPTION OF THE SYNOPTIC PANEL

The synoptic panel is divided in two parts. The top shows the graphical symbols of the available functions as well as the two LEDs signalling the power on and the welding time. The bottom includes two potentiometers for time and power adjustment.

DESCRIPTION OF THE FUNCTIONS

S2 is a microprocessor welding control for managing the welding cycle. A mains period is the timer's unit of time, corresponding to 1/50 of a second with 50 Hz mains frequency or 1/60 of a second with 60 Hz mains frequency.

If, for instance, a welding time of 50 periods is set, time will be equal to 1 second (with 50Hz network)

	Weld time (0.5-60 periods): time during which the pieces to be welded have welding current passing through them.
	Power adjustment (0-100%): The value of the welding current is determined as a percentage of power.

OPERATING INSTRUCTIONS

When the welding machine is turned on the welding control turns on all the power on indicator light **I**.

Simply press START for the welding machine to start the work cycle.

During welding **S2** displays the welding time of the cycle by turning the function LED on.

DESCRIPTION OF CONTROL CONNECTIONS M1

No.	name	Description
4	START (in)	Start cycle: active if closed with + 24V (COM)
7	SPOT (in)	Start cycle: active if closed with + 24V (COM) BUT DOES NOT CONTROL THE EV1 SOLENOID VALVE
2	WELD (in)	Welding consent: if active, it carries out the complete welding cycle; if it is not active, it blocks the approach cycle without welding.
12	SAFE (in)	Safety input: if open, cycle is not possible and both green LEDs flashing
5	SQZ (in)	When active, change status of output EV1
1-3-6-11	COM	+24Volt, common line for all the inputs
9-10	-EV+EV (out)	EV1 supply (welding stroke) 24V d.c.3.5W max.
8	NC	Not connected

DESCRIPTION OF CONTROL CONNECTIONS JP7

AC1		Supply Voltage 18V AC
AC2		Supply Voltage 18V AC
PE		Protection earth connection