C3-T10



The CS-T10 is a welding control suitable to drive spot welding machines and flash butt welding machines. It is a combination of a reliable hardware and easy high performances user interface. The programming is very easy due to a simple key board and to the direct display indications. Malfunctions and wait conditions appear on the display for operator guidance. The capability of writing and running 32 remote or locally selectable programs increase the flexibility of the control.

## **Main features**

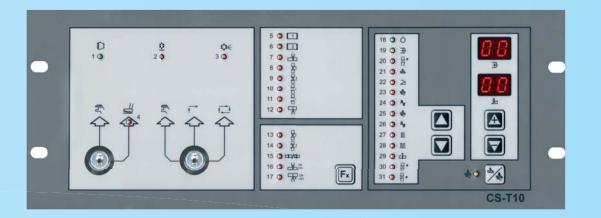
The unit is based on a powerful microcontroller for industrial applications that combines control power, reliability, simple operation and programming. It is a multi function control suited to manage different weld procedures they are: Spot-weld, flash butt-weld and annealing cycles. The high grade protection against external disturbances is obtained by mean of high quality filtering, galvanic insulation of the inlets, and outlets, and trough the use of multilayer print circuit's boards. Moreover the front panel is electrically shielded.



## **Systems** s.r.l. ®

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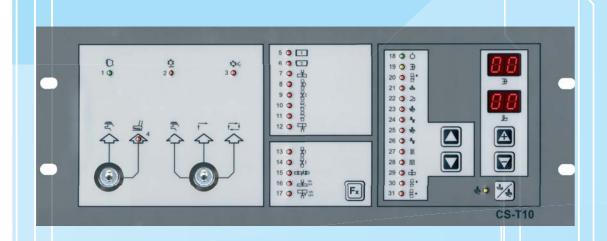


## Spot and Flash Butt Welders Control



**Systems** s.r.l. ®

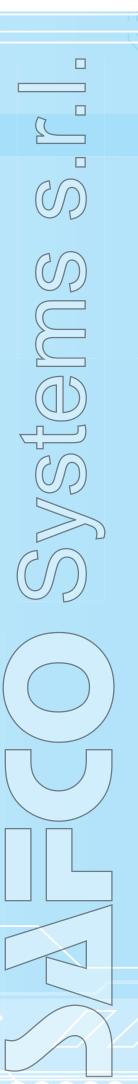
## **C3-T10**



POWER SUPPLY COOLING WATER AIR START CYCLE WITH OUTLETS MANUAL DRIVE FOOTSWITCH (FOR SERVICING) START CYCLE WITH SELECTION OF SEMI-AUTOMATIC CYCLE BUTTONS SELECTION OF AUTOMATIC CYCLE 0 PROTECTION SCREEN - 1 -PROTECTION SCREEN - 2 -

CENTERING DEVICE 501 6 0 2 LEFT 70 4 8 0 1 VICE -1 90 3: 10 0 **RIGHT** 11 0 1 VICE - 2 -120 7 SLIDE FORWARD SLIDE BACKWARD

EXTRACTOR



LEFT

VICE -1 -

DISPLAY OF ACTIVE PROGRAM RIGHT VICE -2-13 0 1 DISPLAY OF CYCLES-14 0 \$2 ALARMS- PARAMETERS SPOT WELDING// FLASH BUTT WELDING 15 **()** ctc/ctc 16 0 H ON Fx PARAMETERS SETTING 17 9 7 37 CENTERING DEVICE ON - OFF WELD - NO WELD INTERNAL - EXTERNAL EXTRACTOR ON - OFF INITIAL SETTINGS FLASHING CYCLE STAND BY STAND BY UNIT READY UNIT READY PROGRAMMING PROGRAMMING Selection of Program N° to Run or to Modify. Selection of Program N° to Run or to Modify. UNIT READY UNIT READY SPOT CYCLE VICES CLOSURE TIME VICES CLOSURE TIME 20 0 0 21 🔾 📥 22 0 2 FLASHING CURRENT SQUEEZE TIME 23 🔾 🍁 25 0 4 26 0 4 27 0 III 28 0 M 29 0 ib 30 0 0 18 0 0 FORGING TIME UP SLOPE 20 0 G 21 0 ± 22 0 ≥ FORGING CURRENT 23 🔾 💠 PREHEAT TIME 24 0 4 25 0 4 26 0 4 27 0 III 28 0 M 29 0 th 30 0 0 **COOLING TIME** PREHEAT CURRENT VICES OPENING TIME WELDING TIME SLIDE BACKWARD TIME WELDING CURRENT PAUSE TIME STAND BY UNIT READY ANNEALING CYCLE NUMBER OF PULSES PROGRAMMING Selection of Program N° to Run or to Modify. HOLD TIME UNIT READY 18 0 0 19 0 <del>1</del> 20 0 <del>1</del> 21 0 <del>4</del> VICES CLOSURE TIME VICES OPENING TIME 22 0 2 SLIDE BACKWARD TIME UP SLOPE 23 🔾 🍁 24 0 4

25 **4** 26 **4** 

27 O II

29 🛈 🕁

30 ○ =. 31 0 =- ANNEALING CURRENT

VICES OPENING TIME

**COOLING TIME** 

