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### typical applications

T4SW/1 replacement



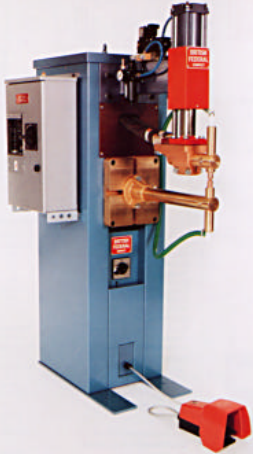
S4SW/1 replacement



S6SW/1 replacement



heavy-duty compacts



# A1SW/1 welding control

data sheet



## A rugged, low-profile T4/S4/S6 replacement

The A1SW/1 is a robust unit providing basic control for resistance welding. Installation, set-up and operation are quick and simple and the integrated programmer has a water-resistant membrane front panel. The A1SW/1 will mount in the same way as the earlier T4/S4/S6 timers, and as such offers a simple replacement or upgrade. All connections are via a high-quality multi-pole connector, and an optional housing and cable form is available for easy interfacing.

features	benefits
8 programs	store settings for different material and thicknesses
single/repeat spot modes	versatile
dual weld + pulsation	can be used for coated materials
380..480V, 50/60 Hz operation	international
counter with optional lock-out	can be used for electrode maintenance
T4/S4/S6 compatible	maintain your investment
anode-fired current control	compatible with ignitrons and SCRs with R1 firing boards
built-in heat control	THC/8 is not required for T4 applications
digital and synchronous	high accuracy and improved welding

### options

sheet metal housing + interface cable form #90-70-01

### configurations

none

# A1SW/1 welding control

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<b>welding parameters x 8</b>		<b>environmental</b>	
mode	single/repeat	temperature	
heat1	0..99%	- operating	0° to +35°C
heat2	0..99%	- storage	-25° to +70°C
presqueeze	0..99 cycles	humidity	
squeeze	0..99 cycles	- operating	up to 80% (relative)
weld1	0..99 cycles	- storage	10% to 90%
cool1	0..99 cycles		
weld2	0..99 cycles		
cool2	0..99 cycles		
pulses	1..9		
hold	0..99 cycles		
off	0..99 cycles		
<b>counter</b>		<b>dimensions</b>	
actual count	0..9999	height	180 mm
end count	0..9999	width	295 mm
at end of count	stop/continue	depth	130 mm + 80 mm for connector
		weight	3 kg
<b>configuration</b>		<b>power requirements</b>	
type		voltage	380..480 V ac
- 00	spot/repeat with 2 <sup>nd</sup> stage and non-beat inputs	frequency	50/60 Hz
- 01	spot/repeat with 2 <sup>nd</sup> program and non-beat inputs	current	< 500 mA
- 02	spot/repeat with counter and 2 <sup>nd</sup> stage input		
- 03	spot/repeat with counter and 2 <sup>nd</sup> program input		
frequency	50/60 Hz		
heat range	high/low		
		<b>i/o ratings</b>	
		inputs	< 10mA @ 24V dc
		outputs	1A @ 480V ac maximum
		SCR drive	anode firing for ignitrons or R1 control of SCRs

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