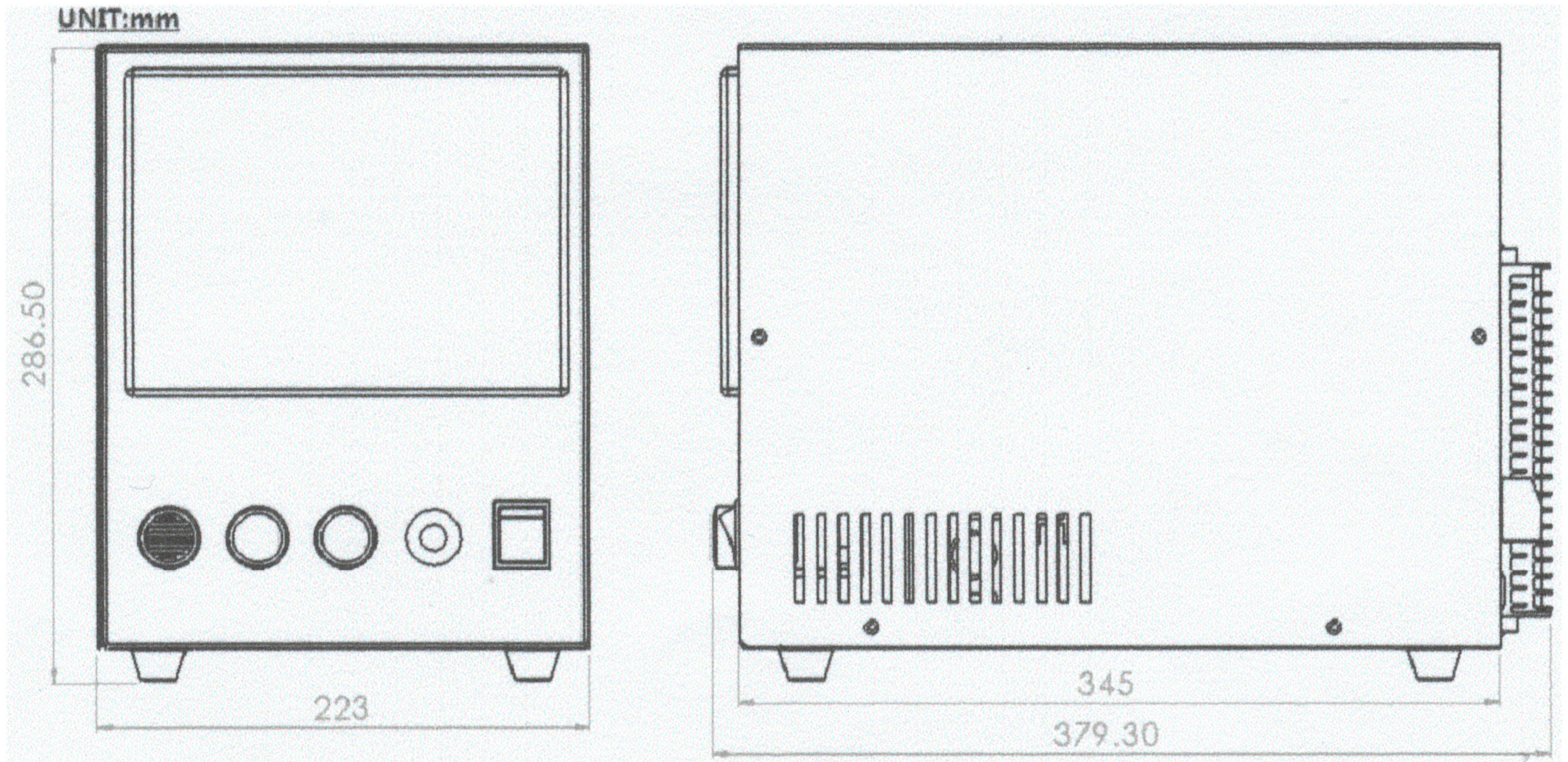


BWAS-A1 Manual of electric control box

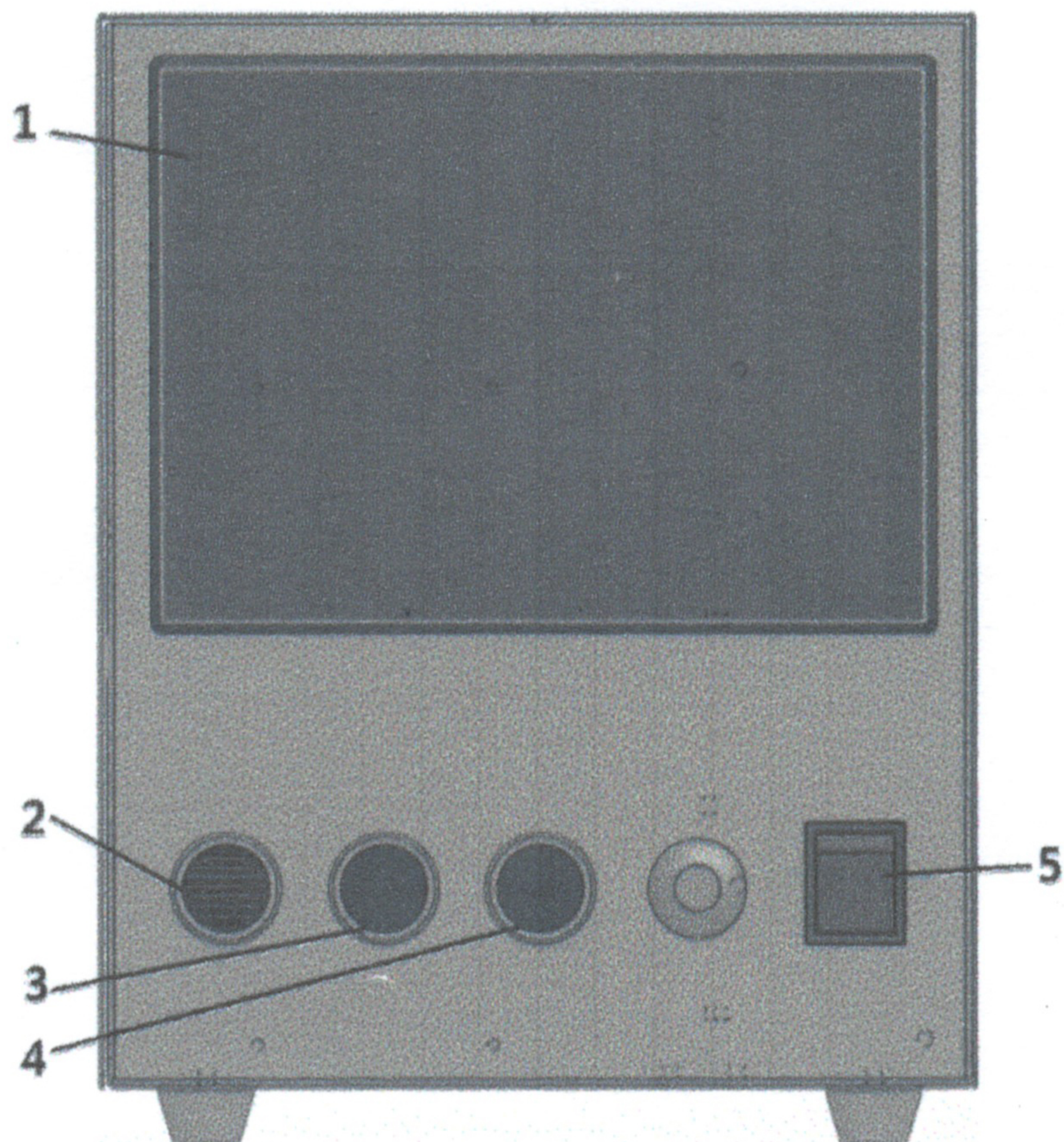
1. Description of the function

The electric control box is used to control the movement of the X and Y axes and the movement of the welding machine.

2. Dimension



3. Front panel



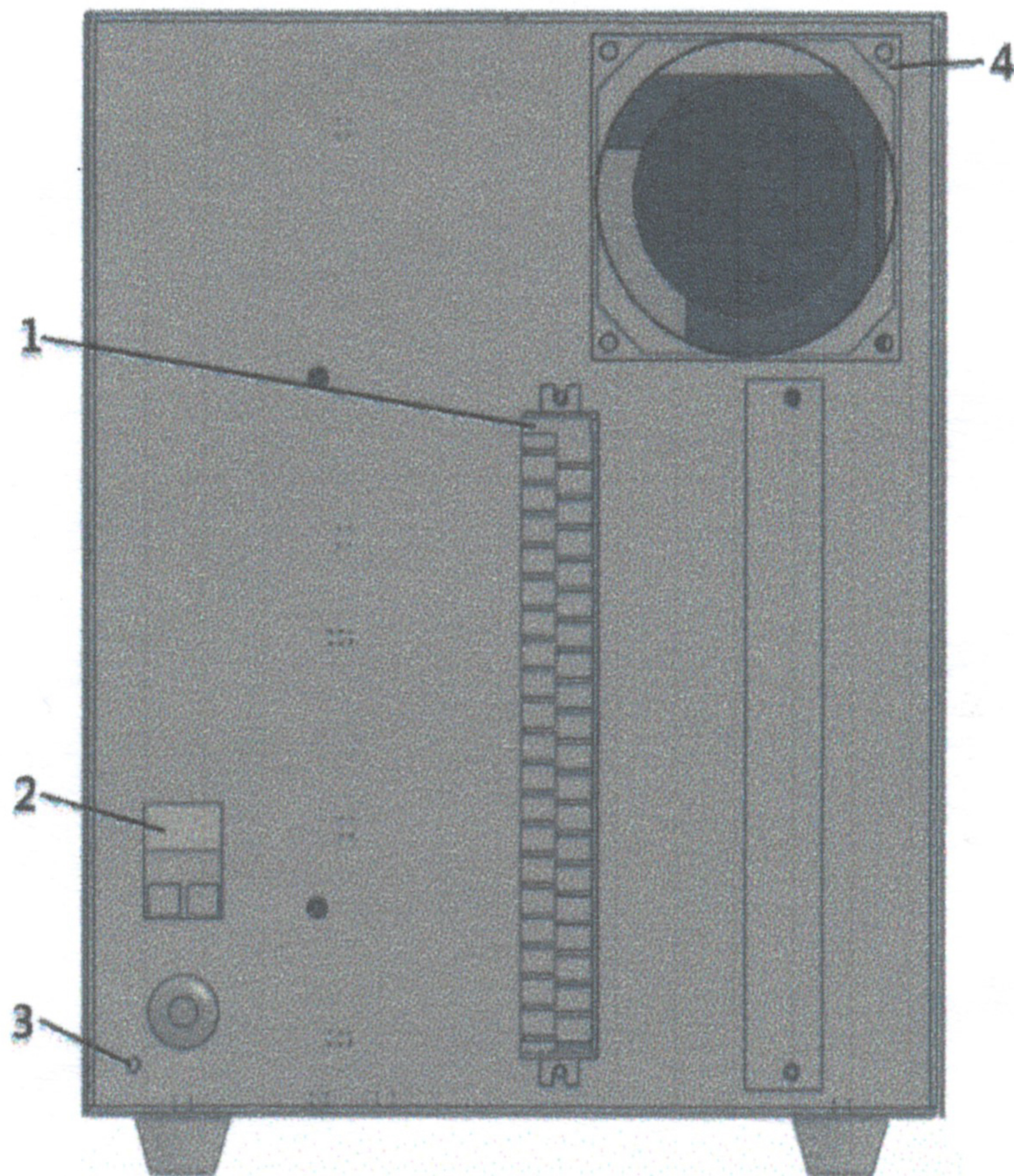
(1) Touch screen:used to set the operating parameters of BWAS-A1 and the monitoring of the operation process.

* Refer to the BWAS-A1 Touch Screen Manual for details

(2) Buzzer: Alarm

- (3) Reset button: Press this button, the machine will return to the state when it was started.
- (4) Start button: Press the key to start automatic welding once.
- (5) Power switch: For powering on and off 220vac.

4. Rear panel



(1) N1 Wiring block

The pin description is as follows:

Pin	Name	Fuction
1	XA	Connect the A line of the X-axis motor
2	/XA	Connect the /A line of the X-axis motor
3	XB	Connect the B line of the X-axis motor
4	/XB	Connect the /B line of the X-axis motor
5	24V+	io dc power supply (24Vdc) Positive
6	24V-	io dc power supply (24Vdc) negative
7	0.06	Connect the origin sensor of x-axis
8	0.00	Connect the CW limit sensor of x-axis
9	0.01	Connect the CCW limit sensor of x-axis
10	NOP	
11	YA	Connect the A line of the Y-axis motor
12	/YA	Connect the /A line of the Y-axis motor
13	YB	Connect the B line of the Y-axis motor
14	/YB	Connect the /B line of the Y-axis motor
15	24V+	io dc power supply (24Vdc) Positive
16	24V-	io dc power supply (24Vdc) negative
17	0.07	Connect the origin sensor of Y-axis
18	0.02	Connect the CW limit sensor of Y-axis
19	0.03	Connect the CCW limit sensor of x-axis
20	NOP	

21	24V+	io dc power supply (24Vdc) positive
22	100. 4	Connect the solenoid valve of the positioning cylinder
23	100. 5	Connect the solenoid valve of the welding head cylinder
24	24V-	io dc power supply (24Vdc) negative
25	0. 08	preserved function
26	24V-	io dc power supply (24Vdc) negative
27	0. 09	Connect the external start button
28	24V-	io dc power supply (24Vdc) negative
29	0. 04	Connect the 【GD】 output signal of welding power source
30	0. 05	Connect the 【NG】 output signal of welding power source

4. 1

- (2) Power wiring block: connect to 220 VAC power supply
- (3) Ground screw: connect the ground wire
- (4) Cooling fan