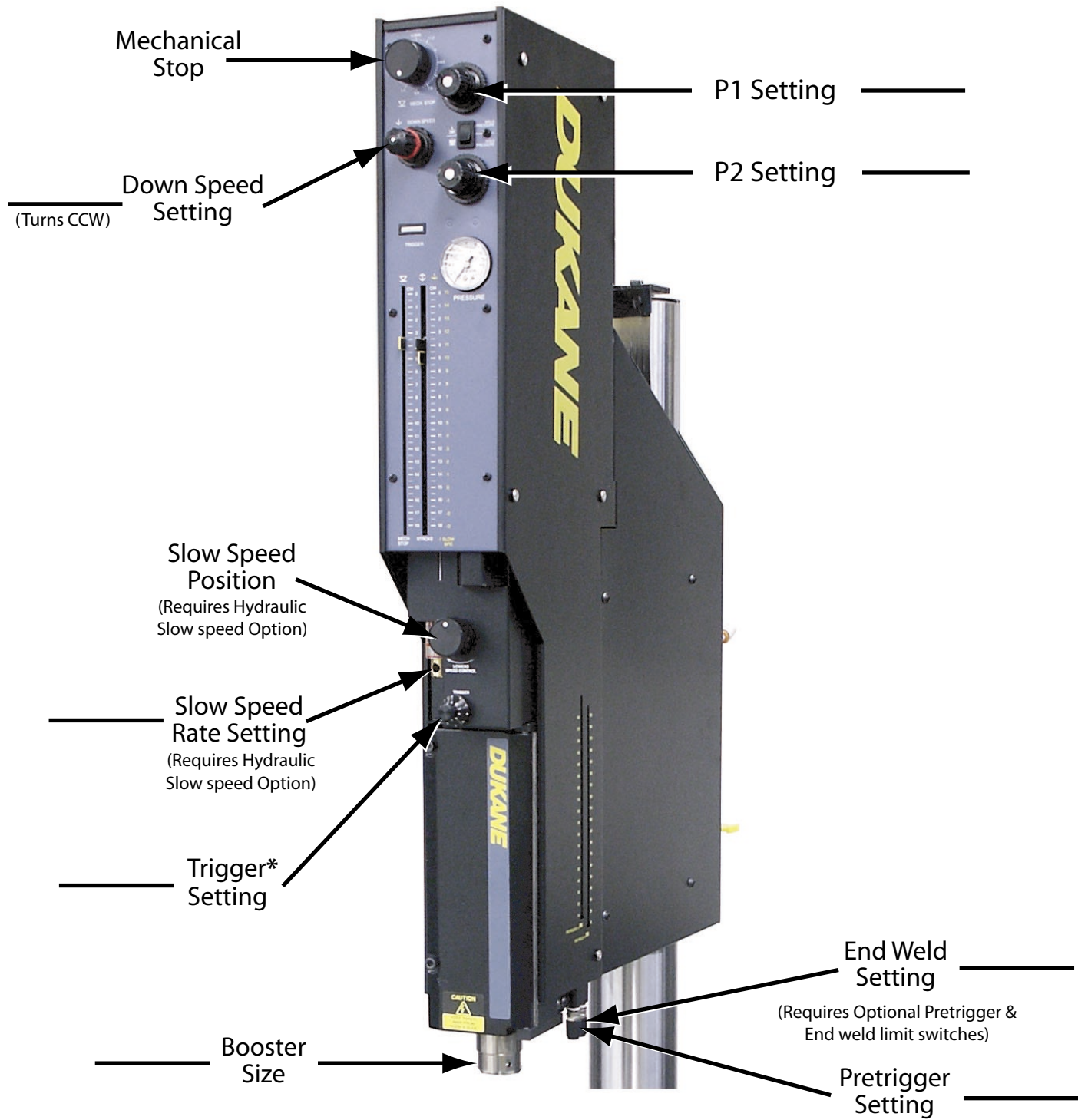


Intelligent Assembly Solutions



# Process Control Settings

# Press Setup Sheet

Job # \_\_\_\_\_

Horn # \_\_\_\_\_

Fixture # \_\_\_\_\_

## Initiate Mode

- Manual
- Auto

## Trigger Method

- Maintained
- Momentary
- Force (if applicable)\* \_\_\_\_\_ lbs.
  - △ Normal Trigger
  - △ Trigger Delay by Time \_\_\_\_\_ sec
  - △ Trigger Delay by Distance \_\_\_\_\_ in/mm Max. time \_\_\_\_\_ sec
  - △ Trigger Delay til Auto-In \_\_\_\_\_
  - △ Pretrigger by Distance \_\_\_\_\_ in/mm
    - ◇ Start weld at Trigger or Pretrigger

- Single Pressure
- Dual Pressure

## Weld Method

### Pressure 1

- △ Time \_\_\_\_\_ sec Max. weld time \_\_\_\_\_ sec
- △ Distance \_\_\_\_\_ in/mm Max. weld time \_\_\_\_\_ sec
- △ Ab. Distance \_\_\_\_\_ in/mm Max. weld time \_\_\_\_\_ sec
- △ Energy \_\_\_\_\_ joules Max. weld time \_\_\_\_\_ sec
- △ Peak Power \_\_\_\_\_ watts Max. weld time \_\_\_\_\_ sec

### Pressure 2

- ◇ Time \_\_\_\_\_ sec Max. weld time \_\_\_\_\_ sec
- ◇ Distance \_\_\_\_\_ in/mm Max. weld time \_\_\_\_\_ sec
- ◇ Ab. Distance \_\_\_\_\_ in/mm Max. weld time \_\_\_\_\_ sec
- ◇ Energy \_\_\_\_\_ joules Max. weld time \_\_\_\_\_ sec
- ◇ Peak Power \_\_\_\_\_ watts Max. weld time \_\_\_\_\_ sec

- Continuous
  - △ Report Interval \_\_\_\_\_ sec

## Scrub

- Disable
- Enable
  - △ Scrub time \_\_\_\_\_ sec

## Hold Method

- Time \_\_\_\_\_ sec
- Distance \_\_\_\_\_ in/mm Max. hold time \_\_\_\_\_ sec
- Auto Max. hold time \_\_\_\_\_ sec

## Afterburst

- Disable
- Enable
  - △ Afterburst delay \_\_\_\_\_ sec Duration \_\_\_\_\_ sec

## Pressure\*

- Downstroke \_\_\_\_\_ psi
- Weld P1 \_\_\_\_\_ psi
- Weld P2 \_\_\_\_\_ psi
- Hold \_\_\_\_\_ psi
- Upstroke \_\_\_\_\_ psi

- Hydraulic Slow Speed \_\_\_\_\_ Rate

## Amplitude

- Amplitude P1 \_\_\_\_\_ %
- Amplitude P2 \_\_\_\_\_ %

## Secondary Controls

- Weld Distance P1 \_\_\_\_\_ in/mm
- Weld Energy P1 \_\_\_\_\_ joules
- Peak Power P1 \_\_\_\_\_ watts
- Weld Distance P2 \_\_\_\_\_ in/mm
- Weld Energy P2 \_\_\_\_\_ joules
- Peak Power P2 \_\_\_\_\_ watts
- Abs. Distance P2 \_\_\_\_\_ in/mm
- Total Weld Time \_\_\_\_\_ sec
- Total Weld Energy \_\_\_\_\_ joules
- Total Cycle Time \_\_\_\_\_ sec
- Total Stroke \_\_\_\_\_ in/mm
- Booster Size \_\_\_\_\_ Ratio

\* If the press is equipped with Electronic Regulator and load cell, program these settings using the Generator/Power Supply front panel