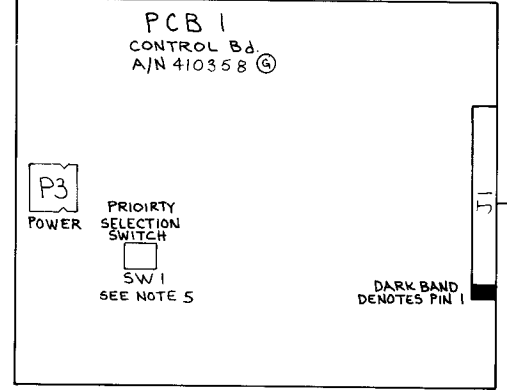
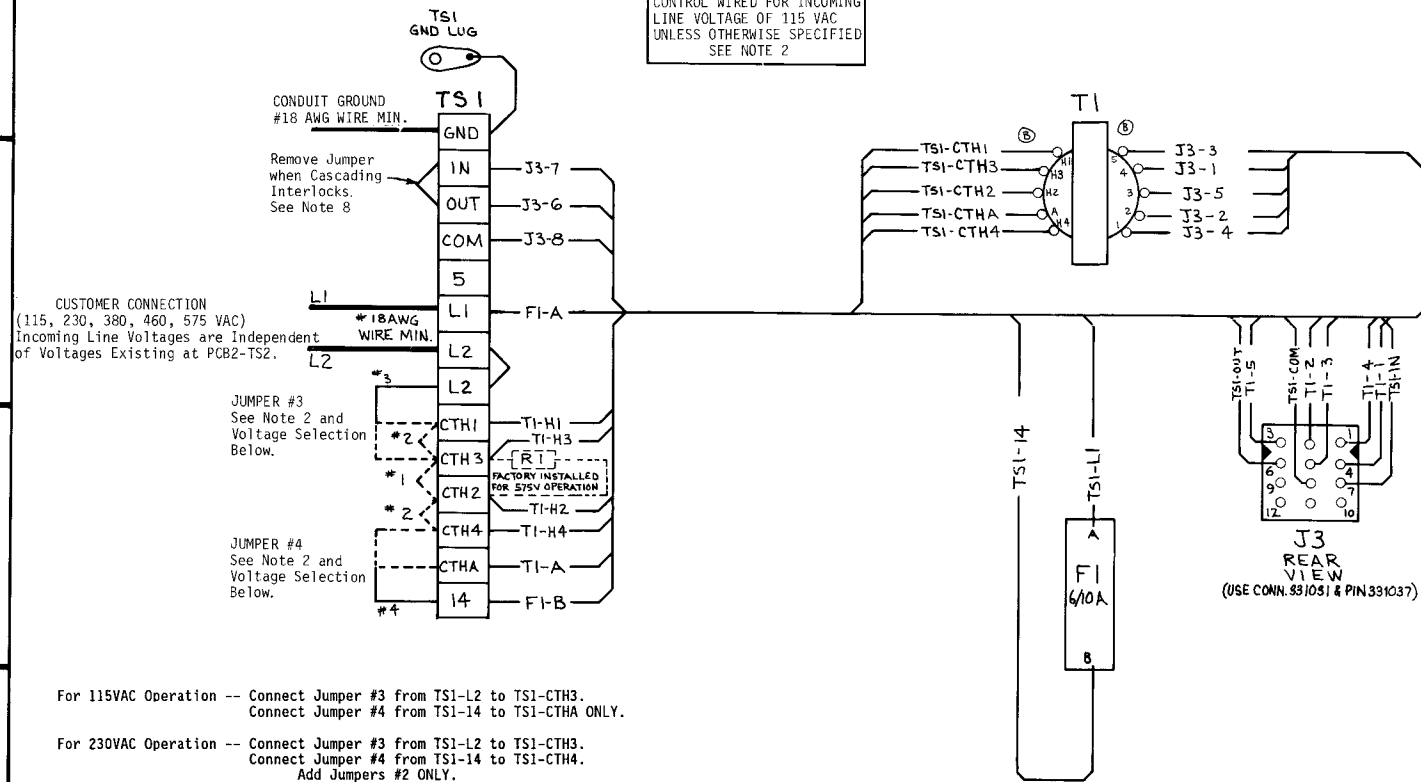


CAUTION CONTROL WIRED FOR INCOMING LINE VOLTAGE OF 115 VAC UNLESS OTHERWISE SPECIFIED SEE NOTE 2.

CAUTION-READ ALL NOTES BEFORE INSTALLING OR OPERATING THIS CONTROL.



NOTE: As of 8/22/03 PCB 410256 is obsolete for Mfr., replaced by 410358.

CUSTOMER CONNECTION (115, 230, 380, 460, 575 VAC) Incoming Line Voltages are Independent of Voltages Existing at PCB2-TS2.

JUMPER #3 See Note 2 and Voltage Selection Below.

JUMPER #4 See Note 2 and Voltage Selection Below.

- For 115VAC Operation -- Connect Jumper #3 from TS1-L2 to TS1-CTH3. Connect Jumper #4 from TS1-14 to TS1-CTHA ONLY.
For 230VAC Operation -- Connect Jumper #3 from TS1-L2 to TS1-CTH3. Connect Jumper #4 from TS1-14 to TS1-CTHA. Add Jumpers #2 ONLY.
For 380VAC Operation -- Connect Jumper #3 from TS1-L2 to TS1-CTH1. Connect Jumper #4 from TS1-14 to TS1-CTHA. Add Jumper #1 ONLY.
For 460VAC Operation -- Connect Jumper #3 from TS1-L2 to TS1-CTH1. Connect Jumper #4 from TS1-14 to TS1-CTHA. Add Jumper #1 ONLY.
For 575VAC Operation -- Connect Jumper #3 from TS1-L2 to TS1-CTH1. Connect Jumper #4 from TS1-14 to TS1-CTHA. Add 2k, 10W Resistor as shown ONLY.

Table with columns: QTY., DESIG., PART NO., DESCRIPTION. Lists parts like PCB1, PCB2, TS1, CRI, CRO, F2-17, T1, TS1, F1, F2, J3, R1, CRO.

PACK CABINET DOOR KEY IN POLY BAG 900148 AND TAPE TO INSIDE OF CABINET DOOR USING YELLOW TAPE 900118.

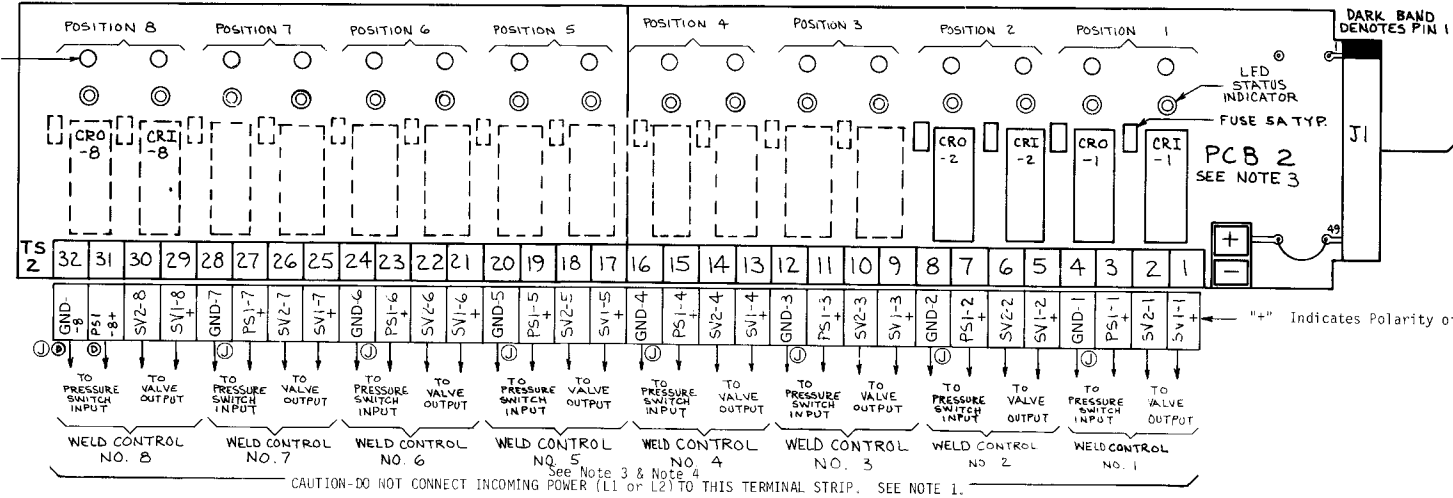
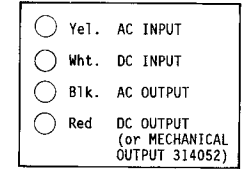
Relay Selection per Customer Spec. See Note 3. Additional Part when 575V control is specified. FOR SERVICE ONLY. See Drawing 440275 & 600347 for Mechanical Assembly Instructions.

Table with columns: POSITION, OPTION DESTG. Rows 1-8.

Table with columns: OPTION, VALVE INPUT ON VOLTAGE, ENTRON PART NUMBER, DOT COLOR CODE, PRESSURE SWITCH OUTPUT VOLTAGE, ENTRON PART NUMBER, DOT COLOR CODE. Lists options A through M.

5-8 WELDER INTERLOCK 2-4 WELDER INTERLOCK

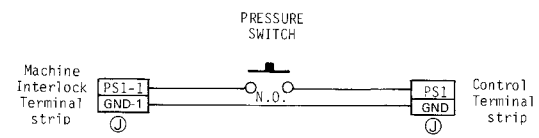
Color Coded Dots Represent type of Relays Installed. See Note 3



"+" Indicates Polarity of Relays. See Note 7.

- NOTES: 1. It is recommended that pressure switch wiring (PS1,PS2) be physically separated from high voltage wiring (115V or Higher) (SV1,SV2).
2. For 115VAC Operation -- Connect Jumper #3 from TS1-L2 to TS1-CTH3. Connect Jumper #4 from TS1-14 to TS1-CTHA ONLY.
3. PCB2 A/N 410254 (2-4 Welder Interlock) or A/N 410255 (5-8 Welder Interlock) relays to be specified by customer. Please refer to chart for input relay (CRI) & output relay (CRO) selection.
4. PS1 & GND denote connections to pressure switch terminals located in the welding controls being interlocked. SV1 & SV2 denote connections to solenoid valve output terminals located in the welding controls being interlocked.
5. Set Switch, SW1 to position 1-8 to give machine 1-8, respectively, priority over Any others initiated. Set SW1 to position 0 when priority is not required. Control is shipped with SW1 set to 0.

6. When a machine interlock is to be used with pressure switches, it should be connected as shown below.



- 7. If DC relays are installed, polarity marked on TS2 must be observed.
8. Expansion Provision - When more than 8 controls are to be interlocked, additional welder interlocks can be interlocked as follows. Connect TS1 "OUT" of the first welder interlock to TS1 "IN" of the second. Connect TS1 "OUT" of the second unit to TS1 "IN" of the next unit, etc. Connect TS1 "OUT" of the last unit to TS1 "IN" of the first unit. Connect "COM" of all controls in parallel. Each additional unit may provide for interlocking up to 8 welder controls. The priority switch, SW1, must be set to position 8 or 9. There is no priority schedule when 2 or more units are connected in this manner.

Revision table with columns: REV, AUTH, DESCRIPTION, DATE. Lists revisions from K to A.

ENTRON CONTROLS INC. SCALE, DATE, DRAWN BY, CHK'D BY, APPROVED BY. Includes drawing number 420721 and revision K.