



421262-004 D

PARTS LIST - CONTROL SECTION			
QTY.	DESIG.	PART NO.	DESCRIPTION
1		600566-002	Assem., Dial Plate, w/Sw. Assem., EN1000, Consisting of:
1		600566-003	Assem., Dial Plate, w/Sw. Assem. & Keylock, EN1000, Consisting of:
1	PCB1	600541-004	Assem., Switch, Sequence Control & Display Board
1	SW1	600531-001	Assem., Switch, Keylock, Momentary, SPDT
1	SW2	600403-001	Assem., Switch, Polarity/Reverse, (Part of J3 Harness)
1		540246	Illustrated Panel, Dial Plate, EN1000, "B" Cabinet
1		515104	Panel, Display, Window, Red Filter, EN1000
1		565003	Hole Plug, 3/4" Diam., Black, (See Note 4)
1	PMR.LT.	305001	Lamp, Neon, Red, 230V
1	WLD.LT.	305002	Lamp, Neon, Clear, 230V
1	J2-J2	322349	Assem., Harness, Control Bd. to Terminal Bd.
1	J3	322350-003	Assem., Harness, Power, EN1000
1	J4-J4	322384	Assem., Harness, Control Bd. to RS232 Driver Bd.

EN1000-150B

PARTS LIST - CONTACTOR/POWER SECTION			
QTY.	DESIG.	PART NO.	DESCRIPTION
1	TS4	335007	Terminal Strip, 2 Pin, (For IDS), (Part of J3 Harness)
1	T1	310001	Transformer, Control, (Part of J3 Harness)
1	T2	311002	Transformer, Sense, (Part of J3 Harness)
1	F1	308001	Fuseholder, Mini, 600V, HPC-L (BBS), (Part of J3 Harness)
1	F1	307018	Fuse, Control, 6/10A, BBS 6/10
1	J232-J232	322369-002	Assem., Harness, RS232 Driver Bd., to Rear Panel
2	R74	600048	Resistor, Power, 2000 Ohm, 10W, (For 575V)
1	R70, 71	225016	Resistor, Power, Surge, 500 Ohm, 100W
1	(R70, 71)	325024	Assem., Wire, Surge Resistor, 18 Ga., Black
1	TLS	600613	Assem., Contactor, Thyristor, Air, 150A, 460/575V, w/TLS
1	PCB5	300020	Switch, Temp. Limit, (N.C.), (Part of 600613)
1	PCB2	410326	Assem., PCB, RS232 Driver Board
1	PCB2	410333-003	Assem., PCB, Terminal Strip Bd., EN1000, "B" Cabinet
1	F6(PCB2)	307022	Assem., Fuse, 1 Amp, Slow Blow, 2 Ag, (Part of 410333-003)
1	(PCB2)	510236-001	Plate, Mounting, Terminal Strip Board
1		346004	Lug, Screw, Chassis GND, 2/0 Wire
1		565001	Hole Plug, 1" Diam., Black
1	IDS	600044	Assem., Interlocking Door Solenoid
1		314001	Coil Assem., Only, IDS
1		510001-002	Cabinet, Control Style "B", Bench, Modified
1		530004	Door, Cabinet, "B", Bench
1		700140	APPLICATION NOTE, RS232 OPTION
4		580001	Jumper, Terminal Strip Board, TS1, Voltage #1 & #2
1		700117	Manual, EN1000
1		421262-004	Wiring Diagram, EN1000-Series/232, "B" Cabinet

Optional Keylock, when specified by customer. See Note 4. Pack Key in Poly Bag 900148 & attach to Door w/Yellow Tape 900118.  
 Substitution or Addition of parts when 575V Control is specified.  
 See Drawing #600567 for Mechanical Assembly Instructions.  
 See Drawing #440269 for Packing Instructions, "B" Cabinet.  
 See Drawing #440353 for Label Locations, "B" Cabinet.

- NOTES:
- It is recommended that control wiring (i.e.: initiation, pressure switch, etc.) be physically separated from the high voltage wiring (115 volts or higher).
  - For 460 VAC Operation - Use Jumpers #1 on TS1. As shipped unless otherwise specified.  
 For 230 VAC Operation - Use Jumpers #2 on TS1.  
 For 575 VAC Operation - FACTORY WIRED ONLY.  
 Use Jumper #1 between H2 & H3 on TS1. Use Resistor R74 (2000 Ohm, 10 Watt) in place of Jumper #1 between CTH2 & CTH3 on TS1.  
 For 115 VAC or 380 VAC Operation - CONSULT FACTORY.
  - For Single Stage Pilot Operation - Connect pilot switch to TS1-FS3 & TS1-GND. No jumpers required across TS1-FS1 & TS1-GND.  
 For Two Stage Pilot Operation - Connect 1st stage pilot switch to TS1-FS1 & TS1-GND. Connect 2nd stage pilot switch to TS1-FS3 & TS1-GND.  
 For DUAL COUNT/DUAL CURRENT (Dual Weld/Dual Heat) SEE MANUAL.
  - When Optional Program Lockout is specified by customer. Dial Plate A/N 600566-003 replaces A/N 600566-002, Add Switch P/N 600531-001 & remove Hole Plug P/N 565003.
  - See Wiring Diagram #421180 for EN1000-Series, "S" Cabinet.  
 See Wiring Diagram #421189 for EN1000-Series, "R" Cabinet.  
 See Wiring Diagram #421210 for EN1000-Series, "D/T/LF/LS" Cabinet, w/Optional Circuit Isolation Device.  
 See Wiring Diagram #421212 for EN1000-Series, "E" Cabinet.
  - Connect TS1-L2/CTH4 to L2/H2 side of Welding Transformer Primary.

**WARNING: HIGH VOLTAGE**  
 VOLTAGES PRESENT IN THIS CONTROL CAN CAUSE SEVERE OR FATAL INJURIES  
 NOTE: EVEN THOUGH SUPPLY POWER TO THIS UNIT HAS BEEN DISCONNECTED, THERE MAY BE VOLTAGES IN THIS CONTROL ORIGINATING FROM OTHER SOURCES.  
 FOR ALL VOLTAGE POTENTIAL TO BE REMOVED FROM THIS CONTROL, POWER MUST BE REMOVED FROM ALL EXTERNAL CONTROL CIRCUITS CONNECTED TO TERMINALS IN THIS CABINET 44091

**FOR SERVICE ON THIS CONTROL CONTACT YOUR MACHINE DEALER OR**  
**ENTRON CONTROLS INC. DIRECTLY: (630) 882-8600**  
 485 EAST RANDY ROAD  
 CAROL STREAM, IL 60188  
 FAX # (630) 882-3377 44092

<b>ENTRON CONTROLS INC</b>			
SCALE	DATE	DRAWN BY	CHK'D BY
1/2"	95	DEC	DEC
TOLERANCE UNLESS SPECIFIED		REVISED	
ANGLES: ± 1/2°	REV LTR	APPROVED BY	
DECIMALS: ± .010	D	DATE	
FRACTIONS: ± 1/64	DATE	11-18-96 DEC	
WIRING DIAGRAM, EN1000-SERIES/232, "B" CABINET			
NEXT ASSM/USED ON		DRAWING NUMBER	
		421262-004 D	

ADD  
 TS1 600630  
 PER 60052422  
 SEE 441262

CHG  
 J3 2/11  
 1056 H102 P/N  
 2474 300 P/W  
 412262  
 DEC 3 21-01  
 441262-004

DRAWING NUMBER 421262-004 D REV