

NO CIRCUIT CALIBRATION OR ADJUSTMENT EVER REQUIRED.

CAUTION Control Shipped Wired for 380 VAC Unless otherwise specified - See Note 2.

NOTE: CURRENT 150A CONTACTOR AS OF JANUARY, 1996. AFTER JULY, 1996, 70A CONTACTOR HAS BEEN REPLACED BY CURRENT 150A CONTACTOR. AFTER JANUARY, 1996 & BEFORE JULY, 1996, 70A CONTACTOR IS A/N 600614. FOR 70/150A CONTACTORS PRIOR TO JANUARY, 1996 SEE VIEW AT RIGHT.

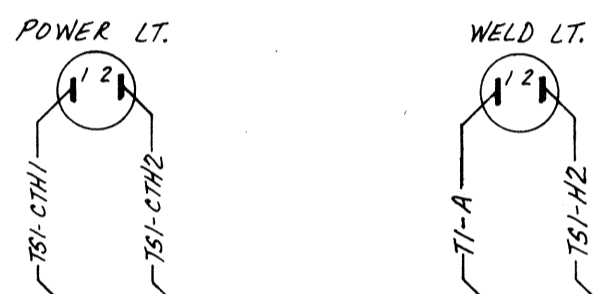
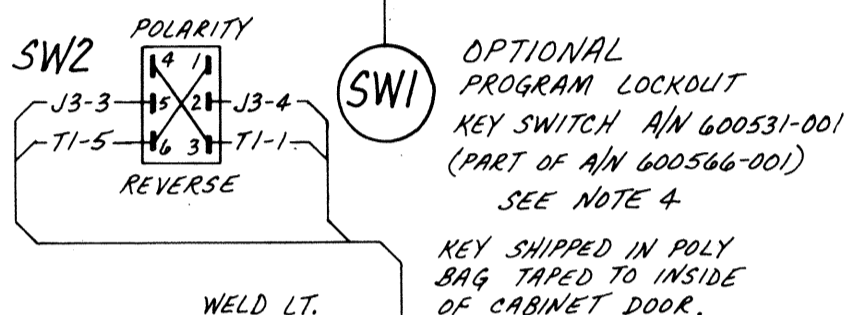
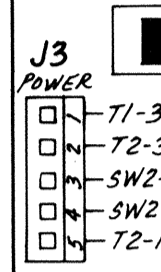
NOTE: PRIOR TO APRIL, 1993, 70A CONTACTOR IS A/N 600568. 150A CONTACTOR IS A/N 600569. AFTER APRIL, 1993 & BEFORE JANUARY, 1996, 70A CONTACTOR IS A/N 600570. 150A CONTACTOR IS A/N 600571. AFTER JANUARY, 1996, 70A & 150A CONTACTORS HAVE BEEN REPLACED BY CURRENT VIEW AT LEFT.

CONTACTOR WIRING DIAGRAM EN1000-70B (After April, 1993) (Before January, 1996) EN1000-150B (After April, 1993) (Before January, 1996)

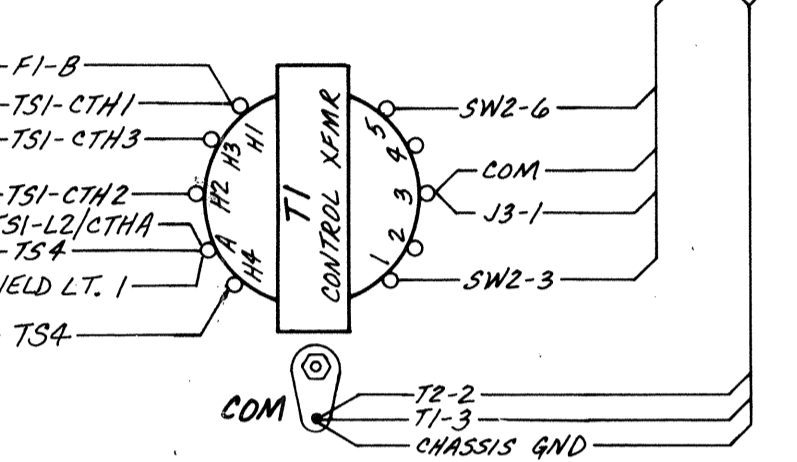
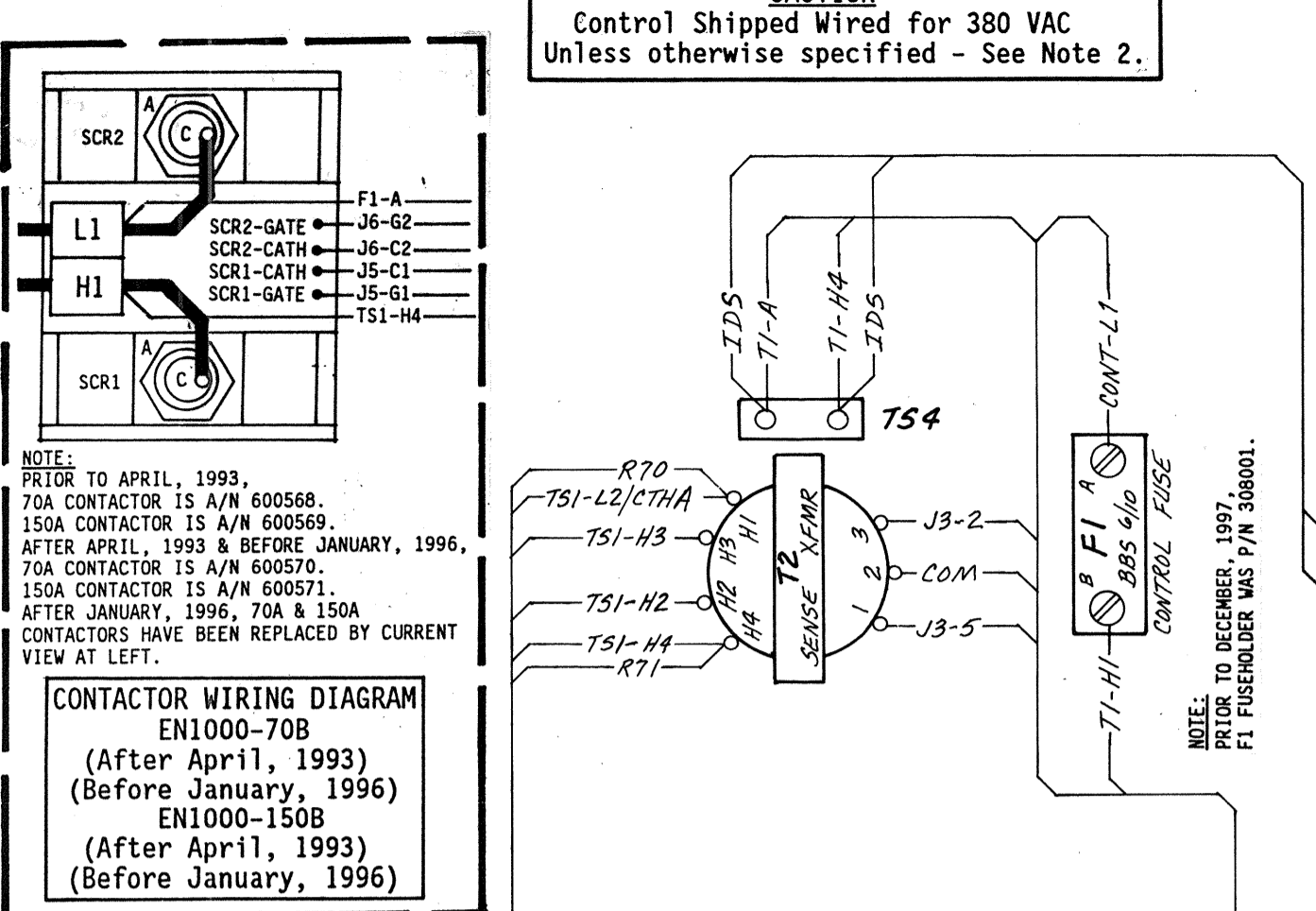
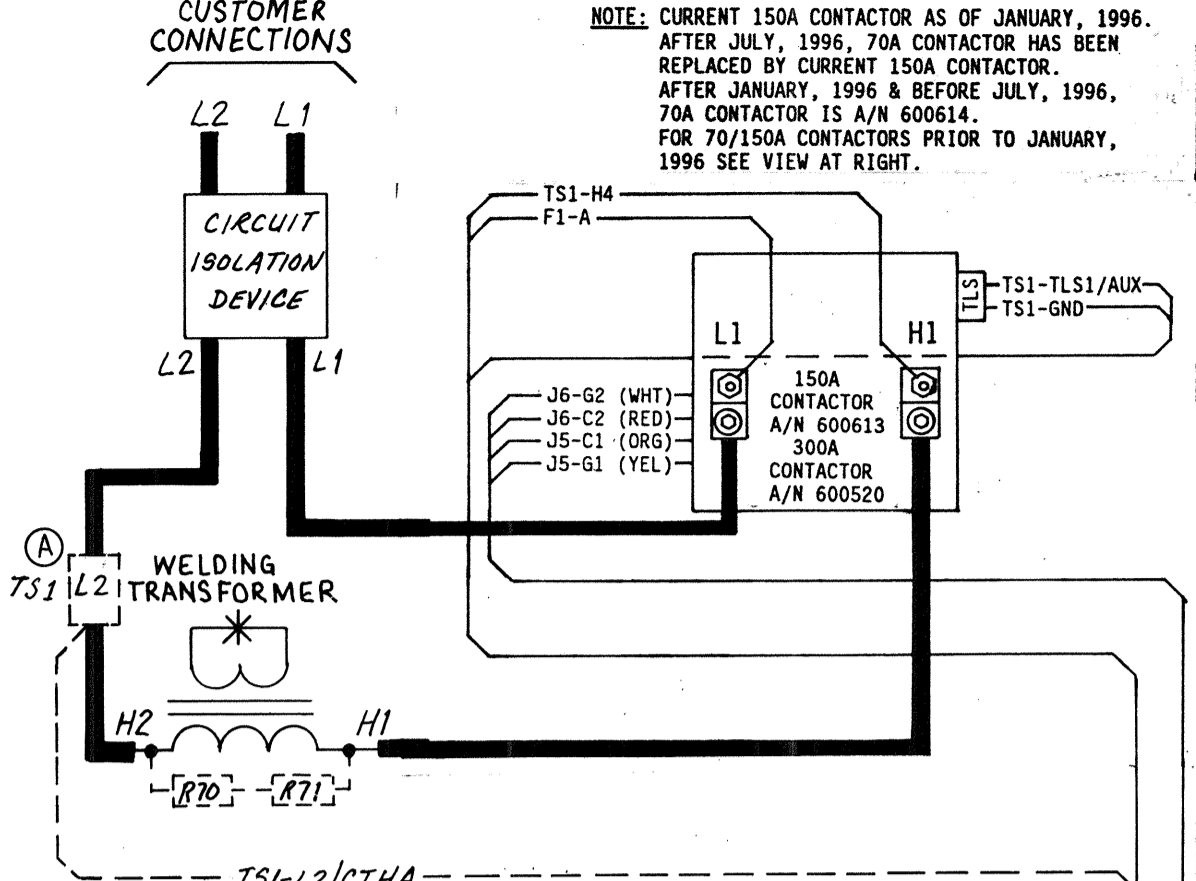
NOTE: PRIOR TO DECEMBER, 1997, F1 FUSEHOLDER WAS P/N 308001.

DIAL PLATE ASSEMBLY EN1000, "B" CABINET A/N 600566 OR A/N 600566-001 w/KEY SWITCH (SEE NOTE 4)

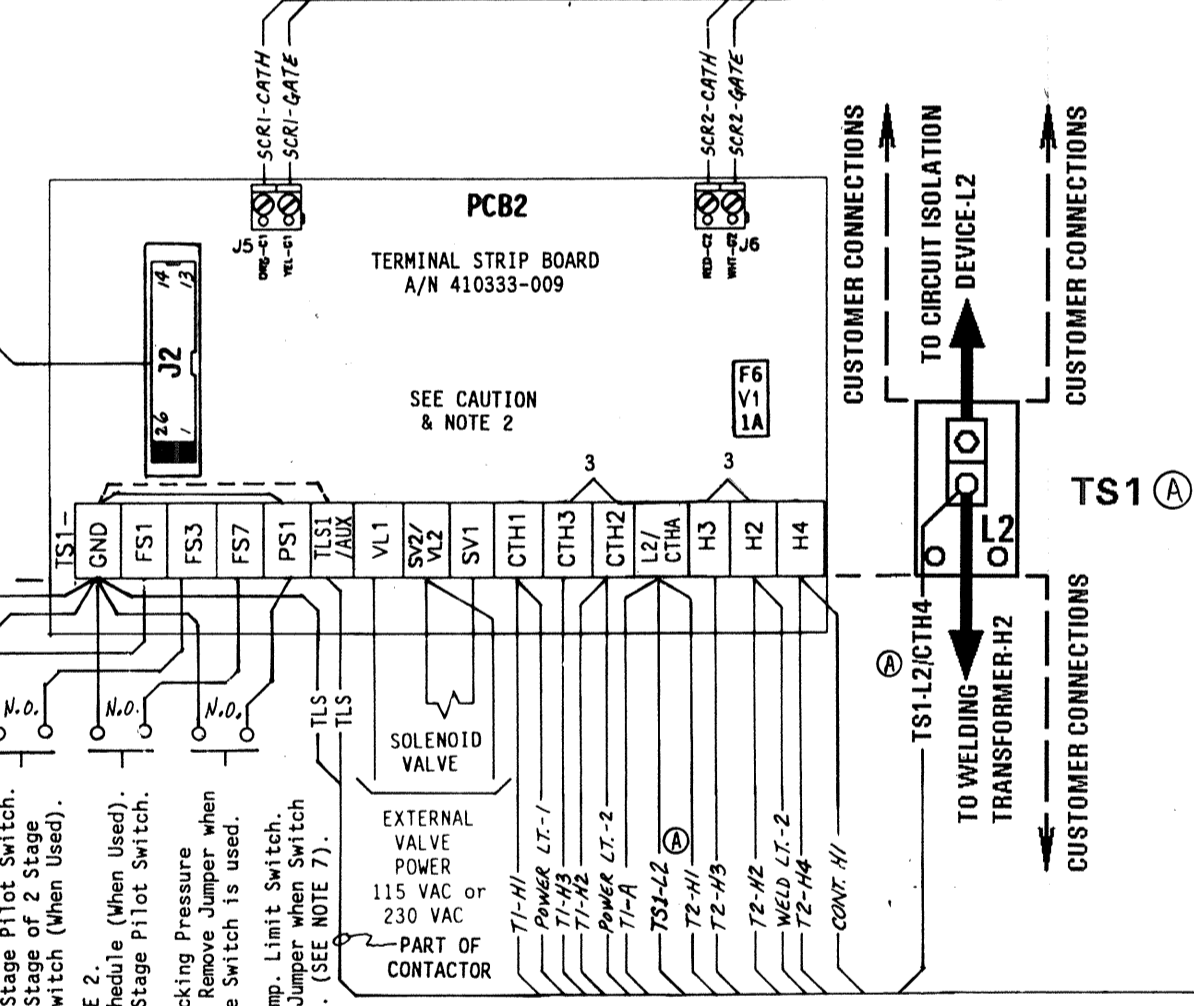
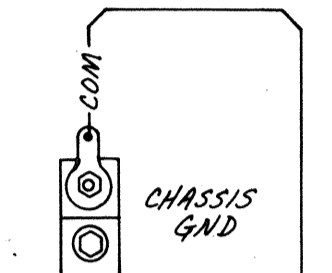
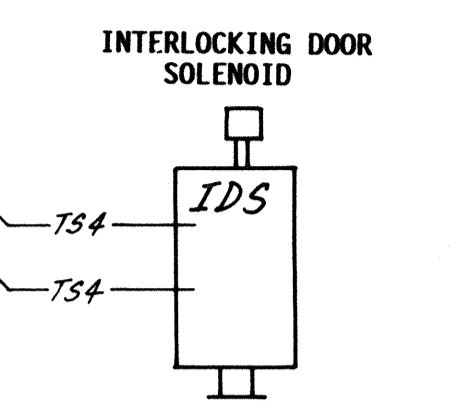
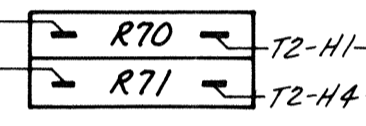
PCB1 SWITCH ASSEMBLY SEQUENCE CONTROL & DISPLAY BOARD A/N 600541



Switches & Lights shown as viewed from inside of cabinet.



SURGE RESISTORS 500 OHM, 100W, EACH



CAUTION SEE NOTE 2

For 380 VAC Operation - Use Jumpers #3 on TS1.

DO NOT CHANGE JUMPERS!

For 230, 460, & 575 VAC Operation - CONSULT FACTORY.

CAUTION - CONTROL WIRED FOR 380 VAC OPERATION - UNLESS OTHERWISE SPECIFIED. CUSTOMER CONNECTIONS - CAUTION - READ MANUAL & ALL NOTES BEFORE INSTALLING OR OPERATING CONTROL. SEE NOTE 1.

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 SERVICE ON THIS CONTROL CONTACT YOUR MACHINE DEALER OR ENTRON CONTROLS INC. DIRECTLY: (630) 882-9800

INSTRUCTIONS TO CONVERT A EN1000 "B" CABINET CONTROL FROM 230/460 VAC OPERATION TO 380 VAC OPERATION.

- On Control Transformer T1 terminal "H4", disconnect the two (2) wires from TSI-L2/CTHA (Violet) and WELD LT.1 (Violet). NOTE: Terminal "TS1-L2/CTHA" was previously "TS1-L2/CTH4" on Terminal Strip Board. Do NOT remove TS4 (Black) wire on T1-H4. On Control Transformer T1, connect the two (2) wires from TSI-L2/CTHA (Violet) and WELD LT.1 (Violet) to terminal "H4". On PCB2 Terminal Strip Board, previous terminal "TS1-L2/CTH4" now becomes "TS1-L2/CTHA". The Terminal Strip Board for 380 VAC Operation now becomes A/N 410333-009. Use Jumpers #3 on PCB2 Terminal Strip Board. Do NOT use Jumpers #1 & #2 from previous Wiring Diagram #421262 on the Terminal Strip Board (PCB2).

- NOTES: 1. It is recommended that control wiring (i.e.: initiation, pressure switch, etc.) be physically separated from the high voltage wiring (115 volts or higher). 2. For 380 VAC Operation - Use Jumpers #3 on TS1. DO NOT CHANGE JUMPERS! For 230, 460, & 575 VAC Operation - CONSULT FACTORY. 3. 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. 4. When Optional Program Lockout is specified by customer. Dial Plate A/N 600566-001 replaces A/N 600566. Add Switch P/N 600531-001 & remove Hole Plug P/N 565003. 5. 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. 6. 7. EN1000-150B & EN1000-300B: ENTRON supplies Temperature Limit Switch (TLS) P/N 300020 and provides connections to TSI-TLS1/AUX & TSI-GND. Jumper not required between TSI-TLS1/AUX & TSI-GND. NOTE: TLS Thyristor will open at temperatures greater than or equal to 150° F. After January, 1996 the Temperature Limit Switch (TLS) is a part of 150A Contactor Assemblies. 8. For EN1000 "B" Cabinet controls built before April, 1993 with 70A Contactor A/N 600568 & 150A Contactor A/N 600569, see Wiring Diagram 421262 revision "A".

Table with 4 columns: QTY, DESIG, PART NO., DESCRIPTION. Lists parts like Dial Plate, Switch Assembly, Transformer, Fuseholder, Resistor, Contactor, and Solenoid.

Table with 4 columns: QTY, DESIG, PART NO., DESCRIPTION. Lists parts like Terminal Block, Terminal Strip, Transformer, Fuseholder, Resistor, Contactor, Terminal Strip Board, Lug, Interlocking Door Solenoid, Cabinet, Jumper, and Manual.

- 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.

ENTRON CONTROLS INC. drawing header and revision table. Includes fields for SCALE, DATE, DRAWN BY, CHK'D BY, APPROVED BY, and a revision table with columns for REV, AUTH, DESCRIPTION, DATE, and BY.

Table with 3 columns: REV, AUTH, DESCRIPTION. Shows revision history for part EN1000-150B.