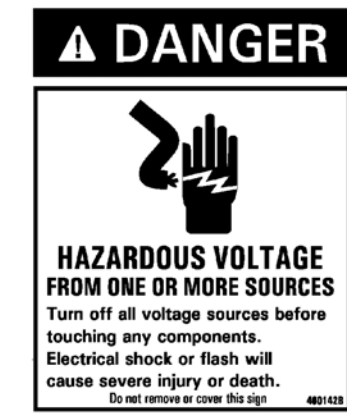
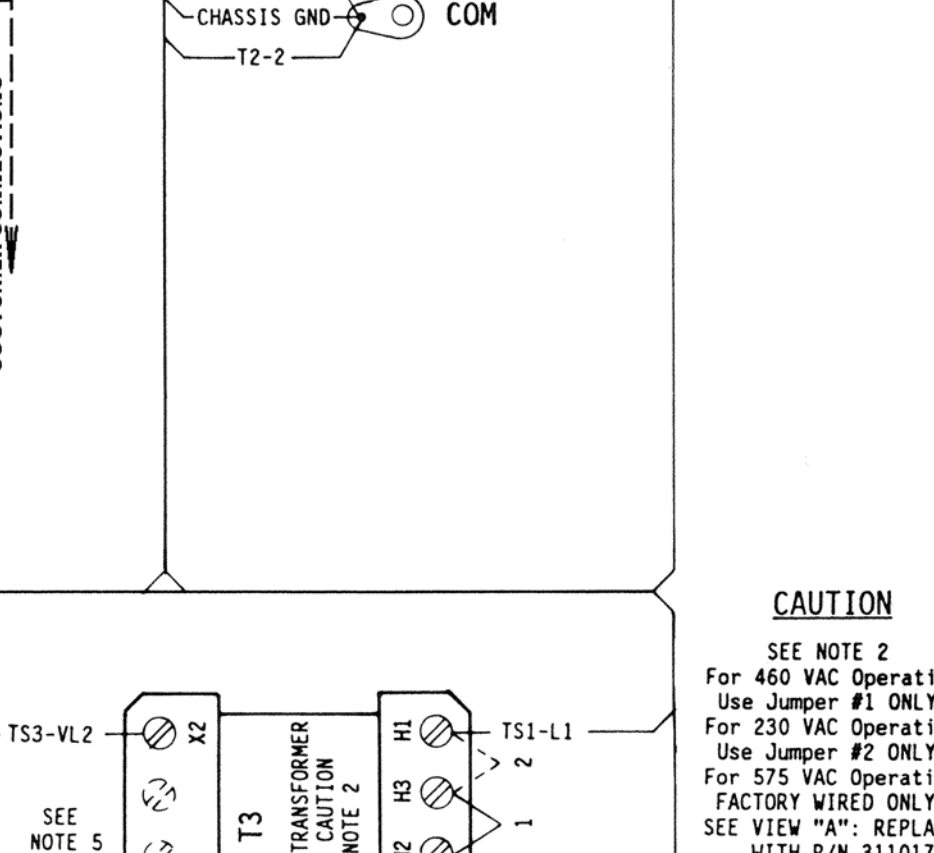
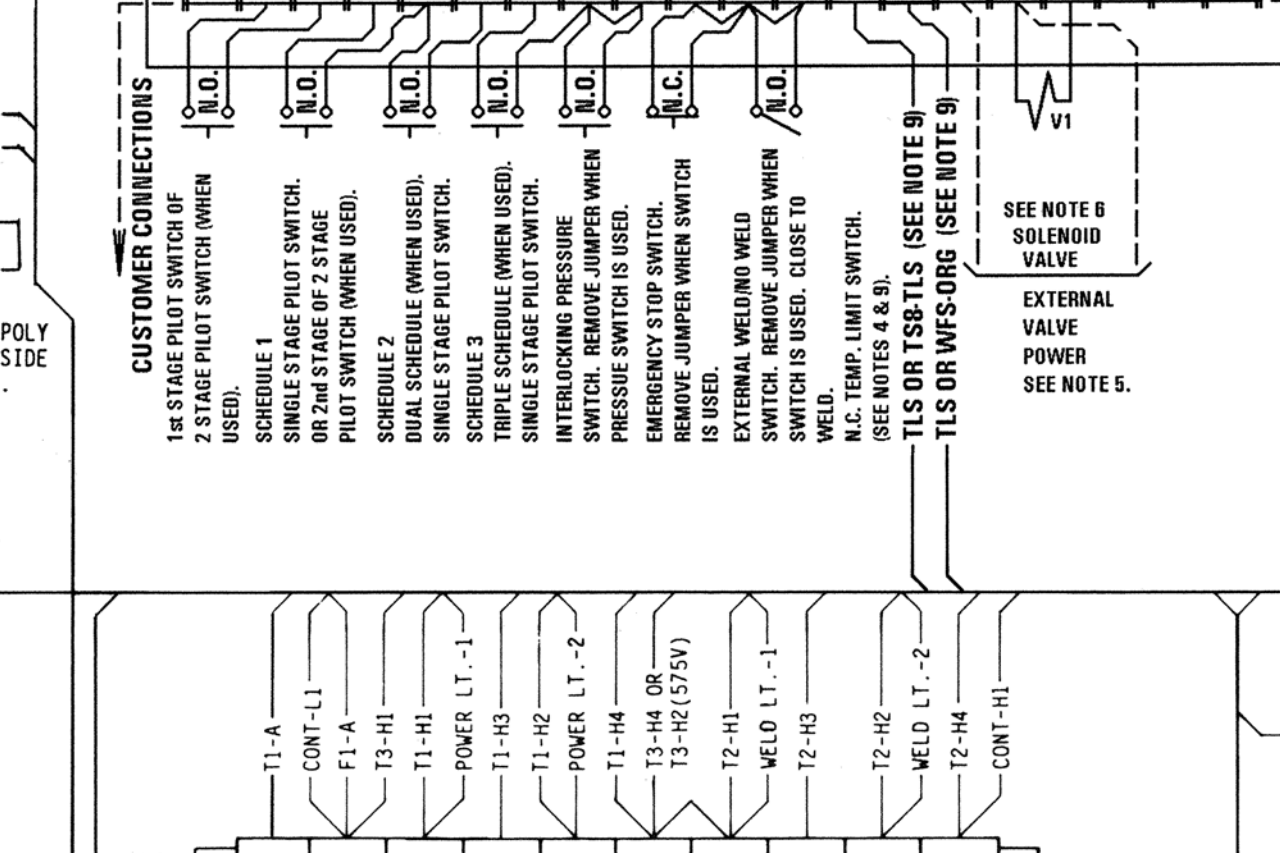
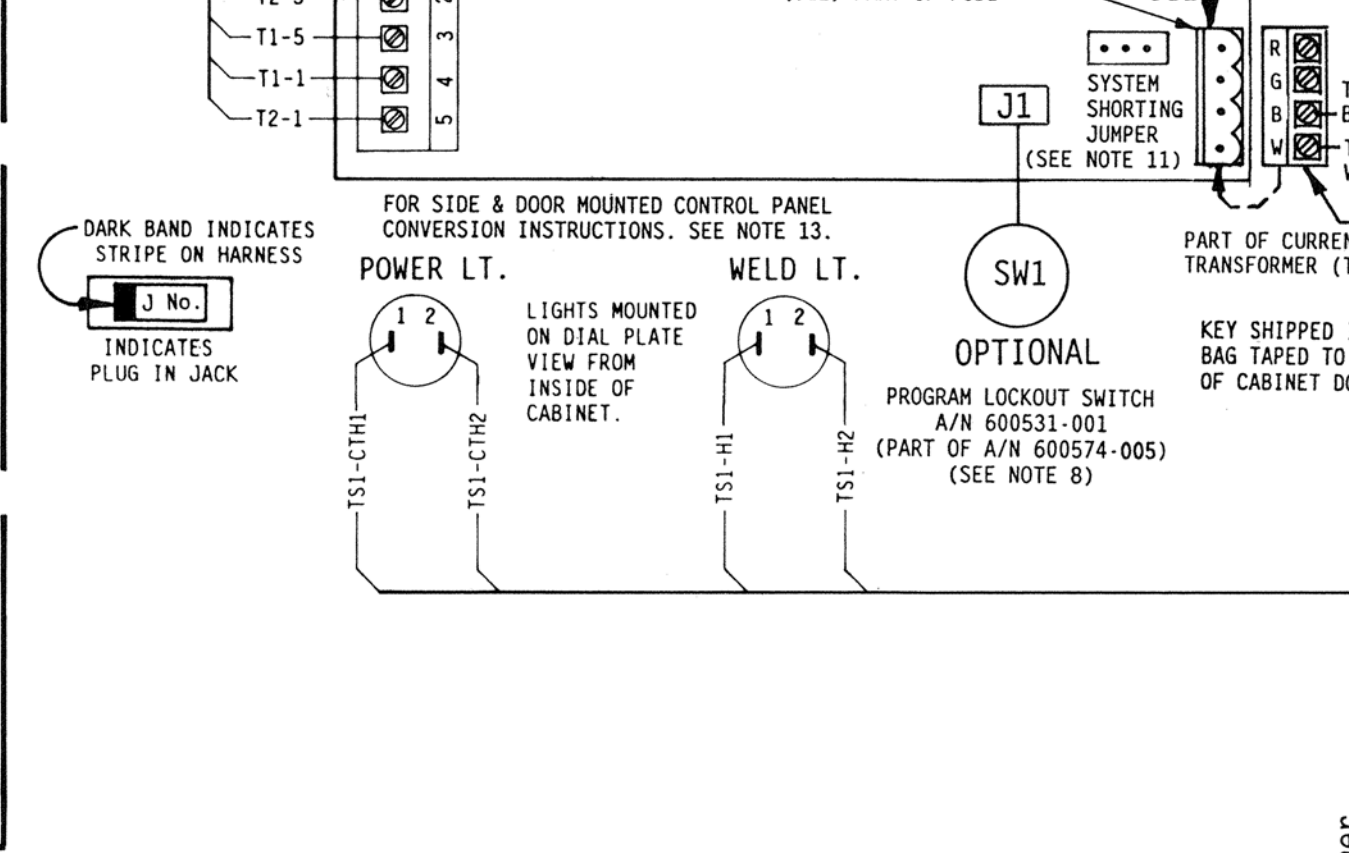
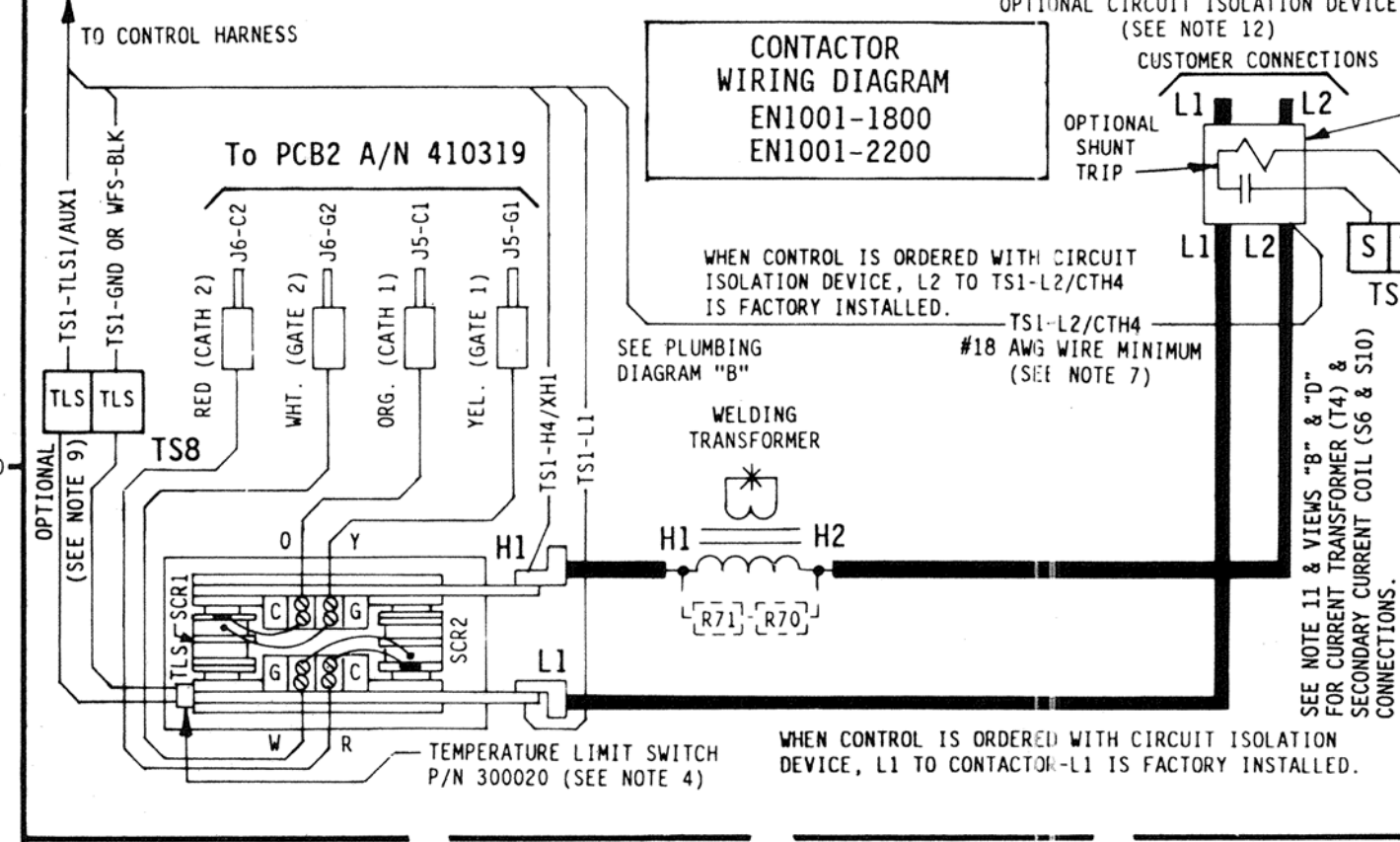
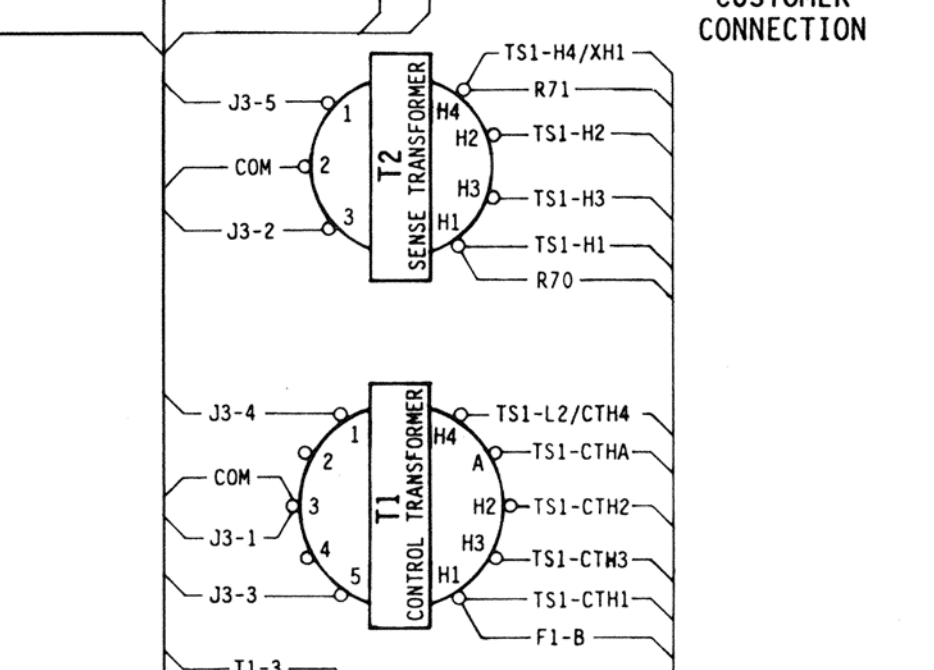
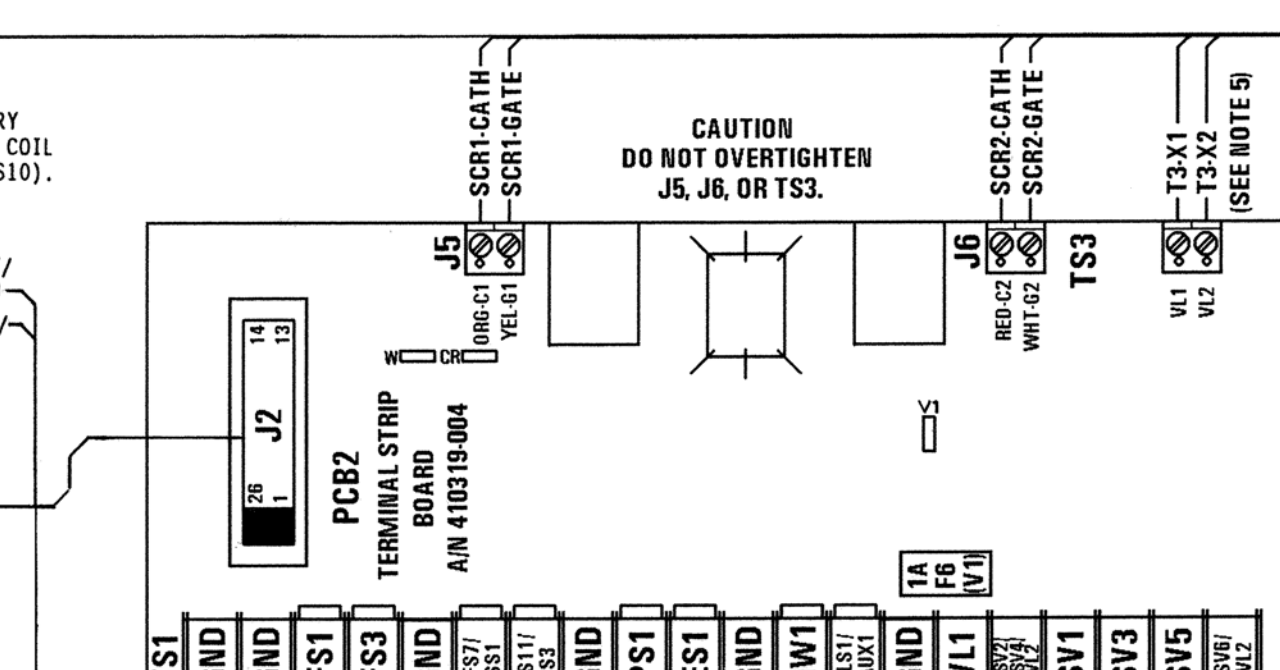
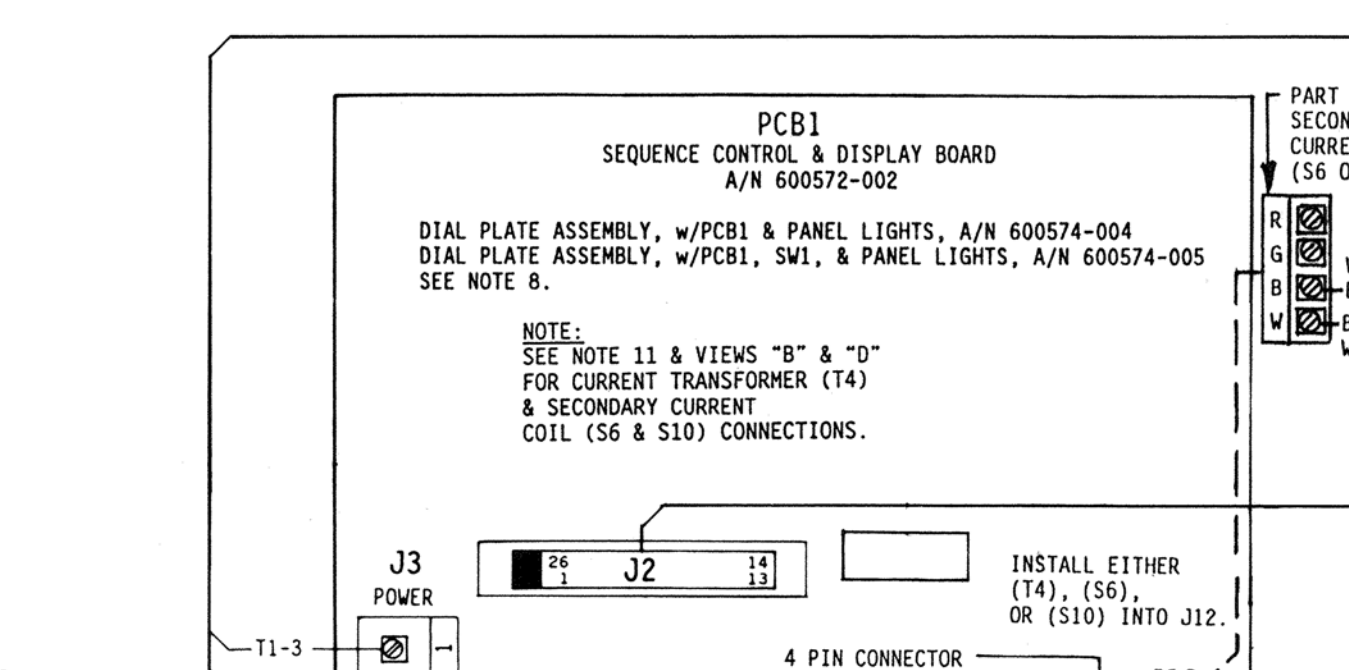
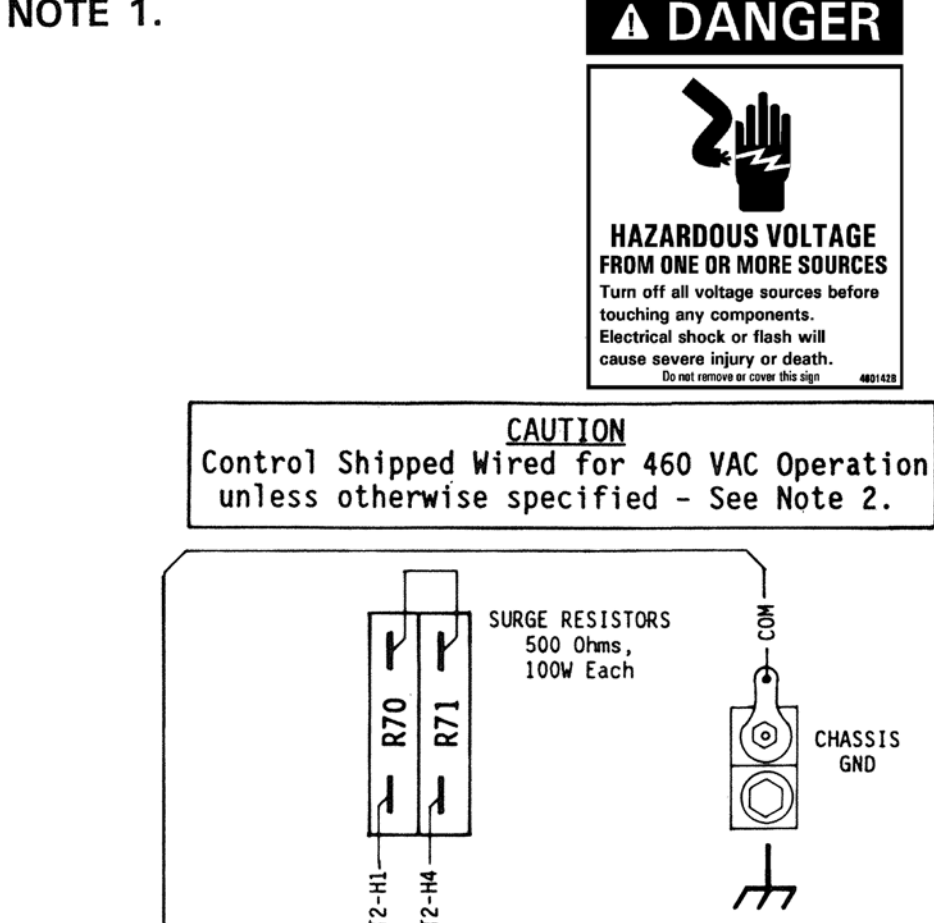
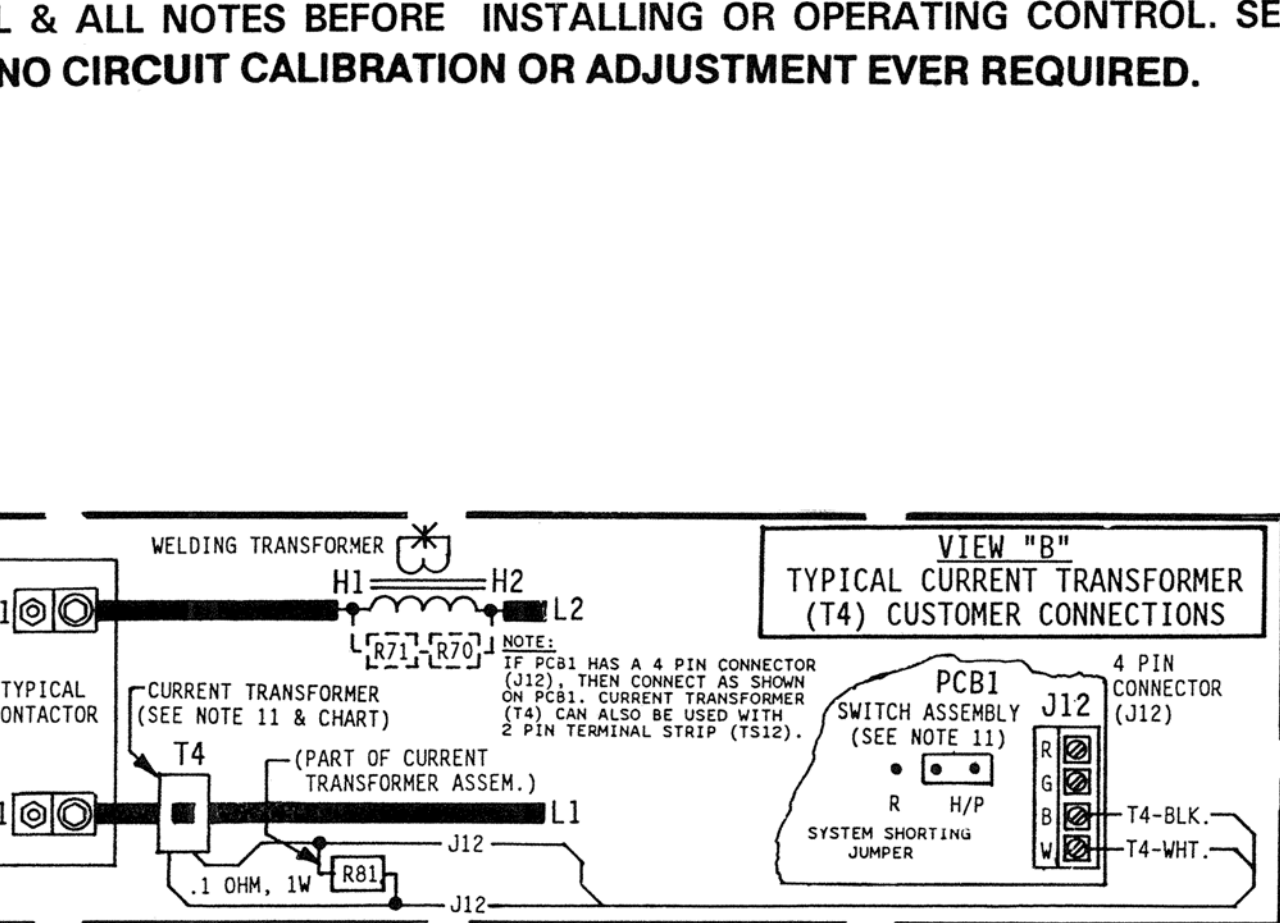
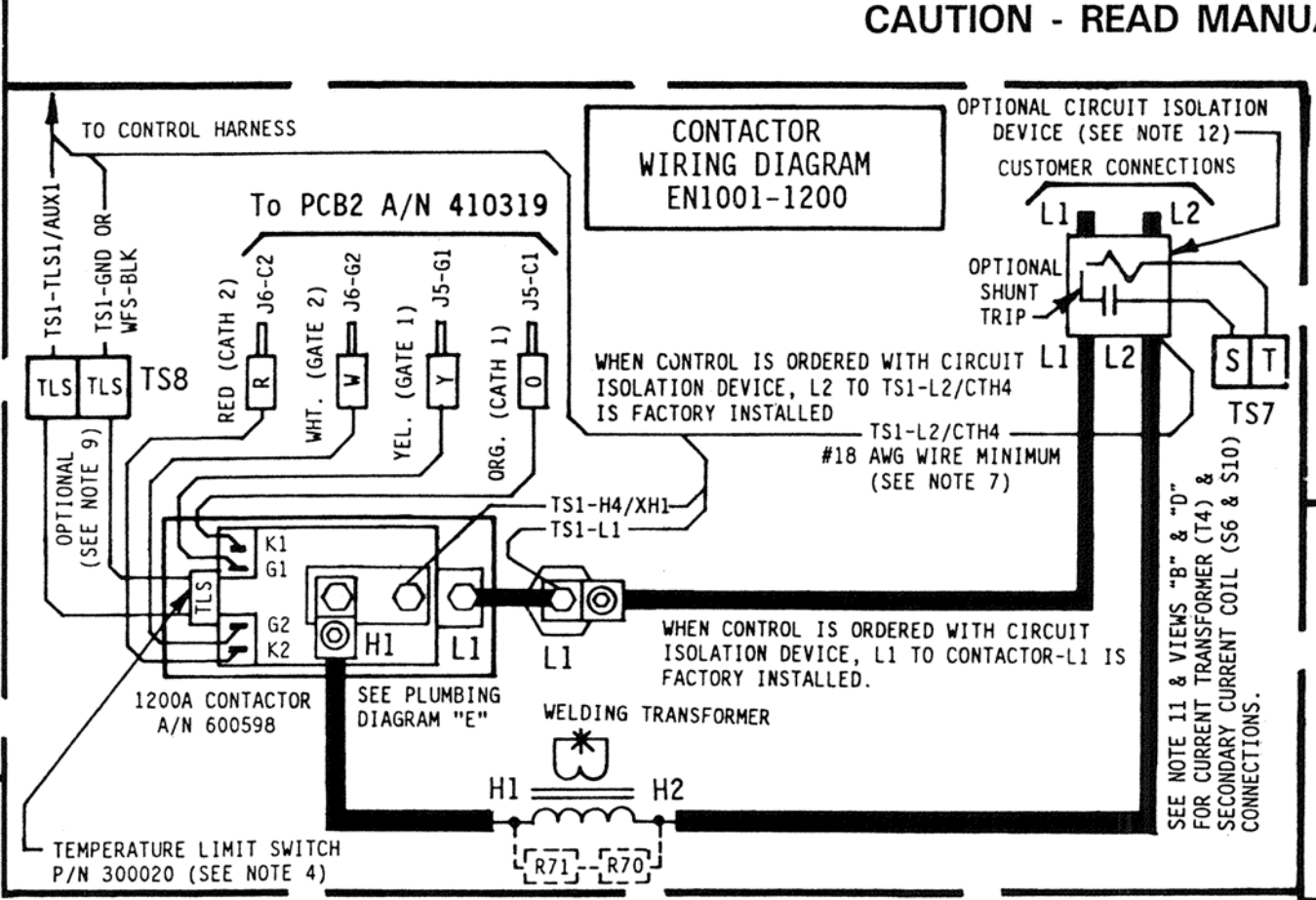
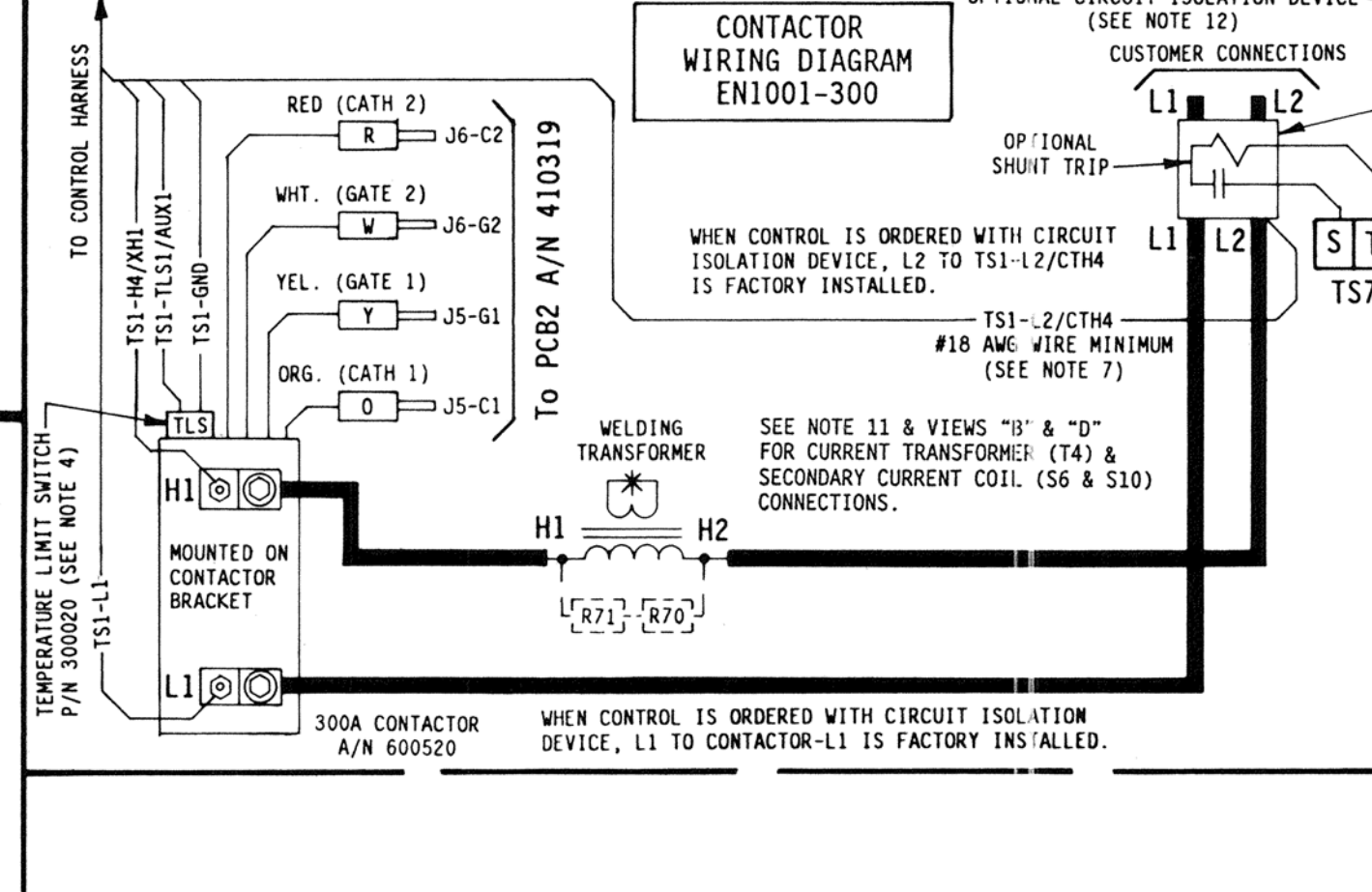


CAUTION - READ MANUAL & ALL NOTES BEFORE INSTALLING OR OPERATING CONTROL. SEE NOTE 1. NO CIRCUIT CALIBRATION OR ADJUSTMENT EVER REQUIRED.



NOTICE FOR SERVICE ON THIS CONTROL Contact Your Machine Dealer Or ENTRON CONTROLS LLC. DIRECTLY: (864) 416-0190 601 HIGH TECH COURT GREER, SC 29605 FAX# (864) 416-0195

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- 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 460 VAC Operation - Use Jumper #1 on T3 & T51. As shipped unless otherwise specified. For 230 VAC Operation - Use Jumper #2 on T3 & T51. For 575 VAC Operation - FACTORY WIRED ONLY. SEE VIEW "A". Replace T3 with P/N 311017. Wire per View "A". Use Jumper #1 between H2 & H3 on T51. Use Resistor R74 (2000 Ohm, 10 Watt) in place of Jumper #1 between CTH2 & CTH3 on T51. For 115 VAC or 380 VAC Operation - CONSULT FACTORY. 3. For Single Stage Pilot Operation - Connect pilot switch to T51-F53 & T51-GND. No jumpers required across T51-F51 & T51-GND. For Two Stage Pilot Operation - Connect 1st stage pilot switch to T51-F51 & T51-GND. Connect 2nd stage pilot switch to T51-F53 & T51-GND. For DUAL COUNT/DUAL CURRENT (Dual Weld/Dual Heat) or TRIPLE COUNT/TRIPLE CURRENT (Triple Weld/Triple Heat) or External Schedule Selection, SEE MANUAL. 4. EN1001-SERIES, "D/T"/LS/LF" CABINET: ENTRON supplies Temperature Limit Switch (TLS) P/N 300020 and provides connections to T51-TLS1/AUX1 & T51-GND. Jumper not required between T51-TLS1/AUX1 & T51-GND. NOTE: TLS SCR will open at temperatures greater than or equal to 150°F. 5. When external valve power is supplied to the control, remove and insulate leads T53-VL1 & T53-VL2 on the Terminal Strip Board (PCB2), (from T3-X1 & T3-X2). Connect external AC power supply (24-240 VAC) to T51-VL1 & T51-SV2/SV4/VL2. CAUTION: Do not over tighten T53. 6. VALVE USAGE: T51-SV1 & T51-SV2 can ONLY be used for Solenoid Valve. Valve 2 and 3 are used to Disable SCR1 & SCR2 for 1/2 Cycle Operation. See Application Note 700114 for more information. 7. Connect T51-L2/CTH4 to L2/H2 side of Welding Transformer Primary. (Factory wired on controls supplied with Circuit Isolation Device). 8. When Optional Program Lockout Switch is specified by customer, Dial Plate A/N 600574-005 replaces A/N 600574-004. Add Switch P/N 600531-001 & remove Hole Plug P/N 565003. 9. When TLS and WFS are used together, add WFS P/N 600297 & Terminal Strip T58 P/N 335017. Wire as shown below. Jumper not required between T51-TLS1/AUX1 & T51-GND. WFS will open with flows less than .75 GPM. 10. CURRENT TRANSFORMER (T4) CONNECTIONS: Wire per view "B". Current Transformer coil (T4) shown installed on L1, may be installed on H1. Wires from Current Transformer (T4) to J12 should be kept as short as possible. SECONDARY CURRENT COILS (S6 & S10) CONNECTIONS: Wire per view "D". Secondary Current Coils (S6) & (S10) may be used in place of Current Transformer (T4). Add J12-J12 Harness A/N 322475. (NOTE 11 CONTINUED)

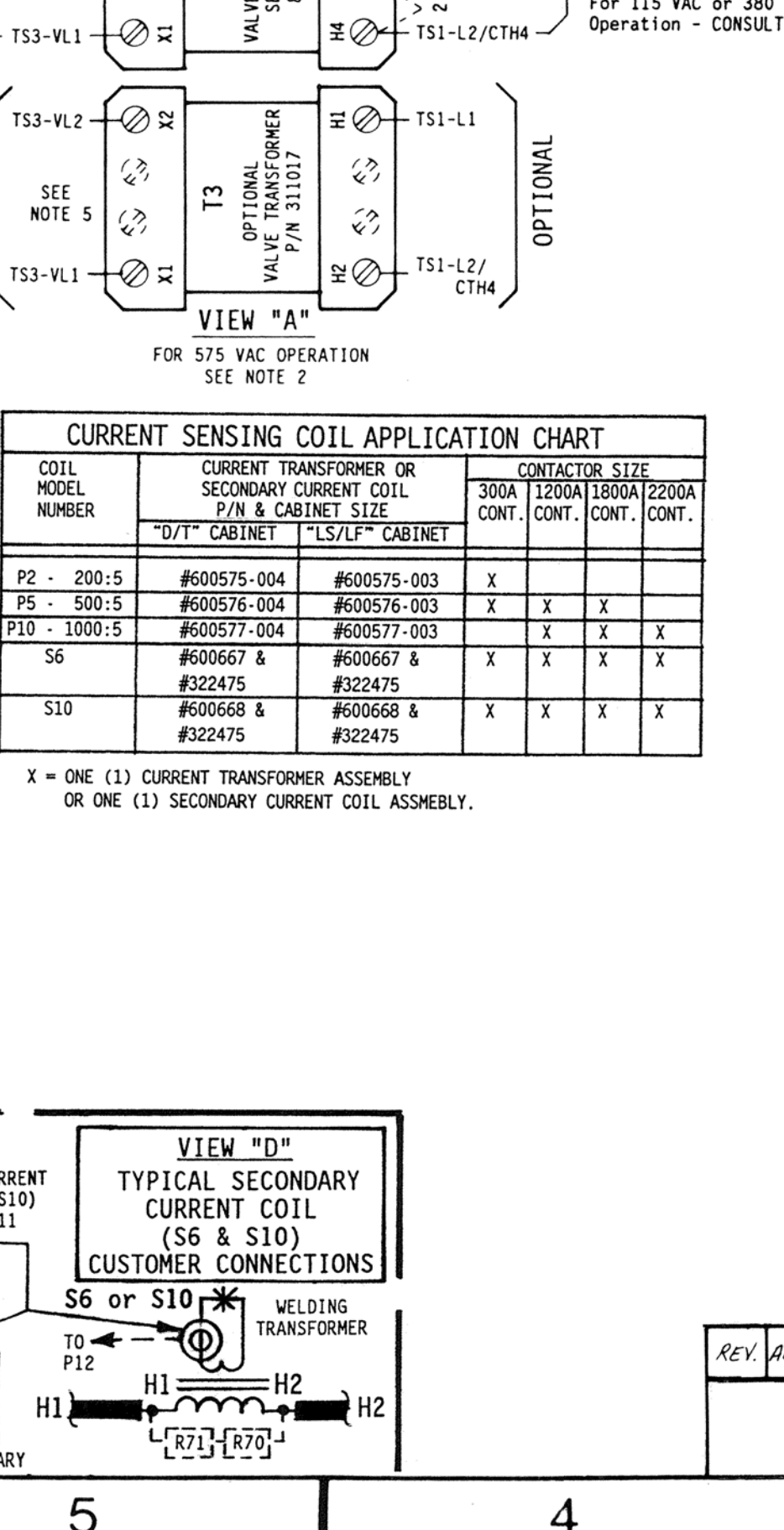
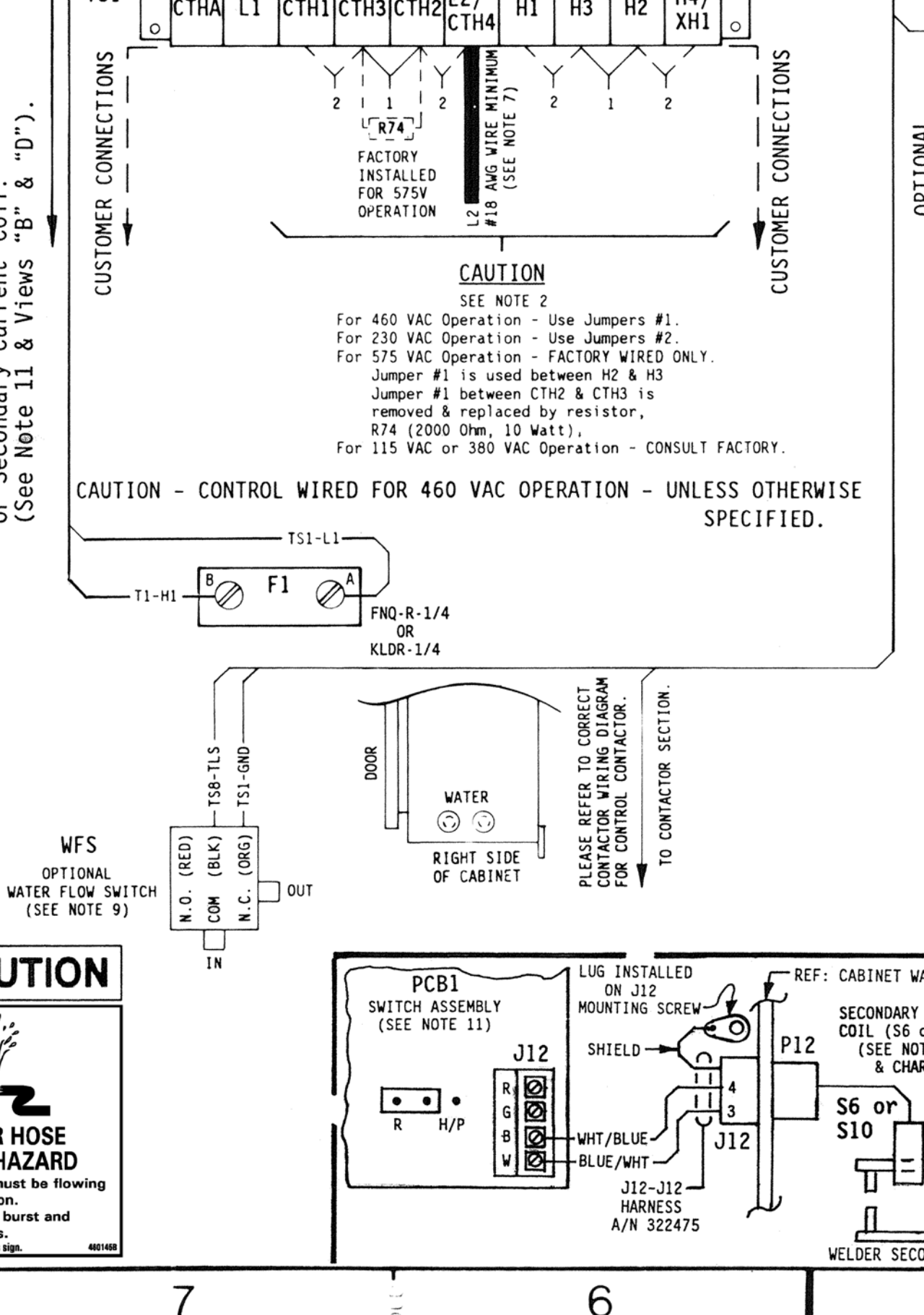
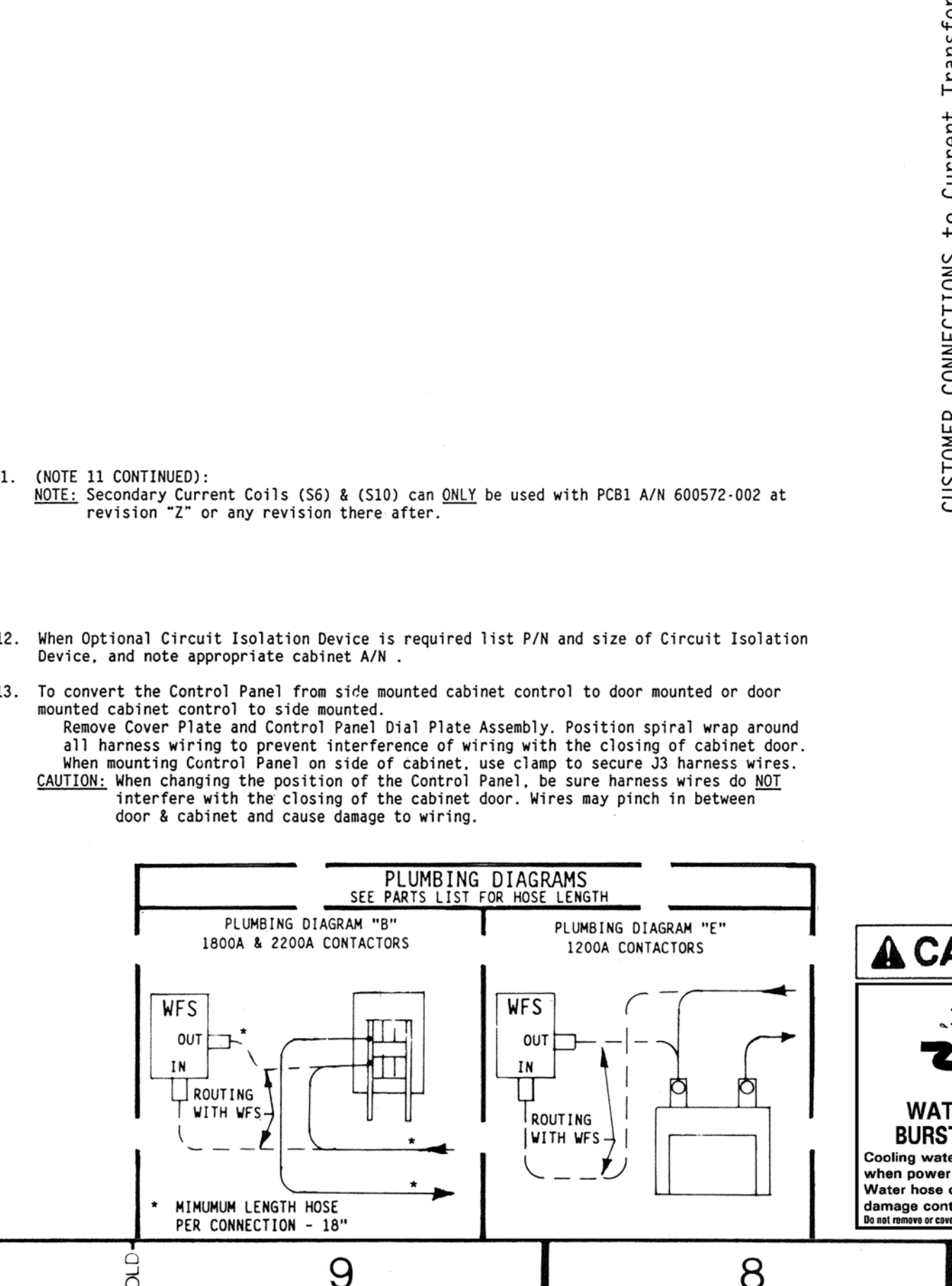


Table with 4 columns: QTY., DESIG., PART NO., DESCRIPTION. Lists various components like terminal strips, transformers, resistors, and switches.

Table with 4 columns: QTY., DESIG., PART NO., DESCRIPTION. Lists various components like surge resistors, terminal strips, and switches.

MANUFACTURING INSTRUCTIONS: See Drawings #440365, #515114, & #600552 for Mechanical Assembly Instructions of EN1001 "LS/LF" Cabinet. See Drawing #440190-001 for Mechanical Layout of "LS/LF" Cabinet Rear Panel. See Drawing #440093 for Crating Instructions of "LS/LF" Cabinet. See Drawing #600562 for Mechanical Layout/Assem. of EN1001 "D/T" Cabinet. See Drawing #440366 for Inner Pack & Use Carton #650016 for "D/T" Cabinet Packing Instructions. See Drawing #440437 for Circuit Breaker to L1 Contactor Cable connections. See Drawing #600526 for Layout/Assem. of Front Panel. See Drawing #440457 for Current Transformer Assembly. SEE DRAWING #440476 FOR SECONDARY CURRENT COIL ASSEMBLY.

Table with 4 columns: QTY., DESIG., PART NO., DESCRIPTION. Lists various components like surge resistors, terminal strips, and switches.

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WIRING DIAGRAM, EN1001/1/2-SERIES "D", "T", "LS", or "LF" CABINET. NEXT ASSM/USED ON. DRAWING NUMBER. REV. 421269-033