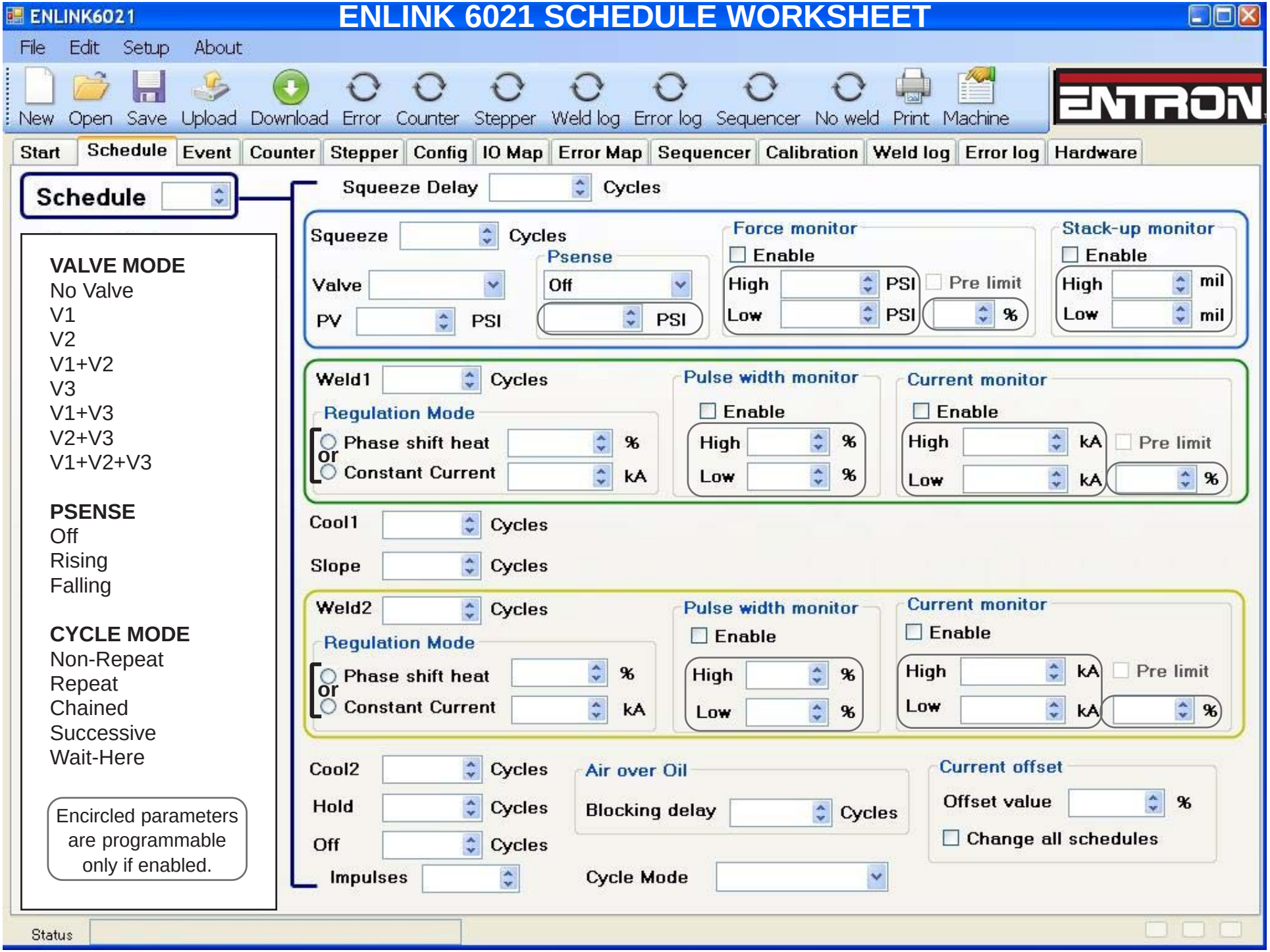
EN6021 SCHEDULE WORKSHEET

SCHEDULE # _____

SQUEEZE DELAY TIME _____ Cycles
SQUEEZE TIME _____ Cycles
VALVE MODE ☐ No Valve ☐ V1 ☐ V2 ☐ V1+V2 ☐ V3 ☐ V1+V3 ☐ V2+V3 ☐ V1+V2+V3
SQUEEZE PRESSURE/FORCE (PV) _____ PSI / Lb / mA
PRESSURE/FORCE SENSE MODE ☐ Off ☐ Rising ☐ Falling
P/F TRIGGER _____ PSI / Lb / mA
PRESSURE/FORCE MONITOR ☐ Enable
P/F LIMIT HIGH _____ PSI / Lb / mA
P/F LIMIT LOW _____ PSI / Lb / mA
PRESSURE/FORCE PRE-LIMIT MONITOR ☐ Enable P/F PRE-LIMIT _____ %
STACK-UP MONITOR ☐ Enable
STACK-UP LIMIT HIGH _____ mil
STACK-UP LIMIT LOW _____ mil
WELD1 TIME _____ Cycles
WELD1 REGULATION MODE ☐ Phase Shift WELD1 HEAT _____ %
– or – ☐ Constant Current WELD1 CURRENT _____ kA
WELD1 PULSE WIDTH MONITOR ☐ Enable
PW1 HIGH _____ %
PW1 LOW _____ %
WELD1 CURRENT MONITOR ☐ Enable
CURRENT1 LIMIT HIGH _____ kA
CURRENT1 LIMIT LOW _____ kA
CURRENT1 PRE-LIMIT MONITOR ☐ Enable CURRENT1 PRE-LIMIT _____ %
COOL1 TIME _____ Cycles
SLOPE TIME _____ Cycles
WELD2 TIME _____ Cycles
WELD2 REGULATION MODE ☐ Phase Shift WELD2 HEAT _____ %
– or – ☐ Constant Current WELD2 CURRENT _____ kA
WELD2 PULSE WIDTH MONITOR ☐ Enable
PW2 HIGH _____ %
PW2 LOW _____ %
WELD2 CURRENT MONITOR ☐ Enable
CURRENT2 LIMIT HIGH _____ kA
CURRENT2 LIMIT LOW _____ kA
CURRENT2 PRE-LIMIT MONITOR ☐ Enable CURRENT2 PRE-LIMIT _____ %
COOL2 TIME _____ Cycles
HOLD TIME _____ Cycles AIR OVER OIL BLOCKING DELAY _____ Cycles
OFF TIME _____ Cycles CURRENT OFFSET _____ % ☐ Change all schedules
IMPULSES _____
CYCLE MODE ☐ Non-Repeat ☐ Repeat ☐ Chained ☐ Successive ☐ Wait-Here

Highlighted Parameters are programmable only if enabled.

ENLINK 6021 SCHEDULE WORKSHEET



VALVE MODE
No Valve
V1
V2
V1+V2
V3
V1+V3
V2+V3
V1+V2+V3

PSENSE
Off
Rising
Falling

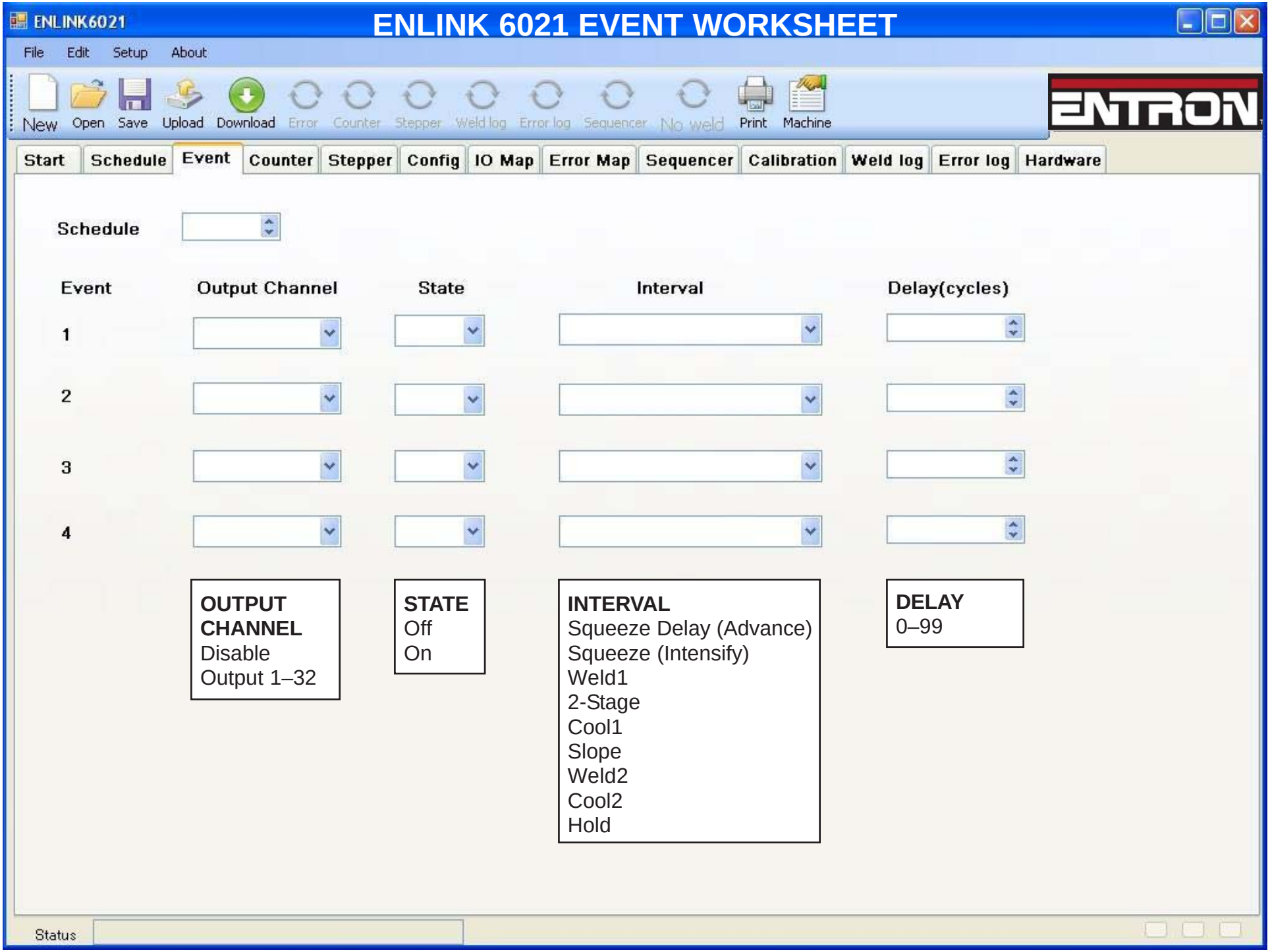
CYCLE MODE
Non-Repeat
Repeat
Chained
Successive
Wait-Here

Encircled parameters are programmable only if enabled.

SCHEDULE # _____

EVENT 1	OUTPUT CHANNEL	☐ Disable	☐ Output # _____
	STATE	☐ Off	☐ On
	INTERVAL	☐ Squeeze Delay (Advance)	☐ Squeeze (Intensify)
		☐ Weld1	☐ 2-Stage
		☐ Cool1	☐ Slope
		☐ Weld2	☐ Cool2
		☐ Hold	
	DELAY	_____ Cycles	
EVENT 2	OUTPUT CHANNEL	☐ Disable	☐ Output # _____
	STATE	☐ Off	☐ On
	INTERVAL	☐ Squeeze Delay (Advance)	☐ Squeeze (Intensify)
		☐ Weld1	☐ 2-Stage
		☐ Cool1	☐ Slope
		☐ Weld2	☐ Cool2
		☐ Hold	
	DELAY	_____ Cycles	
EVENT 3	OUTPUT CHANNEL	☐ Disable	☐ Output # _____
	STATE	☐ Off	☐ On
	INTERVAL	☐ Squeeze Delay (Advance)	☐ Squeeze (Intensify)
		☐ Weld1	☐ 2-Stage
		☐ Cool1	☐ Slope
		☐ Weld2	☐ Cool2
		☐ Hold	
	DELAY	_____ Cycles	
EVENT 4	OUTPUT CHANNEL	☐ Disable	☐ Output # _____
	STATE	☐ Off	☐ On
	INTERVAL	☐ Squeeze Delay (Advance)	☐ Squeeze (Intensify)
		☐ Weld1	☐ 2-Stage
		☐ Cool1	☐ Slope
		☐ Weld2	☐ Cool2
		☐ Hold	
	DELAY	_____ Cycles	

ENLINK 6021 EVENT WORKSHEET



EN6021 COUNTER WORKSHEET

COUNTER ENABLE ☐ Enable

MAX PART COUNT _____ WELDS PER PART _____

EN6021 CALIBRATION WORKSHEET

TOROID SENSITIVITY _____ mV/kA

MAX SECONDARY CURRENT _____ kA

TURNS RATIO _____ : 1

IPC FORCE CALIBRATION: ☐ Enabled (using Configure Menu)

PT1: _____ mA → _____ LB

PT2: _____ mA → _____ LB

IPS FORCE CALIBRATION: ☐ Enabled (using Configure Menu)

PT1: _____ mA → _____ LB

PT2: _____ mA → _____ LB

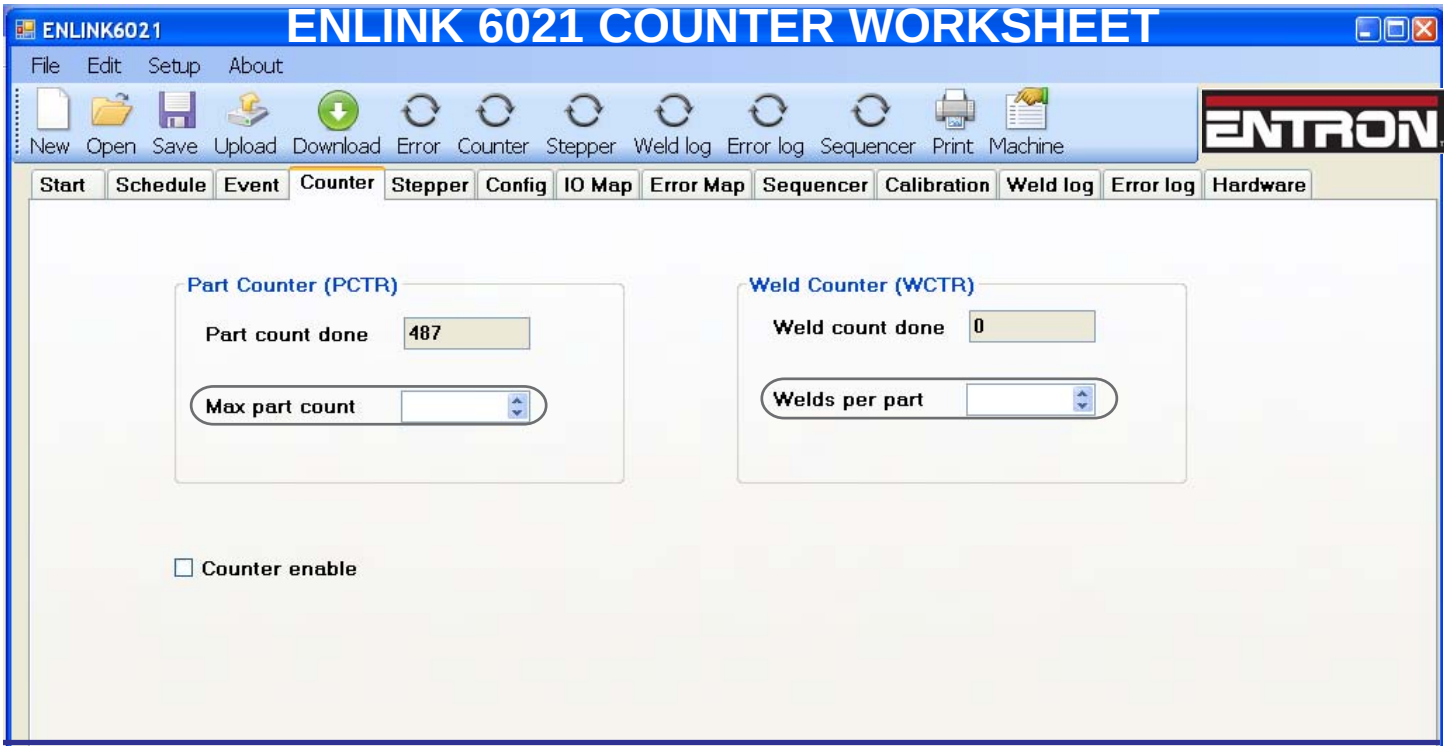
STACK-UP CALIBRATION:

PT1: _____ mA → 0 mil

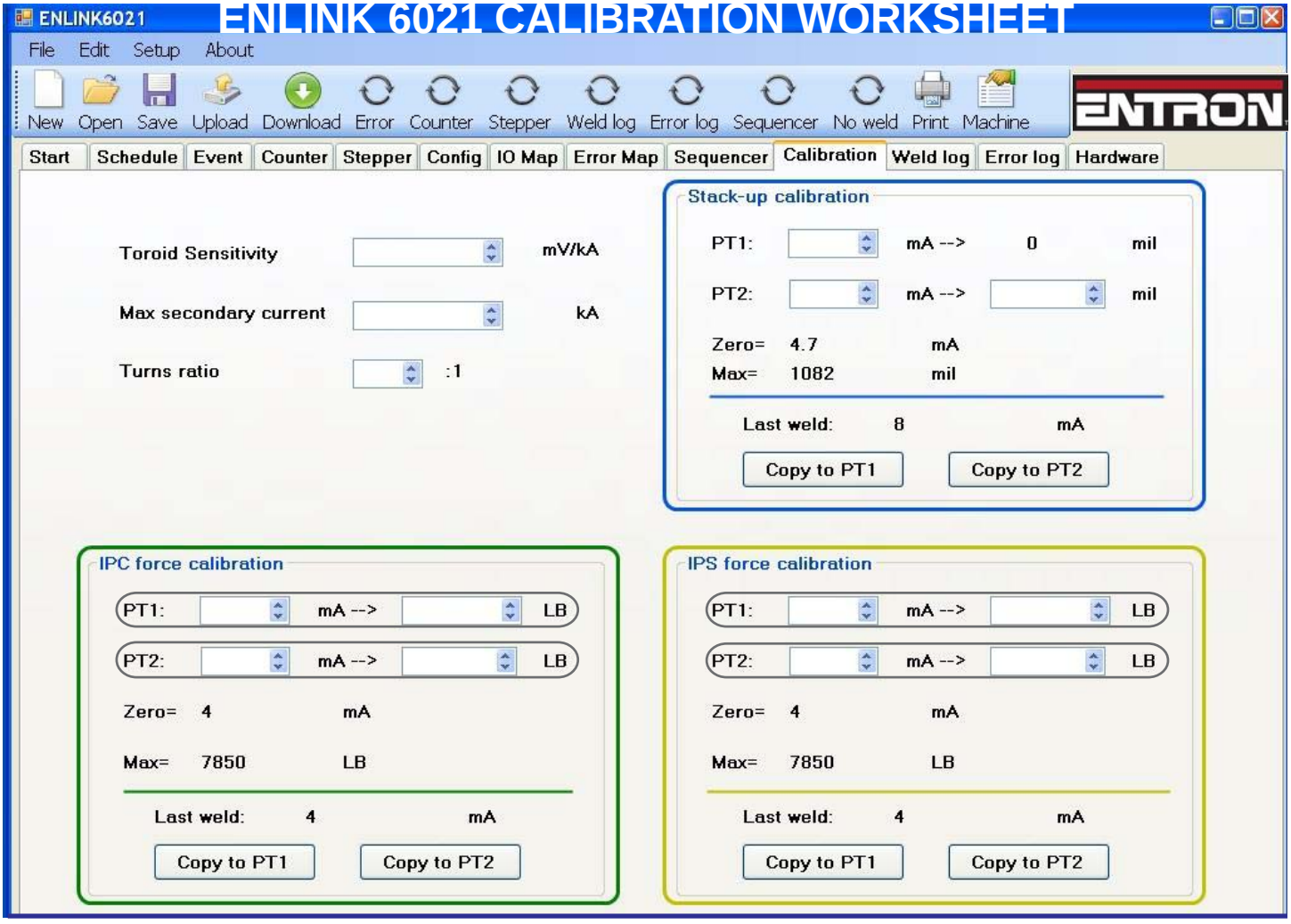
PT2: _____ mA → _____ mil

Highlighted Parameters are programmable only if enabled.

ENLINK 6021 COUNTER WORKSHEET



ENLINK 6021 CALIBRATION WORKSHEET



Encircled parameters are programmable only if enabled.

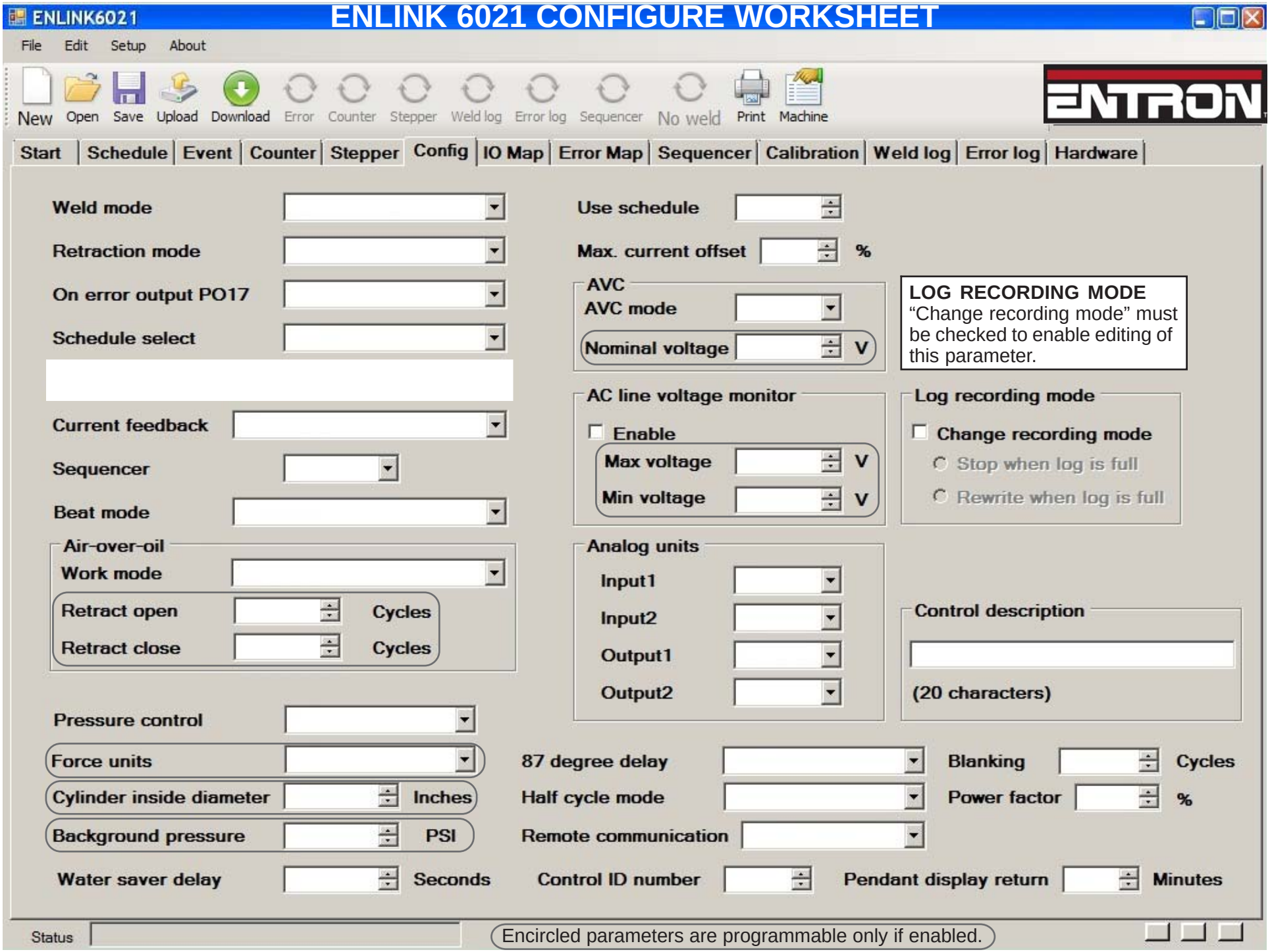
EN6021 CONFIGURE WORKSHEET

WELD MODE ☐ Spot ☐ Seam1 ☐ Seam2
RETRACTION MODE ☐ Off ☐ Momentary ☐ Maintained
ON ERROR OUTPUT 17 ☐ Continue ☐ Stop on fault ☐ Head lock on fault
SCHEDULE SELECT ☐ Internal ☐ External

CURRENT FEEDBACK ☐ Primary ☐ Secondary ☐ Secondary with Primary Coil
SEQUENCER ☐ Off ☐ On
BEAT MODE ☐ Non-Beat ☐ Beat during SQZ ☐ Beat during SQZ + WELD ☐ Enable Wait-Here
AIR-OVER-OIL MODE ☐ Off ☐ Without Retraction ☐ With Retraction
RETRACT OPEN _____ Cycles
RETRACT CLOSE _____ Cycles
PRESSURE CONTROL MODE ☐ None ☐ P Sensing ☐ P Control ☐ P Sensing + Control
FORCE UNITS ☐ PSI ☐ Lb ☐ mA ☐ Calibrated Lb
CYLINDER INSIDE DIAMETER _____ Inches
BACKGROUND PRESSURE _____ PSI / Lb
WATER SAVER DELAY _____ Seconds
USE SCHEDULE #_____
MAX CURRENT OFFSET _____ %
AVC MODE ☐ Disable ☐ Maximum _____ %
NOMINAL VOLTAGE _____ V
AC LINE VOLTAGE MONITOR ☐ Enable MAX VOLTAGE _____ V
MIN VOLTAGE _____ V
ANALOG UNITS INPUT1 ☐ V ☐ mA
INPUT2 ☐ V ☐ mA
OUTPUT1 ☐ V ☐ mA
OUTPUT2 ☐ V ☐ mA
87 DEGREE DELAY ☐ Off ☐ On
HALF CYCLE MODE ☐ Off ☐ + ☐ – ☐ AC
REMOTE COMMUNICATION ☐ MB Ethernet ☐ MB RS232 RTU ☐ MB RS485 RTU
☐ Label Printing ☐ EIP+MB Ethernet
CONTROL ID #_____
CONTROL DESCRIPTION _____
BLANKING _____ Cycles
POWER FACTOR _____ %
PENDANT DISPLAY RETURN _____ Minutes
LOG RECORDING MODE ☐ Stop when log is full ☐ Rewrite when log is full

Highlighted Parameters are programmable only if enabled.

ENLINK 6021 CONFIGURE WORKSHEET



INPUT	FUNCTION		SOURCE		USE
PI1	**Retraction**	☐	**Local**	☐	
P3-1	Sequencer	☐	PLC	☐	
PI2	**Parts Counter Reset**	☐	**Local**	☐	
P3-2	Sequencer	☐	PLC	☐	
PI3	**Error Reset**	☐	**Local**	☐	
P3-3	Sequencer	☐	PLC	☐	
PI4	**TT1**	☐	**Local**	☐	
P3-4	Sequencer	☐	PLC	☐	
PI5	Interlock	☐	**Local**	☐	
P3-5	**Sequencer**	☐	PLC	☐	
PI6	**Edit Lock**	☐	**Local**	☐	
P3-6	Sequencer	☐	PLC	☐	
PI7	**Escape**	☐	**Local**	☐	
P3-7	Sequencer	☐	PLC	☐	
PI8	**Back Step**	☐	**Local**	☐	
P3-8	Sequencer	☐	PLC	☐	
PI9	2nd Stage	☐	**Local**	☐	
P3-11	**Sequencer**	☐	PLC	☐	
PI10	**SchSelect1**	☐	**Local**	☐	
P3-12	Sequencer	☐	PLC	☐	
PI11	**SchSelect2**	☐	**Local**	☐	
P3-13	Sequencer	☐	PLC	☐	
PI12	**SchSelect3**	☐	**Local**	☐	
P3-14	Sequencer	☐	PLC	☐	
PI13	**SchSelect4**	☐	**Local**	☐	
P3-15	Sequencer	☐	PLC	☐	
PI14	**SchSelect5**	☐	**Local**	☐	
P3-16	Sequencer	☐	PLC	☐	
PI15	**SchSelect6**	☐	**Local**	☐	
P3-17	Sequencer	☐	PLC	☐	
PI16	**SchSelect7**	☐	**Local**	☐	
P3-18	Sequencer	☐	PLC	☐	
PI17	**Stepper Reset**	☐	**Local**	☐	
P11-1	Sequencer	☐	PLC	☐	
PI18	**Weld Counter Reset**	☐	**Local**	☐	
P11-2	Sequencer	☐	PLC	☐	
PI19		☐	**Local**	☐	
P11-3	Sequencer	☐	PLC	☐	
PI20		☐	**Local**	☐	
P11-4	Sequencer	☐	PLC	☐	
PI21		☐	**Local**	☐	
P11-5	Sequencer	☐	PLC	☐	
PI22		☐	**Local**	☐	
P11-6	Sequencer	☐	PLC	☐	
PI23		☐	**Local**	☐	
P11-7	Sequencer	☐	PLC	☐	
PI24	**Not used**	☐	**Local**	☐	
P11-8	Sequencer	☐	PLC	☐	
PI25	**Not used**	☐	**Local**	☐	
P11-10	Sequencer	☐	PLC	☐	
PI26	**Not used**	☐	**Local**	☐	
P11-11	Sequencer	☐	PLC	☐	
PI27	**Not used**	☐	**Local**	☐	
P11-12	Sequencer	☐	PLC	☐	
PI28	**Not used**	☐	**Local**	☐	
P11-13	Sequencer	☐	PLC	☐	
PI29	**Not used**	☐	**Local**	☐	
P11-14	Sequencer	☐	PLC	☐	
PI30	**Not used**	☐	**Local**	☐	
P11-15	Sequencer	☐	PLC	☐	
PI31	**Not used**	☐	**Local**	☐	
P11-16	Sequencer	☐	PLC	☐	
PI32	**Not used**	☐	**Local**	☐	
P11-17	Sequencer	☐	PLC	☐	

Bold function indicates default value

OUTPUT	FUNCTION				USE
PO1 P2-1	**EOS** Sequencer	☐	Event PLC	☐ ☐	
PO2 P2-2	**Not Ready** Sequencer	☐	Event PLC	☐ ☐	
PO3 P2-3	**Tip Dress** Sequencer	☐	Event PLC	☐ ☐	
PO4 P2-4	**Retraction** Sequencer	☐	Event PLC	☐ ☐	
PO5 P2-5	**Count End** Sequencer	☐	Event PLC	☐ ☐	
PO6 P2-6	**Error** Sequencer	☐	Event PLC	☐ ☐	
PO7 P2-7	**Step End** Sequencer	☐	Event PLC	☐ ☐	
PO8 P2-8	**Interlock** Sequencer	☐	Event PLC	☐ ☐	
PO9 P2-11	**Water Saver** Sequencer	☐	Event PLC	☐ ☐	
PO10 P2-12	Sequencer	☐	Event PLC	☐ ☐	
PO11 P2-13	Sequencer	☐	Event PLC	☐ ☐	
PO12 P2-14	Sequencer	☐	Event PLC	☐ ☐	
PO13 P2-15	**Not used** Sequencer	☐	Event PLC	☐ ☐	
PO14 P2-16	**Not used** Sequencer	☐	Event PLC	☐ ☐	
PO15 P2-17	**Not used** Sequencer	☐	Event PLC	☐ ☐	
PO16 P2-18	**Not used** Sequencer	☐	Event PLC	☐ ☐	
PO17 P10-1	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO18 P10-2	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO19 P10-3	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO20 P10-4	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO21 P10-5	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO22 P10-6	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO23 P10-7	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO24 P10-8	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO25 P10-10	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO26 P10-11	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO27 P10-12	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO28 P10-13	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO29 P10-14	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO30 P10-15	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO31 P10-16	**Error Map** Sequencer	☐	Event PLC	☐ ☐	
PO32 P10-17	**Error Map** Sequencer	☐	Event PLC	☐ ☐	

Bold function indicates default value

P1 WELD CONTROL		
IN/OUT	**FUNCTION**	**USE**
SV1 P1-2	**Solenoid Valve 1**	
SV2 P1-3	**Solenoid Valve 2**	
SV3 P1-4	**Solenoid Valve 3**	
FS1 P1-7	**Foot Switch 1**	
FS2 P1-8	**Foot Switch 2**	
FS3 P1-10	**Foot Switch 3**	
FS4 P1-11	**Foot Switch 4**	
ES1 P1-13	**Emergency Stop***	
TC1 P1-14	**Temperature Limit Switch Contactor***	
NW1 P1-16	**External Weld/ No Weld Input***	
PS1 P1-17	**Pressure Switch***	

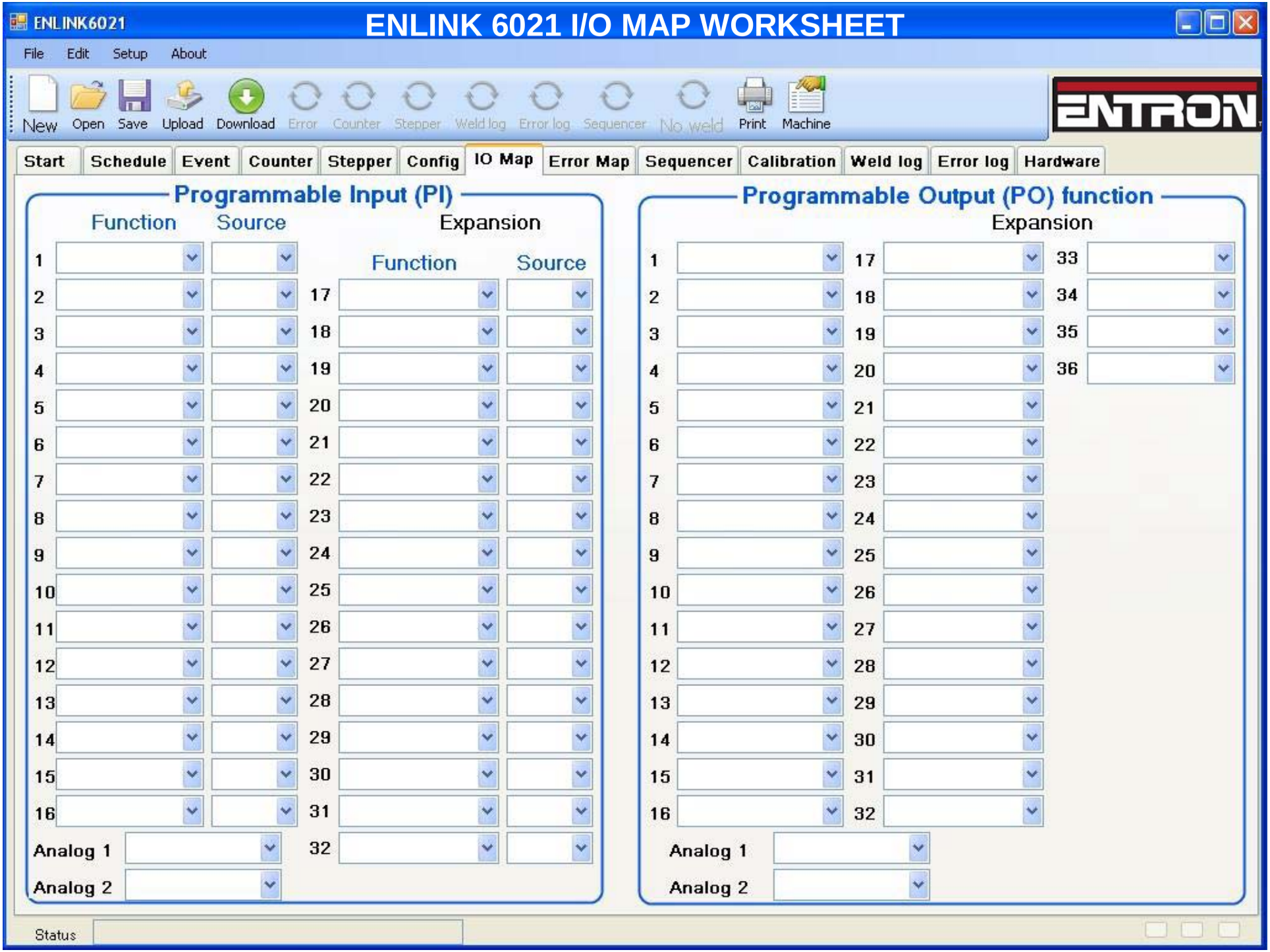
P7 ANALOG I/O		
IN/OUT	**FUNCTION**	**USE**
IN1 P7-9	**PV** ☐ Sequencer ☐	
IN2 P7-10	**Stack-up** ☐ Sequencer ☐	
OUT1 P7-11	**PV** ☐ Sequencer ☐	
OUT2 P7-12	**Sequencer** ☐ Not used ☐	

P14 AC OUT		
OUTPUT	**FUNCTION**	**USE**
PO33 P14-1	**Valve 1 AC Output**	
PO34 P14-3	**Valve 2 AC Output**	
PO35 P14-5	**Valve 3 AC Output**	
PO36 P14-7	**EOS** ☐ Not Ready ☐ Tip Dress ☐ Retraction ☐ Count End ☐ Error ☐ Step End ☐ Interlock ☐ Water Saver ☐	

* Jumper when not used.

Bold function indicates default value

ENLINK 6021 I/O MAP WORKSHEET



EN6021 ERROR MAP WORKSHEET

ERROR	OUTPUT 17-32*	DESCRIPTION	ERROR	OUTPUT 17-32*	DESCRIPTION
1		Configuration error	49		High force pre-warn
2		Calibration error	50		Low force pre-warn
3		Schedule error	51		High current 1 pre-warn
4		Sequencer error	52		Low current 1 pre-warn
5		Event error	53		High current 2 pre-warn
6		Counter error	54		Low current 2 pre-warn
7		Stepper error	55		High Stack-up
8		I/O Map error	56		Low Stack-up
9		E-stop error	57		Reserved
10		TC1 (Contactor) error	58		Reserved
11		P1-NW error	59		Reserved
12		PS error	60		Reserved
13		SCR short	61		Reserved
14		Second Stage error	62		Reserved
15		Pressure Sense error	63		Reserved
16		Interlock error	64		Reserved
17		High force	65		Battery low
18		Low force	66		Use Schedule error
19		High current 1	67		Reserved
20		Low current 1	68		Reserved
21		High current 2	69		Reserved
22		Low current 2	70		Reserved
23		High line voltage	71		Reserved
24		Low line voltage	72		Reserved
25		PCTR counter end	73		Weld Log full
26		Stepper end	74		Weld Log warn
27		High pulse width1	75		Error Log full
28		Low pulse width1	76		Error Log warn
29		High pulse width2	77		Flash RAM error
30		Low pulse width2	78		Reserved
31		Tip dress pre-warn	79		Reserved
32		AVC error	80		Reserved
33		Power on with STARTs closed	81		Reserved
34			82		Reserved
35		PNW (Pendant No-Weld)	83		Reserved
36		TT1 (Transformer) error	84		Reserved
37		Safety Relay error	85		Reserved
38		No 24V for CPU I/O ports	86		Reserved
39		No 24V for Expansion Board	87		Reserved
40			88		Reserved
41			89		
42			90		
43			91		Retraction input closed
44		Reserved	92		Pressure Sensor not ready
45		AC120V Safety Relay error	93		Retract not ready
46		Reserved	94		Second Stage not ready
47		No AC120V for Expansion Board	95		Pressure Sense not ready
48		Reserved	96		Interlock not ready

* NOTE: Control can stop on Error 17 if set in Configuration Menu.

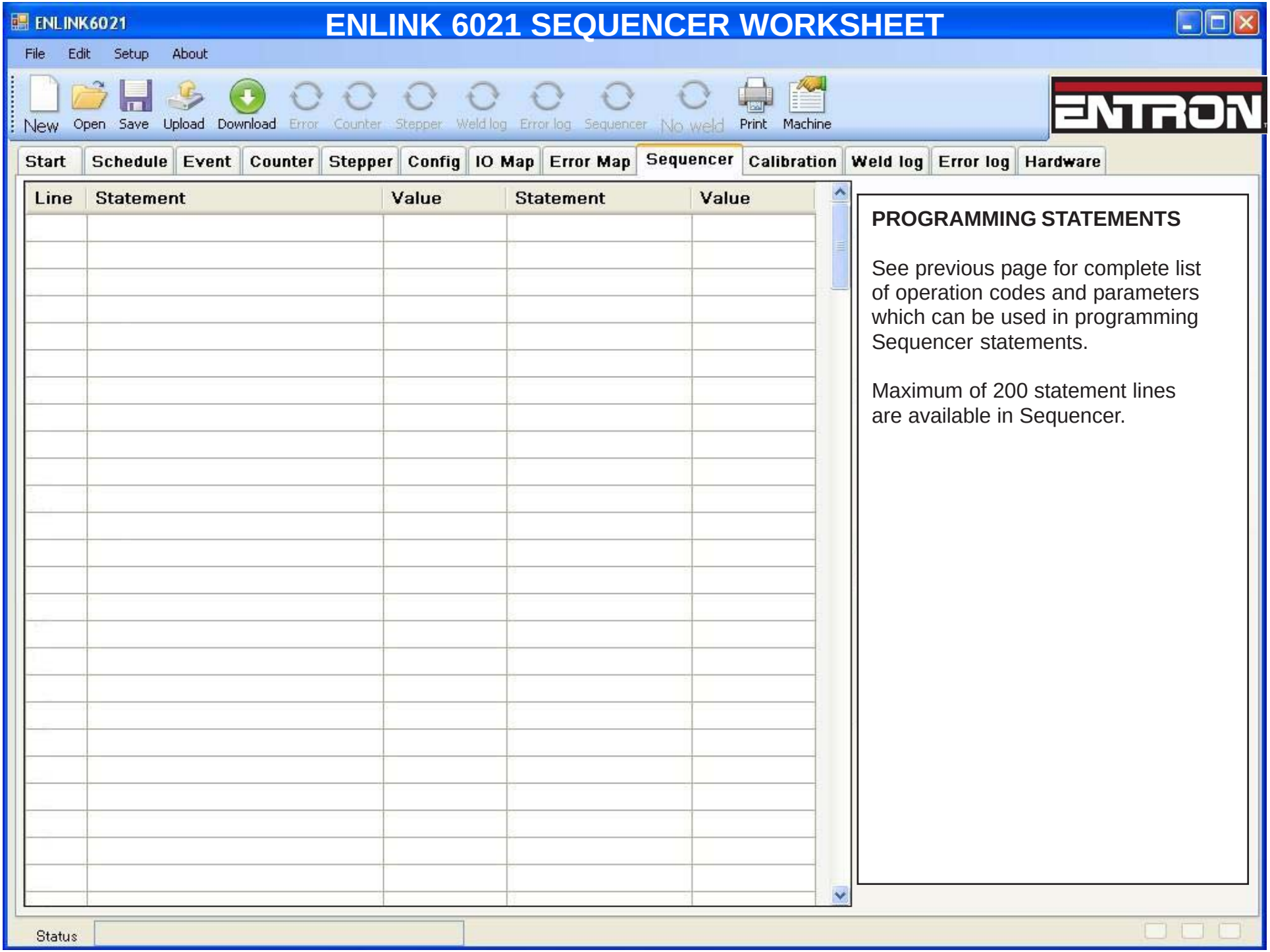
ENLINK 6021 ERROR WORKSHEET

Error	Output port	Error	Output port
1: Configuration error	No output	2: Calibration error	No output
3: Schedule error	No output	4: Sequencer error	No output
5: Event error	No output	6: Counter error	No output
7: Stepper error	No output	8: I/O map error	No output
9: E-stop error	No output	10: TC1(Contactor) error	No output
11: P1-NW error	No output	12: PS error	No output
13: SCR short	No output	14: 2 stage error	No output
15: P sense error	No output	16: Interlock error	No output
17: High force	No output	18: Low force	No output
19: High current 1	No output	20: Low current 1	No output
21: High current 2	No output	22: Low current 2	No output
23: High line voltage	No output	24: Low line voltage	No output
25: PCTR counter end	No output	26: Stepper end	No output
27: High pulse width1	No output	28: Low pulse width1	No output
29: High pulse width2	No output	30: Low pulse width2	No output
31: Tip dress Pre-warn	No output	32: AVC error	No output
33: Power on with STARTs closed	No output	34:	No output
35: PNW(Pendant No-weld)	No output	36: TT1(Transformer) error	No output
37: Safety relay error	No output	38: No 24V for CPU I/O ports	No output
39: No 24V for expansion board	No output	40:	No output
41:	No output	42: Tip dress input on	No output
43:	No output	44: Reserved	No output
45: AC120V safety relay error	No output	46: Reserved	No output
47: No AC120V for expansion	No output	48: Reserved	No output
49: High force pre-warn	No output	50: Low force pre-warn	No output
51: High current 1 pre-warn	No output	52: Low current 1 pre-warn	No output
53: High current 2 pre-warn	No output	54: Low current 2 pre-warn	No output
55: High stack-up	No output	56: Low stack-up	No output
57: Reserved	No output	58: Reserved	No output
59: Reserved	No output	60: Reserved	No output
61: Reserved	No output	62: Reserved	No output
63: Reserved	No output	64: Reserved	No output
65: Battery low	No output	66: Use schedule error	No output
67: Reserved	No output	68: Reserved	No output
69: Reserved	No output	70: Reserved	No output
71: Reserved	No output	72: Reserved	No output
73: Weld log full	No output	74: Weld log warn	No output
75: Error log full	No output	76: Error log warn	No output
77: Flash RAM error	No output	78: Reserved	No output
79: Reserved	No output	80: Reserved	No output
81: Reserved	No output	82: Reserved	No output
83: Reserved	No output	84: Reserved	No output
85: Reserved	No output	86: Reserved	No output
87: Reserved	No output	88: Reserved	No output
89:	No output	90:	No output
91: Retraction input closed	No output	92: PS not ready	No output
93: Retract not ready	No output	94: 2-stage not ready	No output
95: P sense not ready	No output	96: Interlock not ready	No output

EN6021 SEQUENCER WORKSHEET

OPERATION CODE	RANGE	FUNCTION
Blank	N/A	Not programmed (has no effect)
Step *xxx*	1 to 100	Has no effect, but serves as target for Jump statement or as logical divider in program
Sub *xxx*	1 to 100	Has no effect, but serves as target for Call SUB statement or as logical divider in program
Await PI*xx* = On	1 to 32	Waits for Input PI*xx* to be On
Await PI*xx* = Off	1 to 32	Waits for Input PI*xx* to be Off
Set PO*xx* = On	1 to 32	Turns On Output PO*xx*
Set PO*xx* = Off	1 to 32	Turns Off Output PO*xx*
Set Flag*xx* = On	1 to 32	Sets Flag *xx* On
Set Flag*xx* = Off	1 to 32	Sets Flag *xx* Off
Delay *xx.x* Second	0.1–99.9 seconds	Waits for specified time
Jump to step *xxx*	1 to 200	Program continues at specified Step number
Call SUB *xxx*	1 to 100	Program continues with subroutine at specified SUB number (maximum of 8 nesting levels)
Return	N/A	Return from subroutine
Set Counter*x* = *yyy*	*x*=1-8, *y*=1-999	Loads Counter *x* with value *yyy* (non-volatile)
Decrease Counter*x*	1 to 8	Value in Counter *x* is reduced by 1 (non-volatile)
If Counter*x*>0, JP *yyy*	*x*=1-8, *y*=1-200	If value in Counter *x* is greater than 0, jump to Step yyy
If PO*xx* = On, JP *yyy*	*x*=1-32, *y*=1-200	If Output PO*xx* is On, jump to Step *yyy*
If PO*xx* = Off, JP *yyy*	*x*=1-32, *y*=1-200	If Output PO*xx* is Off, jump to Step *yyy*
If Flag*xx* = On, JP *yyy*	*x*=1-32, *y*=1-200	If Flag *xx* is On, jump to Step *yyy*
If Flag*xx* = Off, JP *yyy*	*x*=1-32, *y*=1-200	If Flag *xx* is Off, jump to Step *yyy*
If PI*xx* = On, JP *yyy*	*x*=1-32, *y*=1-200	If Input PI*xx* is On, jump to Step *yyy*
If PI*xx* = Off, JP *yyy*	*x*=1-32, *y*=1-200	If Input PI*xx* is Off, jump to Step *yyy*
Spot-weld with Sch *xxx*	*x*=0-100	Execute spot weld sequence using Schedule *xxx* (0–99). SEQUENCER will wait until weld reaches End of Sequence before continuing with next statement. If *xxx* set to 100, starting schedule selected by Internal or External Select.
Set Aout*x* = *yy.y* mA / V	*x*=1 or 2, *y*=4.0-20.0mA or 0.0-10.0V	Set Analog Output 1 or 2 to specific current/ voltage (set in **Configure Menu**)
If Ain1 > *xx.x* mA, JP *yyy*	*x*=4.0-20.0, *y*=1-200	If Analog Input 1 is greater than *xx.x* mA, jump to Step *yyy*
If Ain1 < *xx.x* mA, JP *yyy*	*x*=4.0-20.0, *y*=1-200	If Analog Input 1 is less than *xx.x* mA, jump to Step *yyy*
If Ain2 > *xx.x* mA, JP *yyy*	*x*=4.0-20.0, *y*=1-200	If Analog Input 2 is greater than *xx.x* mA, jump to Step *yyy*
If Ain2 < *xx.x* mA, JP *yyy*	*x*=4.0-20.0, *y*=1-200	If Analog Input 2 is less than *xx.x* mA, jump to Step *yyy*
End	N/A	End of Sequence
If Err*xx* = On, JP *yyy*	*x*=1-96 or Any, *y*=1-200	When *xx*=1-96, if Error *xx* is On, jump to Step *yyy* When *xx*=Any, if one or multiple Errors are On, jump to Step *yyy*
If Err*xx* = Off, JP *yyy*	*x*=1-96 or All, *y*=1-200	When *xx*=1-96, if Error *xx* is Off, jump to Step *yyy* When *xx*=All, if all Error are Off, jump to Step *yyy*
Seam-weld with Sch *xxx*	*x*=0-99	Execute seam weld sequence using Schedule *xxx* (0–99). SEQUENCER will continue with next statement when seam weld sequence has been started. Sequence will be ended when SEQUENCER implements **Seam-weld end** statement or when Start1 initiation switch is released.
Seam-weld end	N/A	Stop seam weld sequence.

ENLINK 6021 SEQUENCER WORKSHEET



PROGRAMMING STATEMENTS

See previous page for complete list of operation codes and parameters which can be used in programming Sequencer statements.

Maximum of 200 statement lines are available in Sequencer.