

EN1000/1001 CASCADE SCHEDULE WORKSHEET

SCHEDULE #

CHAINED OR SUCCESSIVE TO SCHEDULE #

SQUEEZE

WELD/HEAT

PERCENT CURRENT

HOLD

OFF

IMPULSES

COOL

VALVE MODE

HEX CODE

0	0	0	0	0	0	0	0
1	2	3	4	5	6	7	8

0	0	0	0	0	0	0	0
9	10	11	12	13	14	15	16

9-16 Valve Extension Option

CYCLE MODE

00 = NON REPEAT
02 = CHAINED

01 = REPEAT
03 = SUCCESSIVE

SLOPE MODE

00 = NO SLOPE 01 = UPSLOPE 02 = DOWNSLOPE

SLOPE COUNT

CONTACTOR

HEX CODE

0	0	0	0	0	0	0	0
1	2	3	4	5	6	7	8

COMMENTS

_____ TAP SETTING _____ WELDING PRESSURE _____ MACHINE

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SCHEDULE #

- I.d.* Identification Number – 01-64
- C.5.* Simultaneous Contactor Firing – 00=Single Contactor; 01=Multiple Contactors
- S.5.* Schedule Select – 00=Internal; 01=External; 02=Anti-Tie Down; 03=External Binary
- C.C.* Auto Voltage Compensation/Monitoring (See Manual 700194)

- b.5.* Back-Step / Water Flow Switch – 00=Water Flow Switch; 01=Back-Step
- P.O.* Process Outputs (See Manual 700194)

- b.E.* Beat Mode – 00=Non-Beat; 01=Beat during Squeeze; 02=Beat during Squeeze & Weld
- B.7.* 87° Delay – 00=Off; 01=On
- P.P.* Manual Power Factor Programming – 00=Automatic; 01-99=Manual
- S.d.* Squeeze Delay – 00-99
- b.L.* Blocking Delay – 00-99
- C.r.* Constant Current Modes (See Manual 700194) _____
- r.R.* Range or Ratio (See Manual 700194)

- C.O.* Current Offset – 00=Off Single; 01-19=On Single; 20=Off All; 21-39=On All
- S.t.* Stepper (See Manual 700194) _____
- P.C.* Pressure Control Mode _____
- b.d.* Background Pressure — See Manual 700178 _____
- S.I.* Sensor Input _____
- P.n.* PIN # of Control _____