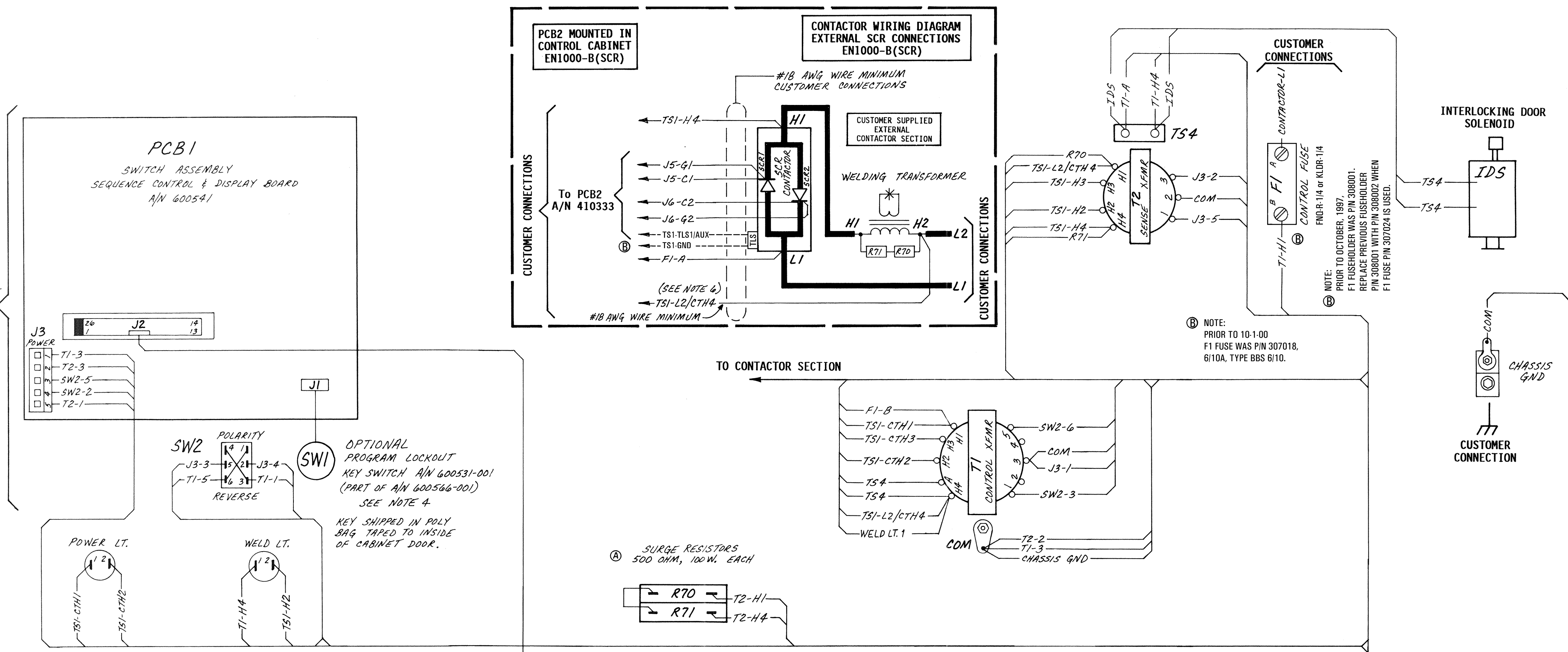


NO CIRCUIT CALIBRATION OR ADJUSTMENT EVER REQUIRED.

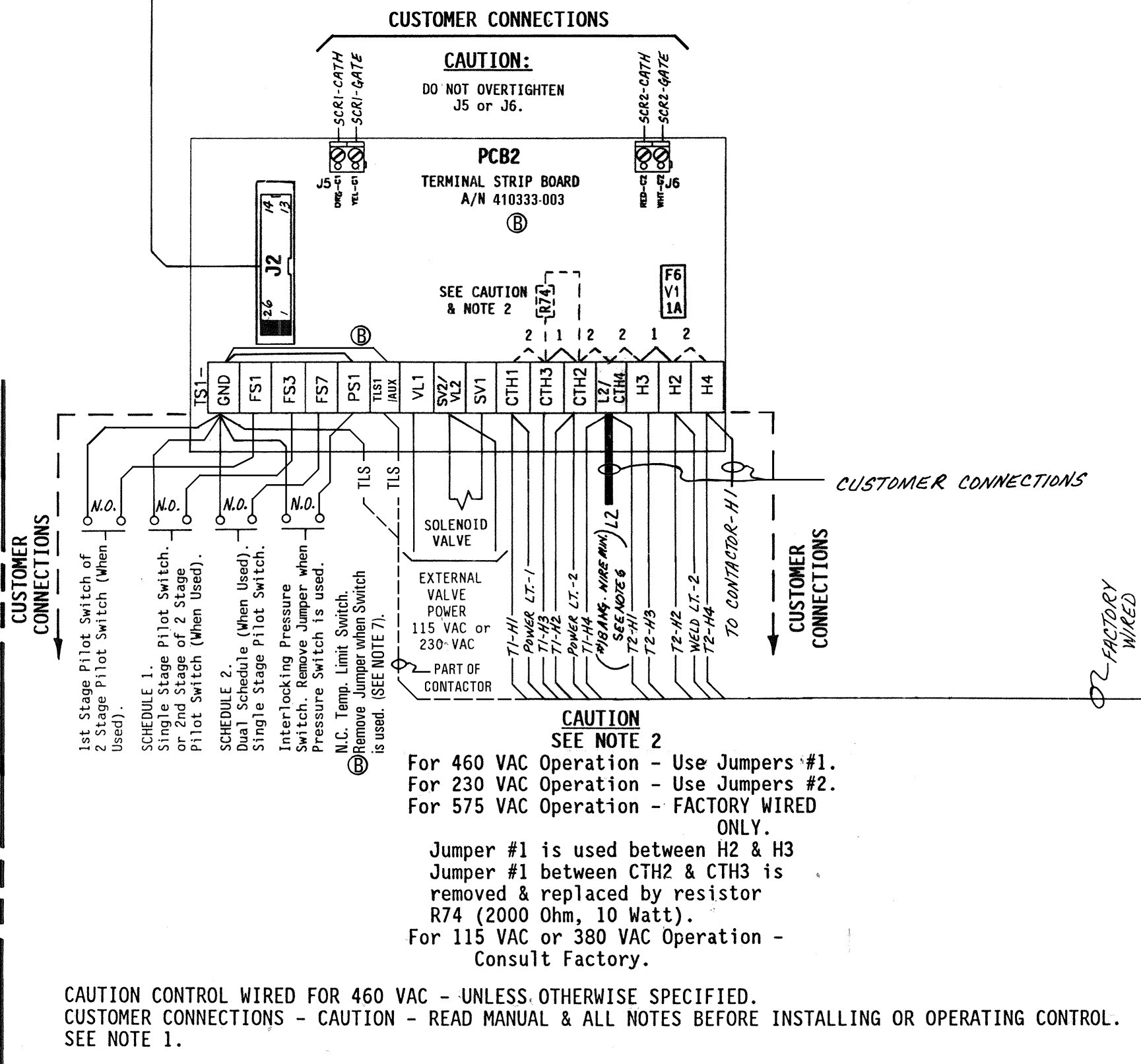
**CAUTION**  
Control Shipped Wired for 460 VAC  
Unless Otherwise specified - See Note 2.

PARTS LIST - CONTROL SECTION			
QTY.	DESIG.	PART NO.	DESCRIPTION
1		600566	Assem., Dial Plate, w/Sw. Assem., EN1000, Consisting of:
0		600566-001	Assem., Dial Plate, w/Sw. Assem. & Keylock, EN1000, Consisting of:
1	PCB1	600541	Assem., Switch, Sequence Control & Display Board
0		600531-001	Assem., Switch, Keylock, Momentary, SPDT
1	SW1	60043-001	Assem., Switch, Polarity/Reverse, (Part of J3 Harness)
1	SW2	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	322359-002	Assem., Harness, Power, EN1000-B(SCR)



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	308010	Fuseholder, 1 Pole, Mini, 600V
1	F1	307024	Fuse, Control, 1/4A, FNO-R-1/4 or KLD-R-1/4
1	R74	325226	Wire Assem, Jumper, TSI-GND to TSI-TLS1/AUX
1	R70, 71	600048	Resistor, Power, 2000 Ohm, 10W, (For 575V)
1	(R70, 71)	225016	Resistor, Power, Surge, 500 Ohm, 100W
1		325024	Assem., Wire, Surge Resistor, 18 Ga., Black
1	(PCB2)	510236-001	Plate, Mounting, Terminal Strip Board
1	PCB2	410333-003	Assem., PCB, Terminal Strip Bd., EN1000, "B" Cabinet
1	F6(PCB2)	307022	Fuse, 1 Amp, 5/16 Blow, 2 AG, (Part of 410333)
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	Cabinet, Control Style "B", Bench
1		510004	Door, Cabinet, "B", Bench
1		700117	Manual, EN1000
1		421262-002	Wiring Diagram, EN1000-(SCR), "B" Cabinet

Switches & Lights shown as viewed from inside of 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 TSI1. As shipped unless otherwise specified.  
For 230 VAC Operation - Use Jumpers #2 on TSI1.  
For 575 VAC Operation - FACTORY WIRED ONLY.  
Use Jumper #1 between H2 & H3 on TSI1. Use Resistor R74 (2000 Ohm, 10 Watt) in place of Jumper #1 between CTH2 & CTH3 on TSI1.  
For 115 VAC or 380 VAC Operation - CONSULT FACTORY.
  - For Single Stage Pilot Operation - Connect pilot switch to TSI1-FS3 & TSI1-GND. No Jumpers required across TSI1-FS1 & TSI1-GND.  
For Two Stage Pilot Operation - Connect 1st stage pilot switch to TSI1-FS1 & TSI1-GND. Connect 2nd stage pilot switch to TSI1-FS3 & TSI1-GND.  
For DUAL COUNT/DUAL CURRENT (Dual Weld/Dual Heat) SEE MANUAL.
  - When Optional Program Lockout is specified by customer. Dial Plate A/N 600566-001 replaces A/N 600566. 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.  
See Wiring Diagram #421262 for EN1000-Series, "B" Cabinet.
  - EN1000-1508:  
ENTRON supplies Jumper between TSI1-TLS1/AUX & TSI1-GND. When Temperature Limit Switch is to be used by Customers External SCR, remove Supplied Jumper P/N 325226 between TSI1-GND & TSI1-TLS1/AUX.

**⚠ DANGER**  
**HAZARDOUS VOLTAGE**  
FROM ONE OR MORE SOURCES  
Turn off all voltage sources before touching any components.  
Electrical shock or flash will cause severe injury or death.  
Do not remove cover this sign.

**NOTICE**  
**FOR SERVICE ON THIS CONTROL**  
Contact Your Machine Dealer Or  
ENTRON CONTROLS LLC.  
DIRECTLY: (864) 416-0190  
601 HIGH TECH COURT  
GREER, SC 29650  
FAX# (864) 416-0195

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.

REV	DATE	DESCRIPTION	DRWN BY	CHK'D BY	DATE
-	-	ORIGINAL RELEASE			
REV	AUTH	DESCRIPTION	DRWN BY	CHK'D BY	DATE

**ENTRON CONTROLS INC**

SCALE	DATE	DRAWN BY	CHK'D BY	APPROVED BY
1/8"	5-31-94	DEC	DEC	

TOLERANCE (UNLESS SPECIFIED) REVISED

ANGLES:	± 1°	REV	DATE	APPROVED BY
DECIMALS:	± .010			
FRACTIONS:	± 1/64		25 JUN 08	DPH

WIRING DIAGRAM, EN1000-(SCR), "B" CABINET

NEXT ASSM/USED ON	DRAWING NUMBER	REV
	421262-002	B

EN1000-B(SCR)

DRAWING NUMBER 421262-002