



## APPLICATION NOTE 700157C SEAM MODE 06

EN1000, EN1001, EN1003 Control Software

**SEAM mode 06** was primarily designed as a NON-BEAT SEAM mode. This mode enables execution of a fixed time weld using a number of repetitions in addition to alternating two heats within single schedule. It is available in EN1000, EN1001, and EN1003 Controls with PROM firmware version 619016 or higher.

The schedule is programmed as follows:

1. Use the SELECT push button until the DATA display shows **EF**.
2. Use the SCHEDULE push buttons to find **S.E.** in the SCHEDULE display.
3. Program a value of **06** for **S.E.** and press the ENTER push button.
4. Use the following information to program your control.

### NOTICE

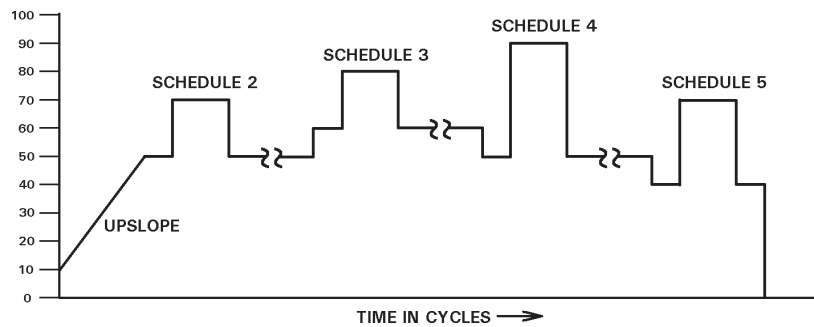
By definition, the SEAM mode is a BEAT mode operation. In normal SEAM modes, CHAINED mode is not available.

SQUEEZE		[normal SQUEEZE]
WELD/HEAT count	[WELD 1]	[normal WELD time]
PERCENT CURRENT	[PERCENT 1]	[normal PERCENT]
HOLD count		[normal HOLD time]
OFF count	[PERCENT 2]	[new second PERCENT heat]
IMPULSES	[Weld(1+2)*Factor]	[repetition factor for overall WELD time]
COOL count	[WELD 2]	[new COOL will execute a second WELD/HEAT]
VALVE MODE		[normal VALVE MODE]
CYCLE MODE		[normal CYCLE MODE]
SLOPE MODE		[normal SLOPE MODE]
SLOPE COUNT		[normal SLOPE COUNT]

In order to obtain a long series of heat patterns, the schedules can be CHAINED as normal to execute a second, third or more subsequent schedules with a similar set of heat patterns. See next page for example.

# SEAM MODE 06 EXAMPLE

SCHEDULE	SQUEEZE	WELD/ HEAT	PERCENT CURRENT	HOLD	OFF	IMPULSES	COOL	VALVE MODE	CYCLE MODE	SLOPE MODE	SLOPE COUNT
		WELD1			WELD2						
01 slope	05	00	10	00	00	01	00	01	02	00	00
02 seq.A	05	01	50	00	70	37	02	01	02	01	10
03 seq.B	05	01	55	00	85	54	02	01	02	01	10
04 seq.C	05	01	50	00	95	16	02	01	02	01	10
05 seq.D	05	01	40	10	70	15	02	01	02	01	10



**SEAM WELD HEAT PATTERN**