



BEFORE YOU START

The Inputs/Outputs (I/O) of the HF-2500A/2700A 25 kHz High Frequency DC Resistance Welding Control **MUST** be configured before operation or the Control will **NOT** function.

Default Configuration

The HF-2500A and HF-2700A Ship Kits contain a **Configuration Plug** that is factory-wired for negative logic. This default configuration allows you to weld with all AMADA WELD TECH weld heads and foot switches. Simply connect the **Configuration Plug** to the rear of the Power Supply as shown below, connect your weld head and footswitch to the Power Supply and you're ready for operation.



Changing Configuration

The HF-2500A/2700A can be re-configured in order to match your PLC or other welding equipment. Each Ship Kit contains unwired “blank” 10-pin connectors that can be used for remote operation. These connectors have screw-terminal wire connections so no soldering is required.

For complete instructions and wiring diagrams, see *Appendix B, Electrical and Data Connections* in the **User's Manual**.

REVISION HISTORY				
REV	DATE	ECO	BY	APPR
C	11/13	42840	T. Houy	T. Houy
D	04/20	45804	S. Loveland	T. Houy
E	04/21	46311	S. Loveland	T. Houy