

ADDENDUM

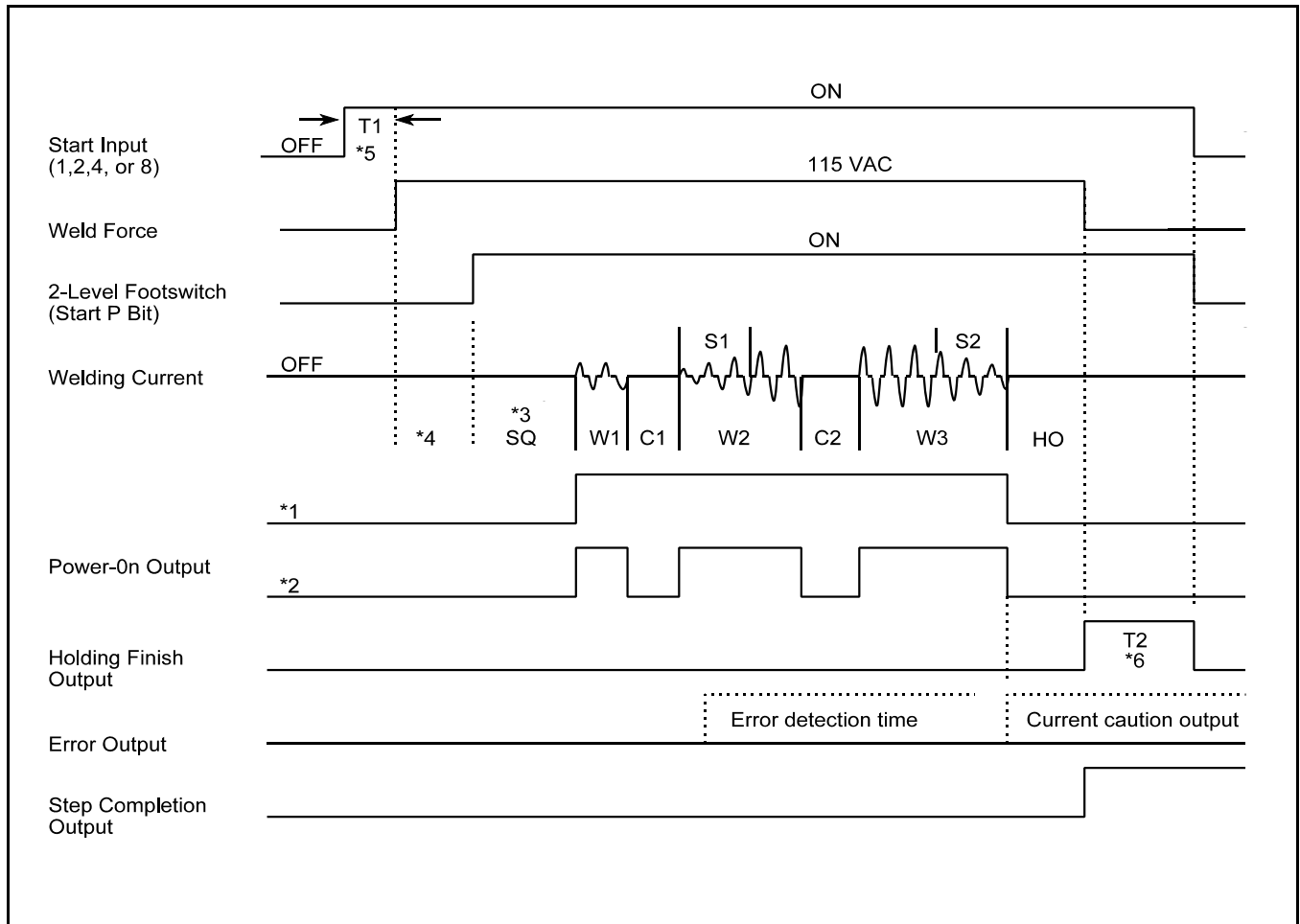
995-037, Rev B, 5/98

CT-110B User's Manual	993-039	A	12/97
CY-210B User's Manual	993-037	A	12/97
Manual Title	Manual Part No.	Manual Rev	Manual Date

REVISION RECORD

Revision	EO	Date	Basis of Revision
A	17403	3/98	Incorporate timing diagrams
B	17469	5/98	Add CT-110B to title

BASIC OPERATION WITH A 2-STAGE INITIATION SWITCH

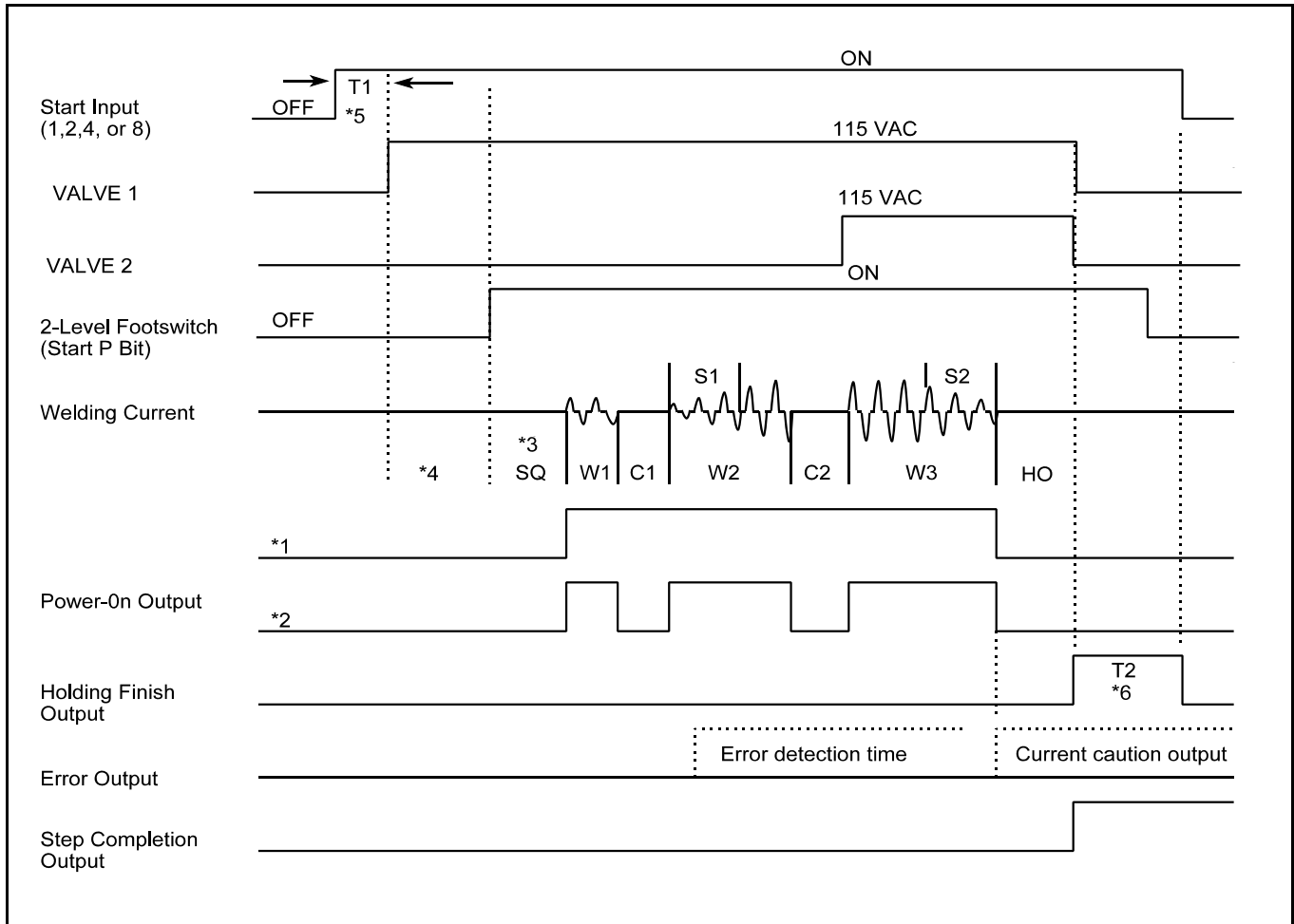


C12BSTMG.WPG

NOTES:

- *1. When DIP switch DSW1-3 is off: Power-on timing output is for Weld Checker MM-365A.
- *2. When DIP switch DSW1-3 is on: Flicker (weld On/cool OFF) output.
- *3. To start the SQ period, the START P input must be turned on.
- *4. Time until the 2-level foot switch is closed (0 to unlimited msec).
- *5. Time after the start signal is input until welding starts (20 msec typical, 60 msec maximum).
- *6. T2 is set to 200 msec if the start signal is turned off before the hold period starts, or if the start signal is turned off within 200 msec after the hold period ends.

FORGE WELD OPERATION WITH A 2-STAGE INITIATION SWITCH



C12FGTMG.WPG

NOTES:

- *1. When DIP switch DSW1-3 is off: Power-on timing output for Weld Checker MM-365A.
- *2. When DIP switch DSW1-3 is on: Flicker output.
- *3. To start the SQ period, the START P input must be turned on.
- *4. Time until the 2-level foot switch is closed (0 to unlimited msec).
- *5. Time from the start signal input until welding starts (20 msec typical, 60 msec maximum).
- *6. T2 is set to 200 msec if the start signal is turned off before the hold period starts, or if the start signal is turned off within 200 msec after the hold period ends.

Forge weld operation activated when DIP switch DSW1-5 on. VALVE (VALVE 1 for CY-210A) output turned on to drive the normal force valve and the OPTION (VALVE 2 for the CY-210A) output is turned on to drive the forge weld valve (see the schematic diagram on Page B-2 of Appendix B). OPTION (VALVE 2) is turned on during the Weld 3, Slope 2, and Hold periods.