MIYACHI
The Perfect Weld Starts Here

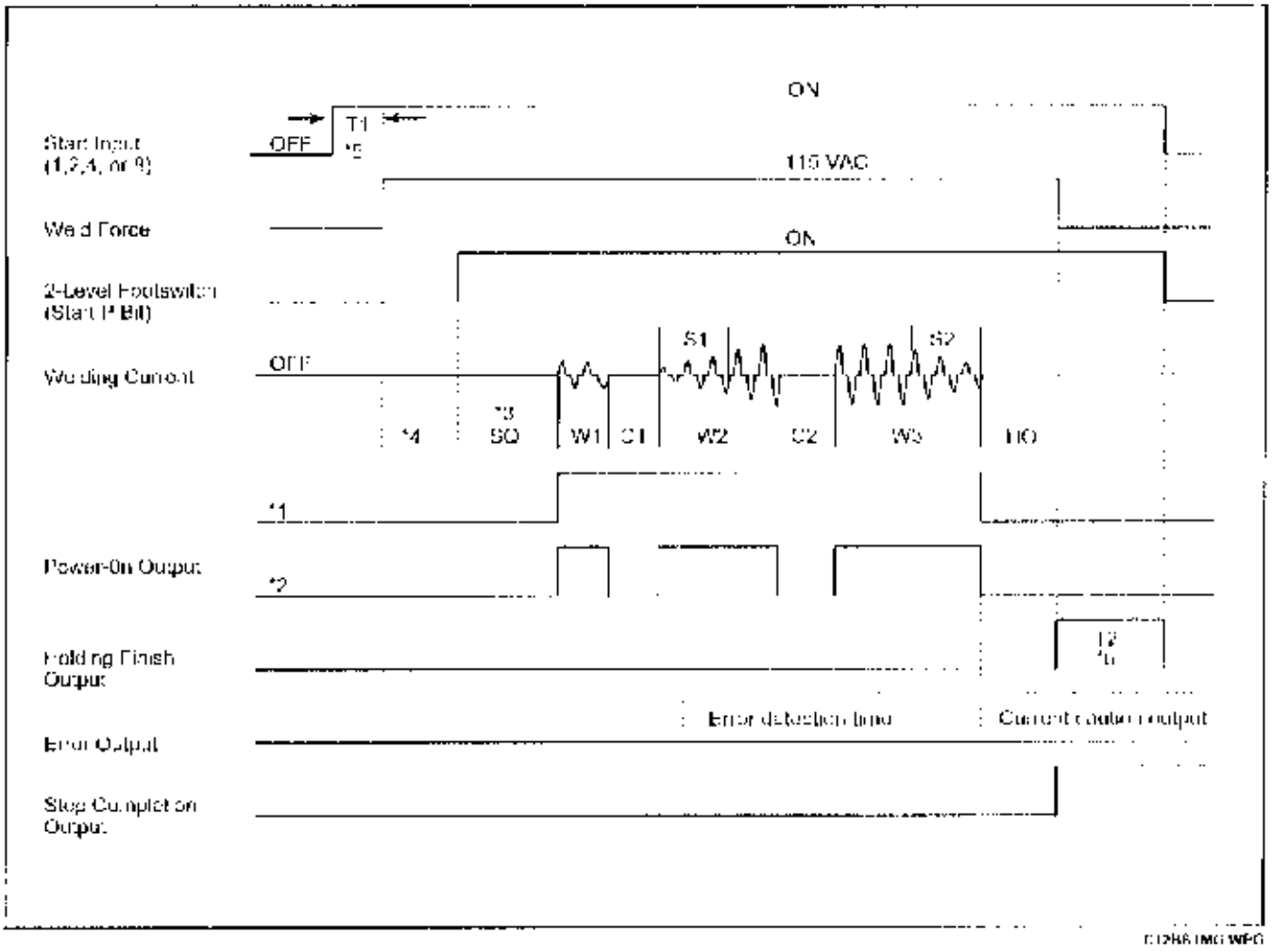
ADDENDUM
995-037, Rev C, 6/00

Manual Title	Manual Part No.	Date	Rev	Addendum Date
CY-210B User's Manual	993-037	12/97	B	6/00

REVISION RECORD

Revision	EO	Date	Basis of Revision
A	17403	3/98	Incorporate timing diagrams
B	17469	5/98	Add CT-110B to title of Addendum
C	18302	6/00	Add foot switch connection. Delete CT-110B from title of Addendum

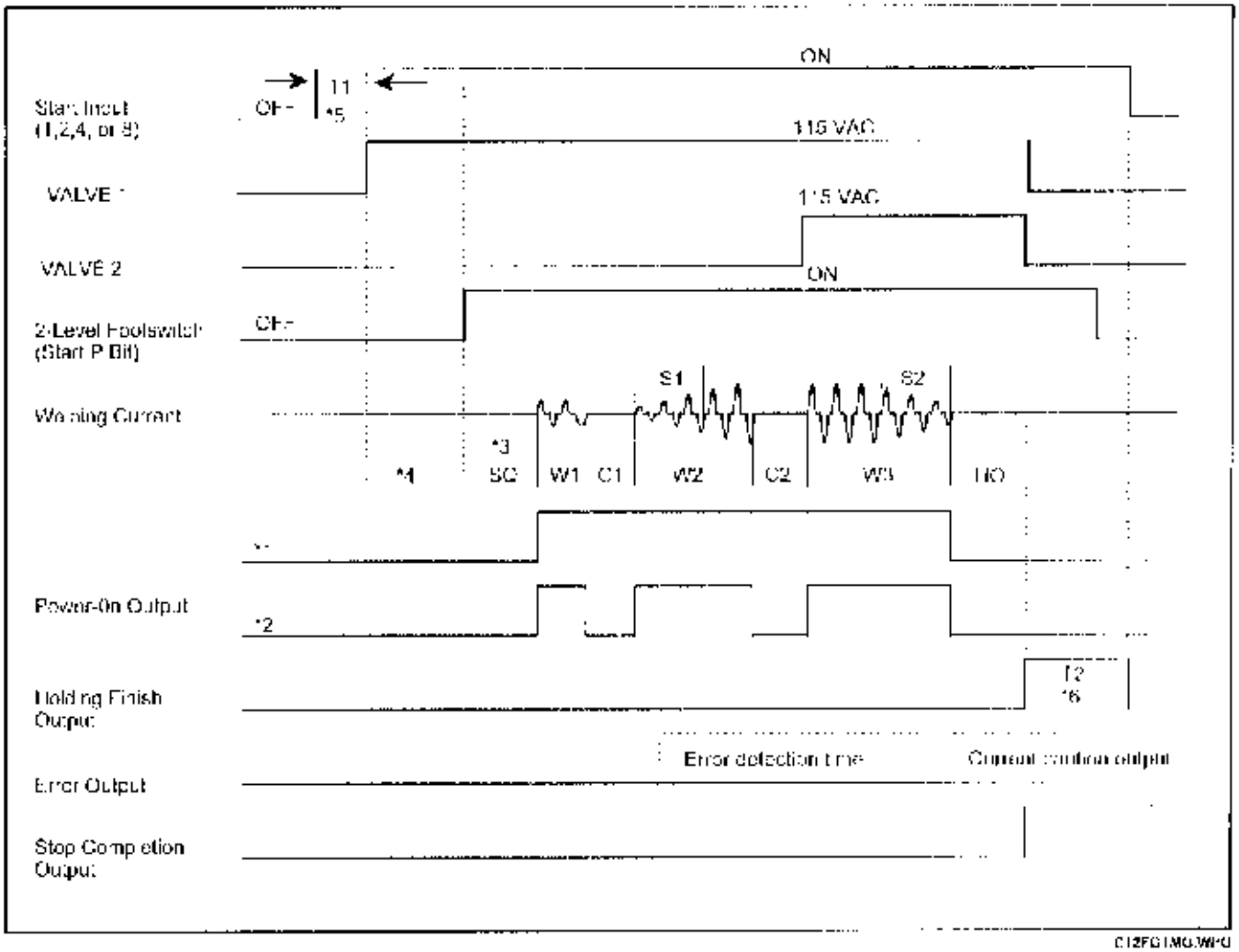
BASIC OPERATION WITH A 2-STAGE INITIATION SWITCH



NOTES:

*1. When DIP switch DSW1-3 is **OFF**: Power-on timing output is for Weld Checker MM-356A
*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



C12FG1MG.WMF

NOTES:

*1. When DIP switch DSW1-3 is **OFF**: Power-on timing output for Weld Checker MM-356A.
*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 is activated when DIP switch DSW2-5 is turned **ON**. VALVE 1 output must be turned **ON** to drive the normal force valve. VALVE 2 output is turned **ON** to drive the forge weld valve (see the schematic diagram on Page B-2 of Appendix B). VALVE 2 is turned **ON** during the Weld 3, Slope 2, and Hold periods.

Page 5-2, After Step 6) "Pins 7 -11," Add:

FOOT SWITCH GENERAL INFORMATION

The CY-210B can be used with either a single-level foot switch or a dual-level foot switch. Foot switches are connected to the CY-210B by connecting wires from the foot switch to a screw-type terminal block on the back of the CY-210B.

Weld schedules are selected by attaching wires to different screws on the terminal block. The following instructions describe the connection for **Schedule 1** which is normally used with foot switches. Paragraph 4-13 of this manual describes how to select different weld schedules by using different connecting screws (binary combinations).

Labels near the terminal block identify each screw. You need to know the location of the following screws:

Screw	Label
6	Common
7	Start 1
8	Start 2
9	Start 4
10	Start 8
11	Start P

CONNECT A SINGLE-LEVEL FOOT SWITCH

1 Get a piece of insulated wire (minimum size 24 AWG), approximately 3 to 4 inches long, to use as a jumper wire. Strip each end of the wire.

2 Connect one end of the jumper wire to screw #11.

3 Connect the following two wires to screw #6:

- The other end of the jumper wire.
- One of the wires from the foot switch.

4 Connect the other wire from the foot switch to screw #7 for the **Start 1** schedule. (For different weld schedule connections, refer to Paragraph 4-13.)

CONNECT A DUAL-LEVEL FOOT SWITCH

There should be two wires coming from the foot switch that connect to **Level One**, and two wires that connect to **Level Two**. Use a continuity checker to verify which wires are for **Level One**, and which wires are for **Level Two**.

1 Connect the following two wires to screw #6:

- One of the **Level One** connecting wires.
- One of the **Level Two** connecting wires.

2 Connect the other **Level One** connecting wire to screw #7 for the **Start 1** schedule. (For different weld schedule connections, refer to Paragraph 4-13.)

3 Connect the other **Level Two** connecting wire to screw #11.