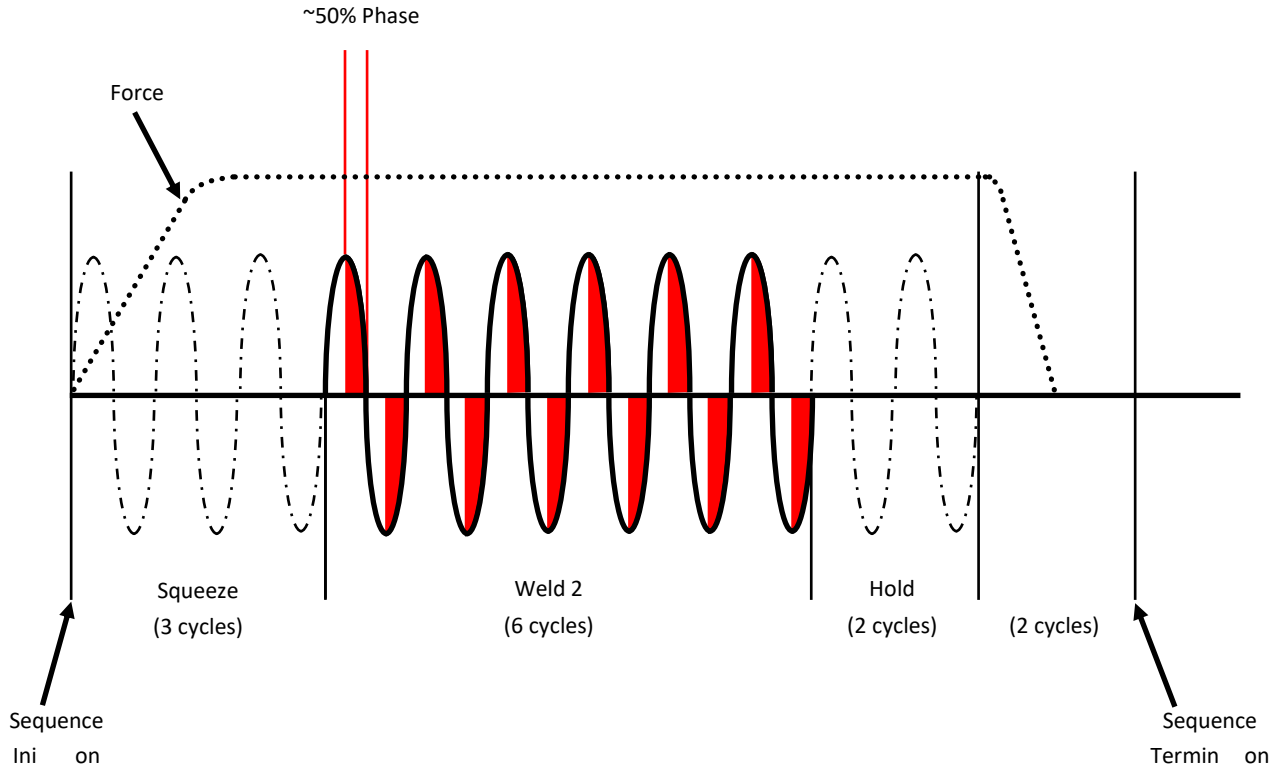
5.3 Timing Cycles

(traditional spot weld)

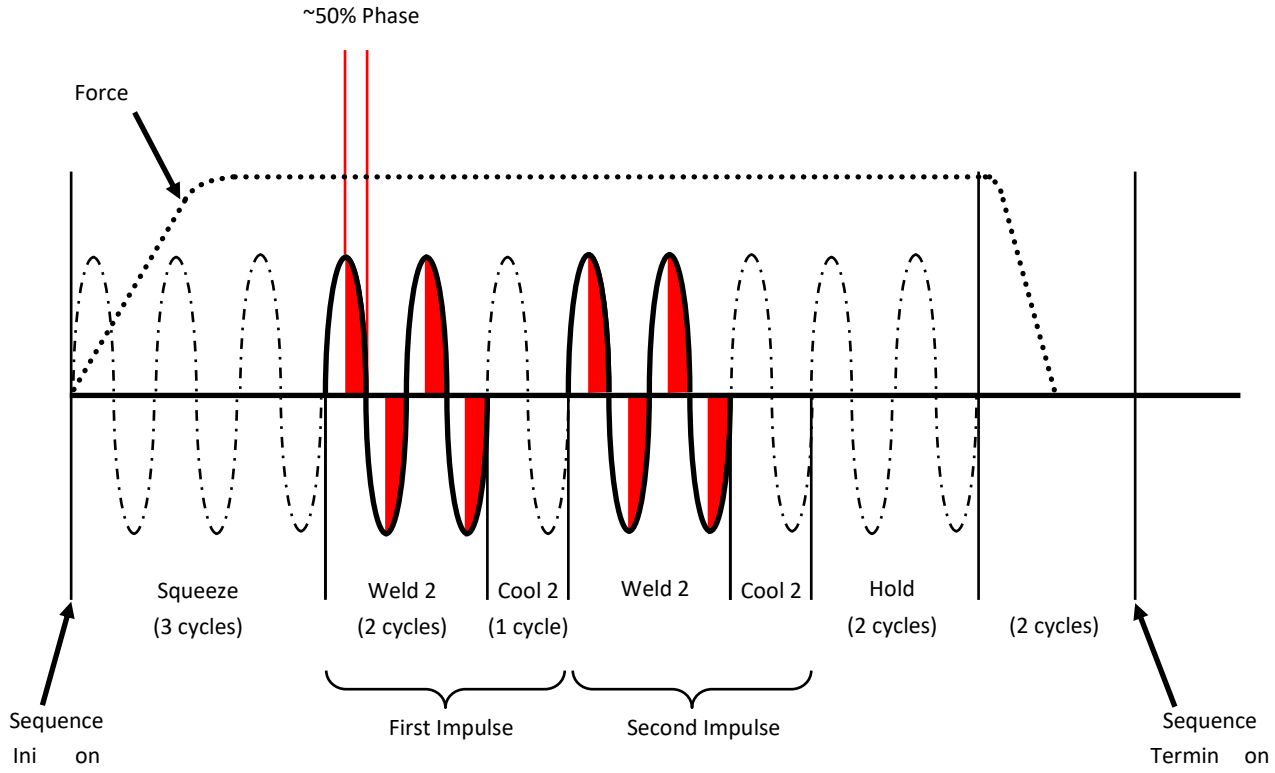


PARAMETER	SETTING
Squeeze Delay	0 cycles
Squeeze	3 cycles
Weld 1	0 cycles
Cool 1	0 cycles
Slope	0 cycles
Weld 2	6 cycles
>Mode	Phase Shift
>Heat	50 %
Cool 2	0 cycles
Hold	2 cycles
Off	2 cycles
Impulses	1 cycle

The diagram above is intended to demonstrate a resulting welding timing cycle using the attached parameters; it is not recommended as part of a functional weld schedule.

5.3 Timing Cycles

(multiple impulses)

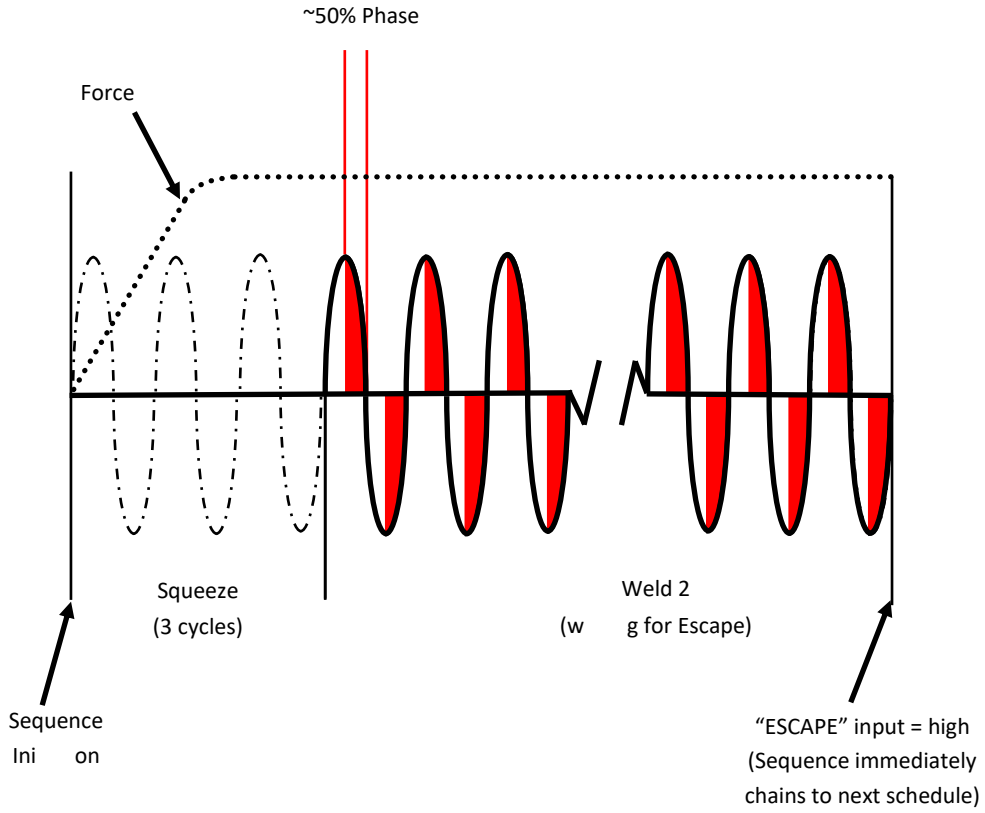


PARAMETER	SETTING
Squeeze Delay	0 cycles
Squeeze	3 cycles
Weld 1	0 cycles
Cool 1	0 cycles
Slope	0 cycles
Weld 2	2 cycles
>Mode	Phase Shift
>Heat	50 %
Cool 2	1 cycle
Hold	2 cycles
Off	2 cycles
Impulses	2 cycles

The diagram above is intended to demonstrate a resulting welding timing cycle using the attached parameters; it is not recommended as part of a functional weld schedule.

5.3 Timing Cycles

(“Wait-Here” weld)



PARAMETER	SETTING
Cycle Mode	Wait-Here
Beat Mode	Wait-Here
Squeeze Delay	0 cycles
Squeeze	3 cycles
Weld 1	0 cycles
Cool 1	0 cycles
Slope	0 cycles
Weld 2	99 cycles
>Mode	Phase Shift
>Heat	50 %
Cool 2	0 cycles
Hold	2 cycles
Off	2 cycles
Impulses	1 cycle

The diagram above is intended to demonstrate a resulting welding timing cycle using the attached parameters; it is not recommended as part of a functional weld schedule.