Process Control Settings

**Press Setup Sheet**

**Initiate Mode**
- Manual
- Auto

**Trigger Method**
- Maintained
- Momentary
- Force (if applicable)*
  - Normal Trigger:
    - Trigger Delay by Time: __________ sec
    - Trigger Delay by Distance: __________ in/mm
    - Max. time: __________ sec
  - Momentary:
    - Pretrigger by Distance: __________ in/mm
    - Start weld at Trigger or Pretrigger

- Single Pressure
- Dual Pressure

**Weld Method**

**Pressure 1**
- Time: __________ sec
- Distance: __________ in/mm
- Ab. Distance: __________ in/mm
- Energy: __________ joules
- Peak Power: __________ watts
- Max. weld time: __________ sec

**Pressure 2**
- Time: __________ sec
- Distance: __________ in/mm
- Ab. Distance: __________ in/mm
- Energy: __________ joules
- Peak Power: __________ watts
- Max. weld time: __________ sec

- Continuous
  - Report Interval: __________ sec

**Scrub**
- Disable
- Enable
  - Scrub time: __________ sec

**Hold Method**
- Time: __________ sec
- Distance: __________ in/mm
- Max. hold time: __________ sec
- Auto
  - Max. hold time: __________ sec

**Afterburst**
- Disable
- Enable
  - Afterburst delay: __________ sec
  - Duration: __________ sec

**Pressure**
- Downstroke: __________ psi
- Weld P1: __________ psi
- Weld P2: __________ psi
- Hold: __________ psi
- Upstroke: __________ psi

**Hydraulic Slow Speed**
- Rate

**Amplitude**
- Amplitude P1: __________ %
- Amplitude P2: __________ %

**Secondary Controls**
- Weld Distance P1: __________ in/mm
- Weld Energy P1: __________ joules
- Peak Power P1: __________ watts
- Weld Distance P2: __________ in/mm
- Weld Energy P2: __________ joules
- Peak Power P2: __________ watts
- Abs. Distance P2: __________ in/mm
- Total Weld Time: __________ sec
- Total Weld Energy: __________ joules
- Total Cycle Time: __________ sec
- Total Stroke: __________ in/mm

**Booster Size**
- Ratio

*If the press is equipped with Electronic Regulator and load cell, program these settings using the Generator/Power Supply front panel.*