

# FW-200 MS/HS/HSA GENERAL SETTINGS

| BLADE<br>SIZE/TYPE | WELD SETTINGS   |                |                 |                   |                    |                     | ANNEAL SETTINGS  |                  |                  |                  |
|--------------------|-----------------|----------------|-----------------|-------------------|--------------------|---------------------|------------------|------------------|------------------|------------------|
|                    | JAW GAP<br>(in) | TIMING<br>(in) | WELD<br>VOLTAGE | FLASHING<br>SPEED | SPRING<br>PRESSURE | DELAY TIME<br>(sec) | RAMP STAGE       |                  | SOAK STAGE       |                  |
|                    |                 |                |                 |                   |                    |                     | ANNEAL HEAT<br>1 | ANNEAL TIME<br>1 | ANNEAL HEAT<br>2 | ANNEAL TIME<br>2 |
| 1/4"               | .250 - .300     | .000 - .002    | 1 - 2           | 5 - 6             | 0 - 4              | 0+                  |                  | 3 - 6            |                  | 2 - 10           |
| 3/8"               | .280 - .310     | .002 - .010    | 1 - 2           | 5 - 6             | 0 - 6              | 1+                  |                  | 3 - 6            |                  | 3 - 10           |
| 1/2"               | .300 - .325     | .005 - .010    | 2 - 3           | 4 - 6             | 4 - 10             | 2+                  |                  | 3 - 6            |                  | 3 - 10           |
| 3/4"               | .325 - .350     | .005 - .015    | 2 - 3           | 4 - 6             | 10 - 20            | 3+                  |                  | 4 - 8            |                  | 5 - 10           |
| 1"                 | .350 - .400     | .010 - .040    | 3 - 4           | 4 - 6             | 25 - 40            | 4+                  |                  | 4 - 10           |                  | 5 - 10           |
| 1-1/4"             | .400 - .475     | .020 - .050    | 4 - 5           | 4 - 6             | 35 - 45            | 5+                  |                  | 5 - 10           |                  | 5 - 20           |
| 1-1/2"             | .475 - .550     | .030 - .075    | 4 - 6           | 3 - 5             | 45 - 60            | 7+                  |                  | 5 - 15           |                  | 10 - 25          |
| 2"                 | .500 - .575     | .035 - .125    | 5 - 6           | 3 - 5             | 50 - 60            | 10+                 |                  | 5 - 15           |                  | 10 - 30          |
|                    |                 |                |                 |                   |                    |                     |                  |                  |                  |                  |
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