

# FW-200 MS/HS/HSA SPECIFIC SETTINGS

BLADE SIZE/TYPE	WELD SETTINGS						ANNEAL SETTINGS			
	JAW GAP (in)	TIMING (in)	WELD VOLTAGE	FLASHING SPEED	SPRING PRESSURE	DELAY TIME (sec)	RAMP STAGE		SOAK STAGE	
							ANNEAL HEAT 1	ANNEAL TIME 1	ANNEAL HEAT 2	ANNEAL TIME 2
Starrett 1-1/4" Powerband Matix II (Bimetal)	.450	.075	4	4	45	5				
Starrett 1-1/4" Powerband M-42 (Bimetal)	.450	.040	5	4	45	5				
Lenox 1" Woodmaster C (Bimetal)	.350	.010	3	5	20	4	290	5	240	4
Greenfield 1-1/4" Bimetal	.500	.085	4	6	40	5	350	5	300	15
	Max. Strength = 1-1/4 Turns									
Bahco/Sandvik 1" Bimetal	.400	.030	3	6	30	4	350	4	290	7
Bahco/Sandvik 3/4" Bimetal	.350	.010	2	5	12	3	320	4	275	5
Bahco/Sandvik 5/8" Bimetal	.350	.005	2	6	10	3	310	4	265	5
Bahco/Sandvik 3/4" Carbon	.350	.005	2	6	10	3				
Bahco/Sandvik 1/2" Carbon	.325	.005	2	6	5	2	272	4	244	5
Bahco/Sandvik 1/4" Carbon	.250	0	1	6	2	1	255	3	230	4
Woodmizer 1-1/4" Carbon	.450	.060	4	6	25	5	320	5	250	15
	Anneal Temp. = 1050°F : Max. Strength = 2 Turns									
Woodmizer 1-1/2" Carbon	.500	.060	5	6	30	7	350	6	275	15
	Anneal Temp. = 1150°F									