

FW-200 HPA GENERAL SETTINGS

BLADE SIZE/TYPE	WELD SETTINGS							ANNEAL SETTINGS			
	JAW GAP (in)	TIMING (in)	WELD VOLTAGE	FLASHING SPEED	FORGE PRESSURE (psi)	FOLLOW PRESSURE (psi)	DELAY TIME (sec)	RAMP STAGE		SOAK STAGE	
								ANNEAL HEAT 1	ANNEAL TIME 1	ANNEAL HEAT 2	ANNEAL TIME 2
1/4"	.250 - .300	.000 - .002	1 - 2	5 - 6	4 - 6	2 - 3	0+		3 - 6		2 - 10
3/8"	.280 - .310	.002 - .010	1 - 2	5 - 6	4 - 8	3 - 5	1+		3 - 6		3 - 10
1/2"	.300 - .325	.005 - .010	2 - 3	4 - 6	6 - 10	3 - 5	2+		3 - 6		3 - 10
3/4"	.325 - .350	.005 - .015	2 - 3	4 - 6	15 - 25	4 - 6	3+		4 - 8		5 - 10
1"	.350 - .400	.010 - .040	3 - 4	4 - 6	25 - 40	4 - 6	4+		4 - 10		5 - 10
1-1/4"	.400 - .475	.020 - .050	4 - 5	4 - 6	35 - 45	5 - 8	5+		5 - 10		5 - 20
1-1/2"	.475 - .550	.030 - .075	4 - 6	3 - 5	35 - 55	7 - 10	7+		5 - 15		10 - 25
2"	.500 - .575	.035 - .125	5 - 6	3 - 5	40 - 60	7 - 10	10+		5 - 15		10 - 30