

FAQ_PM_021 The current shuts off after some production time, or you receive cans with "stitching/glueing mode".

Cause:

Display No. 2																
W	E	L	D	P	O	W	E	R	L	I	M	I	T	E	R	
M	a	x	.	1	9	8	@	D	o	t	1	0	2			
S	e	t		2	1	5	(L	i	m	i	t)			
T	o	t	a	l	D	o	t	s						3	5	4

The actual value of the weld power limiter increases with the heating of the machine.




Corretive:

L	i	m	i	t											2	1	5
S	k	i	p	D	o	t	s										4
M	o	d	e							G	l	u	e	i	n	g	
-	-	>	D	o	t	W	e	l	d	i	n	g					

Readjust the weld power limiter, to a higher value. Observe the "Max" value from a "cold" start to a "warm up" machine during production. See also note below.



L	i	m	i	t											2	1	5
S	k	i	p	D	o	t	s										4
M	o	d	e							G	l	u	e	i	n	g	
-	-	>	D	o	t	W	e	l	d	i	n	g					



NOTE:
Power limit to activate the weld guard (stitch welding). Normally 5 – 10 % more than the actual "Max" value during production.
0 = Weld Power Limiter Off !