ENTRON

APPLICATION NOTE 700167B
ROTARY INPUT BOARD OPTION
EN1280, EN1380, EN1500, EN2130 & EN2150 CONTROLS

The Rotary Input Board (RIB) is a device to adjust weld control parameters "online" without entering the PROGRAM mode. Adjustments are made via a knob on the front panel of the weld control. The operator will feel detents (clicks) as the knob is rotated indicating units of change. The knob is rotated clockwise for increasing values and counterclockwise for decreasing values. The RIB requires no extra programming to the weld control. Just plug it in, the internal software recognizes the option and is installed automatically.

The RIB can be installed as an option in selected ENTRON models. It can be factory or field installed. In some models it is part of the standard control. See the Instruction Manual for the specific type of control in question.

NOTICE
Different models use the RIB in different ways as the application dictates. See specific types of operation in the sections below.

EN1280 Band Saw Welding Controls – see Instruction Manual 700145

EN1380 Flash and Butt Welding Controls
1. The RIB adjusts ANNEAL 1 and ANNEAL 2 PERCENT CURRENT (using FS7).
2. Adjustments can be made while the control is **annealing** in OPERATE mode.
3. When in PROGRAM mode, the RIB can be used to enter data (similar to how 1s and 10s push buttons function).
4. When adjustments are made, the data changes are entered into control memory and are retained.

EN1500 Seam Welding Controls (also applies to Obsolete EN1501 Ctrls.)
1. The RIB adjusts weld PERCENT CURRENT. The RIB will vary the PERCENT CURRENT of the **displayed** schedule.

NOTICE
The EN1500 Series Controls can operate between three schedules depending on initiations used. The schedule adjusted will be current schedule in display at the time RIB is adjusted.

2. Adjustments can be made while the control is **welding** in OPERATE mode.
3. When in PROGRAM mode, the RIB can be used to enter data (similar to how 1s and 10s push buttons function).
4. When adjustments are made, the data changes are entered into control memory and are retained.

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EN2130 Bench Type Controls

1. The RIB adjusts weld PERCENT CURRENT for **schedule 1**.
2. The adjustments must be made while the control is **idle**.
3. When adjustments are made, the data changes are entered into control memory and are retained.

EN2150 Bench Type Controls

1. The RIB adjusts weld PERCENT CURRENT for **schedule 1**.
2. The adjustments must be made while the control is **idle**.
3. The Control Board must have PROM firmware version 619030-002 **Original** or higher. Typically, the Control Board Assembly will be numbered 600639**B** or higher.
4. When adjustments are made, the data changes are entered into control memory and are retained.

FIELD INSTALLATION OF ROTARY INPUT BOARD (RIB) OPTION

To install a RIB Option in any ENTRON supplied cabinet, the following items are required:

Kit No. 600652
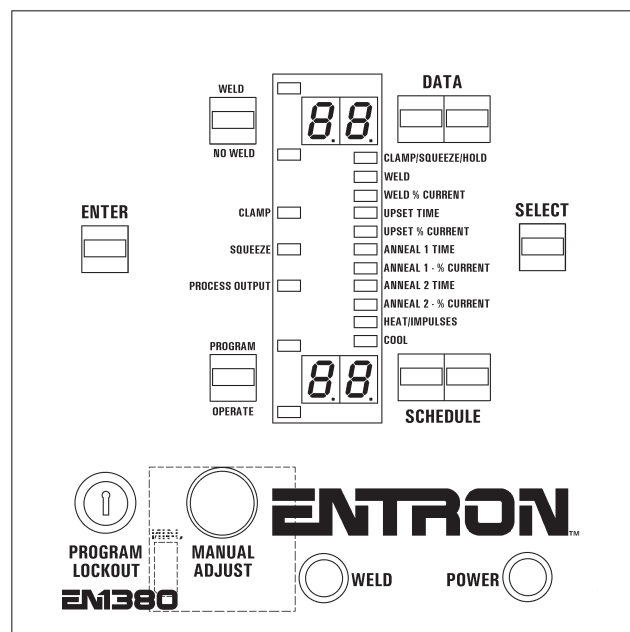For EN1280, EN1380, EN1500, EN2130 and EN2150 Controls made after 1/29/99

1	410350	Assembly, PCB, Rotary Input Bd.
1	319008	Knob, w/o indicator, for 1/4" shaft
1	322447	Harness Assembly, J4 Ribbon
1	700167	App. Note, Field Instal., RIB Option

Kit No. 600652-001
For EN2150 Controls made before 1/29/99

1	410350	Assembly, PCB, Rotary Input Bd.
1	319008	Knob, w/o indicator, for 1/4" shaft
1	322447	Harness Assembly, J4 Ribbon
1	600639B	Assem, Ctrl./Display Bd, EN2150 w/PROM 619030-002
1	700167	App. Note, Field Instal., RIB Option

1. Remove **ALL** power to control. Open door.
2. Remove 3/8″ diameter hole plug from Dial Plate.
3. Assemble PCB Assembly to Dial Plate using panel retaining hardware on Rotary Switch.
4. Attach Knob to shaft of Rotary Switch using appropriate size Allen wrench.
5. On EN2150 Controls with Control/Display Boards at **Original** Revision or Revision **A**, and/or PROM firmware version 619030-001, replace board with Control/Display Board at Revision **B** or higher included with your kit.
6. Plug J4 Ribbon harness into PCB Assembly and Control Board being careful to align the red stripe as shown on the Wiring Diagram included with this kit.

Dial Plate will vary with Control Type