

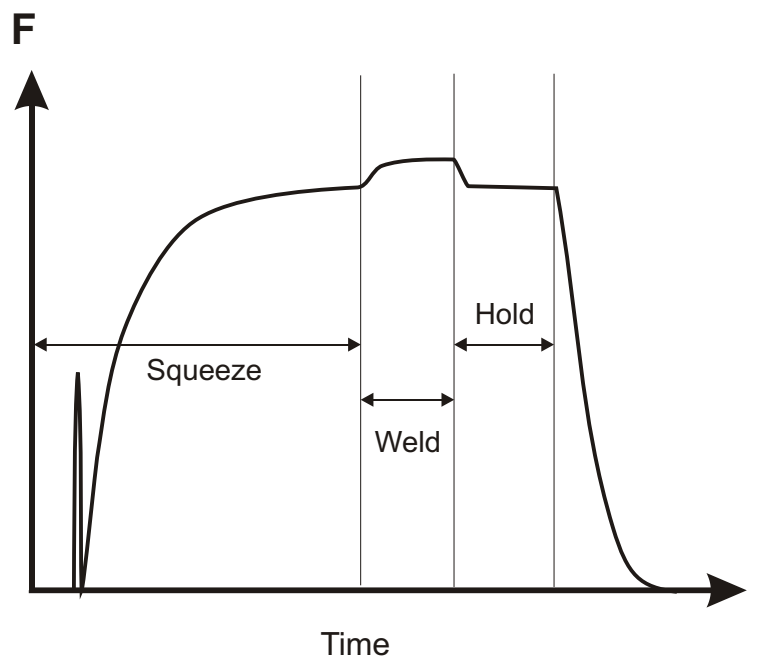
WELD LOBE DIAGRAM

Key Parameters to Monitor/Control

1. Minimum force to fire current
2. Maximum force allowed during weld
3. Current (RMS or peak) range
4. Weld duration
 - Number of weld cycles or time
 - Hold time
5. Initial thickness (stackup of parts)

Key Parameters to Measure Results

1. Final thickness
2. Setdown (initial - final thickness)
3. Actual achieved current



TYPICAL WELD CYCLE