

WELD MONITOR QUALITY CHECKS

STANDARD OPERATING PROCEDURE

MINIMUM ONCE PER SHIFT, OR AT A PRODUCT CHANGEOVER:

BLANKING PULSE AND OVERLAP

CONFIRM THE CORRECT SETTING OF THE BLANKING PULSE DELAY, USING THE MONITOR 'SETUP' SWITCH AS DESCRIBED IN THE VERTEX TRAINING MANUAL. CHECK THE OVERLAP IN THE UNWELDED SECTION OF THE SEAM.

CAN TRACKING COUNT

IS THE CAN TRACKING COUNT NUMBER CORRECT (WHILE MAKING CANS)? IF IN DOUBT, SHUT OFF THE FEEDER AND CONFIRM THAT IT COUNTS DOWN TO ZERO. (IF IT DOES NOT, RESET IT TO ZERO WITH THE 'RESET' BUTTON, THEN FIND AND CORRECT THE CAUSE.)

QUALITY COEFFICIENT

IS IT CLOSE TO THE SET POINT? IF NOT, WHY NOT?
UNLESS YOU EXPECT THE DIFFERENCE TO BE TEMPORARY, CHANGE THE SET POINT TO MATCH THE QUALITY COEFFICIENT.

MONITOR TEST PROCEDURE

STOP THE FEEDER. TURN ON A BRUSH-OFF DOWN THE LINE TO REJECT ALL CANS. MAKE A NOTE OF THE PRESENT WELDER CURRENT ('HEAT') SETTING. TURN UP 10% (EXAMPLE: PRESENT SETTING 760, TURN UP TO 836). RUN FIVE CANS, WHICH SHOULD ALL BE REJECTED AT THE MONITOR STATION. TURN HEAT DOWN BELOW NORMAL SETTING BY 10% (EXAMPLE: PRESENT SETTING 760, TURN DOWN TO 684) RUN FIVE CANS WHICH SHOULD ALL BE REJECTED AT THE MONITOR REJECT STATION. REPORT IF THIS DOES NOT HAPPEN. RETURN WELDER HEAT SETTING TO NORMAL AND RESUME PRODUCTION.

REMEMBER –

NO MONITOR = NO PRODUCTION!