Tipaloy

USE OF CABLE SELECTION CHARTS

The following is based upon individual cable thermal limitations and will demonstrate the correct method for determining circular mil requirements for all types of cables displayed in this catalog.

Regardless of the type cable which may be of interest first consult the Conversion Factor Chart with the known factors:

EXAMPLE:

Cycles of current "on time" per weld .6
Number of welds per minute.............60
Amperes per weld.......................16,000
Kickless Cable length...................10 Ft.

STEP # 1 Lay one side of a straight edge across the 6 cycles of current "on time" on the left hand vertical scale of the Conversion Factor Chart.

STEP #2 Lay the other side of the straight edge across the 60 welds per minute of the vertical right hand scale.

STEP # 3 At the point of intersection with the center slanted scale, a .32 Conversion Factor is indicated by the lower scale. (A duty cycle of .10 or 10% is identified by the lower scale, which in this case is not of interest.)

STEP # 4 Multiply the required current of 16,000 amperes by the .32 Conversion Factor which will amount to a "Continuous Duty Current" of 5,120 amperes.

STEP # 5 Proceeding to the Kickless Cable Chart, draw a horizontal line across the chart from the 5,120 ampere point on the vertical left hand scale.

STEP #6 Draw a vertical line from the 10 ft. point on the lower horizontal scale.

CONVERSION FACTOR & DUTY CYCLE CHART
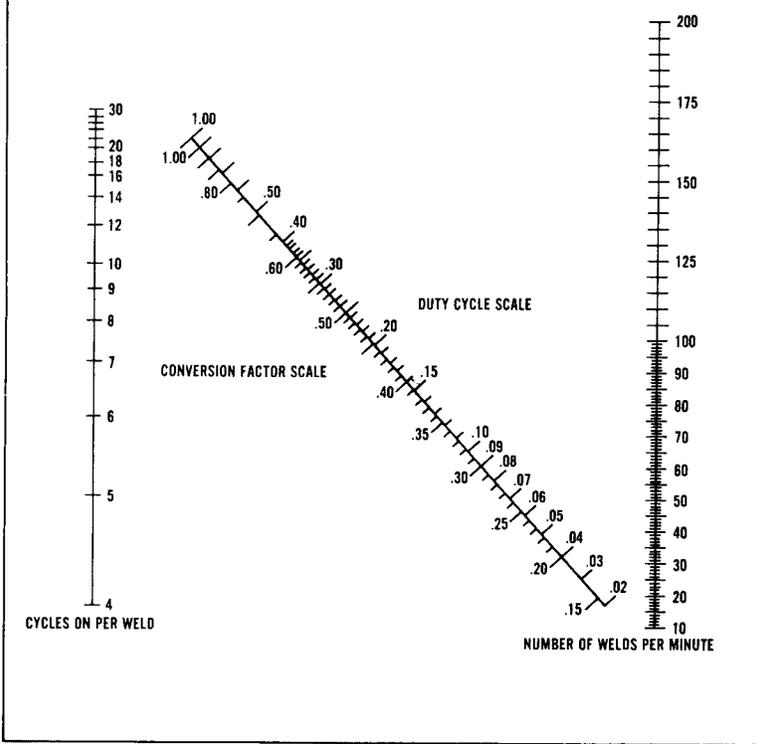
KICKLESS CABLE SELECTION CHART
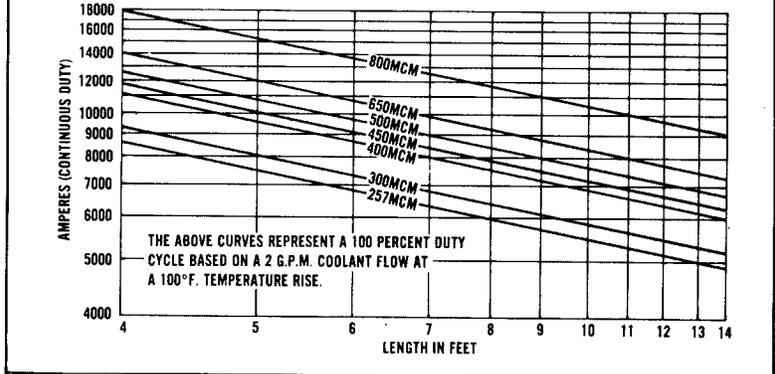
WATER COOLED JUMPER SELECTION CHART

CABLE SELECTION CHART

49