

FW-200 HPA SPECIFIC SETTINGS

	WELD SETTINGS							ANNEAL SETTINGS			
								RAMP STAGE		SOAK STAGE	
BLADE SIZE/TYPE	JAW GAP (in)	TIMING (in)	WELD VOLTAGE	FLASHING SPEED	FORGE PRESSURE (psi)	FOLLOW PRESSURE (psi)	DELAY TIME (sec)	ANNEAL HEAT 1	ANNEAL TIME 1	ANNEAL HEAT 2	ANNEAL TIME 2
Bahco 2"x.050 Bimetal	.550	.060	6	4	40	5	10	335	5	250	10
	Anneal Temp. = 1150°F; Max. Strength = 1 turn (360°)										
Arntz #1 2"x.063 Bimetal	.550	.075	6	4	50	5	10	370	6	275	15
	Anneal Temp. = 1100°F (barely red); Sensitive to anneal heat changes; Max. Strength = 1 turn										
Arntz #2 2"x.063 Bimetal	.550	.090	6	4	50	8	10	370	5	270	15
	Anneal Temp. = 1100°F (barely red); Max. Strength = 1 turn										
Arntz #3 2"x.063 Bimetal	.550	.090	6	4	50	8	10	380	6	270	15
	Anneal Temp. = 1250°F (bright red); Max. Strength = 1 turn										
MunkforsSagar 1.5"x.043 Polished	.500	.040	5	6	45	5	7	285	5	210	7
	Anneal Temp. = 1150°F; Max. Strength = 1-3/4 turns										
Starrett 1-1/4" Powerband Matix II	.450	.075	4	4	45	5	5				
Starrett 1-1/4" Powerband M-42	.450	.040	4	4	45	5	5				
Lenox 1" Woodmaster C	.350	.010	3	5	20	5	3	290	5	240	4
Lenox 1-1/4" Woodmaster C	.425	.015 - .020	4	5	35	5	5				
Amada 2" SV	.575	.115	6	6	40	8	10	355	8	280	40
	Anneal Temp. = 1300°F (bright red); Max. Strength = 3/4 turn										
Amada 1-1/2" SV	.550	.060	5	6	40	8	10	295	7	240	30
	Anneal Temp. = 1300°F (bright red); Max. Strength = 1 turn										
Amada 1-1/4" SV	.450	.035	4	6	30	5	7	275	5	222	30
	Anneal Temp. = 1300°F (bright red); Max. Strength = 1-1/4 turns										
Amada 1" MV	.400	.020	3	6	25	5	5	260	4	208	25
	Anneal Temp. = 1300°F (bright red); Max. Strength = 1-3/8 turns										

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Amada 1-1/2" Super HL	.550	.060	5	6	40	8	10	300	6	235	40
	Anneal Temp. = 1300°F (bright red); Max. Strength = 1 turn										
Amada 1" Super HL	.400	.020	3	6	20	5	5	260	4	210	30
	Anneal Temp. = 1300°F (bright red); Max. Strength = 1-1/2 turns										
Amada 1-1/2" Protector	.550	.060	5	6	40	8	10	300	7	235	40
	Anneal Temp. = 1300°F (bright red); Max. Strength = 1 turn										
Amada 1" Protector	.400	.020	3	6	25	5	5	255	4	205	25
	Anneal Temp. = 1300°F (bright red); Max. Strength = 1-3/4 turns										