**Two point calibration**

Please Reference Page 5-5 in TCI-0003E-M-ACU “NWC-900 Instruction Manual”

**Under GUN No. (G) Schedule**

1. Address: 4 - 2 point calibration: OFF I ON
   1. Enables and disables the 2 point calibration. If “OFF” control will ignore parameters setup in addresses 5-8
   2. Perform a weld test by selecting 2 points near the upper and lower limit of the current actually being used. Record programmed current and result for lower limit and for upper limit.
   3. Output weld current is adjusted based on these parameters

**Set the current set values and measured values as in the following (4)- (7).**

1. Address: 5 - Calibration base 1: 2.00-50.00 [kA]
   1. Set the programed current value for the high limit from the weld test that was performed in advance for the 2 point calibration.
2. Address: 6 - Calibration base2: 2.00- 50.00 [kA]
   1. Set the programed current value for the low limit from the weld test which was performed in advance for the 2 point calibration.
3. Address: 7 - Calibration current 1: 2.00- 50.00 [kA]
   1. Set the measured current value for the high limit from the weld test which was performed in advance.
4. Address: 8 - Calibration current: 2.00 - 50.00 [kA]
   1. Set the measured current value for the low limit from the weld test which was performed in advance.