

Comparing the XM Control against the 9500

<u>Feature</u>	<u>XM Control</u>	<u>9500 Control</u>
On-Board Program Storage	500 Weld programs is standard	25 Weld programs is standard
Back-up/Storage format	128 Mb USB Flash stick	Dedicated PC/MIA data card with memory pendent
Off-Line Software	Optionally Available	Optionally Available, but only one program can be transfer at a time
Display	6"x 4" Color LCD graphic display	4 x 20 character display
Graphical Display of Weld	Yes	No
Non-Volatile Flash memory	Yes	No - if 9500 has a noise problem, all weld programs and system configuration will be lost. Operator would have to re-enter all information.
Digital Meters	Programmable - can be set-up in configuration Shows programmed, actual and override values	Shows program value before weld, actual during weld
Computer Configuration	Multi-processor control - Intel X-Scale Strong Arm processor for overall system control, with each weld parameter having its own DSP processor	One Intel 80KC micro-processor handles all programming and system control
System Configuration	Modular - you can add or remove modules as desired, in a true plug and weld format.	Dedicated 4 channels of control, you cannot add or remove
Maximum Weld parameters	Controls up to 30 weld parameters	Control ONLY 4 weld parameters
Can handle multiple arcs	Yes - simply connect more weld process modules	No - only one arc per 9500 control
Programmed Oscillation	Yes - complete oscillation control on each segment. You can change oscillation parameters for each weld segment	Partial - can choose to control width oscillation as one of the four weld parameters
Number of segments per weld	30 weld segments per weld program	maximum 5 segments per weld program, only 4 if weld time is not used.
Program Linking - Multi-pass	Yes - with Pre/Post Weld Automation Software	Yes - with Multi-pass Software
Scripting - auto Weld Sequence	Yes - with Pre/post weld automation software - Can sequence up to 8 events before & after weld	Limited - typical - touch retract, return to home
Override capability	Yes - up to eight weld parameters via encoder knobs. Not only able to adjust the main parameter, but in some cases, other features of that parameter	Yes - one at a time, via +/- keypad and arrows
Closed-loop control	Yes - using encoder feedback	Yes - using analog tach generator feedback
Data Acquisition	Yes - Optional - for up to 8 parameters	No
Sync pulse with Oscillation	Yes	No
Purge Button - shield gas	Yes	Yes
Purge Button - plasma gas	Yes	No
Purge Button - Backing Gas	Yes	No
Joystick control on pendent	Yes - 3 joysticks, programmable	No
Hardwired/Dedicated E-Stop	Yes	No - software only
220 Volt/ 50 hz operation	Yes	Yes
CNC Motion Control	Yes - Optional Feature	No
Axis Motion between passes	Yes - with Pre/Post Weld Automation Software	No
True Position Control based	Yes - all travel motion is encoder controlled motion	No
Plug and Weld capability	Yes - add or remove control modules and system will configure automatically	No
Ability to disable Wire/Osc/AVC	Yes - by pressing one of the buttons on XMC	Only have ability to disable wire
Pre-weld Positioning	Yes - has two position preweld set	No
Home Buttons - in non-weld screen	Yes - can home one, two or all axis	Can home one travel axis