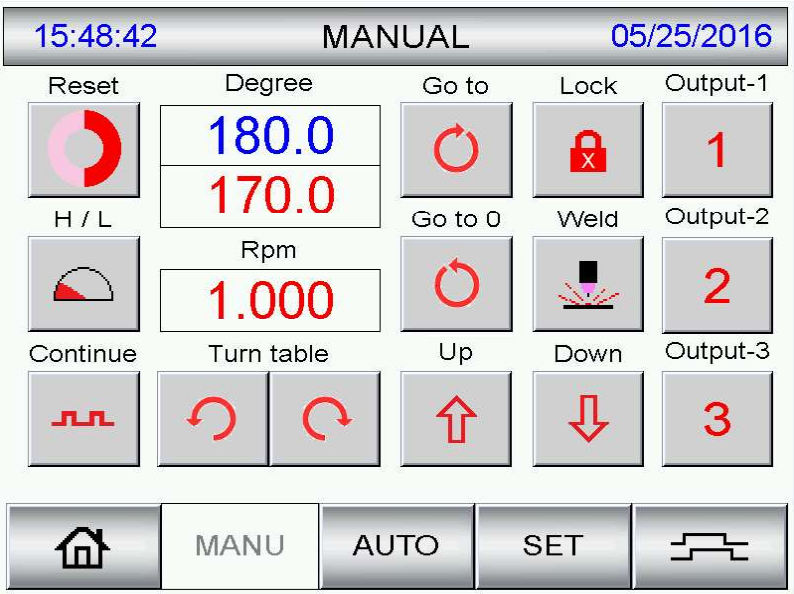
2.1 MAIN SCREEN

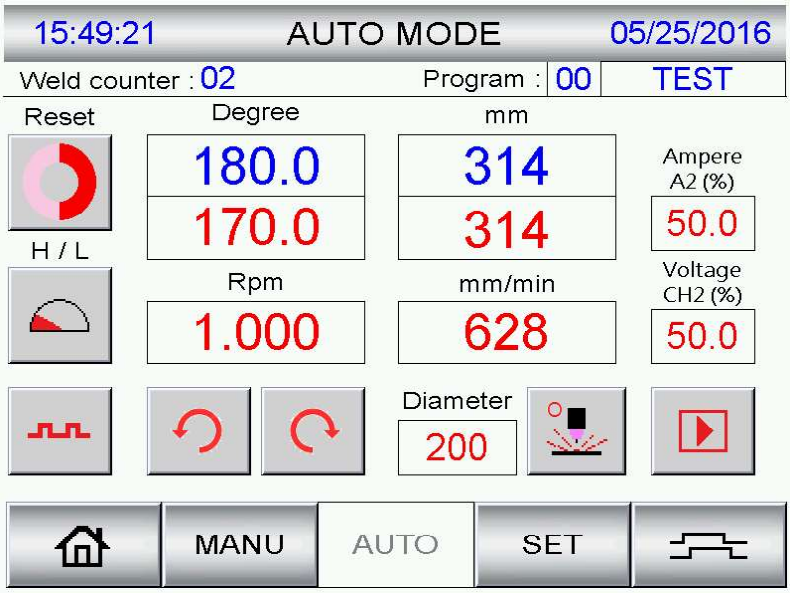
Language (English)	Switch language Chinese/English
MANU	Switch to "Manual Mode" screen
AUTO	Switch to "Auto Mode" screen
SET	Switch to "Setting" screen
Info.	Switch to "System Info" screen

2.2 MANUAL MODE



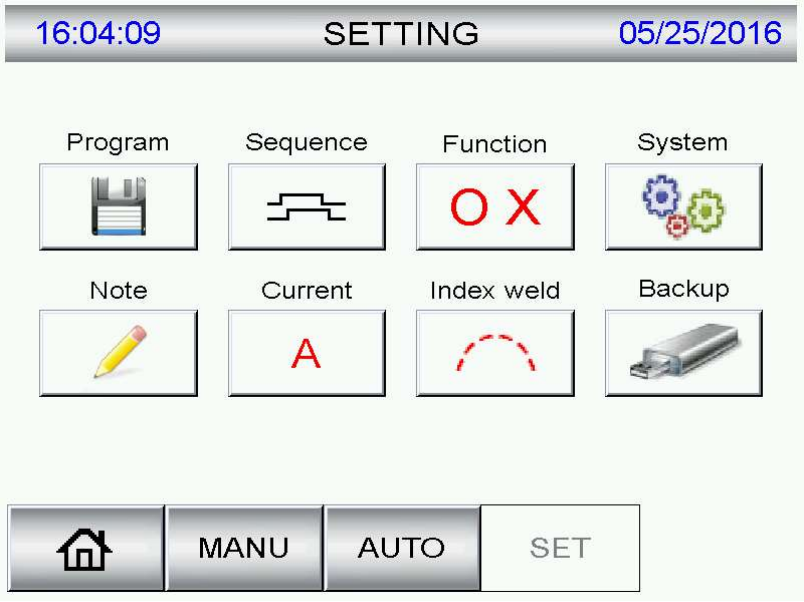
Degree 180.0 170.0	Turn table current position: Blue field: current position. Red field: set position.	Go to	Move to set position
Rpm 1.000	Turn table rotation per round (RPM) setting	Go to 0	Return to beginning position
Reset	Reset current position to 0	Lock Weld	Manual activate welder. First unlock the function by pressing the “Lock” button and press “Weld” button to activate welder.
H / L	Toggle between welding/high turn table speed.	Output-1 1	Force output-1 ON/OFF.
Continue	Jog operation mode. 1. Hold/release the button to rotate. 2. Press to toggle rotation ON/OFF.	Output-2 2	Force Emulator ON/OFF.
Turn table	Turn table jog operation.	Output-3 3	Force dry contact output ON/OFF.
Up Down	Turn table tilting operation.		Switch to welding sequence screen.

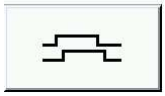
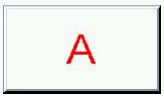
2.3 AUTO MODE



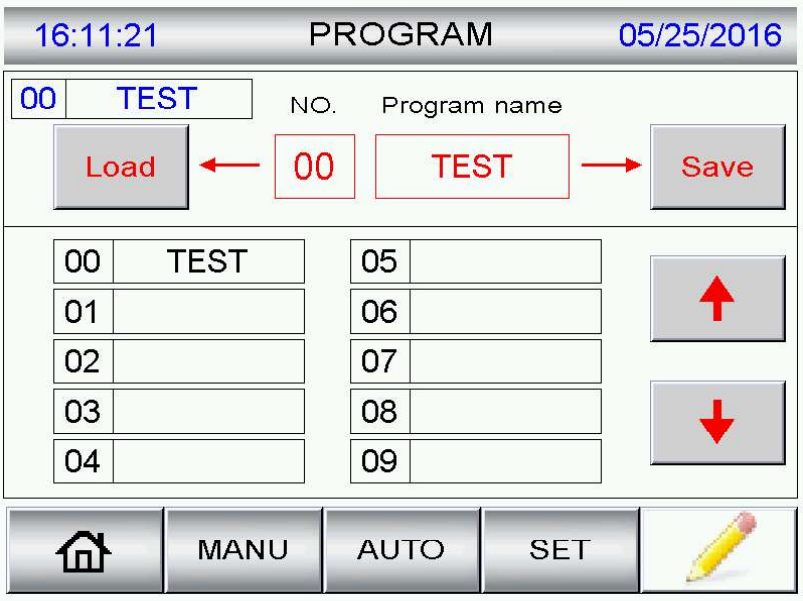
Degree 180.0 170.0	Turn table current position: Blue field: current position. Red field: set position.	mm 314 314	Turn table current position according to angle & diameter: Blue field: current position. Red field: set position.
Rpm 1.000	Turn table rotation per round (RPM) setting.	mm/min 628	Turn table linear speed (mm/min) setting.
Reset	Reset current position to 0	Diameter 200	Welding diameter.
H / L	Toggle between welding/high turn table speed.	Ampere A2 (%) 50.0	Welding current %. 0~100% = 0~15VDC If pulse mode is active, represents the peak %. (please refer to sec 2.8)
Continue	Jog operation mode. 3. Hold/release the button to rotate. Press to toggle rotation ON/OFF.	Voltage CH2 (%) 50.0	Second analog voltage output. 0~100% = 0~15VDC
Turn table	Turn table jog operation.	Weld	Simulation/Auto mode toggle. Welder ON is disable when Simulation mode is active.
	Switch to welding sequence screen.		Activate/stop auto welding sequence.

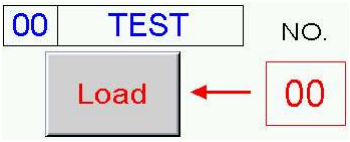
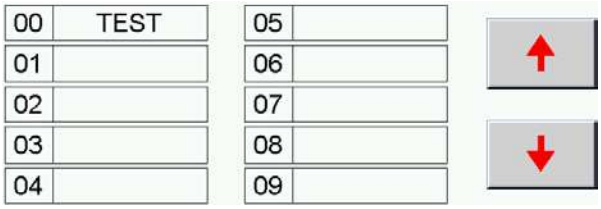
2.4 SETTING



Program 	Switch to Program screen.
Note 	Switch to Program note screen.
Sequence 	Switch to Weld Sequence screen.
Current 	Switch to Weld Current screen.
Index weld 	Switch to Index Weld screen.
Function 	Switch to Autorun function screen.
System 	Switch to system setting screen. User level 1 clearance is required. Default user level 1 clearance password: 123 Default user level 2 clearance password: 456
Backup 	Switch to Program Backup screen.

2.5 PROGRAM SAVE/LOAD

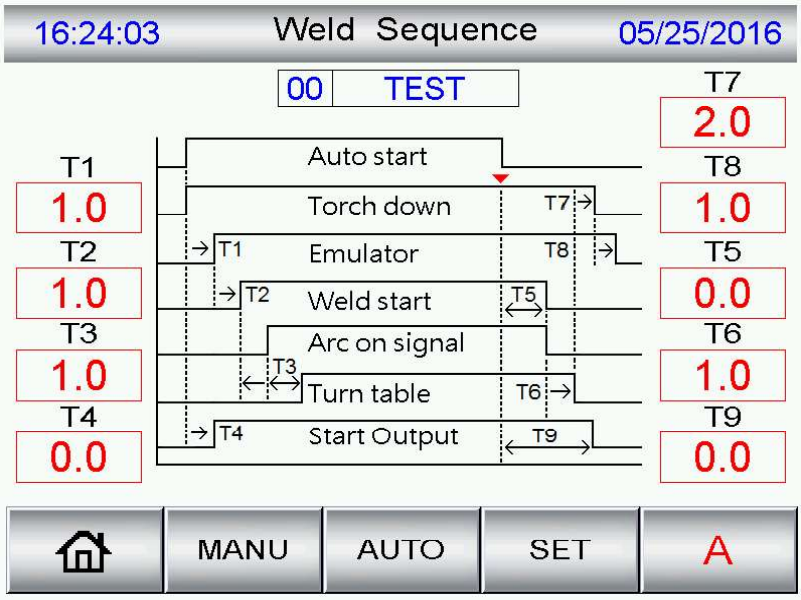


	Enter the program number in No. field and press “Load” button to load the program’s welding parameter.
	Enter the program number and program name, the press “Save” to save the parameters.
	Press ▲ or ▼ button to scroll to next/previous sets of parameters
	Switch to Program note screen.

2.6 PROGRAM NOTE

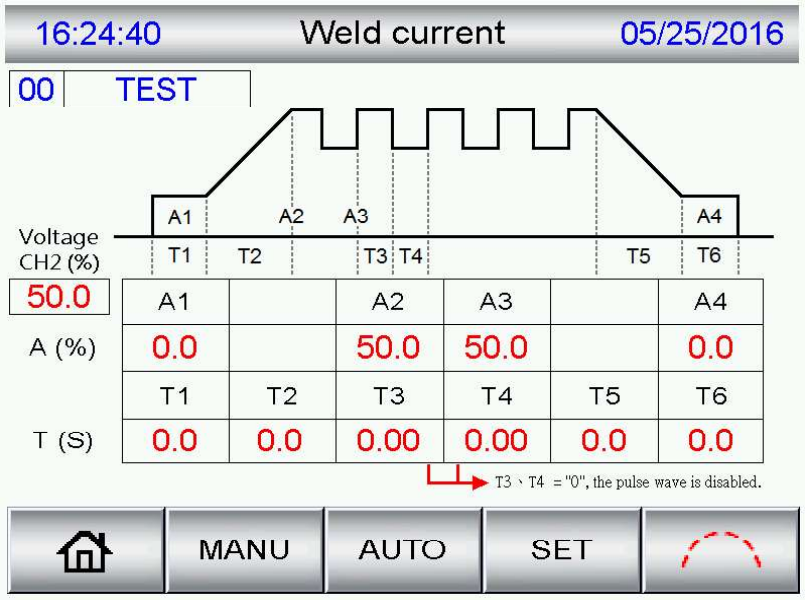
Enter letter or number as program reminder. 10 letters for short field, 24 letters for long field

2.7 WELDING SEQUENCE SETTING



T1	Emulator ON delay after auto start is activated.
T2	Welder ON delay after Emulator is activated.
T3	Turn table rotation delay after arc on signal is received.
T4	Dry contact output ON delay after auto start is activated.
T5	Welder OFF delay after turn table has reached target program position.
T6	Turn table stop delay after welder is OFF.
T7	Torch up delay after turn table is stopped.
T8	Emulator off delay after torch is raised.
T9	Dry contact output OFF delay after turn table has reached target program position.

2.8 WELDING CURRENT SETTING

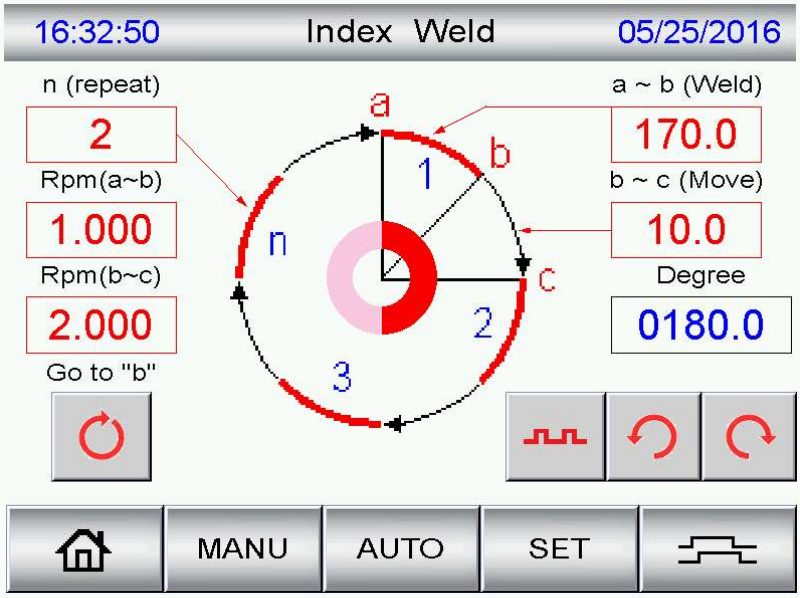


A1	Initial current (%)	0~100%, Initial current level after arc ON signal is received.
A2	Peak current (%)	10~100%, main welding current. If pulse wave function is enabled, this value is the peak current value.
A3	Valley(low) current(%)	0~100%, If pulse wave function is enabled, this value is the low current value. Can't set more than A2
A4	Welding crater current(%)	0~100%
T1	Initial current time(sec)	0~10 sec, initial arc stabilize time after arc ON signal is received.
T2	Rise current time(sec)	0~10 sec, rise time from initial current A1 to peak current A2
T3	Peak current time(sec)	0.01~10 sec, peak current duration before change to valley current.
T4	Valley current time(sec)	0.01~10 sec, valley current duration before change to peak current.
T5	Current fall time(sec)	0~10 sec, amount of time current drop from A2 to A4. The count starts after welder output is switched off.
T6	Welding crater time(sec)	0~10 sec, amount of time for crater current
CH2	Analog voltage(%)	Channel 2 analog voltage 0~100% = 0~15VDC

Note 1: If both T3 & T4 are set to 0, the wave pulse function is disabled.

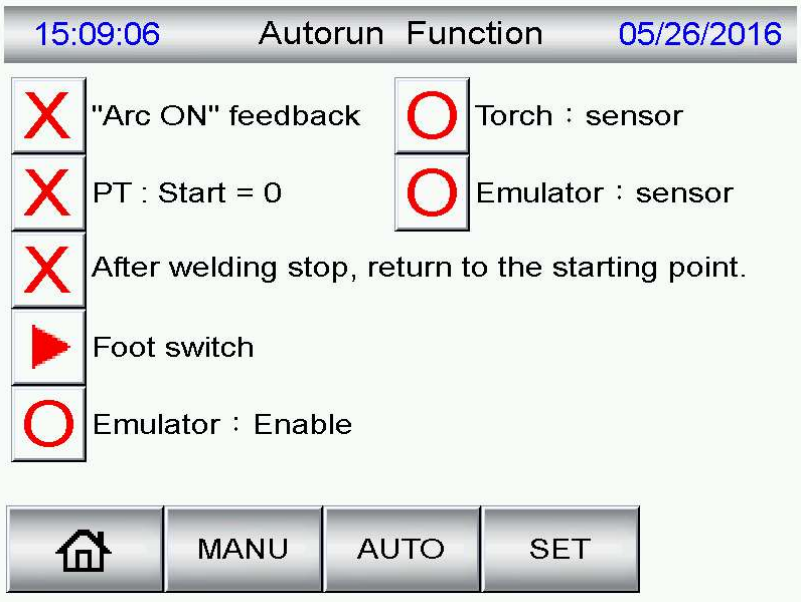
Caution: Even though pulse wave function's output voltage can reach a frequency of 50Hz, the welder may not be able to change current at this rate.

2.9 INDEX WELD SETTING



n (repeat) 2	Set number of index welding
Rpm(a~b) 1.000 a ~ b (Weld) 170.0	a ~ b：Set index welding angle and speed.
Rpm(b~c) 2.000 b ~ c (Move) 10.0	b ~ c：Set positioning angle and speed.
	Turn table jog operation.
Go to "b"	Move to position “b”

2.10 AUTORUN FUNCTION



X O	X：Disable feature O：Enable feature
"Arc ON" feedback	X：Turn table doesn't wait Arc on feedback signal. Turn table start rotation T3 sec after welder on signal is active O：Turn table waits for Arc on feedback signal. Turn table start rotation T3 sec after receiving arc on feedback.
PT：Start = 0	Reset current position to 0 when auto start is activated.
After welding stop, return to the starting point.	Automatically return turn table to original position.
Foot switch	Foot switch function: Rotate CW, rotate CCW, Auto Start.
Emulator：Enable	Activate/disable emulator. When emulator sensor is disabled, emulator sensor is also disabled.
Torch：sensor	Torch sensor enabled. System checks whether torch is raised/lowered before activating emulator (see Sec.2.7)
Emulator：sensor	Emulator sensor enabled. System checks whether emulator is ON/OFF before activating welder(see Sec.2.7)