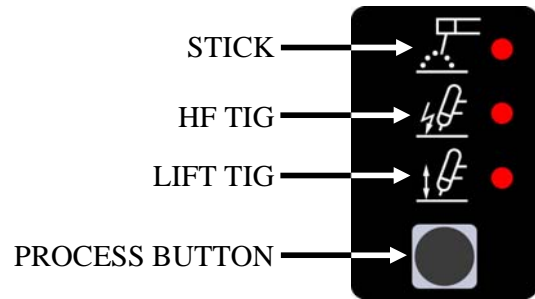


185, 200, 300 ACDC QUICK SET-UP GUIDE

ARCMaster ACDC Front Panel description

Process Functions – Push the Process button to scroll through the three processes: STICK, LIFT TIG, HF TIG. The red LED will light as the process is selected. When in STICK mode the output contactor is activated. A remote device will need to be connected when in TIG mode to activate the output contactor.



TIG Mode Functions – Push the Mode button to scroll through the four TIG modes: STANDARD, SLOPE, SLOPE w/REPEAT, SPOT. The red LED will light as the TIG mode is selected.

STANDARD – TIG operation using remote devices to control contactor and current.

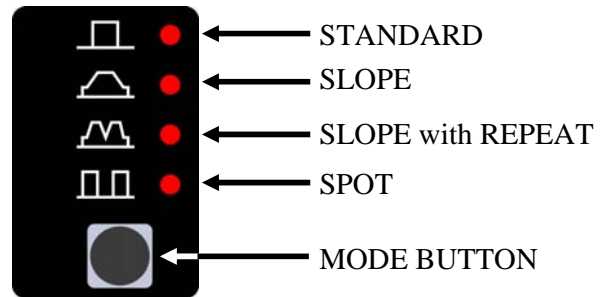
SLOPE – TIG operation using a remote contactor device to step through weld sequence. Sequences include: Initial Current, Up Slope, Weld Current, Down Slope, Final Current.

SLOPE w/REPEAT – Additional Slope function for current control while in the Weld Current sequence activated through the remote ON/OFF device.

For a detailed description of the Slope or Slope w/Repeat functions see your Owner’s Manual under the Slope Mode Sequence section.

NOTE: All Slope functions operate with a Remote ON/OFF switch device only.

SPOT – Timed HF TIG operation using a remote ON/OFF device.

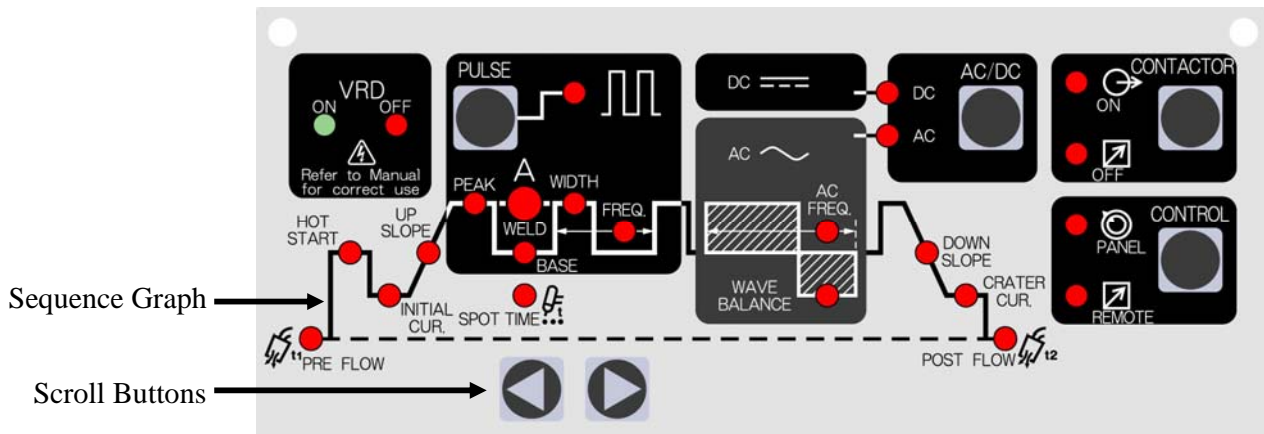


Parameter Functions – Functions are set using the Scroll Buttons and Control Knob.

VRD – Voltage Reduction Device is active when in the STICK process. The green LED will light indicating VRD is activated. When in TIG mode, the red LED will light indicating VRD is inactive.

CONTACTOR button - Pressing this buttons enables CONTACTOR functions to select ON or OFF/REMOTE-ENABLE. Red light is ON when CONTACTOR ON or OFF/REMOTE-ENABLE is selected.

CONTROL button - Pressing this buttons enables amperage control to select PANEL or REMOTE. Red light is ON when PANEL or REMOTE is selected.

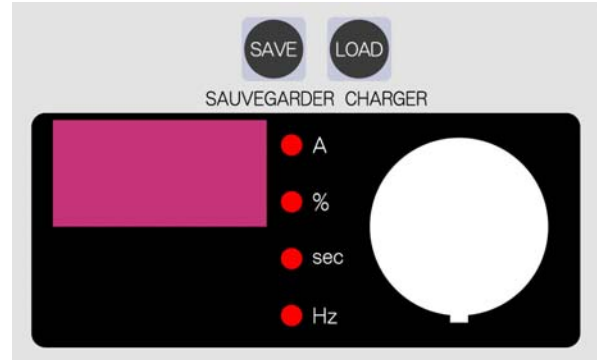


Scroll Buttons – Used to step through the Sequence Graph. The red LED will light to indicate parameter to be set.

AC/DC - Push the AC/DC button to select DC (direct current) output or AC (alternating current) output. The red LED will light to indicate the output selected. When AC output is selected the Wave Balance and AC output Frequency Parameters are active and can be set through the control knob when selected with the scroll buttons.

Pulse - Pushing the Pulse button turns ON or OFF the Current Pulser. The red LED will light when the Current Pulser is active. With the Pulser active the Peak Current, Base Current, Pulse Width and Pulse Frequency can be set through the Control Knob when selected with the scroll buttons. Selection is indicated when the green LED lights.

Digital LED Display – Welding current and parameter values are displayed in this window. The display will show settings in Hertz (Hz), Seconds (SEC), Percent (%), Amperage (A) indicated by the lighted LED above the screen. Internal warnings such as over temperature, low or high input voltage applied are signaled to the operator by a warning sound and error message on the screen. The warning sound will activate when the power source is turned off.



Control Knob – Allows the operator to adjust the output current within the entire range of the power supply, also used to set each parameter value in the Sequence Graph. Pushing the knob inward displays the actual welding voltage.

Save Load Buttons - A total number of 5 programs can be saved into the 300ACDC memory. To *SAVE* the Current Weld Parameters into Memory press the *SAVE* button for about 2 seconds, Select a memory location by rotating the control knob, 1 to 5 is displayed on the meter. After selecting the desired memory location (ie 1 to 5), press the right scroll button and the machine will give a beep to confirm the weld parameters from the control panel are saved. To *LOAD* (retrieve) a Program to the Control Panel press the *LOAD* button for about 2 seconds, select a memory location by rotating the control knob, 1 to 5 is displayed on the meter. After selecting the desired memory location (ie 1 to 5), press the right scroll button and the machine will give a beep to confirm the weld parameters are loaded onto the control panel.

Detailed description of each parameter can be found in the Owner's Manual.

ARCMaster ACDC SETTINGS

Equipment: 300ACDC power supply with TIG kit, argon shielding gas, 3/32" 2% thoriated tungsten (red) or lanthanated (gray) ground to a 30 degree prep.

Aluminum: AC current

1/16" (.062) – pre-flow .1 sec., hot start 20, amperage 70, Hz 100, balance 20%, post-flow 6.0 sec.

For pulse settings - set pulse width 60%, peak current 100, background current 30, Hz 1.0

1/8" (.125) - pre-flow .1 sec., hot start 20, amperage 150, Hz 80, balance 20%, post-flow 6.0 sec.

For pulse settings – set pulse width 60%, peak current 150, background current 50, Hz 1.0

3/16"-1/4" - pre-flow .1 sec., hot start 20, amperage 185, Hz 60, balance 20%, post-flow 8.0 sec.

For pulse settings – set pulse width 60%, peak current 185, Background current 125, Hz 1.0

Mild Steel or Stainless Steel: DC current

1/16" (.062) – pre-flow .1 sec., hot start 20, amperage 70, post-flow 6.0 sec.

For pulse settings - set pulse width 60%, peak current 80, background current 30, Hz 1.0

1/8" (.125) - pre-flow .1 sec., hot start 20, amperage 125, post-flow 6.0 sec.

For pulse settings – set pulse width 60%, peak current 125, background current 50, Hz 1.0

3/16"-1/4" - pre-flow .1 sec., hot start 20, amperage 185, post-flow 8.0 sec.

For pulse settings – set pulse width 60%, peak current 185, Background current 75, Hz 1.0