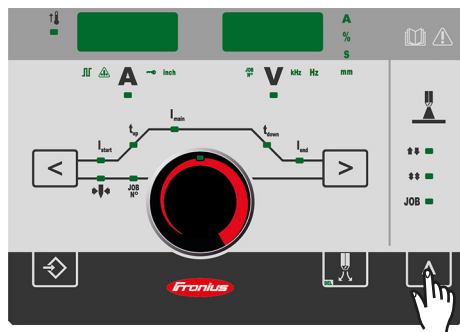
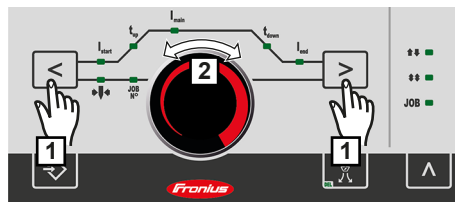


1. Select the operating mode



- 2-step mode:**
 Start: $I_{start} - t_{up} - I_{main}$
 Stop: $t_{down} - I_{end}$
- 4-step mode:**
 Start: I_{start}
 Stop: $t_{up} - I_{main}$
 Start: $t_{down} - I_{end}$
 Stop: End
- JOB** Job Mode

2. Set the process parameters

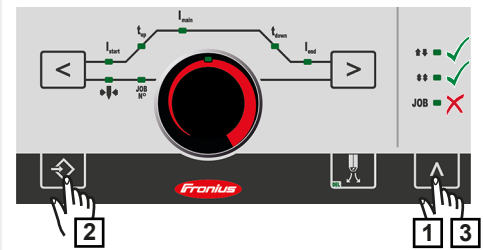


- 1 Press button to select the desired parameter
- 2 Turn selection dial to set the parameter

Process parameters

I_{start}	Starting current
t_{up}	Up-Slope
I_{main}	Main current
t_{down}	Down-Slope
I_{end}	Final current
JOB N°	Job number
	Electrode diameter

Access / exit the Setup Menu



- 1 Select 2-step or 4-step mode
- 2 Press and hold
- 3 Press

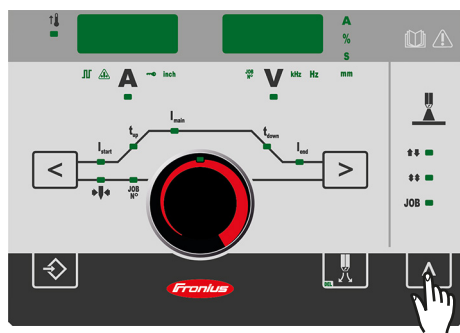
Access the Gas Menu



Exit the Setup Menu / Gas Menu

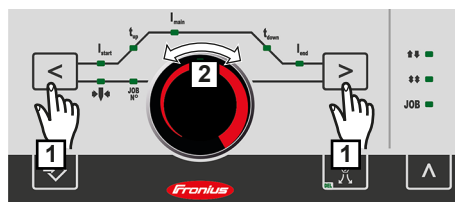


1. Select the operating mode



- 2-step mode:**
 Start: $I_{start} - t_{up} - I_{main}$
 Stop: $t_{down} - I_{end}$
- 4-step mode:**
 Start: I_{start}
 Stop: $t_{up} - I_{main}$
 Start: $t_{down} - I_{end}$
 Stop: End
- JOB** Job Mode

2. Set the process parameters

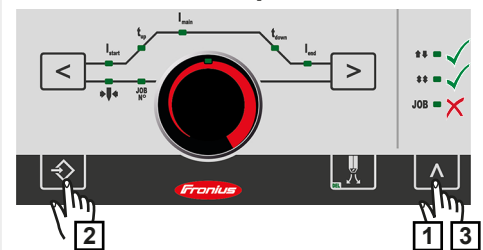


- 1 Press button to select the desired parameter
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Process parameters

I_{start}	Starting current
t_{up}	Up-Slope
I_{main}	Main current
t_{down}	Down-Slope
I_{end}	Final current
JOB N°	Job number
	Electrode diameter

Access / exit the Setup Menu

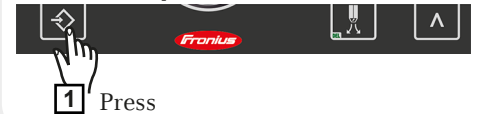


- 1 Select 2-step or 4-step mode
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- 3 Press

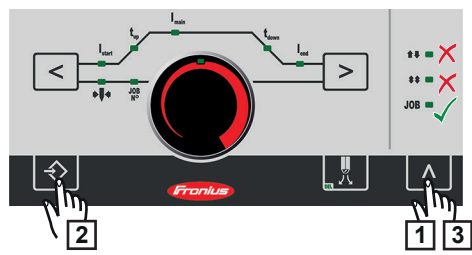
Access the Gas Menu



Exit the Setup Menu / Gas Menu



Access / exit the Job Correction Menu



- 1 Select Job Mode
- 2 Press and hold
- 3 Press

Exit the Job Correction Menu



- 1 Press

Setup Menu

- F-P* Pulse frequency ¹⁾
- dcY* Dutycycle ^{1) 2)}
- i-G* Base current ^{1) 2)}
- t-S* Starting current time ¹⁾
- t-E* Final current time ¹⁾
- FR* Reset plasma system
- 2nd* 2nd Level Setup Menu

2nd Level Setup Menu

- ε-ε* Cooling unit controls
- ε-t* Cooling time
- HFE* High Frequency time
- Pr* Delayed ignition for immediate high frequency start
- εor* Gas correction ^{1) 3)}
- r* Plasma system resistance
- L* Plasma system inductance
- i t o* Ignition time out
- RR* Arc break monitoring
- SE* Country-specific setting
- E-P* External parameter
- RC* Main current changeover

Gas Menu

- εPr* Gas pre-flow time ¹⁾
- ε-L* Gas post-flow time at minimum process current ¹⁾
- ε-H* Gas post-flow time at maximum process current ¹⁾
- εRS* Set value for gas flow ^{1) 3)}
- εPU* Gas purging

Job Correction Menu

- εLd* Diameter of electrode
- i-S* Starting current
- UP* Up-Slope
- i-i* Main current
- dSL* Down-Slope
- i-E* Final current
- JSL* Job-Slope
- εr* Operating mode selection
- i-ε* *I_{main}* correction range

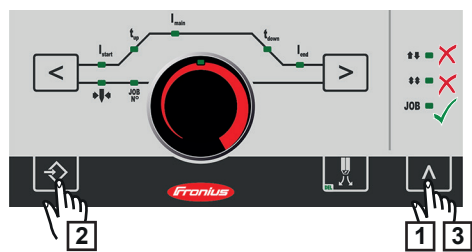
¹⁾ The parameter is also available in the Job Correction Menu
²⁾ Only available if parameter "F-P" (pulse frequency) is not "oFF"
³⁾ Only available if an external gas regulator is connected

SAFETY



Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

Access / exit the Job Correction Menu



- 1 Select Job Mode
- 2 Press and hold
- 3 Press

Exit the Job Correction Menu



- 1 Press

Setup Menu

- F-P* Pulse frequency ¹⁾
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