

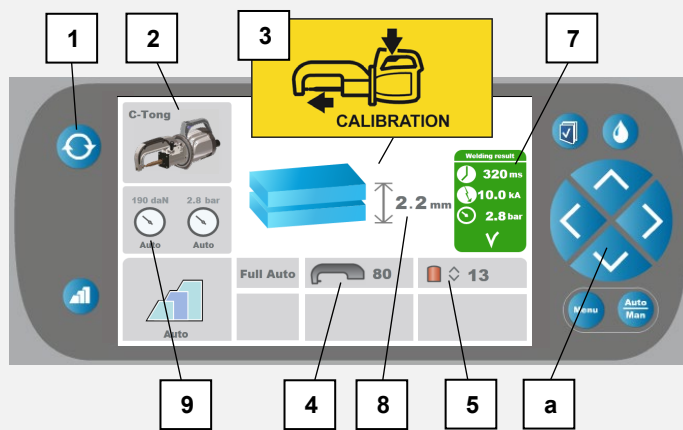
Fully Automatic mode (default mode)

In this mode all values are automatically set, except caps.

1 Turn the main switch "ON"

2

1. Select tool by pressing the "Change tool" button.
2. Selected tool is displayed, in the given example the C-Tong.
3. "Calibrate electrodes" will be displayed when entering "Full auto", see *Instruction manual, section 8.2 Display information messages*.
4. Fitted (automatically detected) yoke is displayed.
5. Select caps by pressing "up/down" button [a]. Check that cap size is matching your setting.
6. Start welding by pressing C-Tong trigger.
7. Successfull welding! If welding is faulty, a red box with "X" is displayed. A buzzing sound and red light in the handle display also helps to indicate faulty welding.
8. After welding, measured material thickness is displayed.
9. Displayed electrode force (daN) and air pressure (bar).



IMPORTANT! Calibration must be done with copper clean electrode cap, without work piece (electrode to electrode).

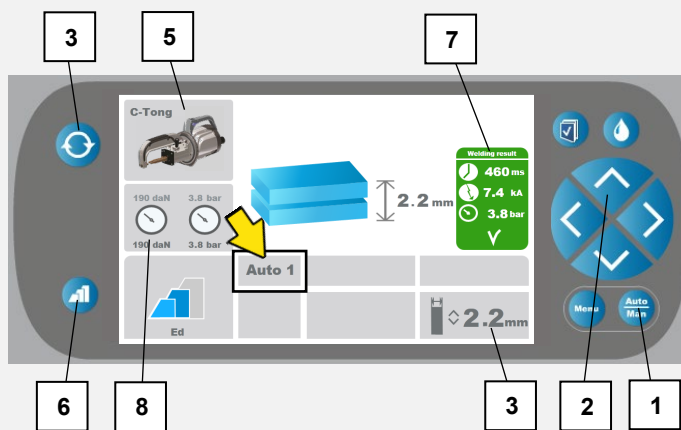
Auto 1 mode

In this mode all values are automatically set, except the total material thickness which has to be manually set.

1 Turn the main switch "ON"

2

1. Set the "Auto 1" mode by pressing the "Auto/Man" button. With this button you can toggle between "Auto 1", "Auto 2" and "Manual" modes.
2. Set the material thickness by pressing the "up/down" buttons.
3. Material thickness is displayed
4. Select tool by pressing the "Change tool" button.
5. Selected tool is displayed, in the given example the C-Tong.
6. Pre pulse – select type of coating (see *Instruction manual, section 6.5 Pre pulse*)
7. Successfull welding! If welding is faulty, a red box with "X" is displayed. A buzzing sound and red light in the handle display also helps to indicate faulty welding.
8. Displayed electrode force (daN) and air pressure (bar).



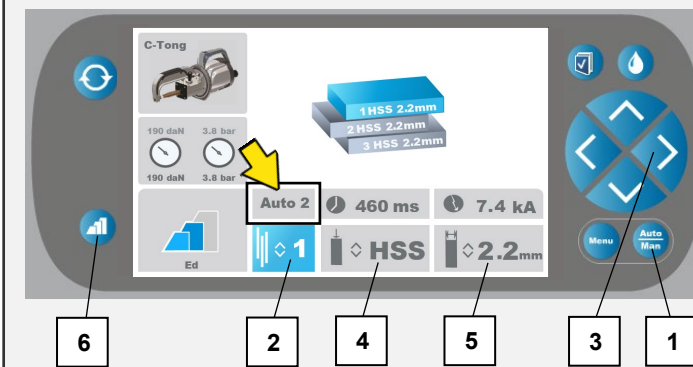
Auto 2 mode

In this mode you can individually set number of metal sheets, type of material and total material thickness. Tool selection and pre pulse function similar to "Auto 1".

1 Turn the main switch "ON"

2

1. Set the "Auto 2" mode by pressing the "Auto/Man" button.
2. Set the number of metal sheets. Change number of metal sheets by using the up/down buttons.
3. Select "Set the type of material" by pressing the "right/left" buttons.
4. Set the type of material by pressing the "up/down" buttons.
5. Set the material thickness by pressing the "up/down" buttons.
6. Pre pulse – select type of coating (see *Instruction manual, section 6.5 Pre pulse*).



Manual mode

In this mode all settings are the same as in "Auto 2" except for the settings of welding time, welding current and electrode force that can be manually set.

1 Turn the main switch "ON"

2

1. Set the "Manual" mode by pressing the "Auto/Man" button.
2. Set the welding time by pressing the "left" button twice when you are in "Number of metal sheets" position. Change value by using "up" or "down" button.
3. Set the welding current by pressing the "left" button when you are in "Number of metal sheets" position. Change value by using "up" or "down" button.
4. Set the air pressure by pressing the "left" button. Change value by using "up" or "down" button.
5. Electrode force (daN) and air pressure is displayed.

