

# SYN Parameter

Program	Wire Size	Wire Type	Shielding Gas	Drive Roller Type	Torch / Earth Connection	Polarity Setup	Functions																																													
0	Manual (Non-Synergic)		Refer to relevant application below.																																																	
1	0.6mm	Solid Fe	Mixed (Argon + CO <sup>2</sup> )	V-groove		Stick (MMA)	<table border="1"> <thead> <tr> <th>Display</th> <th>Description</th> <th>Symbol</th> </tr> </thead> <tbody> <tr> <td colspan="3">MIG MODE</td> </tr> <tr> <td><i>PrG</i></td> <td>Pre-Gas Time (sec)</td> <td></td> </tr> <tr> <td><i>PosG</i></td> <td>Post-Gas Time (sec)</td> <td></td> </tr> <tr> <td><i>SFT</i></td> <td>Soft Start Adjustment</td> <td></td> </tr> <tr> <td><i>bUB</i></td> <td>Burnback Adjustment</td> <td></td> </tr> <tr> <td><i>SPL</i></td> <td>Spot/Stitch Weld Time (sec)</td> <td></td> </tr> <tr> <td><i>SRP</i></td> <td>Stitch Weld Gap/Interval Time (sec)</td> <td></td> </tr> <tr> <td><i>SPo</i></td> <td>Spool Gun (On/Off)</td> <td></td> </tr> <tr> <td colspan="3">TIG MODE</td> </tr> <tr> <td><i>PosG</i></td> <td>Post-Gas Time (sec)</td> <td></td> </tr> <tr> <td><i>SLo</i></td> <td>Slope Up Time (sec)</td> <td></td> </tr> <tr> <td colspan="3">STICK (MMA) MODE</td> </tr> <tr> <td><i>Hot</i></td> <td>Hot Start Adjustment</td> <td></td> </tr> <tr> <td><i>ArC</i></td> <td>Arc Force Adjustment</td> <td></td> </tr> </tbody> </table>	Display	Description	Symbol	MIG MODE			<i>PrG</i>	Pre-Gas Time (sec)		<i>PosG</i>	Post-Gas Time (sec)		<i>SFT</i>	Soft Start Adjustment		<i>bUB</i>	Burnback Adjustment		<i>SPL</i>	Spot/Stitch Weld Time (sec)		<i>SRP</i>	Stitch Weld Gap/Interval Time (sec)		<i>SPo</i>	Spool Gun (On/Off)		TIG MODE			<i>PosG</i>	Post-Gas Time (sec)		<i>SLo</i>	Slope Up Time (sec)		STICK (MMA) MODE			<i>Hot</i>	Hot Start Adjustment		<i>ArC</i>	Arc Force Adjustment	
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Instructions			
MIG Program Selection	Function Adjustment	Job Saving	Job Recalling
<ol style="list-style-type: none"> <li>Press 'P'</li> <li>Rotate Right knob to choose program (refer to chart above ↑)*</li> <li>Press 'P'</li> <li>Press Right knob once</li> <li>Rotate Right knob to choose material thickness</li> </ol> <p>*Program '0' is traditional Manual MIG mode which allows you to manually adjust volts and wire speed. Steps 4-5 do not apply to Program '0'</p>	<ol style="list-style-type: none"> <li>Press 'FN'</li> <li>Rotate Left knob to select Function (refer to Functions chart above ↗)*</li> <li>Rotate Right knob to adjust the parameters for this Function</li> </ol>	<ol style="list-style-type: none"> <li>Set all desired settings</li> <li>Press 'Save'</li> <li>Rotate right knob to choose Job number</li> <li>Press 'Save'</li> </ol>	<ol style="list-style-type: none"> <li>Press 'Recall'</li> <li>Rotate right knob to choose Job number</li> <li>Press 'Recall'</li> </ol>

Job Number Register			
Job No.	Description	Job No.	Description
1		11	
2		12	
3		13	
4		14	
5		15	
6		16	
7		17	
8		18	
9		19	
10		20	