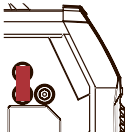
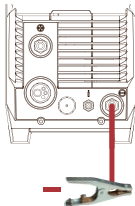
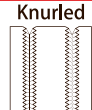


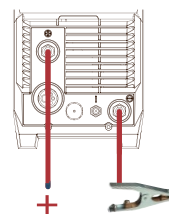
SYN Parmeter

Synergic MIG Program Chart

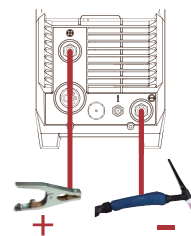
Program	Wire Size	Wire Type	Shielding Gas	Drive Roller Type	Torch Connection	Earth Connection
0	Manual (Non-Synergic)		Refer to relevant application below.			
1	0.6mm	Solid Fe	CO ²	V-groove 	 +	
2	0.8mm					
3	0.9mm					
4	1.0mm					
5	0.6mm		(Argon + CO ²)			
6	0.8mm					
7	0.9mm					
8	1.0mm					
9	0.8mm	Flux Cored Steel	CO ²			
10	0.9mm					
11	1.0mm					
12	0.8mm	Stainless Steel	98%Ar+2% CO ²	V-groove 		
13	0.9mm					
14	1.0mm					
15	0.8mm	AL Mg	Argon	U-groove 		
16	0.9mm					
17	1.0mm					
18	0.8mm	Cu si	Argon	V-groove 		

Polarity Setup

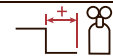
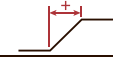
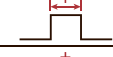
Stick (MMA)



TIG



Functions

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>Spt</i>	Spot/Stitch Weld Time (sec)	
<i>GAP</i>	Stitch Weld Gap/Interval Time (sec)	
<i>Ind</i>	Inductance Adjustment	

Instructions

MIG Program Selection	Function Adjustment	Job Saving	Job Recalling
- Press 'P' - Rotate Right knob to choose program (refer to chart above ↑)* - Press 'P' - Press Right knob once - Rotate Right knob to choose material thickness *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'	- Press 'FN' - Rotate Left knob to select Function (refer to Functions chart above ↗)* - Rotate Right knob to adjust the parameters for this Function	- Set all desired settings - Press 'Save' - Rotate right knob to choose Job number - Press 'Save'	- Press 'Recall' - Rotate right knob to choose Job number - Press 'Recall'

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	