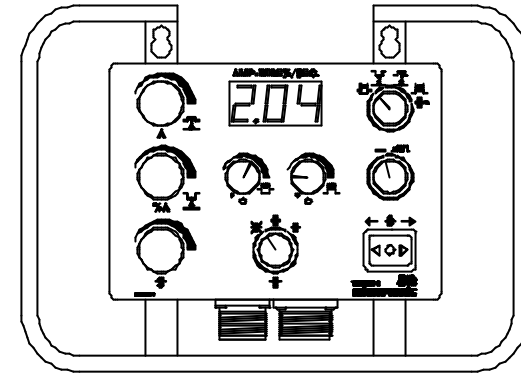# Instructions Manual for

Pulse Remote Control

76118911-1

This pulse remote control is designed to be used together with Migatronic's TIG & Plasma welding machines, with or without a cold wire feed unit. The remote control may also be connected to a robot system, which allows you to control the below from the robot:

- Welding current
- Wire speed (filler wire)
- Interruption of the pulse welding during the welding course, (if the remote control is set to pulse welding)
- Interruption of step for the filler wire, (if the remote control is set to step on the wire)
- Control of wire forward and backwards

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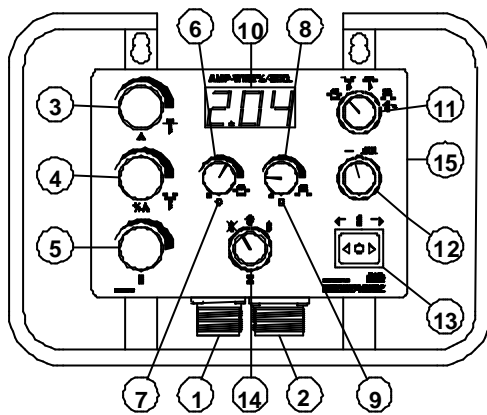
The following description refers to the above drawing.

Before the remote control is taken into application, it should be calibrated to match the welding machine to which it is connected. The calibration is effected in the following manner:

⇒ Turn the switch pos. 11 to pos. 3, so the pulse current may be read on the display pos. 10.

⇒ Turn the button pulse current pos. 3 to max. (If the remote control is applied together with a robot, the robot is set to give the max. welding current).

⇒ Remove the rubber button pos. 15, and set with a small screw driver the trimmer behind the rubber button, so the display shows the max. welding current of the welding machine. The remote control is now calibrated, and the rubber button can be put back.

Description of the Functioning:

Pos. 1: Connection of an 8 pole cable (74340003-0, 5 meter) between the remote control and the welding machine (When the remote control is applied without a cold wire feed unit. A cold wire feed unit MUST NOT be connected to the plug pos. 2 at the same time).

Pos. 2: Connection of a 19 pole cable (74341011-0, 6 meter) between the remote control and the cold wire feed unit. (A welding machine MUST NOT be connected to the plug pos. 1 at the same time, please confer with the operations manual for the cold wire feed unit.

Pos. 3: * Setting of pulse current. The setting may be read on the display pos. 10. Please also confer with the description for pos. 11.The pulse current is the "high" current, when pulsing is effected on the current.

Pos. 4: Setting of the basic current. The setting may be read on the display pos. 10. Please also confer with the description for pos. 11. The basic current is the "low" current, when pulsing is effected on the current.

Pos. 5: *Setting of wire speed. The setting may be read on the display pos. 10. Please also confer with the description for pos. 11. (This button is only applied, if the remote control is connected to a cold wire feed unit).

Pos. 6: Setting of basic current time/interval on wire. The setting may be read on the display pos. 10. Please also confer with the description for pos. 11.

Pos. 7: Lamp / light diode indicating that the basic current time/wire static is active

Pos. 8: Setting of pulse current time/time with running wire. The setting may be read on the display pos. 10. Please also confer with the description for pos. 11.

Pos. 9: Lamp / light diode indicating that the pulse current time/wire running is active.

Pos.10: Digital reading of the parameter setting. Ensures that the known welding parameters may be recreated. Please also confer with the description for pos. 11.

Pos.11: Selection of parameter reading:

Basic current time at pulse welding Time where wire stands still (step on wire)	0.05-2.35 sec.	±20%
Basic current in % of the pulse current	0-100%	
Reading of pulse current	Amps	
Pulse current time at pulse welding Time where wire is running (step on wire)	0.05-2.35 sec.	± 20%
Wire speed in % of max. speed	0-100%	

Pos.12: With or without pulse welding. ```- - - -``` =without pulse, **AПП** = with pulse.

Pos.13: Manual wire forward and backwards during setting. ← = return, → = forward.

Pos.14: Control of the filler wire. ✖ = No wire. = The wire runs continuously, when the arc is established. = The wire runs in step, i.e. the wire runs during welding with pulse current. The wire may however also run in step, even though pulse welding has not been selected.

Pos.15: Adjustment of max. current.

* If the remote control is applied together with a robot system, the button will be disconnected, as the pulse current/wire speed then will be controlled from the robot.

Technical Data:

Mains voltage G & H:	16-35V AC/DC
Effect:	Max. 5W
Weight:	2.30 kg
Dimensions h*w*d. with rack:	225*310*90 mm max.