

# ACCUPOCKET 150/400 TIG

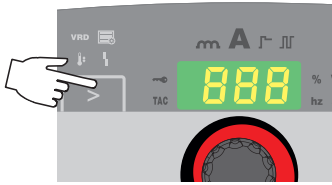
## Quick reference

### SAFETY



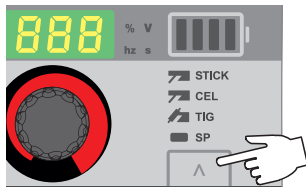
Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online.

### WELDING SETTINGS



#### Setting values:

- ⇒ **m** Arc-force dynamic: 0 - 100 | factory setting = 20
- ⇒ **A** Welding current: 10 - 140 A (STICK), 3 - 150 A (TIG)
- ⇒ **⌋** SoftStart / HotStart function: 0 - 200% | factory setting = 130%
- ⇒ **⌋⌋** TIG pulsing: OFF / 0.5 - 10 Hz Factory setting = OFF



#### Available welding processes:

- ⇒ **STICK** MMA welding
- ⇒ **CEL** MMA welding with Cel electrode
- ⇒ **TIG** TIG welding
- ⇒ **SP** Reserved for special programs



42,0426,0247,EN 002-08082017

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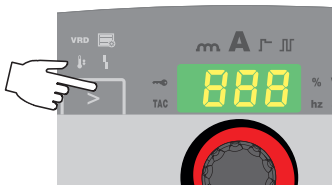
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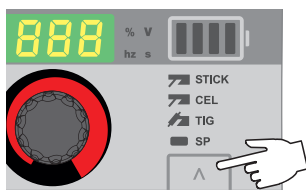
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## ACCESSING THE SETUP MENU



Setup menu - MMA welding



Setup menu - Cel electrodes



Setup menu - TIG



## CHANGING WELDING PARAMETERS

Turn and press the adjusting dial to select and change parameters.

### PARAMETERS FOR MMA WELDING

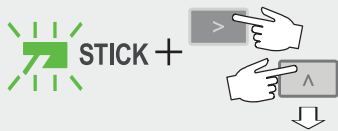
<b>Ht<sub>i</sub></b>	Starting current duration: 0.1 - 1.5 seconds   0.5 seconds*
<b>AS<sub>t</sub></b>	Anti-stick: On*/OFF
<b>U<sub>co</sub></b>	Break voltage: 25 - 80 V   45 V*
<b>SOF</b>	Software version
<b>t<sub>sd</sub></b>	Automatic switch-off: 300 - 900* seconds / OFF
<b>FAC</b>	Factory setting

\* factory setting

### PARAMETERS FOR TIG WELDING

<b>t<sub>ri</sub></b>	Mode: OFF/2-step*/4-step
<b>I-S</b>	Starting current: 1 - 200%   50%*
<b>I-2</b>	Reduced current: 1 - 200%   50%*
<b>I-E</b>	Final current: 1 - 100%   50%*
<b>GP<sub>o</sub></b>	Gas post-flow time: 0.2 - 9.9* seconds
<b>CS<sub>s</sub></b>	Comfort Stop sensitivity: 0.3 - 2.0 V / OFF*
<b>U<sub>co</sub></b>	Break voltage: 12 - 35 volts   15 volts*
<b>t<sub>AC</sub></b>	Tacking function: OFF* / 0.1 - 5.0 seconds
<b>SOF</b>	Software version
<b>t<sub>sd</sub></b>	Automatic switch-off: 300 - 900* seconds / OFF
<b>FAC</b>	Factory setting

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