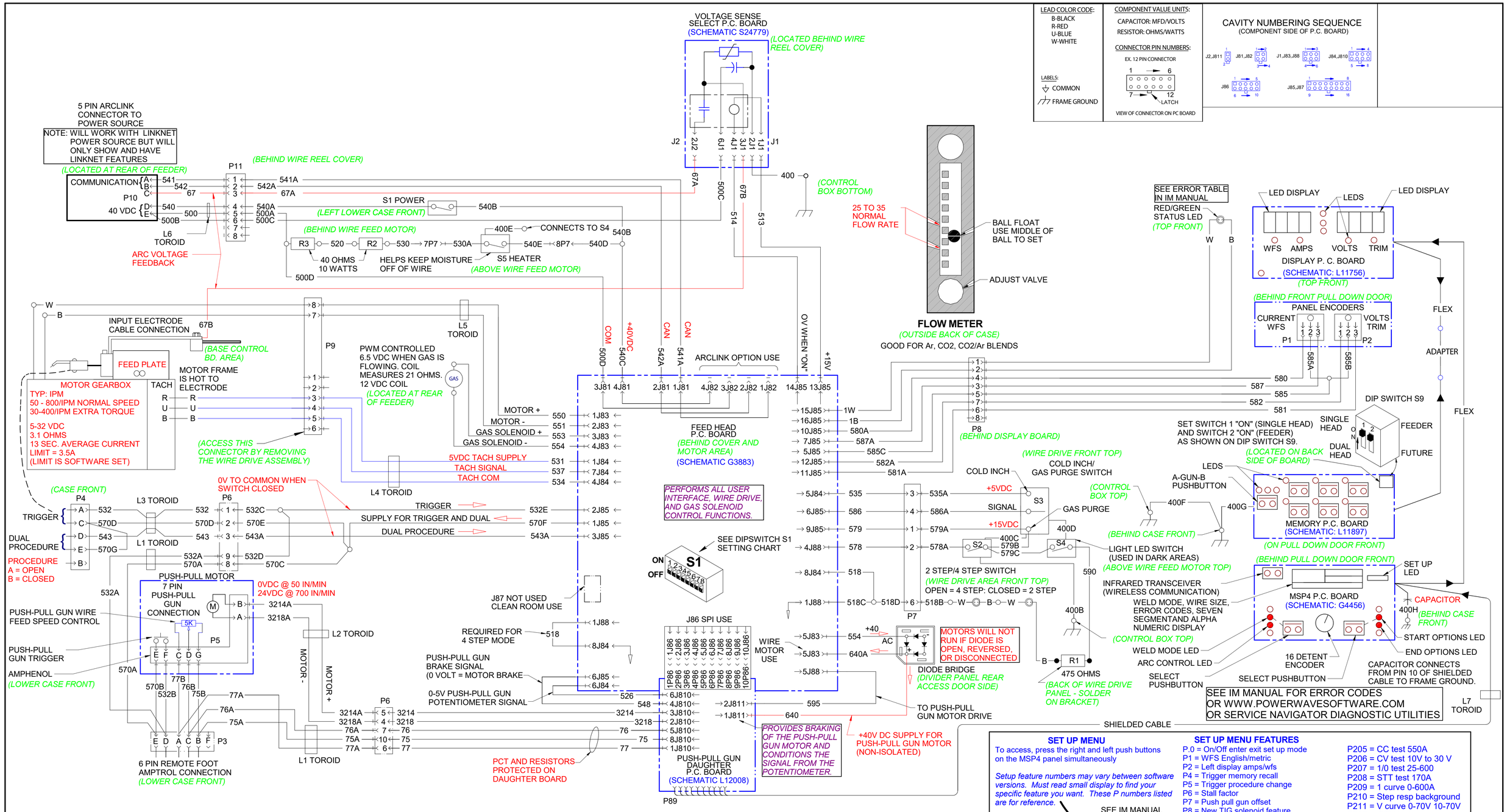
POWER FEED 25M MACHINE SCHEMATIC G5638 REV: A



GENERAL			
	GMAW	STD. CV	5
CV	GMAW	POWER MODE	40
	FCAW	STD. CV	6
	STICK	SOFT (7018)	1
	STICK	CRISP (6010)	2
CC	TIG	TOUCH START	3
	GOUGE	---	9

STEEL		0.030	0.035	0.045	0.052
GMAW	CO2	---	10	20	24
GMAW	Ar (MIX)	94	11	21	25
PULSE (CRISP)	Ar (MIX)	95	12	22	26
PULSE (SOFT)	Ar (MIX)	---	14	19	28
STT (NO TAIL OUT)	CO2 Ar/CO2	109	109	125	125
STTII	CO2 Ar/CO2	110	110	126	126

STAINLESS		0.030	0.035	0.045
GMAW	Ar (MIX)	61	31	41
GMAW	Ar/He/CO2	63	33	43
PULSE	Ar/CO2	66	36	46
PULSE	Ar/O2	62	32	42
PULSE	Ar/He/CO2	---	34	44
STT	Ar/He/CO2	109	109	125
STTII	Ar/He/CO2	110	110	126

ALUMINUM			0.035	3/64	1/16
4043	GMAW	Ar	148	71	73
	PULSE	Ar	149	72	74
	PULSE ON PULSE	Ar	98	99	100
5356	GMAW	Ar	151	75	77
	PULSE	Ar	152	76	78
	PULSE ON PULSE	Ar	101	102	103

METAL CORE		0.045	0.052	1/16
GMAW	Ar/CO2	81	83	85
PULSE	Ar/CO2	82	84	86

DIP SWITCH S1 SETTING CHART

TOGGLE NO.	FUNCTION	OFF DEF.	ON DEF.
1	SPARE		
2	SPARE		
3	SPARE		
4	SPARE		
5	SPARE		
6	SPARE		
7	POLARITY	POS	NEG
8	FEED SPEED GEAR	LOW SPEED EXTRA TORQUE	NORMAL SPEED

SERIAL NUMBER AND CODE NUMBER LOCATED BELOW WIRE FEED DRIVE ROLL AREA

SET UP MENU

To access, press the right and left push buttons on the MSP4 panel simultaneously

Setup feature numbers may vary between software versions. Must read small display to find your specific feature you want. These P numbers listed are for reference.

SEE IM MANUAL FOR MORE DETAILS

SET UP MENU FEATURES

P.0 = On/Off enter exit set up mode
P1 = WFS English/metric
P2 = Left display amps/wfs
P4 = Trigger memory recall
P5 = Trigger procedure change
P6 = Stall factor
P7 = Push pull gun offset
P8 = New TIG solenoid feature
P80-89 = Senses from studs on S25629-09
P99 = Show test mode 200.201
P100 = View diagnostics
P102 = Fatal log
P103 = View software
P104 = Hardware version
P105 = Welding software
P200 = CC test 25-600
P201 = CV test 10-35
P202 = CC test 10A
P203 = CC test 355A
P204 = CC test 455A
P205 = CC test 550A
P206 = CV test 10V to 30 V
P207 = 1/0 test 25-600
P208 = STT test 170A
P209 = 1 curve 0-600A
P210 = Step resp background
P211 = V curve 0-70V 10-70V
P212 = OCV test
P215 = Touch sense
P255 = Show weld file