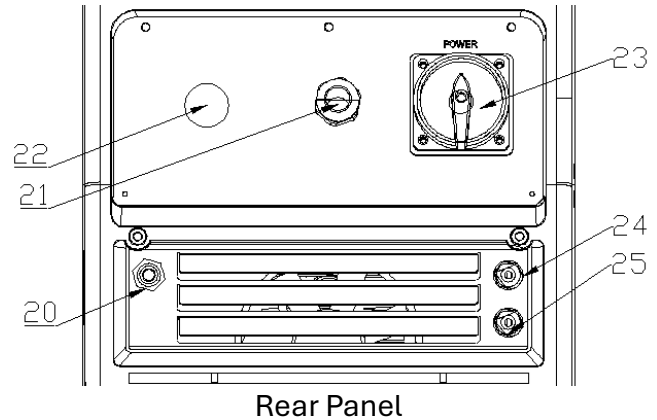
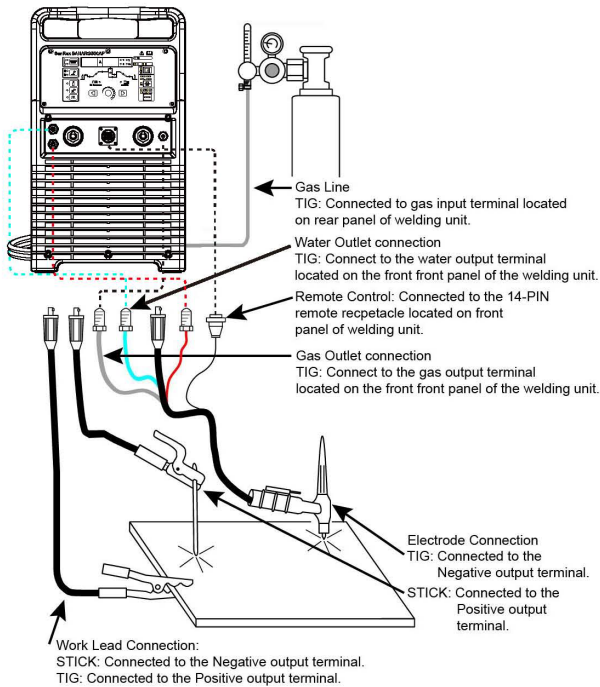


500 ACDC Setup Guide

Water-cooled TIG system start up settings using Foot Control. Refer to Operation manual for detail operation.



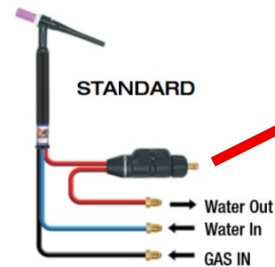
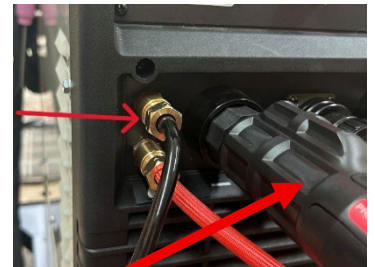
20. Gas input receptacle.

24. Coolant in from Water cooler. Supplied Blue hose with quick disconnect.

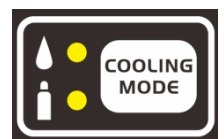
25. Coolant out to Water cooler. Supplied Red hose with quick disconnect.

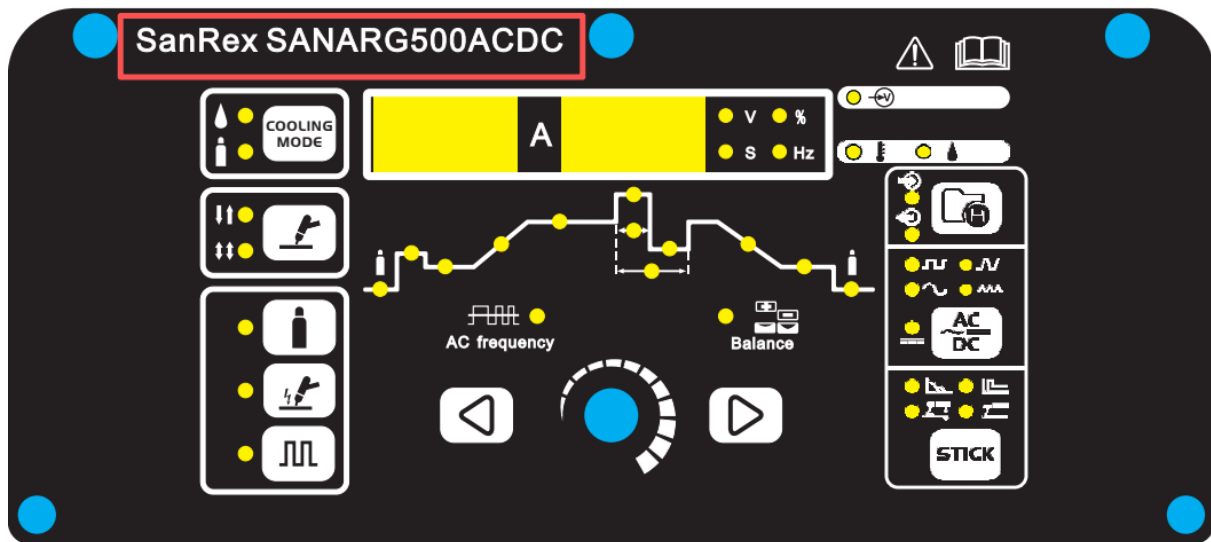
Front Panel TIG connections.

- Torch coolant connections – Located left of Negative output receptacle. Upper coolant fitting is coolant pump supply to TIG Torch (Represented by Red arrow). Lower Red coolant hose is coolant returning from TIG Torch through Power block connected to Negative output receptacle of the power supply. Your TIG Torch hose colors may be different than what is shown.

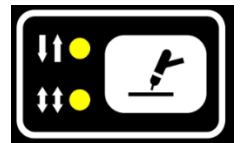


- Turn ON Water cooler power ON/OFF switch. Located on the lower right front panel of the water cooler.
- Cooling Mode is located on the upper left of the 500 ACDC front panel. Push button to light the top eye drop symbol.





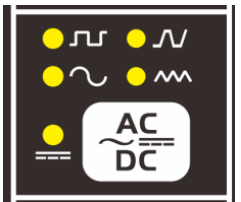
- 2T/4T to 2T position. Push button to light the top Symbol.



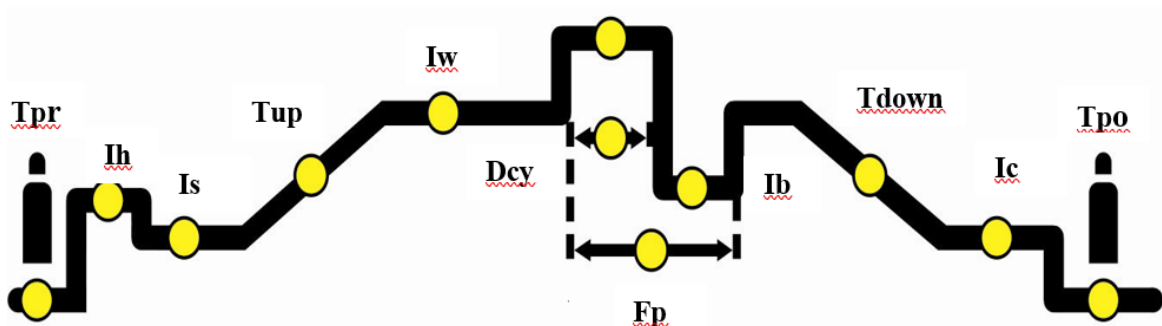
- TIG Start Mode. Lift or HF TIG Start. HF TIG Start mode with Indicator Light ON. Lift TIG Mode when Indicator Light is OFF.



- TIG Wave Shape. For aluminum start in Square Wave mode. Push Button till Square Wave Symbol lights. Square Wave is the upper left symbol.



Sequence Graph settings.



- Use the Left and Right arrows on the front panel to scroll through the graph parameters. Use the encoder knob located between arrows to set parameters.



Tpr – Gas Pre flow – Set to 0.5sec.

Ih – Hot Start – Set to 20 Amps.

Is – Not used in 2T and with Foot control operation.

Tup – Up slope, set to “0” time.

Iw – Maximum Weld amperage. Set to desired maximum foot control Welding Amperage.

Dcy, Fp, Ib used for TIG Pulse.

Tdown – Down Slope, Set to “0” Time.

Ic – Not used in 2T and with Foot control operation.

Tpo – Gas Post Flow, Start setting at 10 seconds.

AC Balance – Set to 15%

AC Frequency – Set to 75Hz.

Note: Coolant Flows in torch only during welding. When not welding Water cooler turns off.