

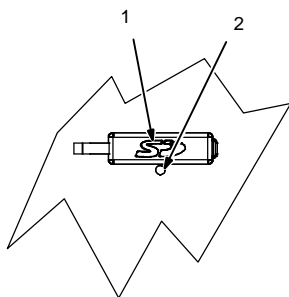


Dynasty® 210 DX and 280 DX AC Independent Expansion



Read and follow the power source Owner's Manual and labels carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.

1-1. Software Expansion



A software update is required to ensure proper operation of all purchased feature expansions. For instructions to download TIG Software updates, see PDF file F269272A on software expansion memory card.

Card Requirements:

Purchased software expansion memory card required.

- 1 Memory Card Port
- 2 Indicator LED

Enabling Software Expansion:

Insert card containing software expansion into port.

LED indicator blinks green while machine is reading from or writing to the card. After successfully reading from or writing to the card, the LED switch-

es from blinking green to continuous green. The machine is now ready to use software expansion. **Do not** remove card while LED is blinking green.

Software expansion card must remain in memory card port to enable software expansion.

Disabling Software Expansion:

Remove the software expansion card from the memory card port.

Troubleshooting:

Problem: Indicator LED is continuous red.

Remedy: Remove and reinsert card. If problem continues, the card is bad. Contact Factory Authorized Service Center for a replacement card.

The memory card port uses an SD memory card. The SD Logo is a trademark of the SD-3C LLC Company.

1-2. AC Independent Amplitude (Dynasty DX Models Only)

1 AC Waveshape Control
Press switch pad until desired function is selected.

2 Encoder Control (Set Value)

3 Ammeter (Displays Value)

4 Voltmeter (Parameter Selection)

EN Amperage [EN] - Use with AC TIG only to select electrode negative amperage value.

EP Amperage [EP] - Use with AC TIG only to select electrode positive amperage value.

Both Balance and AC Frequency LEDs light when either EN or EP Amperage is selected.

5 Amperage Control

Average Amperage Control: Setting EN Amperage, EP Amperage, Balance, and Frequency values creates an average amperage. The operator can change the average amperage value while maintaining the same EN amperage to EP amperage ratio at the existing balance and frequency. To change the average amperage value, press the Amperage switch pad and turn the Encoder control. The changing average value is displayed on the ammeter. Example: If EN Amperage is 150, EP Amperage is 100, Balance is 75%, and Frequency is 120, the average amperage is 138 amps. If you press the Amperage switch pad and turn the Encoder control until 69 amps is displayed, the EN amperage is now 75 and EP amperage is now 50. The balance remains 75%, and the frequency is still 120, and the 1.5 to 1 EN amperage to EP amperage ratio is maintained.

1-3. AC Independent Waveshape (Dynasty DX Models Only)

1 Amperage (A) Control

2 Gas/DIG Control

3 Parameter Display

Press Gas/DIG control until [ACEN] is displayed. Press the Amperage (A) control to toggle between [ACEN] and [ACEP].

4 Setting Display

5 Encoder Control

Use Encoder to select between advanced squarewave [ADVS], soft squarewave [SOFT], sine wave [SINE], or triangle wave [TRI]. The default is [SOFT].