

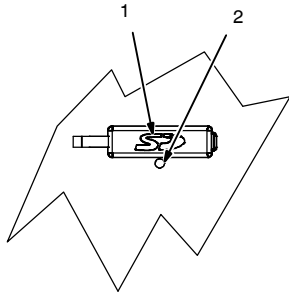


Dynasty® – Maxstar® Hot Start Adjust Expansion



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 F269272 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 switches

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:

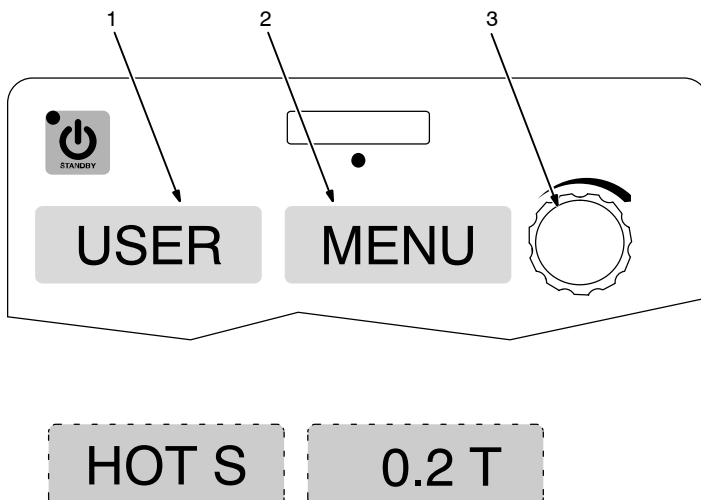
Problem: Indicator LED is continuous red.

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.

Hot Start Adjust Expansion – Enabling the Hot Start Adjust software expansion will allow adjustment of Process Stick's Hot Start Time.

1-2. Hot Start Time



☞ See Operation section in Owner's Manual for additional information on accessing User Setup Menu.

- 1 Parameter Display
- 2 Setting Display
- 3 Encoder Control

Use Encoder control to select Process Stick's Hot Start Time.
(Time range is 0 (OFF) – 2.0 seconds.
Default time is 0.2 second.)

Hot Start is a short time of increased amperage to aid in the starting of a Stick electrode.