

GYS

S 11

Mise à jour : 30/04/02

Declaration of conformity:

- The equipment complies with EEC Directives 83/336 (electromagnetic compatibility) and 73/23 (low voltage).
- The equipment complies with Standards EN 50199 and EN 60974-1.

GYSMI TIG 130 HF

OPERATING INSTRUCTIONS

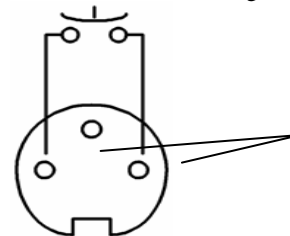
Thank you for choosing our product! In order to make the most of your equipment, please read the following carefully:

I / POWER SUPPLY – STARTING

- 16A plug, 230V (50-60 Hz) + earth. For an intensive use, it is necessary to use a 25 A plug.
- The unit stops and the power indicator light goes off if voltage is more than 265 V or less than 195 V (+/- 15%).
- Your unit has a small switch on the front face and you have 3 modes of welding respectively :
✓ *TIG TSL – MMA Electrode – TIG HF.*

➤ Connect the trigger plug:

The TIG 130 HF without accessories is delivered with the connector of command of the trigger as indicated on the following diagram:



Connect wires of contact normally opened on the studs

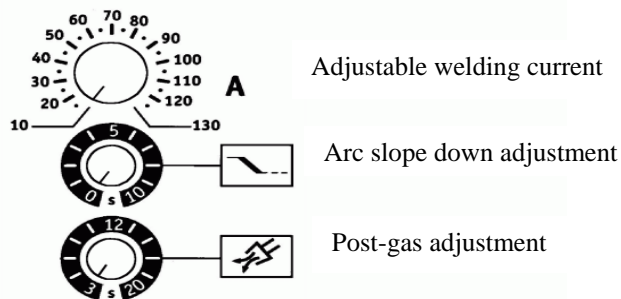
II / ELECTRODES WELDING (from 10 A to 110 A)

- Please follow standard rules for welding.
- After welding, leave the machine connected for cooling.
- Thermal protection: the indicator light comes on and cooling time is about 5 min.
- Your unit is equipped with 3 special Inverter functions: *Hot START* gives arcing overcurrent about 25% more than the displayed setting; *Arc force* provides an overcurrent about 15% more than the setting to avoid sticking when the electrode enters the bath; and *Anti-sticking* lets you separate the electrode easily without reddening in case it sticks.

WELDING PARAMETERS

électrode diameter (mm)	I min	I avg	I max	Power generating set
1,6	30	40	50	4,5 KVA 5,5 KVA
2	45	55	80	
2,5	70	80	95	
3,2	100	110	130	

III / WELDING TIG HF (de 10 A à 130 A)



- When you press on the trigger, a H.F signal allows remote starting between the electrode and the part to be welded (use under gas Argon).
- You can regulate the slope down of the arc from 0 to 10 seconds and post-gas from 3 to 5 seconds.

IV / TSL TIG WELDING (from 10 A to 130 A)

- It is system of striking device without high frequency in TIG:
 - ➔ T = Touch : touch the electrode on the part to be welded
 - ➔ S = Switch : press on the trigger
 - ➔ L = Lift : raise the electrode before a lapse of time of two seconds
- The adjustments of post-gas and the slope down of arc are the same ones as above.

V / SERVICING

- Make sure the generator is switched off and wait for the fans to stop. Voltages and current inside are high and dangerous.
- Remove the cover regularly and remove the dust with an air gun. Also make sure the electrical connections are firm.

VI / TROUBLES SHOOTING

If, when you are ready to weld, the unit does not supply any current, check the following points:

A – Both indicator lights are on: Wait for the end of the cooling period.

B – Both indicator lights are off: The supply voltage is not within the 230V +/- 15% range.

C – The power indicator light is on: Check the connections to the accessories. Otherwise return the unit to After-Sales Service for repair.

If when you put your hand on the outer casing, you feel tingling while the machine is on, this means that the earthing is defective. Check the extension cable, the plug and the earth to your installation.

VII / GENERAL ADVICE – WARNING

- Select a clean place, sheltered from the bad weather.
- Use a filter glass and plain glass helmet, the plain glass has to be fixed against the external side which is exposed to welding, it protects the filter glass from spatters.
- Wear protective clothing (overalls, jeans).
- Use some welder gloves and a fire -proof apron
- Remove the electrode from the electrode-holder when you do not use it.
- Clean your device with an air gun.

VIII / SECURITY

- **Caution** : your **INVERTER** must be connected to a plug with an earth. If not, important caution of electrocution.

Protect yourself and the others from :

- Smokes.
- Heat of the arc.
- Rain, steam, moisture.
- Electric shock.
- Inflammable environment and inflammable products.
- People using Pacemaker.
- Etc .

This device is built in compliance with the new European directives (CEM y D.B.T.). Please read carefully the instructions given below.

XIX / INSTALATION AND USE (EN 50199 : 1995).

The user is responsible for the installation and the use of the equipment according to the manufacturer's instructions. If any electromagnetic disturbance is noticed, the user must solve the problem, if necessary with the manufacturer's technical assistance.

A.1 Surrounding recognition

Before installing this device, the user must evaluate the potential electromagnetic problems that may arise in the surrounding area.

A.2 Disruption reduction methods

A.2/1 Mains power supply

The welding power source must be connected to the supply mains according to the manufacturer's instructions.

In case of interference, it may be necessary to take further precautions like the filtering of the mains power supply the shielding of the power supply cable.

A.2/2 Welder maintenance

The welder must not be modified in any way (except the settings and the modifications).

A.2/3 Welding cables

The welding cables must be kept as short as possible, positioned near one another and laid at or approximately at ground level.