

Automatic Programming

With effectiveness of 1.October 2001 all ORBIMAT C series power sources incorporate a function which allows welding programmes to be automatically calculated. In order to use this feature you should follow the following instructions.

This automatically calculates parameters, which are based on many years experience, however we cannot always guarantee a perfect result every time. The intention of the calculated parameters is to give un-experienced operators an easier start-up in creating welding procedures.

The calculated procedures are proposals only and may be modified occasionally to suit individual preference.

An automatically created procedure can be *Modified*, *Saved* and *Deleted* in the same way as any manually created one.

To create a new automatically generated procedure:

1. Press **MENU**
- 2.Select **WELD/MODIFY PROCEDURE**, press **ENTER**

This will take you to a procedure, it is not important which procedure is loaded as **Autoprogramming** can be initialised from any procedure and will **not** modify the loaded procedure in any way.

- 3.Press the **AMP +/-** Key, now the **AUTOMATIC PROGRAMMING** menu will appear like shown:

autoprogramming	
input parameters	
weldhead type	:
material	:
arc gas	:
tube diameter	: 0.0 mm
wall-thickness	: 0.0 mm
wire-feed	: N (Y/N)
Please hit key (Amp. +/-) again in order to start autoprogramming	
Abort with (MENUE)	

If a weld head is connected, the ORBIMAT C will detect the connected weld head and this will be displayed automatically and go to line 2 (material).

If there is no weld head connected then you must press **INS** and then a weld head list will now be displayed and the correct **weld head type** must be highlighted and then press **ENTER**

To select the **material type** you intend to weld press **INS**. A material list will now be displayed and the correct material must be selected, using the up and down arrow keys, and press **ENTER**.

If the correct material is not listed, select the one, which is closest.

To select the **gas type** you will be using press **INS**. A gas list will now be displayed and you must select the correct gas type, using the up and down arrow keys, and press **ENTER**.

Now enter the **tube diameter** (in mm) to be welded using the numeric key pad and press **ENTER**.

Now enter the tube **wall thickness** (in mm) to be welded using the numeric key pad and press **ENTER**.

If a weld head with a **wire feed** capability is selected or connected then you will have the opportunity to select a wire feed.

Now all details are entered press the **AMP +/-** key to activate auto programming.

The machine will now create a custom weld procedure for the values entered.

The shown procedure is only in **temporary memory** and not saved to the **internal memory**.

If you wish to do this, please follow standard instruction manual.