

TPS 270i C

Quick Guide



SAFETY

Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document only describes the most important functions of the device. For a complete description of the device, refer to the Operating Instructions.

1 Set the filler metal and shielding gas



- Open the material selection



- Turn and press to enable the desired settings

2 Set the welding process



- Press to select the desired welding process

2 Set the operating mode



- Press to select the desired mode

4 Set the welding power



Sheet thickness

Welding current

Wire speed

Special function F1



- select desired parameter



- set desired parameter

5 Adjust the parameters for correction



Arc length correction

Welding voltage

Pulse/dynamic correction

Special function F1



- select desired parameter



- set desired parameter

Text display:

- Activate / deactivate = press left adjusting dial
- Scroll through full text = turn left adjusting dial

Abbreviation

Full text

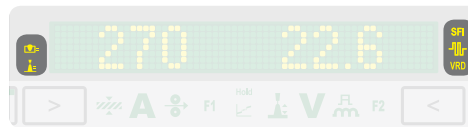
= Start arclenath

Status indicators:

(light up when the respective function is active)

Arc length stabilizer

Penetration stabilizer



Spatter Free Ignition

SynchroPulse

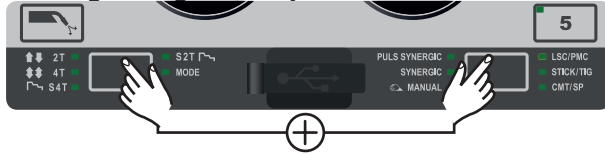
Voltage Reduction Device

Operating Instructions:

www.fronius.com/tpsi-manuals



Entering/exiting the Setup menu



Process parameters

Start/End

I-S	Starting current (135)
AIS	Start arc length correction (0)
t-S	Starting current time (off)
SL1	Slope 1 (1.0)
SL2	Slope 2 (1.0)
I-E	Final current (50)
AIE	End arc length correction (0.0)
t-E	Final current time (off)
SFI	SFI ignition (off)
SFI-HS	SFI HotStart (off)
W-r	Wire retract (0.0)
IgC	Ignition current (manual), (450)
W-r (man.)	Wire retract (manual), (0.0)

Gas Setup

Gpr	Gas pre-flow (0.1)
GPo	Gas post-flow (0.5)

Process control

PSt	Penetration stabilizer (0.0)
AISt	Arc length stabilizer (0.0)

Components

C-C	Cooling unit operating mode (auto)
C-t	Filter time flow sensor (10)
Fdi	Feeder inching speed (10.0)
ito	Ignition timeout (off)

STICK

I-S	Starting current (150)
Hti	Starting current time (0.5)
Eln	Characteristic (I-constant)
Ast	Anti-stick (on)
Uco	Break voltage (90.0)

TIG

Uco	Break voltage (14.0)
CSS	Comfort-Stop sensitivity (0.8)

SynchroPulse

Syn-Puls	SynchroPulse (off)
vd	Wire speed (5.0)
dFd	Delta wire feed (2.0)
F	Frequency (3.0)
DC	Duty cycle (50)
Al-h	Arc correction high (0.0)
Al-l	Arc correction low (0.0)

(Values/entries in brackets show the factory setting)

Activating/deactivating the key lock



Text display

Abbreviation

Full text



Process Mix

vd	Wire speed (1.5)
AIC	Arc length correction (0.0)
PDC	Pulse/dynamic correction (0.0)
Hptc	Upper power time correction (0)
Lptc	Lower power time correction (0.0)
Lpc	Lower power correction (0.0)

R/L-check / alignment

Aligning welding circuit resistance
welding circuit inductivity

Settings

Display

Einh.	Units
Norm	Standards
UIBS	Display brightness setting
F1/F2 Param.	User-defined parameters for F1 and F2
Favorit	Favourite key
IP	System data

System

CLS	Housing lighting setup
FAC	Restore factory settings
Web-PW reset	Reset website password
Information:	IM-V. / SWV / IP
Operating mode setup:	S4T / iJob

Language

cs, de, en, etc.

Favourite

The Favourite key can be assigned the Setup parameter or Setup folder that is currently selected.

Retrieve:					
Save:					
Delete:					

EasyJobs

The EasyJob keys allow up to 5 operating points to be saved. Specifically, the current welding-relevant settings are saved.

Retrieve:				
Save:				
Delete:				

F1 / F2 special function parameters



F1 and F2 can be assigned the currently selected setup parameters.

Retrieve:							
Save:							
Delete:							
Use the key for F2!							