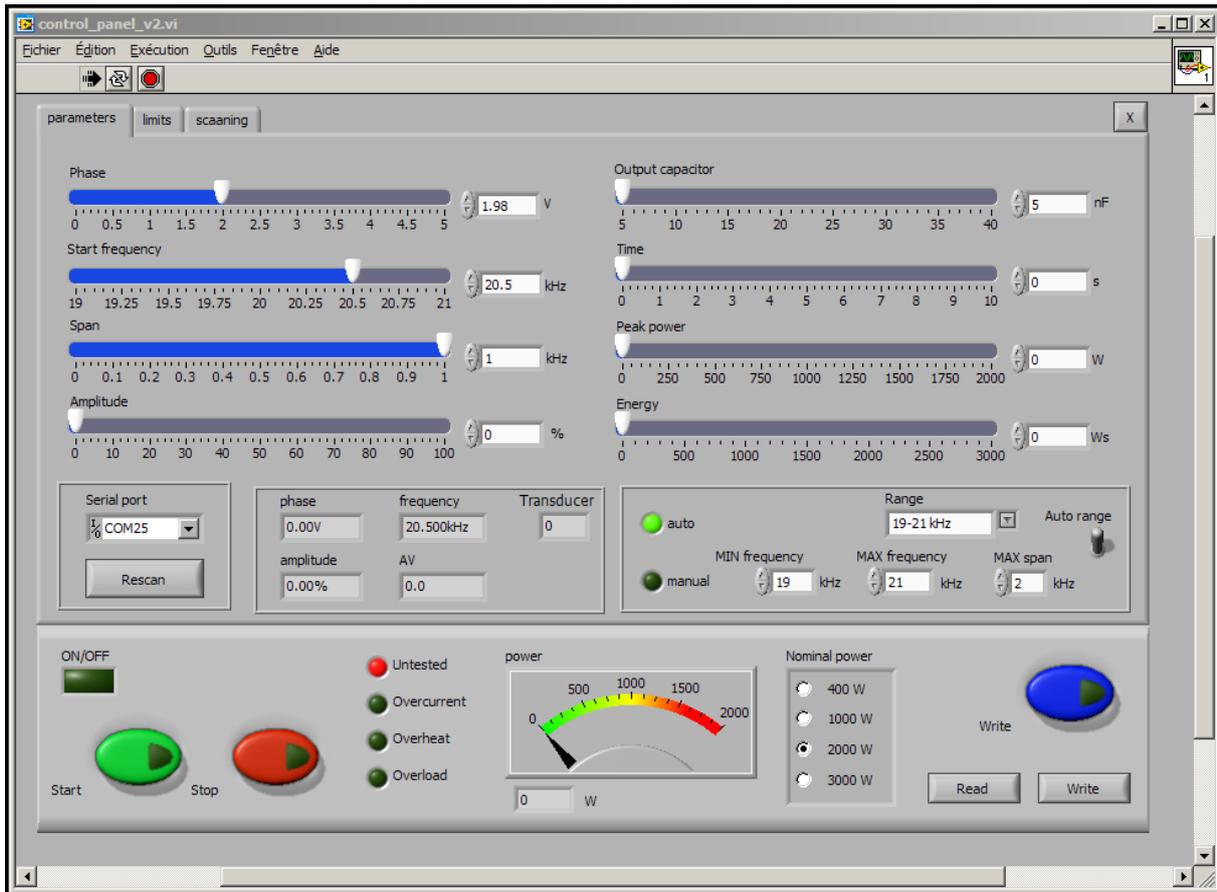
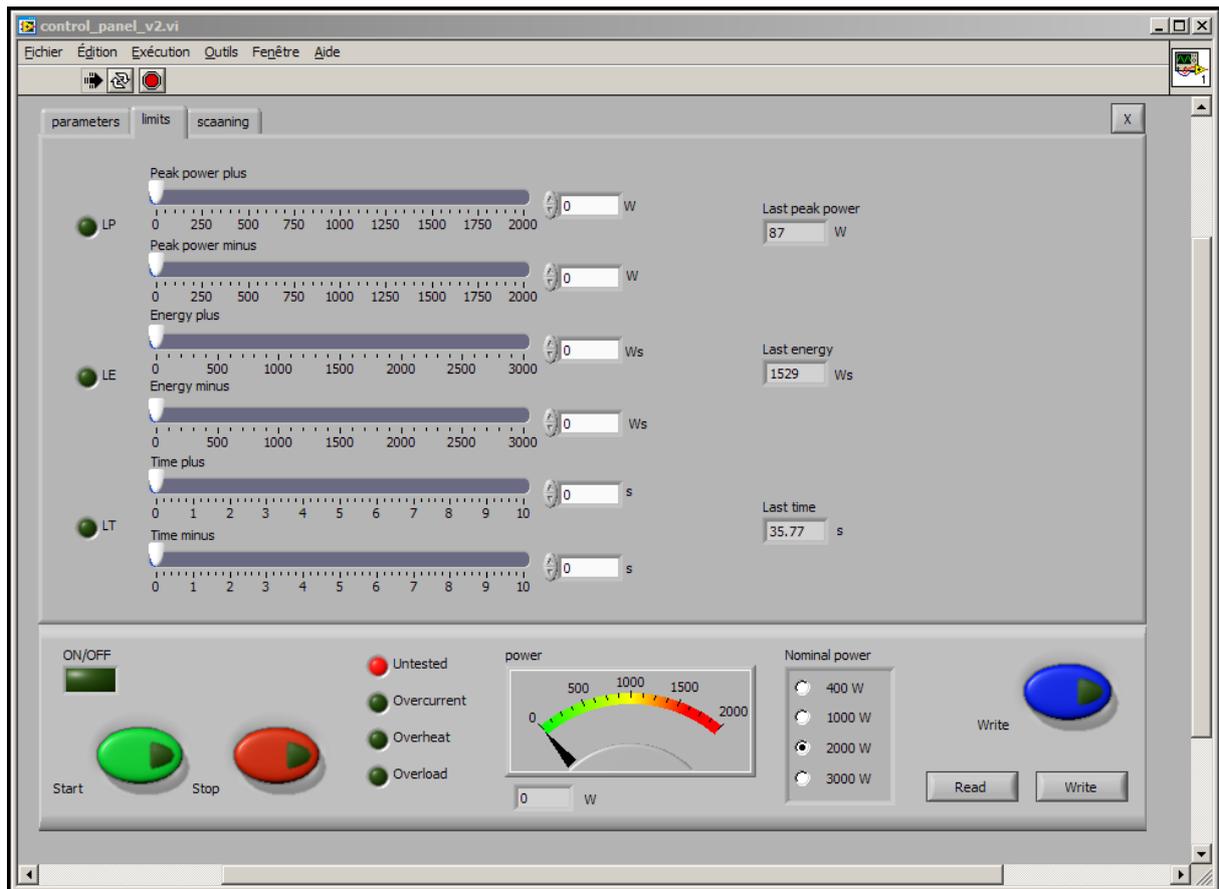


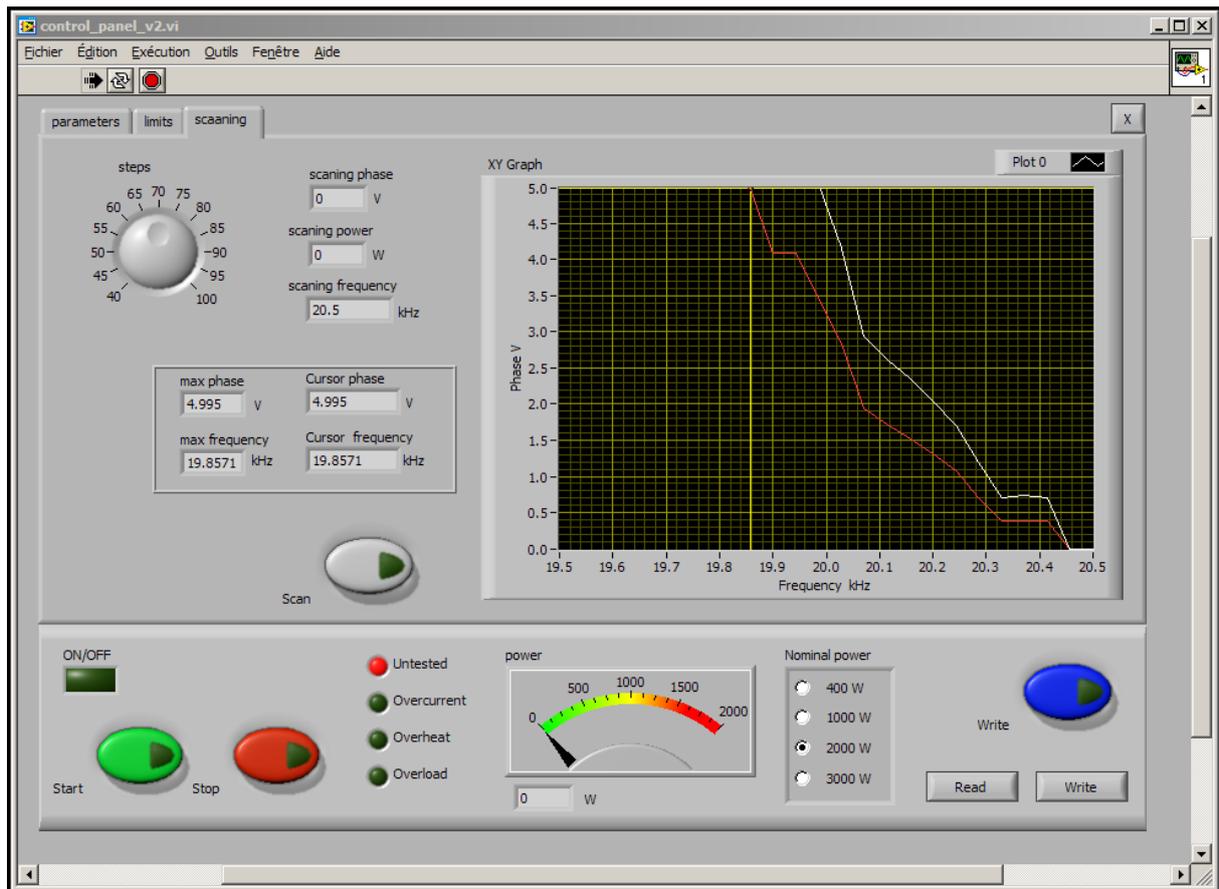
**SETTING & SCANNING example for DUKANE 20 kHz welding converter (2 kW)  
SHORT REMINDER FOR BEGGINERS**



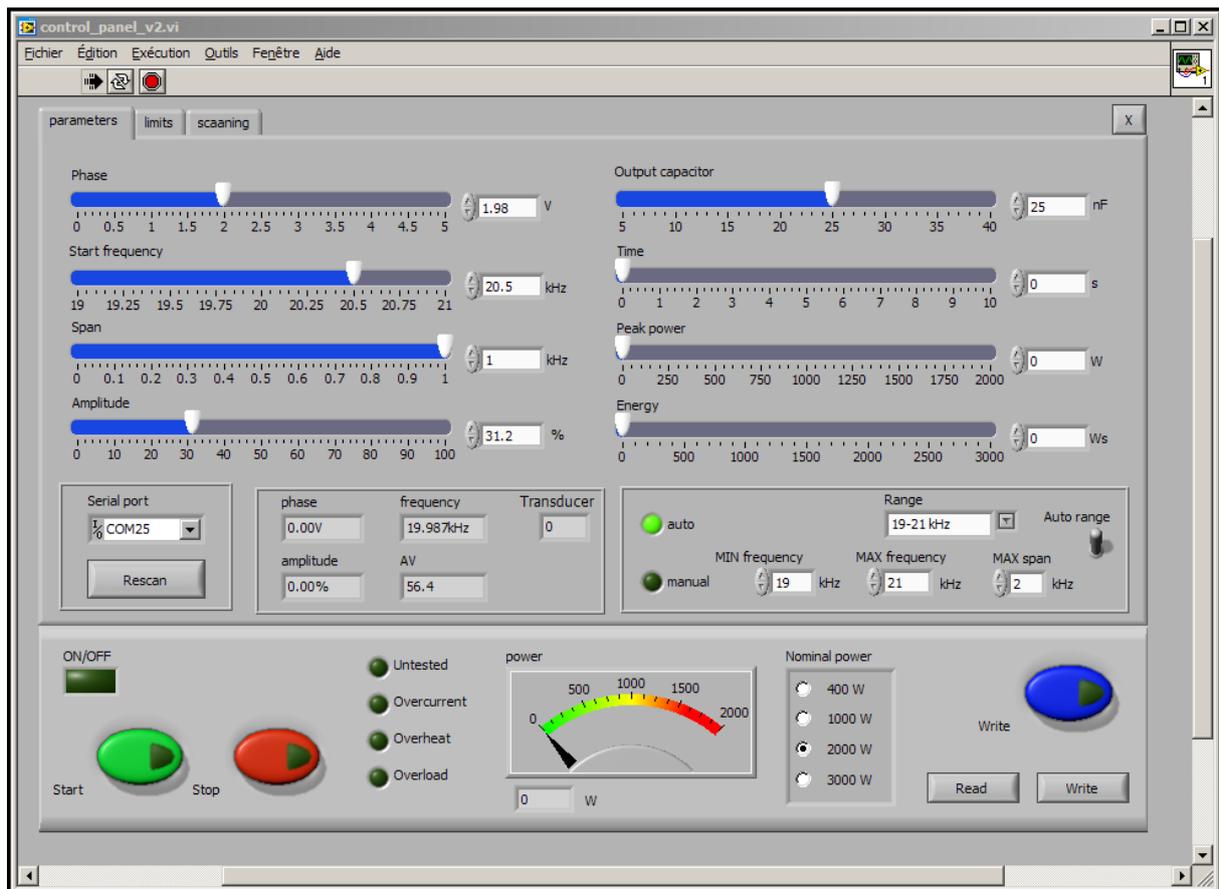
- Install all necessary LabView software (read our manual).
- Activate MPIwelding.exe
- Select proper Serial port (Rescan). Verify that connection to your PC is activated.
- Set output capacitor to minimum (5nF) before scanning
- Set Time, Peak power, Energy to "0"
- Set Nominal power to what correspond to hardware (here 2000W)
- Select frequency Range, or MIN and MAX frequency & MAX span.
- If Auto frequency range is used, span is automatically selected to be 1 kHz
- Always stop the generator before changing "Output capacitor"
- Do not forget to activate blue button "Write" after every modification



- Set all values to « 0 » minimum before scanning
- Do not forget to activate blue button "Write" after every modification



- Scanning diagram (after scanning). In this case we do not see series resonance, but after we add booster/sonotrode... we will be able to see series resonance.
- Select Phase set point in the middle linearity area of white curve (here 2 V looks OK), and go to the first TAB (parameters) and set selected Phase.
- Do not forget to activate blue button "Write" after every modification



- Operating situation after scanning: First TAB (parameters).
- Increase output capacitor gradually, as long automatic amplitude and phase regulation is operating correctly.
- For first Start select Amplitude to 20%, later increase... First Start will repeat and verify Scanning and if everything is OK, generator will stop without generating error message. Second Start (green button) will activate converter.
- In case if/when adding/changing booster/sonotrode/converter, repeat scanning
- Later follow manual. Set operating mode (Time, Peak power, Energy...).
- Always stop the generator before changing "Output capacitor"
- Do not forget to activate blue button "Write" after every modification