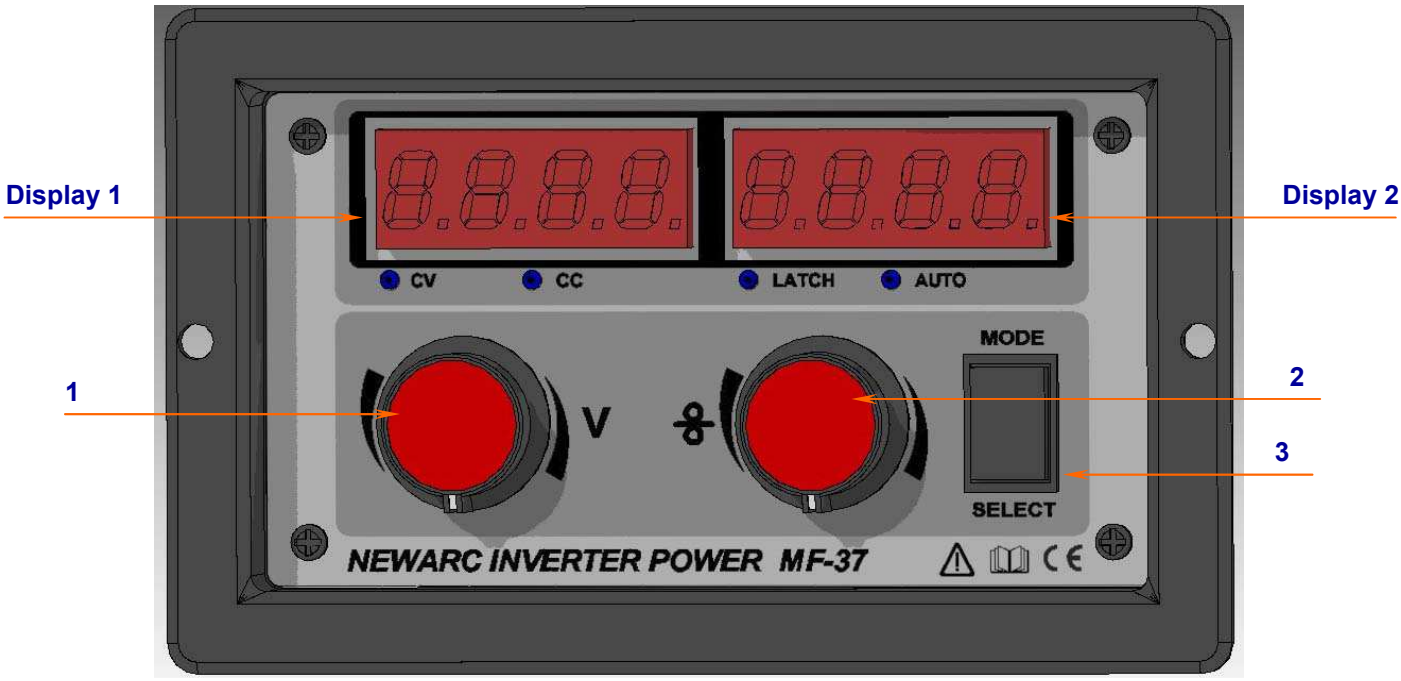
SECTION 4 — OPERATION

4.2 Operational Controls for MF37 Front Panel



1. **Adjustment Control for left display**
2. **Adjustment Control for right display**
3. **Mode select push button/wire inch (long press)**

After initial power up.
Note: The last digit of the display indicates a letter to show the option mode selected.
The following options are shown and can be adjusted with the corresponding knob.

Mode select (3) : Toggles between the 3 modes
- constant voltage (**CV**)
- constant current (**CC**)
- 2 modes **CC1** & **CC2**(CC diode flashes)

CV Mode:

Display1/knob1	**Display2/knob2**
(Not active)	Set Wire-speed (**o**)

Additional options :
Pressing the mode button **(3)** allows other options to be displayed on the two displays and changed using the knob below the corresponding display.

Display1/knob1	**Display2/knob2**
Burn-back (**b**)	Latch (**L**)
Slow-Start (**S**)	Post Gas (**P**)

Mode select (**CC1 CC2 CV**)
Last welding results display: voltage (**U**) and current (**A**) (if available)

Latch (L) 2T, 4T & 4D. In 2T, the MIG torch switch is pressed to start welding and released to stop. In 4T, the torch switch is pressed and released to start welding and pressed and re-leased again to stop welding. 4D is similar to 4T but with a delay time of 1 seconds before it latches on, this allows a quick tack weld feature in latch mode.

CC Mode:
CC1 Dedicated for wire sizes of 1.2mm or below
CC2 Dedicated for wire sizes of 1.6mm or greater.

Display1/knob1	**Display2/knob2**
(Not active)	Maximum Wire-speed (**o**)

Additional options :
Pressing the mode button **(3)** allows other options to be displayed on the two displays and changed using the knob below the corresponding display.

Display1/knob1	**Display2/knob2**
Burn-back (**b**)	Latch (**L**)
(Not active)	Post Gas (**P**)

Mode select (**CC 1, CC 2, CV**)
Last welding results display: voltage (**U**) and current (**A**) (if available)

Note: 1: Any settings that are changed are saved after a 3 second period
*Note 2: During welding the MF36 displays the voltage (**U**) of the welding arc. If the optional current transducer LEM circuit is fitted the displays also displays the current (**A**) of the welding arc*

Note 3: If the MF37 is left idling for more than 4 minutes the panel goes into standby made. This is indicated by a small red LED in display2 pulsing on and off. To reactivate the panel press or turn anything on the MF37 panel or press the MIG torch switch.