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## Refer to PipeWorx 400 Welding System Owner's Manual for equipment safety precautions

Enabling the Trigger Select/Hold feature allows the user to switch memory program slots while welding. This can be used to change welding parameters and/or wire welding processes without stopping.

The Trigger Select/Hold Feature card is used to enable or disable this feature; the card does not need to remain in the PipeWorx system once the feature is configured. This card cannot be duplicated; however, one card has the ability to enable this feature in multiple PipeWorx systems. **Software Version 1.11 or greater is required.**

### Enabling the Trigger Select/Hold feature:

1. Insert the Trigger Select/Hold Option Card
  - a. Hold open the memory card access cover
  - b. Insert the memory card in to the slot (push the card all the way in and then release)
  - c. Close the memory card access cover
  - d. CARD will illuminate on both the feeder and the power source to indicate the presence of the Trigger Select/Hold Option Card
  - e. Volts display (upper display on the feeder will show "tSL" and the Wire Feed Speed display (lower display on the feeder) will show the current setting as "On" or "OFF"
2. Set the desired selection for the Trigger Select/Hold feature
  - a. Use the Wire Feed Speed knob on the wire feeder to set the Trigger Select/Hold feature "On" or "OFF" as desired
    - i. Clockwise will turn the feature "On"
    - ii. Counter-Clockwise will turn the feature "OFF"
3. Remove the Trigger Select/Hold Option card
  - a. Hold open the memory card access cover
  - b. Push in and release the memory card to eject the memory card
  - c. Grasp the memory card and remove it from the slot
  - d. Close the memory card access cover

### Using the Trigger Select/Hold Feature:

The following instructions outline the use of the Trigger Select/Hold Feature:

1. Set up the memory locations with the appropriate weld program desired.
2. Activate Trigger Select on two or more memory locations where selection is desired.
3. Activate Trigger hold on one or more of the memory selections where the selection is desired.
4. Press and hold the gun trigger for more than 0.5 seconds but not more than 6 seconds to start the weld. This places the system in the trigger hold mode.
5. When a memory location change is desired, execute a quick actuation of the gun trigger (less than 0.5 seconds).
  - a. This will automatically switch to the next active memory location.
  - b. This can be done more than once during a weld cycle.
6. To end the weld, press and hold the gun trigger for longer than 0.5 seconds, then release.
  - a. Not holding the gun trigger for more than the required 0.5 seconds results in cycling to the next active memory program configured for Trigger Select/Hold.

*Note: If Trigger Select and Trigger Hold are enabled for the original memory slot, but the next memory location has Trigger Select enabled and Trigger Hold disabled, a quick actuation of the trigger will advance from the original memory location to the next memory location but a subsequent trigger actuation will stop the weld.*



## **PipeWorx Welding System**

Trigger Select/Hold Option

Usage Instructions