











































































































































































Symbol-Functions and Keyboard Summary

: INPUT is activated, : INPUT is deactivated, [Cursor]: Change amount at Cursor Position.

Symbol	Function	Keyboard-Combination
	Operation duration, days, hours, minutes, seconds	Can be cleared in SETUP
P, R	Program No. 0-20, Rail No. 0-29	 :  +  ,  + 
	Dwell time Start 0-2 Seconds	 [Cursor]:  , 
	Dwell time Stop 0-2 Seconds	 [Cursor]:  , 
X,Y,Z,R	Position Side, Drive, Distance, Rotary	Indicated, Movement  :  ,  ,  ,  ,  :  ,  ,  +  , 
	Speed X weaver	 [Cursor]:  , 
 or 	Speed Y FORWARD or REVERSE	 [Cursor]:  ,   :  +   :  + 
	Speed Z Distance-Support	 [Cursor]:  , 
	Speed R Rotary-Support	 [Cursor]:  , 
	Speed or Time LEFT	 [Cursor]:  , 
	Speed or Time RIGHT	 [Cursor]:  , 
	Weld-Power 0-500 Ampere	Left or right torch
	Drive upwards after end (LIFT OFF)	 [Cursor]:  , 
	Speed MID	 [Cursor]:  , 
	Distance between Weaver layers 0-20mm	 [Cursor]:  , 
  	 Multi-Areas,  Multi-Layers,  Corner	 :  + 
   	Work at points,  grasp,  Area,  Parallel	 :  + 
P ₀	Position Point 0-1200, amount +- 0-99	Amounts:  [Cursor]:  , 
P ₊	Teach-In-Point 0-1200, amount 0-99	 [Cursor]:  ,  Point  : set  +  clear  + 
	Amplitude 0-50mm, 0-100mm	 [Cursor]:  , 
	Weaver Speed	 [Cursor]:  , 
	Set Input-Mode, Movement or change amounts	Key  set Cursor:  :  ,  Move  : Arrow keys
	Wire feeder, Test/Weld/Feed In	SET:    :  
	Arc Control sensibility 0-9	 :  , 
S>	Set automatic stick-out amount	Weld power analogue indicated,  :  , 
S> <S	Choose adjustable amount Z (S>) or X (<S)	 : 
	Multi-Area Dwell Time, 0-10 Minutes to get cold	 [Cursor]:  , 
	Counter for layers 0-99, distance between	 [Cursor]:  , 
	Patterns,     	 :  + 
	Torch left and/or right active, ON/OFF	 : 
	Gas pre-flow time, 0-9 Seconds	 [Cursor]:  , 
	Auto-Adjustment left/right, mid position	<S:   
	Drive to active Point P 0000-1200	 :  + 
	 Move to start of line,  end,  X-position	 :  +  ,  Move rotary support (Joint Welder)

Symbol	Function	Keyboard-Combination
JOINT	Rotary support drive to START-Position	+ +
	Save to Chip Card / Show support information	+ +
RESET	Soft-Reset unit, same as after switch on	+ +

SETUP Functions

Symbol	Function	Keyboard-Combination
SET	Change to SETUP screen	+ +
SETUP	Choose mode work in front or behind the unit	
SETUP	Set standard or special program	Normal 20P/3D, RAM-Program, 2 nd internal, Chip card
SETUP	Save actual program data	Parameters from Pxx will be internally memorized
SETUP	Load memorized program data	Transfer from internal memory to actual program Pxx
SETUP	Set display mode	Normal or inverse
SETUP	Set display contrast	less, or more
SETUP	Set drive unit RD200 or RD500	press and hold
SETUP	Set CURSOR mode	Blinking or static, Backlight ON/OFF
SETUP	Reset time to 00000000	
SETUP	Reset active welding time A to 000000	
SETUP	Choose language English/German	
#: xxxx	Serial number of RD100E (Evolution) remote	Key for Bluetooth Pairing
	Send RAM program to AUTO-START area SP9	+ press and hold, AUTO-START with Chip-Card

RD500Pipe Functions

Symbol	Function	Keyboard-Combination
Pipe	Change standard parameters	+ + ...work ... + ...SETUP... ... continue
Pipe	Choose mode work in front or behind the unit	+ +
POS	Set 12 o'clock to 6 o'clock area position	+ + change to standard, use P00-P06 parameters
PAT	Set pattern	+ +
AREA	Set Layer Area 0, 1, 2	+ + +
DRIVE	Drive unit to line start position	+ + Start of welding
DRIVE	Drive unit to line end position	+ + End of welding
Point	Set actual (bold) Teach-In point	+ + point +1, + + point -1, or ,
NewZ	Set new STICK-OUT distance at Z-Point	+ +

General Function: Gun and movement OFF, OFF with DWELL and LIFT-OFF, Unit ON, no drive.

All functions without -key can be adjusted while working.