

FIELD INSTRUCTIONS

2015-04

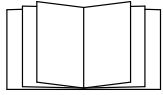
FORM: F270 932A

Use above FORM number when ordering extra manuals.

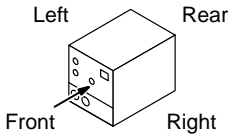
Calibration Procedure For SubArc Digital

Power Sources: 907620, 907621, 907622, 907623, 907624, And 907625

With Field Kit 301294

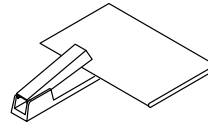


Have only trained and qualified persons install, operate, or service this unit. Call your distributor or the equipment manufacturer if you do not understand the directions. For WELDING SAFETY and EMF information, read Owner's Manual.



All directions are given as facing front panel.

Keep hardware for reuse.



Staple these instructions inside Owner's Manual.

1. Safety Symbol Definitions

	<p>DANGER! – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.</p> <p style="text-align: right;"><small>Fsafe1 2013-10</small></p>		<p>Beware of electric shock from wiring. Disconnect input power before installing this kit. Reinstall all panels and covers.</p> <p style="text-align: right;"><small>Fsafe7 2013-10</small></p>
	<p>Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.</p> <p style="text-align: right;"><small>Fsafe2 2013-10</small></p>		<p>Wear safety glasses with side shields.</p> <p style="text-align: right;"><small>Fsafe8 2013-10</small></p>
<p>NOTICE</p>	<p>Indicates statements not related to personal injury.</p> <p>Indicates special instructions.</p> <p style="text-align: right;"><small>Fsafe3 2013-10</small></p>		

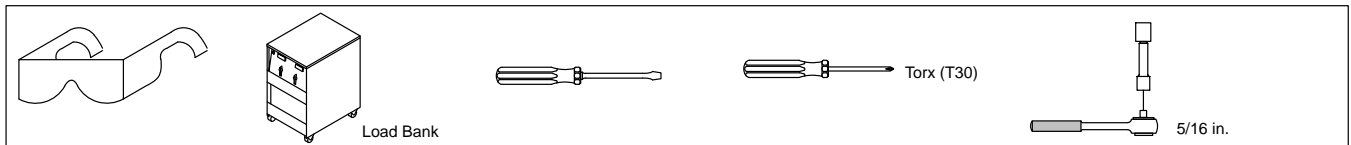
CALIFORNIA PROPOSITION 65 WARNINGS

Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)

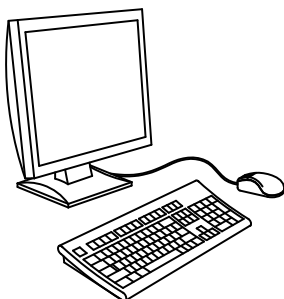
This product contains chemicals, including lead, known to the state of California to cause cancer, birth defects, or other reproductive harm. Wash hands after use.

Fsafe4 2013-10

2. Tools Needed



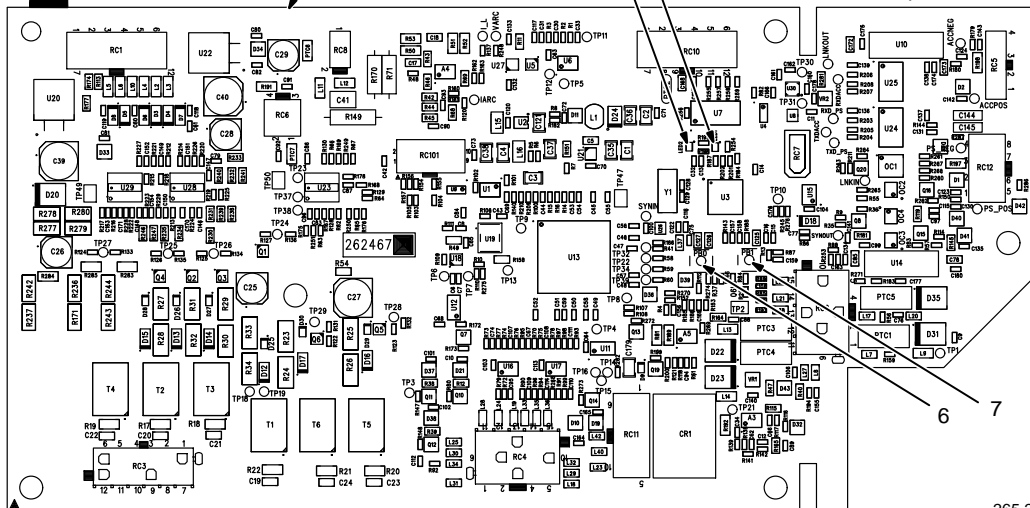
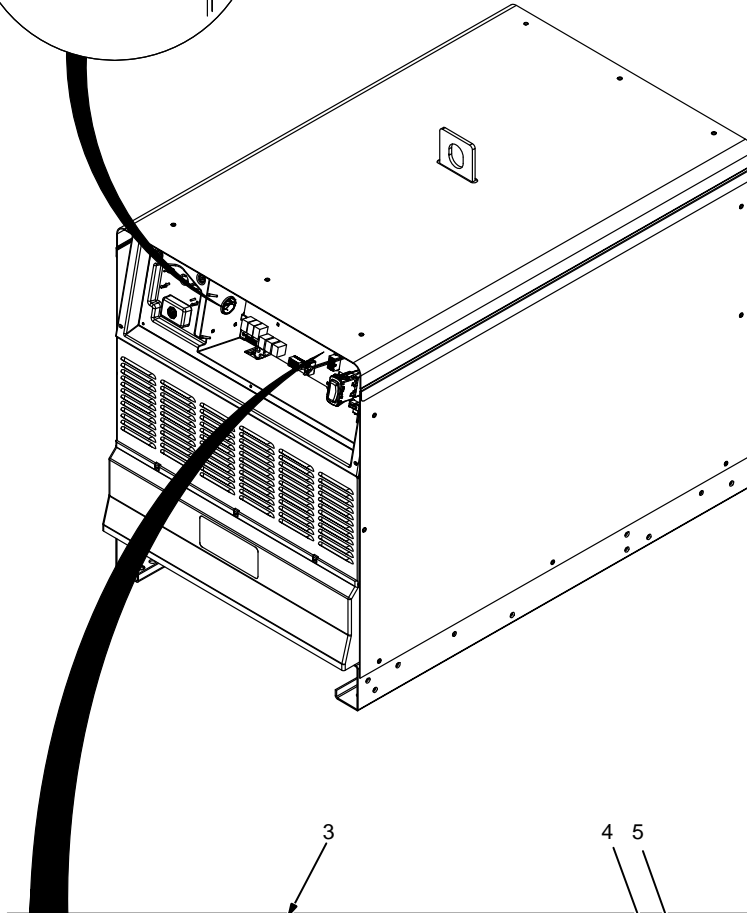
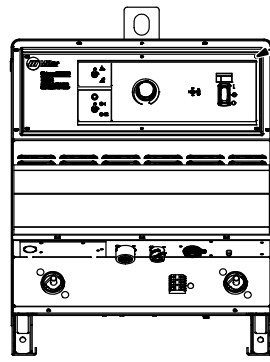
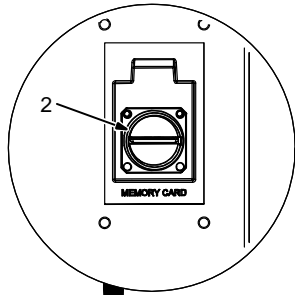
3. Download Software



A computer with an SD memory card port or SD memory card reader is required to download software updates. Download updates at www.Miller-Welds.com. (or, update software with a purchased software update card – stock no. 301294).

The SD logo is a registered trademark of SD-3C LLC.

4. Calibration Procedure For DC Power Source Models



- ⚠ Turn off welding power source.
- ⚠ Disconnect and lockout/tagout input power before removing covers or panels and working inside unit. Follow established procedures regarding the installation and removal of lockout/tagout devices.
- ⚠ This procedure requires an energized unit. Have only personnel familiar with and following standard safety practices do the job.

1 Front Panel Screws

Remove the six 5/16 in. screws from the front panel to expose the electronics box.

2 SD Card Reader

Insert Calibration SD card into SD card reader located on left side of electronics box. Push in SD card, and it will lock in place.

3 Control Board PC1

4 LED2

5 LED1

6 PB0

7 PB1

Disconnect all parallel, tandem, control and automation cables from front of machine.

Connect weld cables to load bank.

Connect volt sense leads to load bank.

Turn on machine (front panel Fault LED turns on. Green LED2 on PC1 turns on. Red LED1 on PC1 single flashes).

Set output to On using On/Remote switch (Output indicator lights and red LED1 flashes 2x).

Rotate A/V Adjust control until 600 amps is displayed on load bank.

Press PB0 on PC1. LED1 turns Off.

Wait until LED1 begins flashing 3x.

Rotate A/V Adjust control until 30 volts is displayed on load bank.

Press PB0, and LED1 turns Off.

Wait until LED1 begins flashing 4x.

Set output to Remote using On/Remote switch. Output indicator and LED1 turn Off.

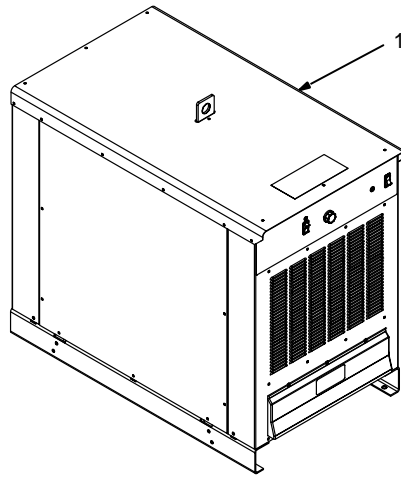
Wait until LED1 begins flashing 10x.

Remove Calibration SD card.

Turn Off machine – Calibration is complete.

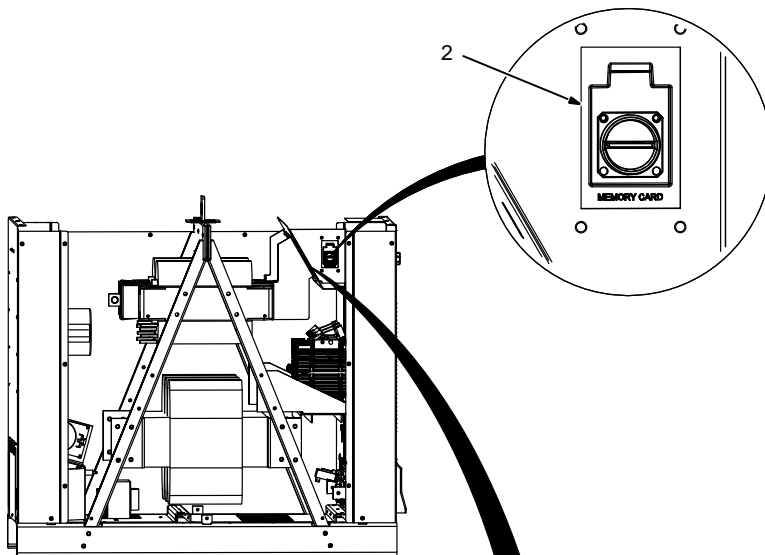
Reinstall front panel with existing hardware.

5. Calibration Procedure For AC/DC Power Source Models



- ⚠ Turn off welding power source.
- ⚠ Disconnect and lockout/tagout input power before removing covers or panels and working inside unit. Follow established procedures regarding the installation and removal of lockout/tagout devices.
- ⚠ This procedure requires an energized unit. Have only personnel familiar with and following standard safety practices do the job.

- 1 Cover
- Remove cover.
- 2 SD Card Reader
- Insert Calibration SD card into SD card reader located on left side of unit. Push in SD card, and it will lock in place.
- Turn power on.
- 3 Control Board PC1
- 4 LED2
- 5 LED1
- 6 PB0
- 7 PB1



Disconnect all parallel, tandem, control and automation cables from front of machine.

Connect weld cables to load bank.

Connect volt sense leads to load bank.

Turn on machine (front panel Fault LED turns on. Green LED2 on PC1 turns on. Red LED1 on PC1 single flashes).

Set output to On using On/Remote switch (Output indicator lights and red LED1 flashes 2x).

Rotate A/V Adjust control until 600 amps is displayed on load bank.

Press PB0 on PC1. LED1 turns Off.

Wait until LED1 begins flashing 3x.

Rotate A/V Adjust control until 30 volts is displayed on load bank.

Press PB0, and LED1 turns Off.

Wait until LED1 begins flashing 4x.

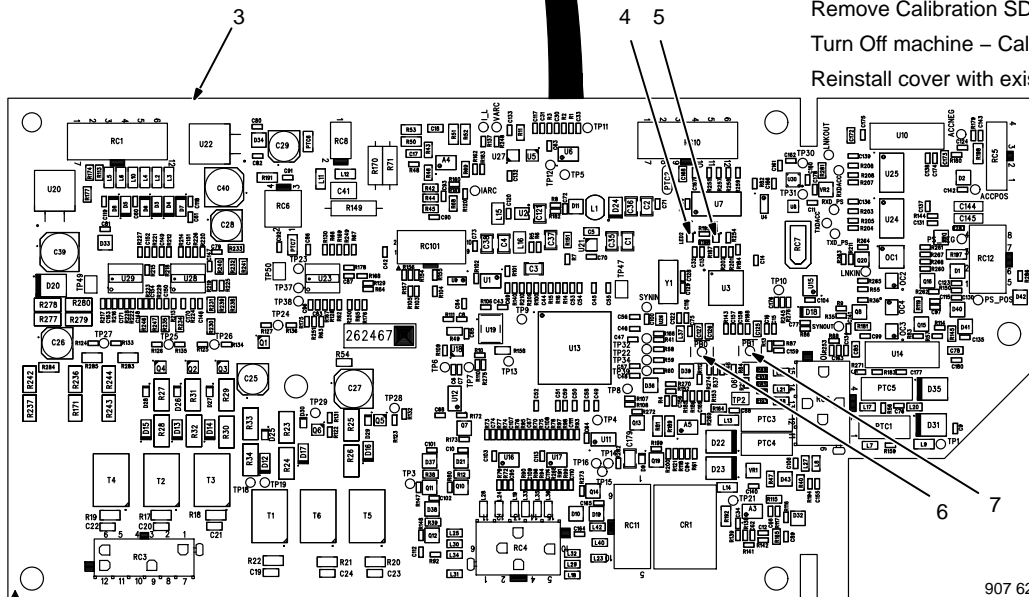
Set output to Remote using On/Remote switch. Output indicator and LED1 turn Off.

Wait until LED1 begins flashing 10x.

Remove Calibration SD card.

Turn Off machine – Calibration is complete.

Reinstall cover with existing hardware.



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