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BULLETIN # 230B

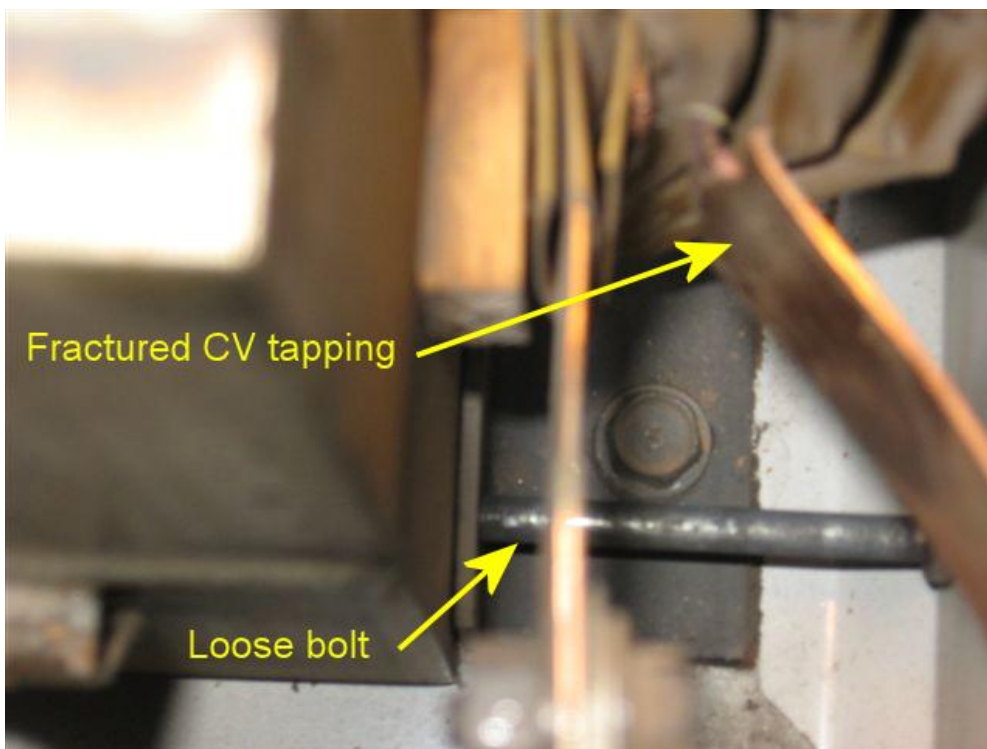
MILLER PRO 300 CAT CC/CV

LOSS OF CV WELDING OUTPUT - DAMAGED INDUCTOR

Loss of welding output in CV mode may be due to a damaged CV tapping on the inductor (stabilizer) of a Pro 300. This can be caused by excessive movement of the inductor which may occur if the bolts which extend through the mounting feet and the bottom of the inductor come loose.

If the CV tapping fractures it is likely that there will not be enough material extending from the inductor to allow for an effective repair, requiring inductor replacement. It is therefore essential that these bolts on a Pro300 are checked for tightness. See page 2 for a procedure for visually checking the nuts.

If they are not tight, the nut and washer must be tightened or replaced (1/4" Whitworth nut with captive washer) as required before the machine is used again to prevent damage to the inductor. Page 3 & 4 explain how to gain access to the front nut and bolt.



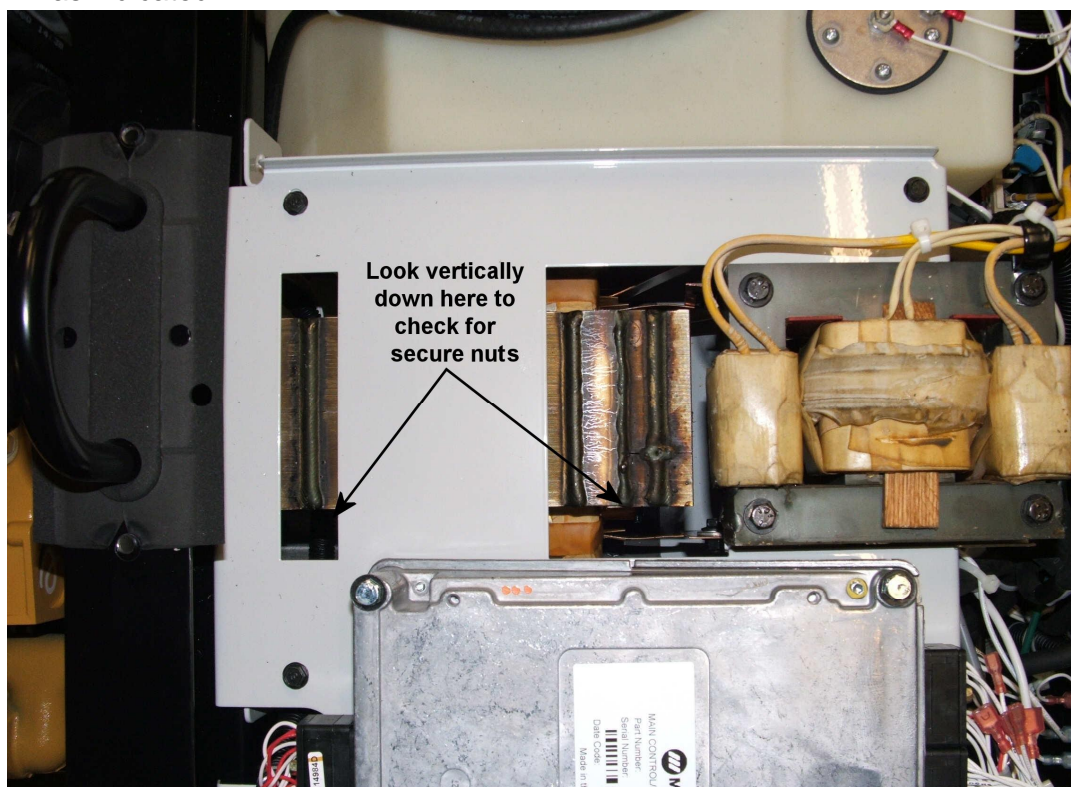
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QUALITY WELDING PRODUCTS, SYSTEMS AND SERVICES

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Remove the left cover and look at the rear mounting bolt and nut. They must be tight in order to secure the inductor and prevent excessive movement. Remove the top cover. Both front & rear mounting bolts can be checked by looking vertically down as indicated.



If the nuts are not securely fastened, tighten them to a torque setting of 4-5 ft lbs or 5-6 NM . Follow this procedure to gain access for tightening the nut closest to the front of the machine. The nut at the rear can be reached without removing extra components.

1. Remove the top cover.
2. Undo 4 screws and lower the Rectifier Assembly out of the way.
3. Undo 2 screws and lower the 240 volt Aux Power Panel at the front of the machine.
Caution: take great care not to drop any small components or they may end up inside the generator!
4. Undo the 4 screws which secure the Main Control SCR Gating Module (vault).
5. Undo the cable restraint which secures the loom running from the rear of the vault. Carefully lift the vault and place it to the left hand side of the machine. There should be no need to remove the main electrical connections to the vault.
6. Undo 2 nuts and remove the connections to the 2 copper terminals at the front of the control transformer.
7. Undo 4 screws that secure the control transformer.
8. Carefully move the control transformer to the right hand side (there is no need to remove other connections).
9. Undo 4 screws and remove the white platform that the Main Control SCR Gating Module (vault) sits on.
10. Undo the nut and bolt and remove cable 19A and 19B from the copper tapping which comes from the inductor.
11. Carefully move the copper tapping to one side to gain access to the inductor securing nut.
12. Use an 11mm socket with short handled ratchet to tighten the nut (4-5 ft lbs or 5-6 NM is the recommended torque).
13. Carefully refit the components previously removed. Ensure that there is sufficient clearance around bare electrical components

