



# Service Bulletin

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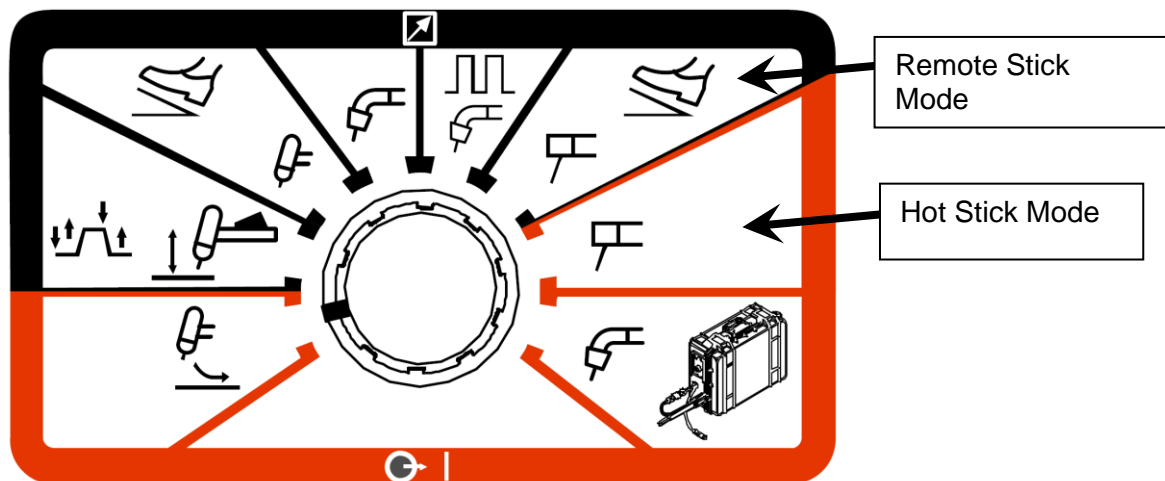
## MILLER XMT350, XMT350 MPA

### ALTERNATE CONFIGURATION OF CURRENT DISPLAY WHEN USING REMOTE CURRENT CONTROL

**CAUTION:** The following information is intended for use by qualified service personnel. When the unit is energised **LETHAL VOLTAGES** are present on the electrical and electronic components. It is not intended that persons without suitable training and knowledge attempt to perform service tasks on the components of welding equipment.

#### **Alternate Configuration Functions, XMT350 and XMT350 MPA.**

There are 3 ways that the remote control can be configured to operate on this machine. The configuration of the meters can be changed by placing the process selection switch into **Hot Stick mode** and turning the output on and off 3–5 times within a few seconds. This can be done by triggering a feeder or by activating the output on–off switch on a remote control. It is difficult to achieve with the RHC-14 as the triggering must be performed quickly. It is much more easily done by flicking the gun trigger on a gun connected to a feeder that is plugged into the XMT350. When the configuration mode is changed in this way, the amperage window will briefly display what mode is selected (C1, C2 or C3) before returning to the preset display.



**Configuration 1** is the **default** that the unit leaves the factory set for. In both Hot Stick mode and Remote Stick mode the current can be adjusted by a connected remote control during welding, but the preset current displayed (before welding) is only the value set by the panel adjustment knob. The value set by the remote is not displayed.

**Configuration 2** changes Hot Stick mode remote operation. When configuration 2 is selected Hot Stick mode operates in Panel Only control, meaning any remote control that is plugged into the remote 14 control **will be ignored** and have no effect on the output in Hot Stick mode.

The information provided in this sheet is accurate and reliable, however no warranty of accuracy or reliability is given and no responsibility arising in any other ways by errors or omissions is accepted.



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Configuration 2 is indicated by a decimal point displayed in the amperage window when Hot Stick mode is selected.

**Configuration 3** changes how the display works in the Remote Stick mode. When configuration 3 is selected, and using Remote Stick mode, the amperage window will display the preset amperage being set from the remote amperage control. The maximum amperage is set by the panel control. In Hot Stick mode the remote will have no effect on the current value.

Configuration 3 is indicated by a decimal point displayed in the amperage window when either Hot Stick mode or Remote Stick mode is selected.

	Remote Stick		Hot Stick	
	Remote Control of Current	Display Preset Current Set by Remote	Remote Control of Current	Display Preset Current Set by Remote
<b>C1</b>	Yes	No	Yes	No
<b>C2</b>	Yes	No	No	No
<b>C3</b>	Yes	Yes	No	No

XMT350 and XMT350 MPa have the ability to change configuration in this way from serial number MD420093U.

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