



Service Bulletin



Date 17/6/2020

BULLETIN # 266

DIMENSION 650 AU MODEL VRD SETTING

INSTRUCTIONS FOR SETTING THE VRD STATUS

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.

Miller Dimension 650 Arcreach model. MR907618001, has three different VRD status' that can be selected as required by customer.

1. VRD Disabled.

In CC mode the Open Circuit Volts (OCV) will be at maximum 71V.
the Display will show OCV of about 71V



2. VRD Enabled: End of weld OCV time, to VRD OCV < 0.3 Seconds

In CC mode the displays will show "VRD ON", and show amps while adjusting, and show weld volts and weld amps while welding.



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.

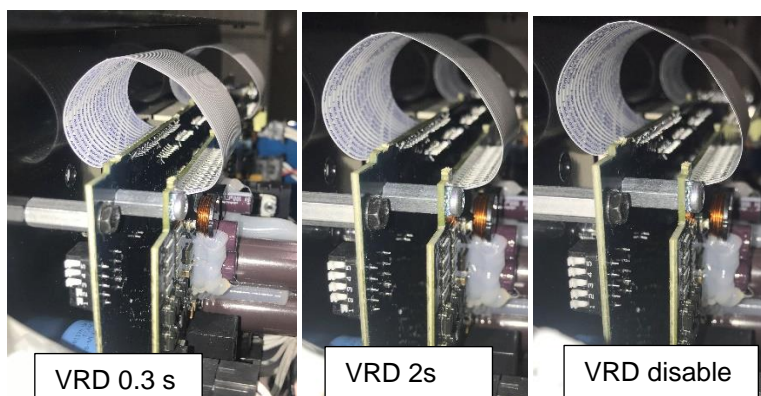
- 3. VRD Enabled: End of weld OCV time, to VRD OCV < 2.0 Seconds
In CC mode the displays will show "VRD* ON", and show amps while adjusting, and show weld volts and weld amps while welding.



The VRD status is controlled by a set of DIP switches on the Front control panel. Adjustment is as follows

| SW 1 | SW 2 | SW 3 | SW 4 | SW 5 | Display | Measured OCV | Turn off time |
|------|------|------|------|------|--------------------|--------------|---------------|
| ON | ON | OFF | OFF | OFF | SMAW / VRD ON | 23.5 | 240<300ms |
| OFF | OFF | OFF | OFF | OFF | SMAW / 75.6 / 69.0 | 69 | NAP |
| ON | OFF | OFF | OFF | OFF | SMAW / VRD* ON | 23.5 | 1.5<2s |

ON position is toward the PCB



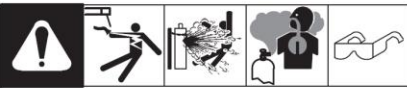
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Always check unit before applying power (see Section 12-1).

12-17. Enabling Low Open Circuit Voltage Welding Modes (Optional)



⚠ Disconnect and lockout/tag-out input power before removing cover.

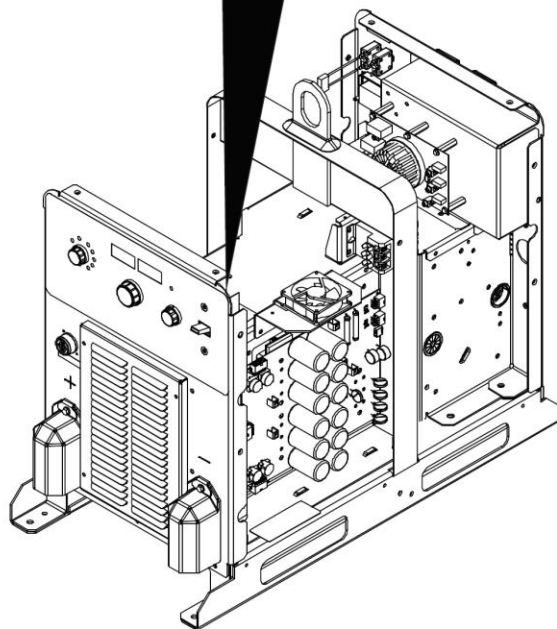
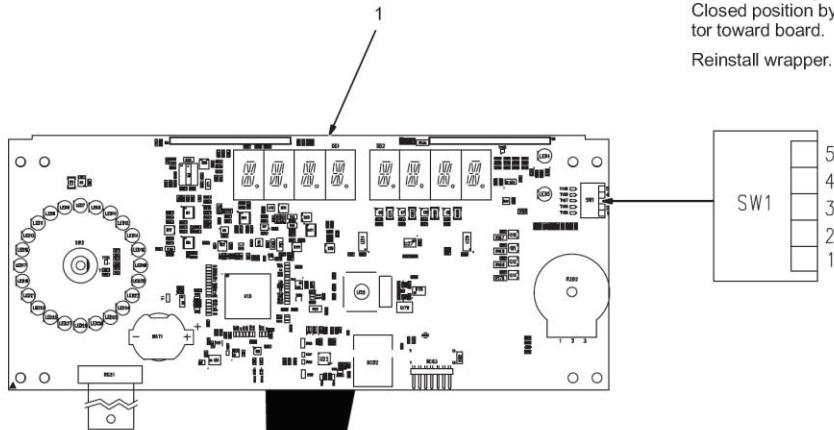
Follow this procedure to configure the unit for low open circuit voltage (OCV) operation in SMAW, GTAW and CAC-A modes. OCV is reduced to about 12 volts DC.

1 User Interface/Control Board PC1

Remove wrapper.

Place switch position 1 in the Closed position by pressing actuator toward board.

Reinstall wrapper.



Ref. 273899-A / 273823-A

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