

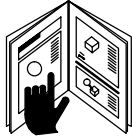
FIELD INSTRUCTIONS

April 2001

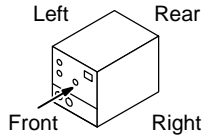
FORM: F096 982A

Use above FORM number when ordering extra manuals.

**For Remote Current Control Kit 041 111
In Dialarc® 250/250P-AC/DC Models**



*Read and follow these instructions and all safety blocks carefully.
Call your distributor if you do not understand the directions.*



All directions are given as facing front panel.

Keep hardware for reuse.



Staple these instructions inside Owner's Manual.

WARNING



ELECTRIC SHOCK can kill

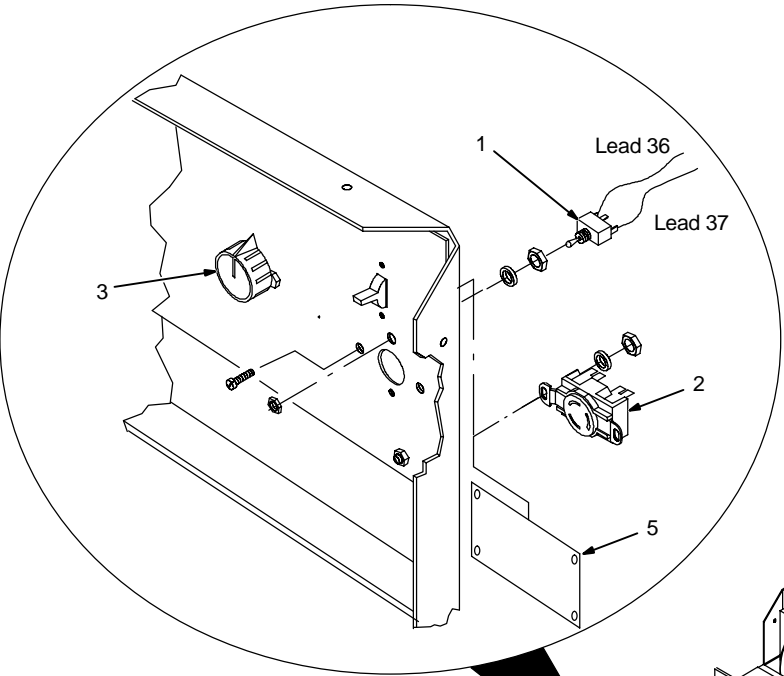
- Do not touch live electrical parts.
- Turn Off welding power source, and disconnect input power before beginning this installation.
- Have only qualified persons familiar with and following standard safety practices install this kit.



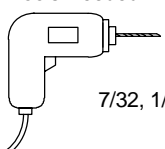
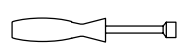
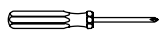
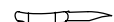
FILINGS AND TOOLS HITTING INSIDE PARTS can damage unit.

- Cover parts.
- Clean unit and remove covers before operating.

fwarn1.1* 5/94 / fwarn4.1 9/91



Tools Needed:

-  7/32, 1/2 in
-  3/8, 9/16 in
- 
- 

Remove top cover and right side panel.

- 1 Supplied Remote Amperage Switch S3
- 2 Supplied Remote Amperage Control Receptacle RC1
- 3 Amperage Adjustment Control R2
- 4 Integrated Rectifier SR2

For Units With Aluminum Nameplate

Locate prepunched mounting holes in front panel for S3 and RC1. Carefully drill 1/2 in hole through nameplate for S3, and 7/32 in holes for RC1 screws. Use front panel opening as a template to mark and cut opening for RC1 body.

For Units With Polycarbonate Nameplate

- 5 Backing Plate

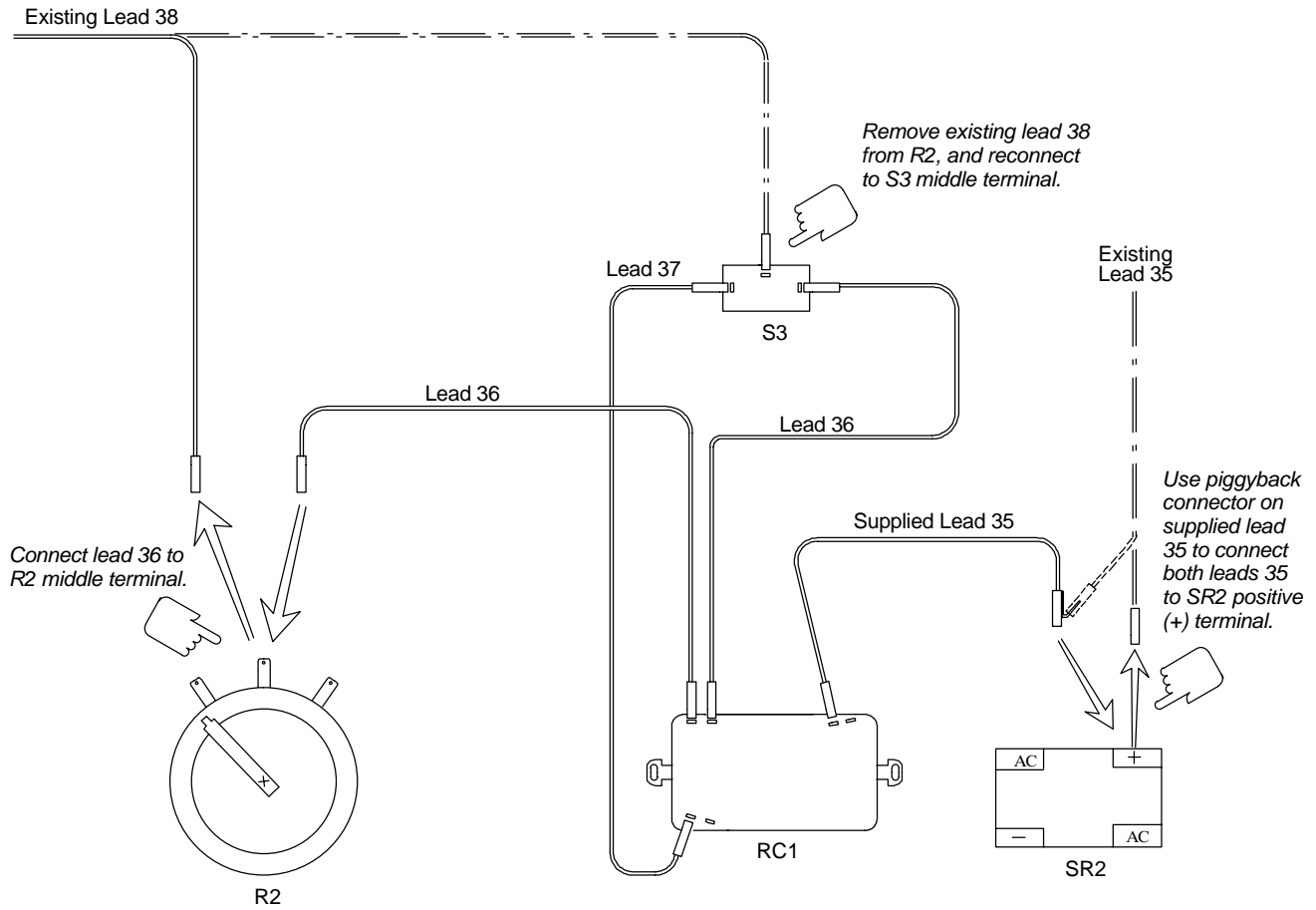
Remove backing plate. Locate prepunched mounting holes in front panel for S3 and RC1. Carefully cut 1/2 in hole through nameplate for S3, and 7/32 in holes for RC1 screws. Use front panel opening as a template to mark and cut opening for RC1 body.

Install S3 and RC1 as shown. Place supplied label over S3 toggle.

801 121

Figure 1. Installing Switch And Receptacle

Make wiring connections as shown. See Figure 1 for Amperage Adjustment control R2 and integrated rectifier SR2 locations.
Reinstall cover and side panel.



Tools Needed:



801 122

Figure 2. Making Wiring Connections

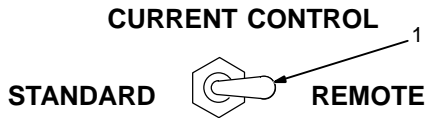
⚠ CAUTION

ARCING can damage switch.

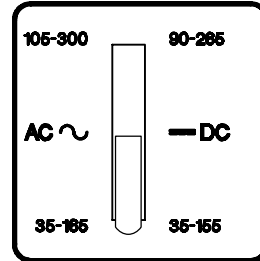
- Do not change Current Control switch position while power is on.
- Arcing inside switch can damage contacts, causing switch to fail.

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Example: Combination Remote Amperage Control



Set Switch



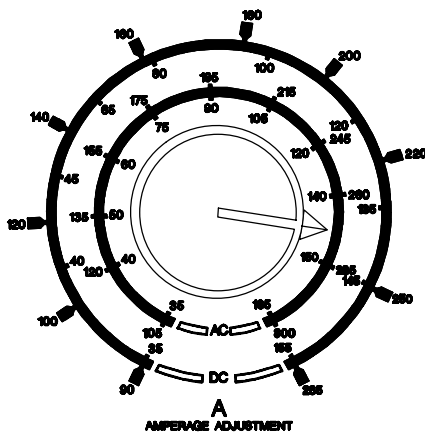
Select Amperage Range

Connect remote amperage control to receptacle RC1 as follows: Insert plug and turn clockwise until tight.

1 Remote Amperage Switch S3

For front panel control, place switch in Standard position. For remote control, place switch in Remote position. See example.

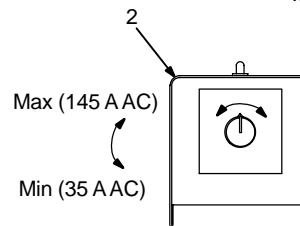
2 Remote Amperage Control



Select Maximum Amperage



In Example:
 Range Selected = 35 to 165 A AC
 Maximum Amperage Selected = 145 A AC
 Min = 35 A AC
 Max = 145 A AC



Adjust Remote Control

S-0774 / Ref. 088 267-D

Figure 3. Operation

Dia. Mkgs.	Part No.	Description	Quantity
Kit, RF-10 Remote Control Facility (Field)			
.. RC1	039 607 ...	RECEPTACLE, twlk 3P3W 20A 250V	1
... S3	011 609 ...	SWITCH, tgl SPDT 15A 125VAC	1
.....	012 305 ...	LABEL, current control std rmte	1
.....	132 272 ...	SCREW, 10-24 x .500 rndhd phl stl	2
.....	602 222 ...	WASHER, tooth .476 ID stl intl	2
.....	602 203 ...	WASHER, lock .193 ID stl split	2
.....	601 861 ...	NUT, 10-24 stl	2
.....	605 321 ...	NUT, .468-32 brs	2