



OWNER'S AND OPERATOR'S MANUAL

Diesel Engine Generator & Welder

DGW600DM

Vertical, Water-Cooled 4-Cycle Diesel Engine



CAUTION

Do not operate the Generator/Welder, or any other appliance, before you have read and understood the instructions for use and keep near for ready use.

DGW600DM-D4V
X753-009 45 0
X753803-690 0

Introduction

We would like to thank you very much for purchasing this Shindaiwa Soundproof Diesel Engine Generator & Welder.

- This manual has been created in order to ensure safe and proper use of this equipment. Be sure to thoroughly read this manual before operating the equipment as the improper operation of this equipment can result in an accident or malfunction.
- This equipment should only be operated by persons who thoroughly understand the contents of this manual and can safely operate the equipment. Persons who are ill, taking medicine, or are in bad health should not operate this equipment if such conditions will affect operation of the equipment and related work.
- Operation and use of this equipment must be in strict compliance with the applicable laws, as well as rules and regulations based on such laws.
- Always be sure to include this manual with the equipment if it is loaned out to another party, and instruct said party that they must thoroughly read this manual before operating the equipment.
- Store this manual securely in a predetermined location so that it can be readily accessed at all times to order parts or arrange for repair. Contact the retail outlet where this equipment was purchased if any parts are lost, the equipment becomes soiled, or is otherwise damaged in any manner.
- Consult with the retail outlet where the equipment was purchased if any of the points are unclear or you would like further information.
Be sure to note the model name and serial number of your equipment, and provide this information when making an inquiry.
- If disposing of this equipment, dispose in a manner according to laws and regulations applicable to industrial waste. Consult with the retail outlet where the equipment was purchased if you have any inquiries regarding proper disposal.

■ The precautions used in this manual are divided into the following three ranks.

⚠ Warning: Improper operation can result in death or serious personal injury.

⚠ Caution: Improper operation can result in moderate or minor personal injury, or physical damage.

<Note>: Explanatory note in order to ensure that equipment protection and performance are fully realized.

- It is possible that items described under **< ⚠ Caution >** or **< Note >** can result in a serious accident depending on the circumstances. The contents of both of these types of precautions are important. Be sure to always comply with all precautions.

■ The following explanatory symbols will be used throughout the manual and on the product itself. Please make sure to understand fully what each symbol stands for.

<i>Symbol form / shape</i>	<i>Symbol description / application</i>
	<i>Read and understand instructions</i>
	<i>Safety / Alert</i>
	<i>Beware of exhaust fumes.</i>
	<i>Beware of fire hazard.</i>
	<i>Beware of electric shock.</i>
	<i>Beware of suffocation from welding fumes.</i>
	<i>Do not use for Indoor wiring.</i>
	<i>Do not use in the rain.</i>
	<i>Beware of eyes and skin.</i>
	<i>Beware of hot surface.</i>
	<i>Beware of burn.</i>
	<i>Beware of injury.</i> <i>Always lock the doors and never open during operation to avoid injury by moving parts.</i>

<i>Symbol form / shape</i>	<i>Symbol description / application</i>
	<i>FALLING EQUIPMENT can injury.</i>

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1. Safety Precautions

Warning: Suffocation from Exhaust Fume

- Do not operate the equipment in a poorly-ventilated area such as indoors or within a tunnel because the engine exhaust fume includes components that are harmful to humans.

Warning: Suffocation from Welding Fume

- Always be sure to wear a fume-proof mask when welding as the fumes generated during welding include harmful gases and dust. Also be careful that the wind direction is not such that it will cause fumes to be inhaled and always operate the equipment in a well-ventilated area.

Warning: Electric Shock

- Do not operate the equipment with any doors or covers open.
- Do not touch wirings or any electric parts inside the equipment during operation.
- Do not touch the equipment during operation if the equipment or your body is wet.
- Be sure to stop the engine whenever touching Weld output terminals such as when installing or removing welding cables.
- Do not connect welding cables to any part other than Weld output terminals.
- Do not insert any metallic objects, such as pins or wires, into AC output receptacles or remote control receptacles.
- Always be sure to turn off all breakers before installing or removing devices using AC output receptacles.
- Always be sure to repair the corresponding earth leakage location when earth leakage circuit breakers operate.
- Always be sure to stop the engine before performing any equipment check or maintenance.

Warning: Fire

- Always be sure to stop the engine when inspecting fuel or refueling, and absolutely never perform such tasks near fire or other open flame. Wait until the engine has completely cooled before inspecting fuel or refueling.
- Always be sure to wipe up any spilled fuel or oil.
- Spilled fuel and oil accumulates in the spill containment. Do not operate the equipment with liquid accumulated in the spill containment.
- Absolutely never use the equipment if there is a fuel, oil or cooling water leak, and be sure to always repair the leak before using.
- Absolutely never inspect or perform maintenance to the equipment near fire or other open flame.
- Keep any ignitable items (such as fuel, gas and paint) or inflammable items away from the equipment because the muffler, exhaust fume and other parts attain high temperatures.
- Keep any ignitable items (such as fuel, gas and paint) or inflammable items away from the work area due to the scattering of weld spatter that occurs during welding.
- Provide at least 1 meter (3 feet) of distance between the equipment and walls and other obstacles, and operate the equipment on a flat surface.
- Allow the equipment to cool before covering with protective covers and similar items.
- Do not ground wiring of earth leakage circuit breakers of the equipment to piping that passes through flammable material.

⚠ Warning: Injury

- Do not operate the equipment with any doors or covers open. There is a danger of hair, body parts and other items being caught up in moving parts such as cooling fans and belts.
- Do not modify the equipment and do not operate with parts removed.
- Always be sure to stop the engine before performing any equipment check or maintenance.
- The lifting lug is designed to be used only for lifting the equipment. Do not lift the equipment with any heavy items (such as a trailer, gas canister and additional fuel tank) added to the equipment.

⚠ Warning: Injury to Eyes and Skin

- Use protective gear, such as rubber gloves, when inspecting or replacing the battery due to the dilute sulfuric acid in the battery fluid. Be sure that fluid does not get into eyes, or on skin or clothing.
- If battery fluid gets into the eyes, or on the skin or clothing, immediately wash with a large amount of water, and always be especially sure to seek medical attention if it gets into the eyes.

⚠ Warning: Explosion

- Do not operate the equipment or recharge the battery when the battery fluid level is below the lower level.
- Do not generate any sparks near the battery and do not allow any fire or other open flame near the equipment because the battery generates ignitable gas.

⚠ Warning: Electromagnetic Interference

- Persons using a heart pacemaker are not allowed near the welder or welding work area while welding is being performed without the permission of a doctor. The welder generates a magnetic field while energized that can negatively affect pacemaker operation.

⚠ Caution: Suffocation from Exhaust Fume

- Do not direct the engine exhaust towards passersby, private homes or similar persons/locations because the engine exhaust fume includes components that are harmful to humans.

⚠ Caution: Electric Shock

- Do not sprinkle water on the equipment and do not use where exposed to rain.
- If wearing gloves, be sure to always wear gloves with dry insulation properties. Do not wear gloves that are damaged or wet.

⚠ Caution: Burn

- The engine, muffler and similar parts are extremely hot during operation and immediately after stopping the equipment. Never touch hot parts.
- Never open the radiator cap during operation or immediately after stopping the equipment. Hot cooling water and steam will spurt out.
- Always be sure to stop the engine and allow it to cool before inspecting or changing the engine oil. Opening the oil gauge or oil plug during operation will result in hot oil spurting out.
- Always be sure to wear leather gloves, apron, shoe covers, arc-proof glasses (face shield), safety shoes, hard hat and long-sleeve clothing to protect against the scattering of weld spatter that occurs during welding.

⚠ Caution: Injury

- Use this equipment with it situated on a stable level surface so that it is prevented from moving.
- Do not move the equipment during operation.
- Always be sure to turn off the switches of all devices using the equipment and turn off the equipment breakers before starting the engine.
- Always be sure to turn off the power switches of all devices using the equipment when turning on the equipment breakers. Leaving on the power switch of a device using the equipment when the equipment breakers are turned on could result in the sudden operation of the corresponding device.
- Do not leave on the power switch of a device using the equipment and do not connect a device to an AC output receptacle.
- Always be sure to use the lifting lug when lifting the equipment, and lift slowly and directly straight above.
- Wear a helmet, safety shoes, gloves and similar protective gear when performing lifting work. Do not stand or get under the equipment while it is suspended.
- Securely fix the equipment with rope or similar item so that it cannot move when transporting by truck or other vehicle.

⚠ Caution: Injury to Eyes and Skin

- Always be sure to wear arc-proof glasses, clothes that completely cover the skin and other protective gear when welding to protect the eyes and skin from harmful light rays generated during welding.

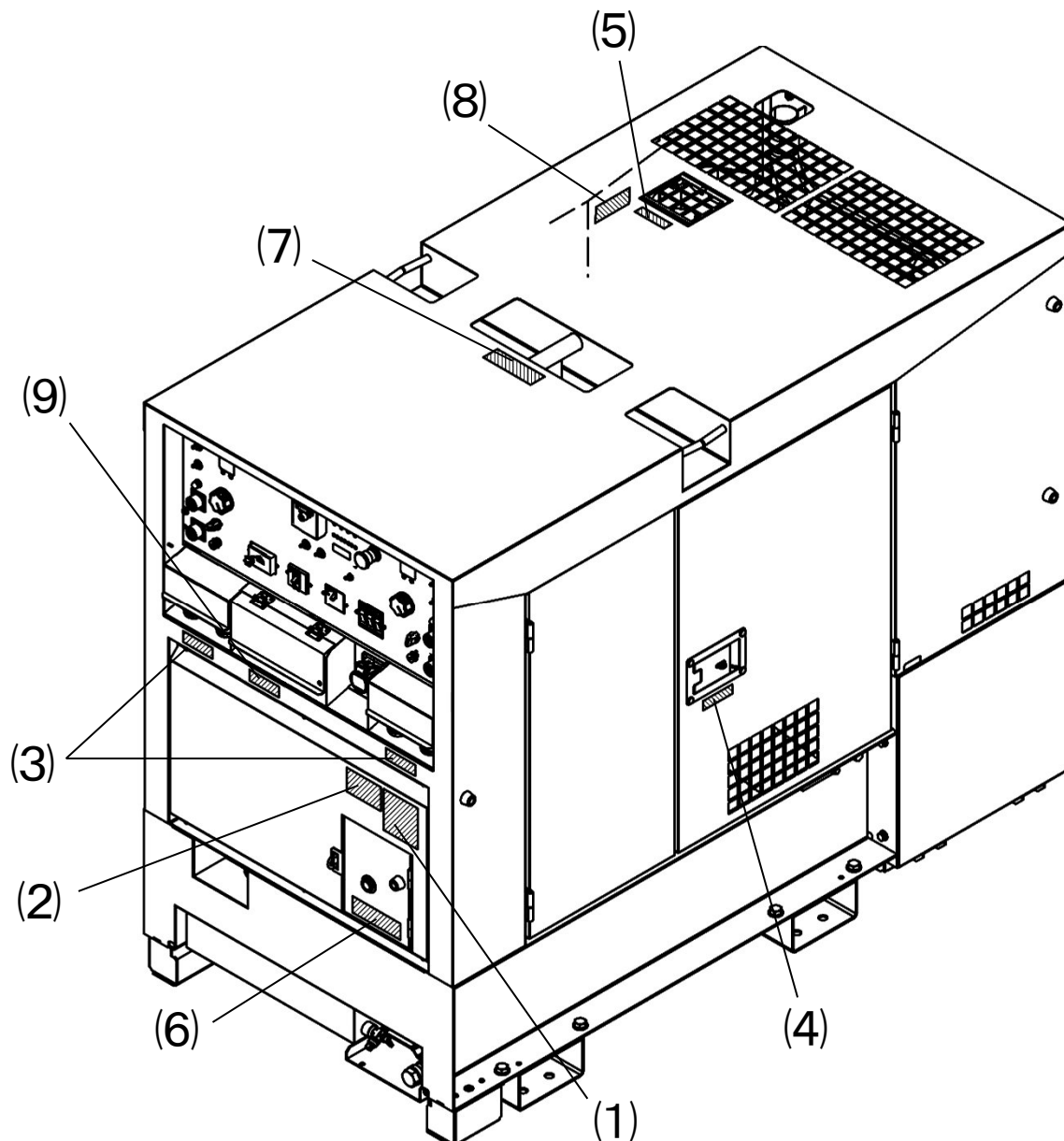
⚠ Caution: Physical and Secondary Damage

- Do not use the equipment for any improper applications. Improper usage can result in an accident or malfunction.
- Do not connect the AC power source to indoor wiring.
- If using the equipment as a power source for medical equipment, you must check with the medical equipment manufacturer, doctor and hospital before using the equipment.
- Set the frequency in accordance with the devices using the equipment.

■ Location of Warning/Caution Labels

Replace warning or caution labels when they become difficult to see or damaged by affixing new labels in the specified locations. Order the necessary labels by numbers in parentheses.

- (1) Suffocation from Exhaust Fume (No. X505-007590)
- (2) Suffocation from Welding Fume (No. X505-007600)
- (3) Electric Shock (No. X505-007610)
- (4) Injury (No. X505-007630)
- (5) Burn (No. X505-007620)
- (6) Fire (No. X505-007650)
- (7) Injury (No. X505-007550)
- (8) Burns (No. X505-007660) ※Left side
- (9) Electric Shock (No. X505-007680)



2. Specifications

(50 / 60Hz)

Model				DGW600DM-D4V			
Generating Method				Rotating Field			
Welding Generator	Operation			Single		Dual	
	CC DROOP	Rated Current (A)		570		300	
		Rated Voltage (V)		42.8		32.0	
		Duty Cycle (%)		60		100	
		Current Adj. Range (A)		30 – 600		30 – 340	
		Welding Rod (Φ)		2.0 – 8.0		2.0 – 6.0	
		Gouging Rod (Φ)		3.2 – 11.0		3.2 – 8.0	
	CV	Rated Current (A)		520		300	
		Rated Voltage (V)		40.8		28.0	
		Duty Cycle (%)		100		100	
		(Current Adj. Range (A))		(60 – 600)		(60 – 340)	
		Voltage Adj. Range (V)		14 – 44		14 – 32	
		Welding Wire (Φ)	MIG/MAG		0.6 – 1.2		0.6 – 1.2
	Self-shielded		0.9 – 2.4		0.9 – 2.4		
Rated Speed (min ⁻¹)			1500 / 1800				
No Load Voltage (V)			MAX 85				
AC Generator	Rated Frequency (Hz)			50 / 60			
	Rated Speed (min ⁻¹)			1500 / 1800			
	Phase			1 Phase		3 Phase	
	Rated Voltage (V)			220 / 240		380 / 415	
	Rated Current (A)			14.5Ax1 / 15Ax1		27.3A / 30A	
	Rated Output (kVA)			3.2 / 3.6		18.0 / 21.5	
	Power Factor			1.0		0.8	
	Rating			Continuous			
Engine	Model (Manufacturer)			Kubota V3600-T			
	Type			Vertical, Water-Cooled 4-Cycle Diesel Engine			
	Displacement (L)			3.620			
	Rated Output (kW / min ⁻¹)			39.4 / 1500		44.9 / 1800	
	Fuel			ASTM No.2-D Fuel or Equivalent			
	Lubricant Oil			API Class CF or better (CJ excluded)			
	Fuel Tank Capacity (L)			105			
	Lubrication Oil Volume (L)			13.2 (Effective 4.4)			
	Cooling Water Volume (L)			12.0 (Sub Tank Capacity 1.1 L included)			
	Starting Motor Capacity (V - kW)			12 – 3.0			
	Charging Alternator Capacity (V - W)			12 - 360			
	Battery Capacity (V - Ah)			12 - 55 (80D26R)			
Dimension	Length (mm)			1900			
	Width (mm)			950			
	Height (mm)			1515			
Dry Weight (kg)				1164			
Net Weight (kg)				1284			

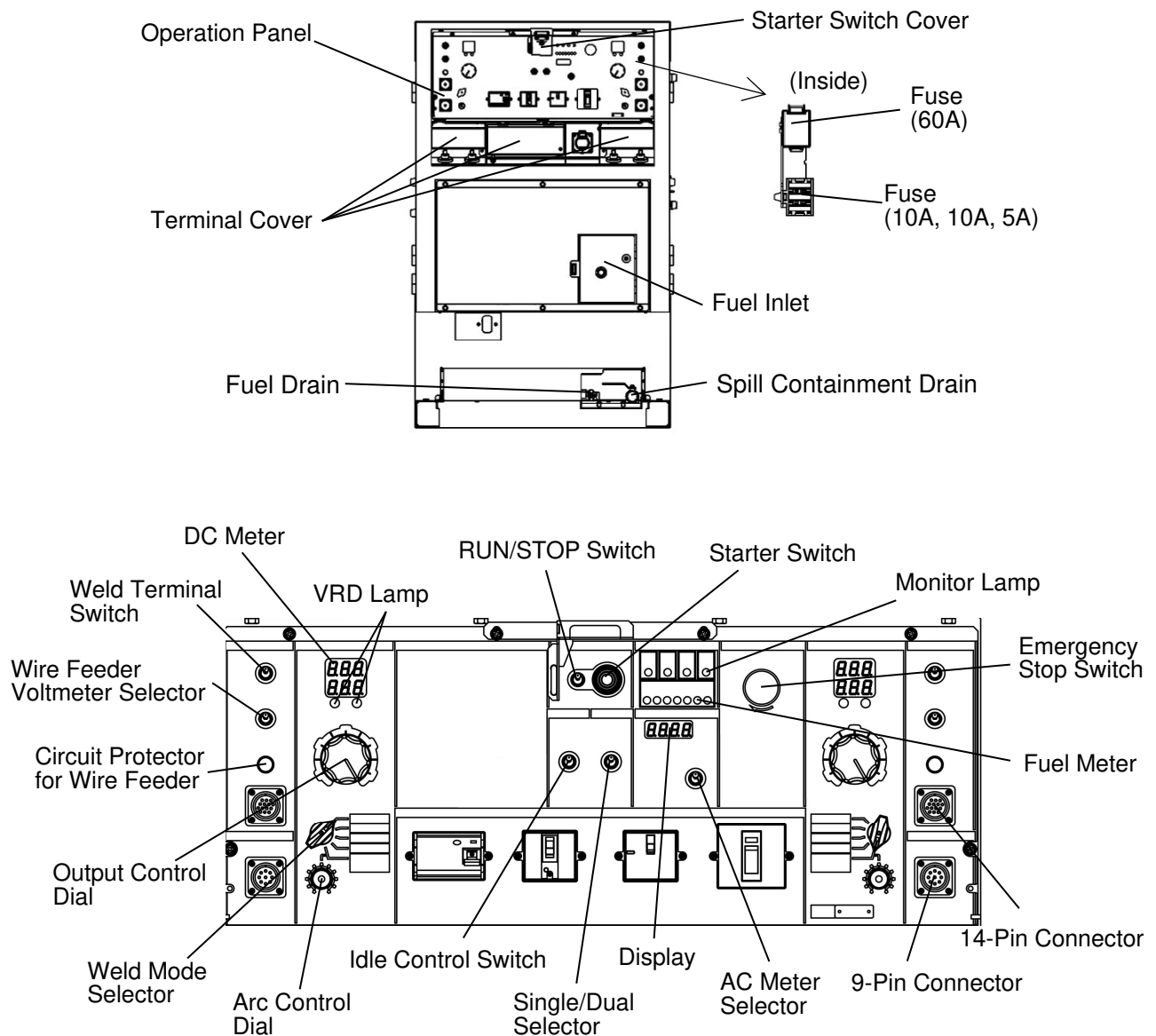
3. Applications

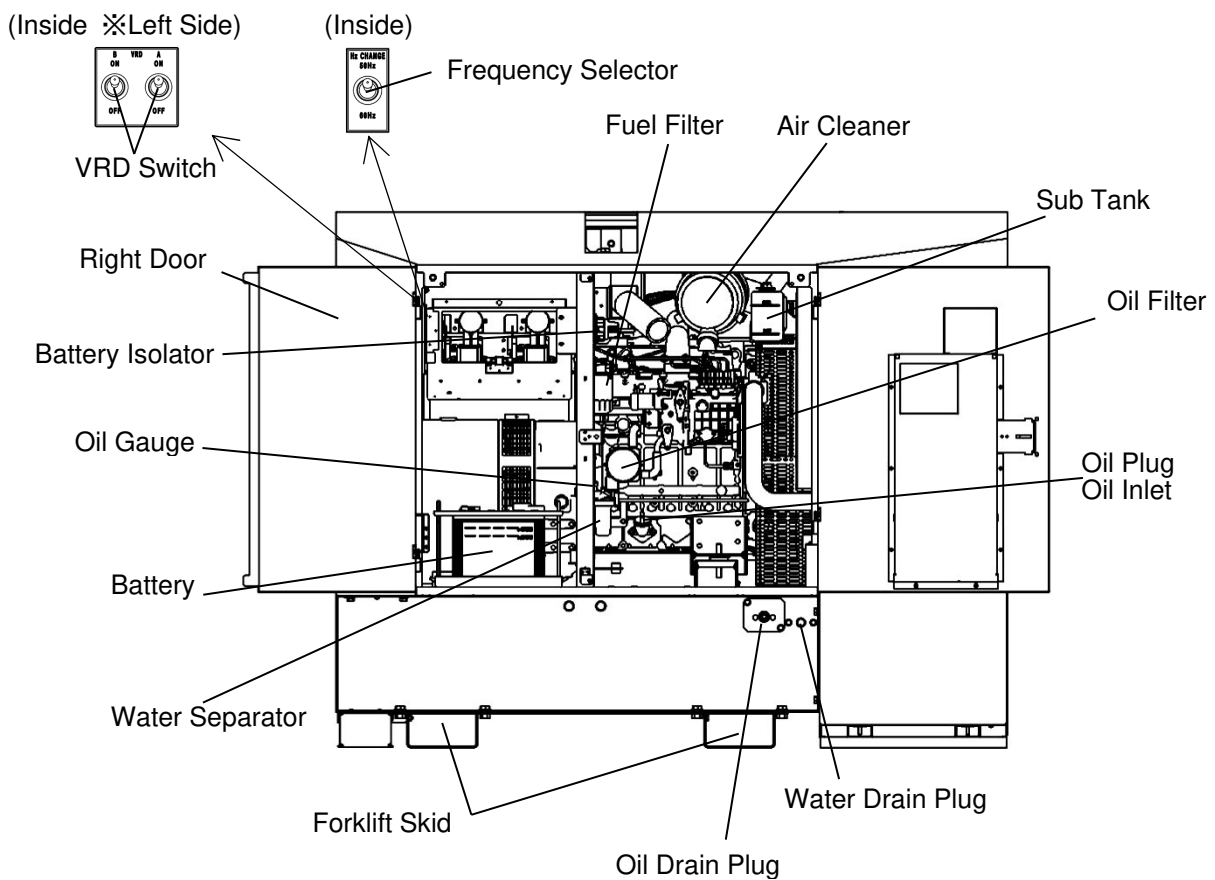
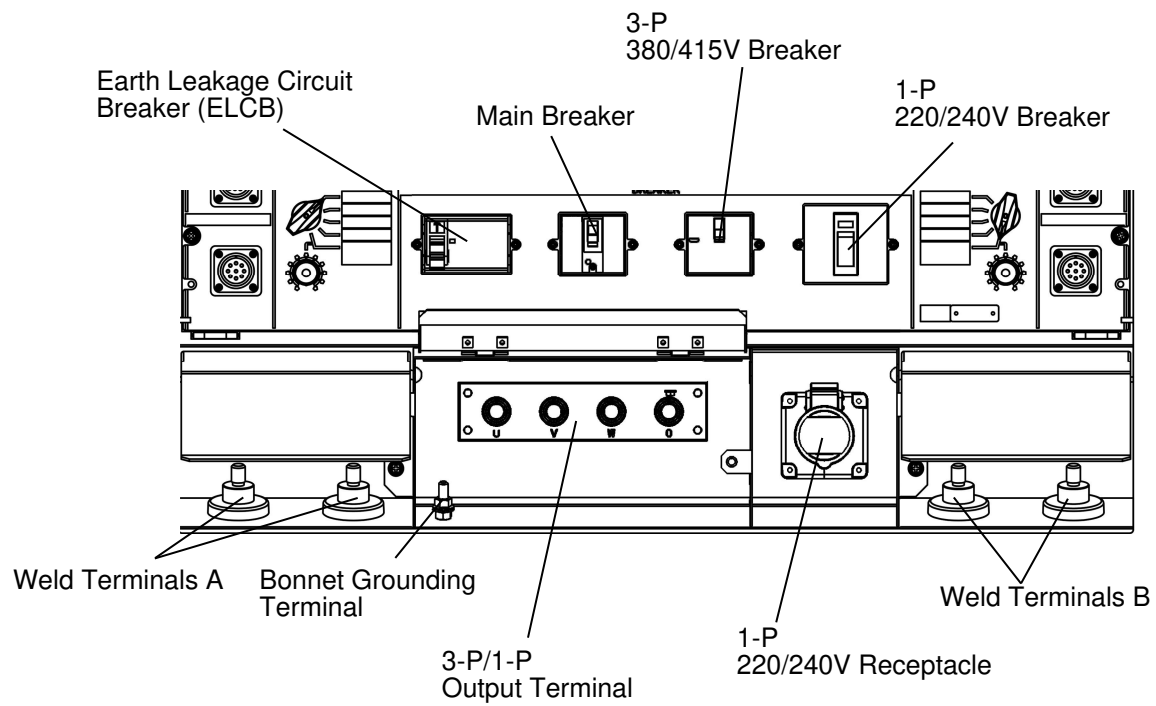
- Shielded Metal Arc Welding
- Semi-automatic Arc Welding (MIG, MAG, Self-Shielded)
- Gouging
- Lift Start TIG, Scratch Start TIG
- Power Source for Light, Electric Tools, Appliances

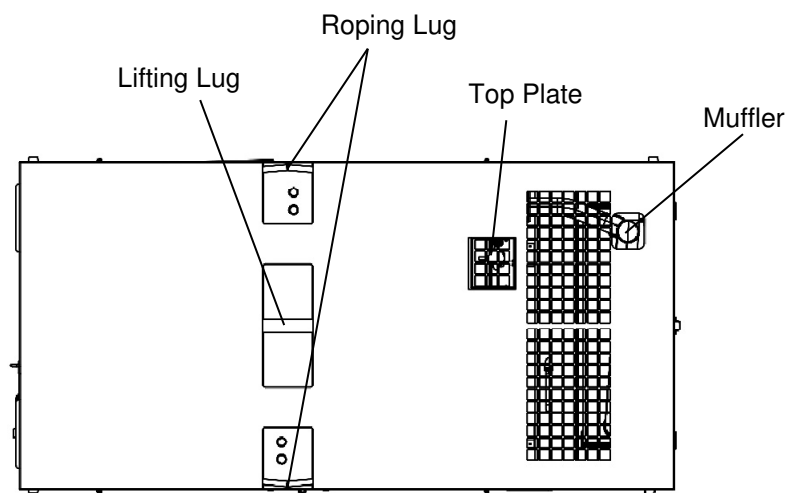
⚠ Caution: Physical and Secondary Damage

- Do not use the equipment for any applications not listed above. Improper usage can result in an accident or malfunction.
- If using the equipment as a power source for medical equipment, you must check with the medical equipment manufacturer, doctor and hospital before using the equipment.

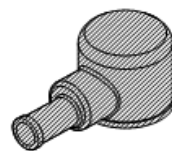
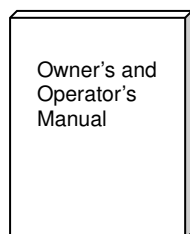
4. Part Names



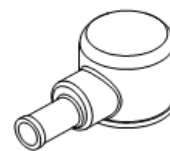




Accessories



Terminal Cap
(Black/For [-]) 2 parts



Terminal Cap
(Red/For [+]) 2 parts

5. Equipment

5-1. Spill Containment

⚠ Warning: Fire

- Always be sure to wipe up any spilled fuel or oil.
- Spilled fuel and oil accumulates in the spill containment. Do not operate the equipment with liquid accumulated in the spill containment.
- Absolutely never use the equipment if there is a fuel, oil or cooling water leak, and be sure to always repair the leak before using.

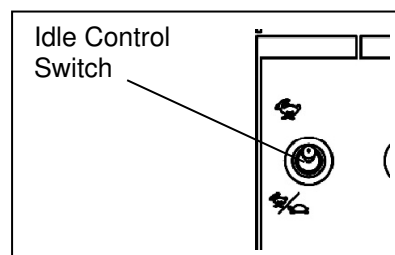
The equipment includes a spill containment (structure that collects leaking liquid) in order to prevent leaking liquid from getting outside of the equipment if oil, fuel or other liquid should leak. Before starting operation, check if there is any fluid accumulated in the spill containment and drain any accumulated liquid. (Refer to section "12.(8) Draining Liquid from the Spill Containment".)

<Note>

- It is necessary to periodically drain the liquid from within the equipment because any rainwater that leaks into the equipment also accumulates in the spill containment.
- Although the fluids that can leak internally consist of oil, fuel and cooling water, the spill containment does not have a function that can separate rainwater that has leaked into the equipment from these internally leaked fluids. Properly dispose of liquid drained from the spill containment in a manner according to the applicable laws and regulations.

5-2. Idle Control

The equipment includes an idle control function. You can use the idle control switch to select an engine speed setting of "AUTO" or "HIGH".



(1) Auto Idle

The equipment includes an auto idle function in order to reduce noise, save fuel, and reduce exhaust gas emission.

You can set the idle control switch to "AUTO" so that the engine operates at low speed when not welding or using the equipment as a power source.

When you start to weld or use as an AC power source, the engine automatically increases to high speed. When in a no-load condition, the engine automatically returns to low speed after approximately 8 seconds of high-speed operation.

<Note>

- Set the idle control switch to "HIGH" if using a high capacity motor, precision instruments or AC load with an attached magnetic switch.
- Set the idle control switch to "HIGH" if using as an AC power source of a device of 0.5A or less because the engine might not reach a high speed as speed control does not operate at that level.

(2) High Idle

You can set the idle control switch to "HIGH" to maintain the engine constantly at high speed.

5-3. Weld Output Control

(1) Weld Mode Selector

You can select a weld mode of "CV-WIRE", "DROOP-STICK", "GOUGING", "LIFT START TIG" or "CC-STICK" in accordance with the type of welding being performed.

■ CV (Constant Voltage) -WIRE

You can use the equipment as a power source for semi-automatic arc welding (MIG, MAG and self-shielded).

■ DROOP (Drooping Characteristic)-STICK, GOUGING

The weld current can be adjusted by manipulating the welding rod due to being able to increase or decrease the current for changing the arc length, thereby allowing you to adjust the arc status and weld beads.

The arc start is good and the arc is strongly felt.

This mode is optimal for welding work such as pipe welding or when using special welding rods.

■ LIFT START TIG

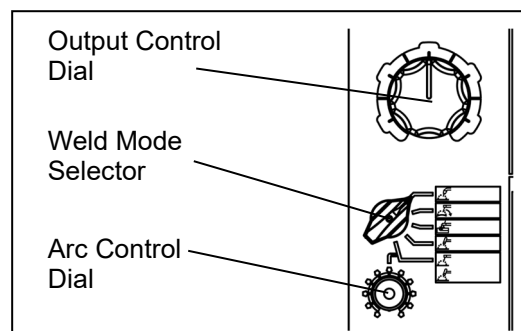
The (DC) TIG welding (Lift Start) is available in this mode. The arc is generated by bringing the tungsten electrode into contact with the base material once and then lifting it up.

■ CC (Constant Current) -STICK

Welding can be performed at a constant uniform current even if the arc length changes due to a shaky hand or similar cause to provide a stable arc that is not easily extinguished.

Welding can be performed at a specified current value without being affected by the length or thickness (thinness) of the welding cable.

This mode is optimal for general welding as the stable arc reduces the amount of spatter.



(2) Weld Output Pre-Set

The equipment includes a weld output pre-set function.

If the weld mode selector is set to "CV-WIRE", you can pre-set the output voltage using the output control dial.

If the weld mode selector is set to "DROOP-STICK", "GOUGING", "LIFT START TIG" or "CC-STICK", you can pre-set the output current using the output control dial.

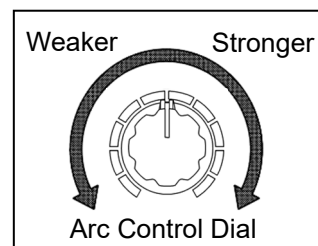
(3) Arc Control (for CC-STICK mode)

The equipment includes an arc control function that adjusts the arc strength.

You can adjust the setting of the short-circuit current of the weld output by turning the arc control dial.

<Note>

- The arc control function is only for "CC-STICK" mode. It does not function if using "CV-WIRE", "DROOP-STICK", "GOUGING" or "LIFT START TIG".
- Always turn the arc control dial to "0"(zero) when the scratch start TIG welding is functioned otherwise a welding current becomes unstable as the arc control is functioned.

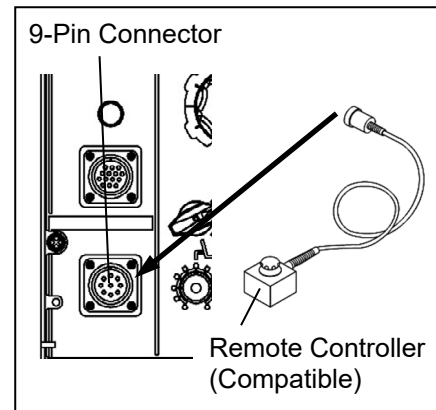


5-4. Remote Control (9-Pin Connector)

You can connect a compatible remote controller to the 9-pin connector to enable remote operation of weld output adjustment.

<Note>

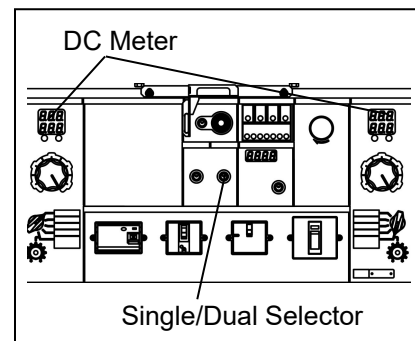
- The output control dial for the remote control connection side of the equipment does not function when a remote controller is connected.
- If the remote controller is removed from the remote controller receptacle while welding, the equipment output control dial becomes functional, possibly resulting in a sudden increase or decrease in weld output.



5-5. DC Meter

The equipment includes a DC meter (DC Ammeter - Voltmeter) that provides digital display of both weld current and voltage.

The DC ammeter and voltmeter display the weld output for both outputs A and B separately. If the single/dual selector is set to "SINGLE", the DC meter for output B does not display current or voltage.



<Note>

- If the weld mode selector is set to "CV-WIRE", the set voltage that has been pre-set using the output control dial is displayed by the voltmeter when not welding. (The DC ammeter display is blank when not welding.)
- If the weld mode selector is set to "DROOP-STICK", "GOUGING", "LIFT START TIG" or "CC-STICK", the set current that has been pre-set using the output control dial is displayed by the DC ammeter when not welding. (The voltmeter display is blank when not welding.)
- During welding, both the DC ammeter and voltmeter display the actual output values. When welding is completed, both meters display the actual output values for approximately 8 seconds, after which display returns to the pre-set values.

5-6. Display

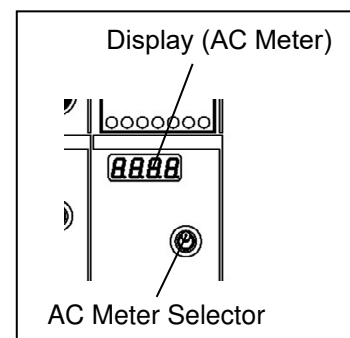
The equipment includes a display that provides operation status.

(1) AC Meter

The equipment includes an AC Meter that displays the three phase 380/415V generated output. The AC meter is equipped with an AC Meter Selector that can be switched to display voltage, current or frequency.

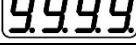
<Note>

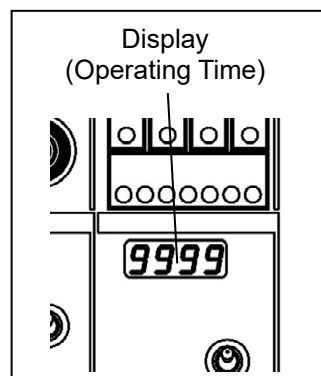
During operation, the three phase 380/415V output voltage of the AC power source is constantly displayed regardless of whether the breaker is set to "ON" or "OFF".



(2) Hour Meter

When the RUN / STOP SWITCH is set to "RUN" while the engine is stopped, the display indicates operating time. Refer to the table below for the display 10,000 hours or more. (Maximum indication up to 49,999 hours)

Operating Time Guide	
Operating Time	Display
0 - 9,999	 -
10,000 - 19,999	 :One dot lights up
20,000 - 29,999	 :Two dots light up
30,000 - 39,999	 :Three dots light up
40,000 - 49,999	 :Four dots light up

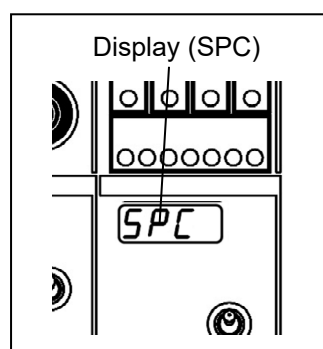


(3) Spill Containment Inspection

The display of spill containment inspection ("SPC") lights up if the level of liquid in the spill containment is approximately approx. 18 L in order to ensure that liquid accumulated in the spill containment does not spill out of the equipment. If this occurs, drain the accumulated liquid from the equipment. (Refer to section "12.(8) Draining Liquid from the Spill Containment".)

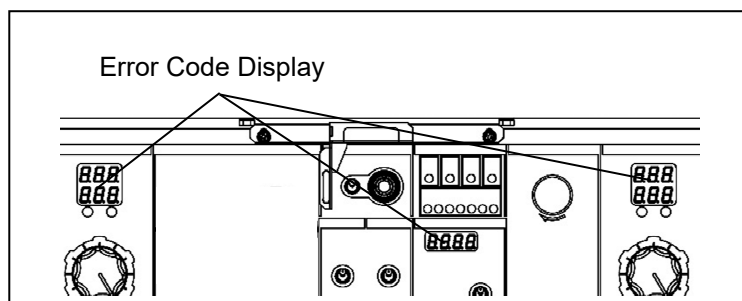
<Note>

- The engine is not stopped if the spill containment monitor lamp lights up during operation.
- When the spill containment monitor lamp lights up during operation, stop the engine, check for fuel, oil and cooling water leakage, and repair as necessary.
- Do not use the equipment with liquid accumulated in the spill containment. Drain the spill containment before using. (Refer to section "12.(8) Draining Liquid from the Spill Containment".)



5-7. Error Code Display

The equipment includes an error code display function that notifies the operator of any errors during operation. If an error is detected during operation, error codes are displayed by the DC and AC meters. If this occurs, stop operation immediately, and inspect and repair the location where the error has occurred. (Refer to section "14. Troubleshooting".)



5-8. Monitor Lamp

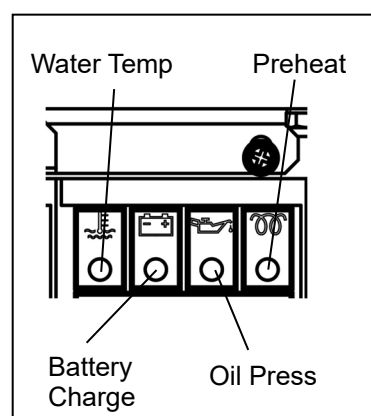
⚠ Warning: Injury/Electric Shock

- Do not operate the equipment with any doors or covers open. There is a danger of hair, body parts and other items being caught up in moving parts such as cooling fans and belts.

⚠ Caution: Burn

- The engine, muffler and similar parts are extremely hot during operation and immediately after stopping the equipment. Never touch hot parts.
- Never open the radiator cap during operation or immediately after stopping the equipment. Hot cooling water and steam will spurt out.
- Always be sure to stop the engine and allow it to cool before inspecting or changing the engine oil. Opening the oil gauge or oil plug during operation will result in hot oil spurting out.

The equipment includes monitor lamps for water temperature, battery charge and oil pressure. If the equipment is normal, the "CHARGE", "OIL PRESS" and "PREHEAT" monitor lamps light up when the RUN/STOP switch is switched to "STOP" to "RUN", and all monitor lamps turn off when the engine is started. If any error occurs during operation, the corresponding monitor lamp lights up and the engine is automatically stopped. If the engine is automatically stopped, return the RUN/STOP switch to "STOP" and restart the engine. Watch the lit/unlit status of the monitor lamps the next time an automatic stop occurs and check the error contents.



(1) Water Temperature Monitor Lamp

The water temperature monitor lamp ("WATER TEMP") lights up and the engine is automatically stopped if the cooling water temperature becomes irregularly high during operation. If this occurs, inspect the water level of the sub tank and add cooling water if the water level is insufficient. (Refer to section "7-2 Cooling Water Inspection".) If the cooling water in the sub tank is at the specified level, it is probable that overloading is the cause. Use within the rated output.

(2) Battery Charge Monitor Lamp

The battery charge monitor lamp ("CHARGE") lights up and the engine is automatically stopped if battery charge fails during operation. If this occurs, it is probable that there is fan belt damage or a wiring fault. Request repair at the retail outlet where the equipment was purchased.

(3) Oil Pressure Monitor Lamp

The oil pressure monitor lamp ("OIL PRESS") lights up and the engine is automatically stopped if the engine oil pressure drops during operation. If this occurs, inspect the engine oil level and fill with engine oil until it reaches the maximum level.

<Note>

- The oil pressure monitor cannot detect oil deterioration. Change the engine oil periodically. (Refer to section "12. Inspection/Maintenance".)
- The charge monitor cannot detect battery deterioration or insufficient battery fluid. Inspect the battery fluid level periodically. (Refer to section "7-6. Battery Inspection".)
- Inspect the fuses if the engine is automatically stopped and none of the monitor lamps ("WATER TEMP", "CHARGE" and "OIL PRESS") light up. (Refer to section "4. Part Names" for fuse location.)
If a fuse has blown, it is probable that there is a fault in an electric part or the wiring. Request repair at the retail outlet where the equipment was purchased.

5-9. Earth Leakage Circuit Breaker and Grounding

⚠ Warning: Electric Shock

- Always be sure to repair the corresponding earth leakage location when earth leakage circuit breakers operate.

⚠ Warning: Fire

- Do not ground wiring of earth leakage circuit breakers of the equipment to piping that passes through flammable material.

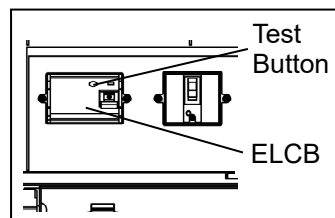
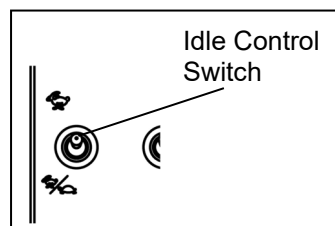
The equipment includes earth leakage circuit breakers (solidly grounded type) in order to prevent electric shock. Immediately isolate the electrical circuit if earth leakage occurs due to insulation failure in devices using the equipment or similar reason.

(1) Operation Check of Earth Leakage Circuit Breaker

Be sure to always check the earth leakage circuit breakers before starting operation according to the following procedures.

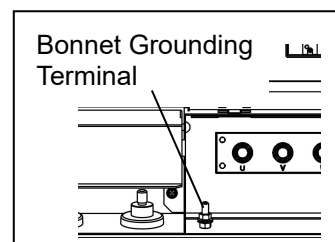
- 1) Start the engine.
(Refer to section "8-1. Starting the Engine".)
- 2) Set the idle control switch to "HIGH".
- 3) Set the ELCB lever to "ON".
- 4) Press the ELCB test button.
Operation is normal if the ELCB lever lowers and turns off at this time.
- 5) Push up the ELCB lever to the "ON" position.

There is a fault in the earth leakage circuit breakers if operation cannot be checked according to the above procedures. Request repair at the retail outlet where the equipment was purchased.



(2) Bonnet Grounding Terminal

The equipment includes a bonnet grounding terminal in order to connect bonnet ground wire.
A neutral point of the AC power source is connected to the bonnet grounding terminal.



<Note>

- Connect using a plug with a grounding pole.
- If using a plug without a grounding pole, perform grounding work and check that used devices are connected to ground.
- Securely ground the bonnet grounding terminal to the metal frame of the vehicle if transporting the equipment by truck or trailer.

(3) If an Earth Leakage Circuit Breaker Operates

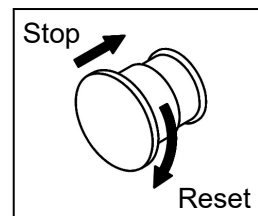
⚠ Caution: Electric Shock/Injury

- Always be sure to turn off the power switches of all devices using the equipment when turning on the equipment breakers after an earth leakage circuit breakers operates. Leaving on the power switch of a device using the equipment when the equipment breakers are turned on could result in the sudden operation of the corresponding device.

The ELCB lever moves to "OFF" when earth leakage circuit breakers operate. When this occurs, immediately stop the engine and repair the earth leakage location. After repairing all faults, push up the ELCB lever to the "ON" side to reset the system.

5-10. Emergency Stop Switch

Press the emergency stop switch to stop the engine immediately. After pressing the emergency stop switch, securely return the RUN/STOP switch to the "STOP" position and turn the emergency stop switch clockwise to reset the switch.



5-11. Frequency Selector

⚠ Warning: Injury/Electric Shock

- Do not operate the equipment with any doors or covers open. There is a danger of hair, body parts and other items being caught up in moving parts such as cooling fans and belts.

⚠ Caution: Burn

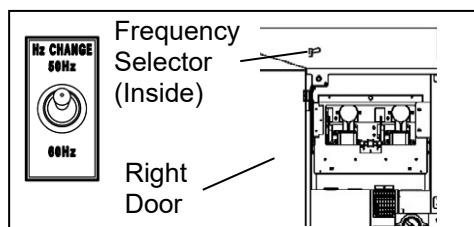
- The engine, muffler and similar parts are extremely hot during operation and immediately after stopping the equipment. Never touch hot parts.

⚠ Caution: Physical and Secondary Damage

- Set the frequency in accordance with the devices using the equipment.

This equipment can operate at either 50Hz or 60Hz.

Set the frequency selector located inside the right door to change the frequency in accordance with the devices using the equipment.



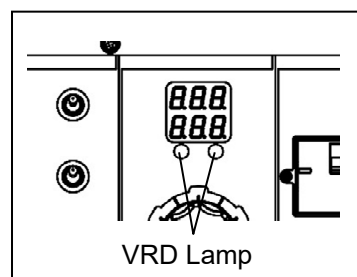
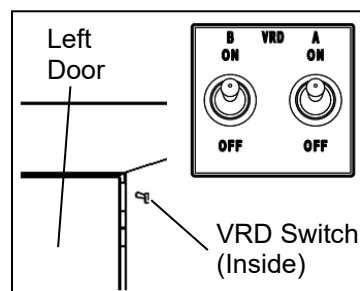
5-12. VRD (Voltage Reduction Device)

The equipment includes a voltage reduction device on the weld output side. The voltage reduction device reduces the output voltage of the welder when welding is paused in order to further increase safety when welding in locations with high humidity, elevated locations, extremely confined spaces near possible hazards, and similar conditions. The voltage reduction device can be operated individually on the A side and B side.

When not welding, the voltage reduction device reduces the voltage of the Weld output terminals to 35V or less.

When welding is started, the voltage-reduction function is cancelled and the equipment returns to the reduced voltage status when welding is completed. Turning the VRD switch to "OFF" also cancels the voltage-reduction function.

The green VRD lamp ("BELOW 35V" side) lights up when weld output voltage is less than 35V and the red lamp ("AT OR ABOVE 35V" side) lights up when the voltage is 15 V or more.



<Note>

- The VRD is only for weld output. It does not function for AC generated output voltage.
- The VRD lamp lights up only when the VRD switch is set to "ON".
- ~~The VRD is only for "CC-STICK" mode. It does not function if using "CV WIRE" or "LIFT START TIG", and it does not output if using "DROOP STICK" or "GOUGING".~~

5-13. Wire Feeder Control

A wire feeder with a 14-pin plug can be used with this equipment.

(1) 14-Pin Connector

Connecting the 14-pin plug of a wire feeder to the 14-pin connector of the equipment allows you to adjust the output voltage by using the wire feeder.

(2) Weld Terminal Switch

Voltage is constantly output from the equipment weld terminals when the weld terminal switch is set to "WELD TERMINALS ON".

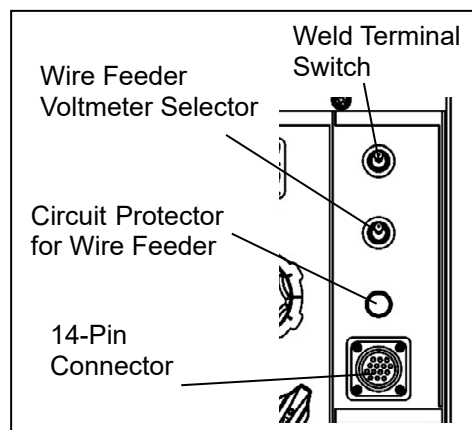
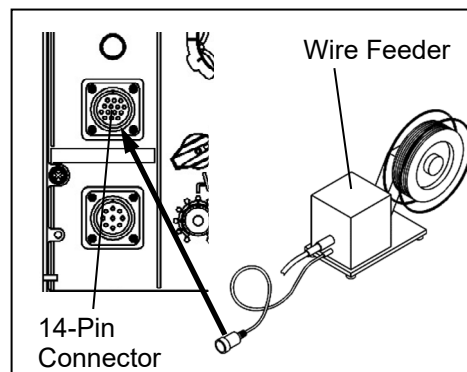
When the weld terminal switch is set to "REMOTE CONTROL", voltage is output from the equipment weld terminals only when the torch switch is set to "ON".

(3) Wire Feeder Voltmeter Selector

By switching the wire feeder voltmeter selector, you can select the polarity of the voltmeter display equipped to the wire feeder.

(4) Circuit Protector for Wire Feeder

The circuit protector for the wire feeder operates to stop the current if there is an overcurrent of 5A or more in the wire feeder.



<Note>

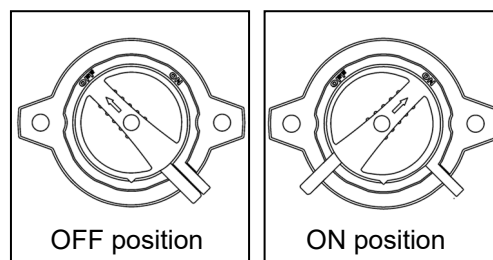
- When the circuit protector for the wire feeder operates due to an overcurrent fault, inspect for the fault and press the circuit protector button after resolving the fault in order to reset the system.

5-14. Battery Isolator

Turn the battery isolator to the "OFF" position to isolate the battery wiring of the engine electrical circuit.

<Note>

- Do not switch the battery isolator while the engine is operating. Doing so can cause a malfunction.



6. Transporting

⚠ Warning: Injury

- The lifting lug is designed to be used only for lifting the equipment. Do not lift the equipment with any heavy items (such as a trailer, gas canister and additional fuel tank) added to the equipment.
- When lifting the equipment, always use a lifting lug. Do not lift the roping lug, for it may cause equipment to drop due to roping lug breaking off.

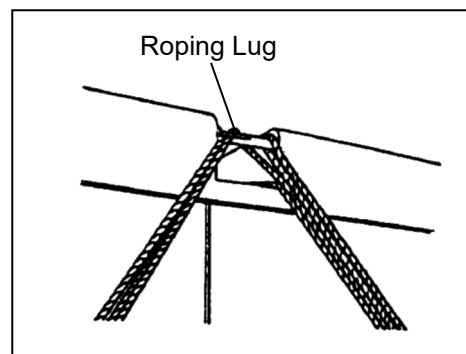
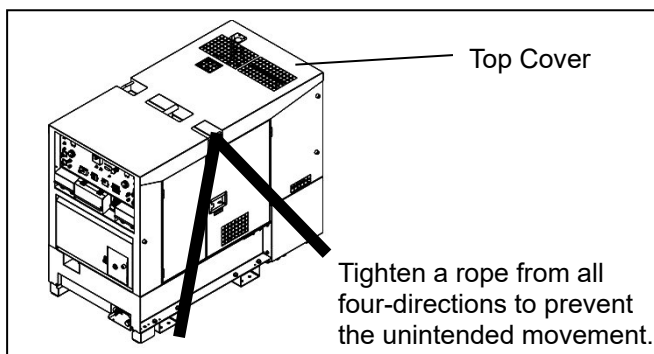
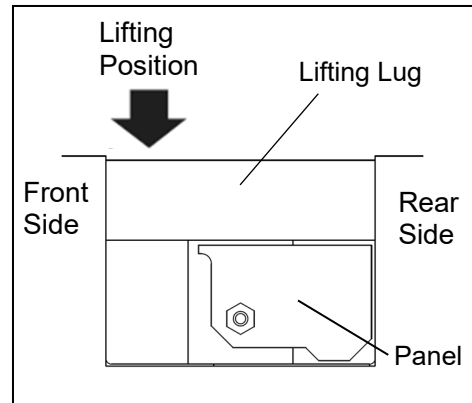
⚠ Caution: Injury

- Do not move the equipment during operation.
- Always be sure to use the lifting lug when lifting the equipment, and lift slowly and directly straight above.
- Wear a helmet, safety shoes, gloves and similar protective gear when performing lifting work. Do not stand or get under the equipment while it is suspended.

Always be sure to fix the equipment securely when transporting the equipment.

<Note>

- Tighten a rope from all four-directions to protect against unintended movement when this equipment intends to transport.
- Handle the equipment with great care when raising, lowering and transporting. Rough handling of the equipment can result in damage or malfunction.
- Do not remove the panel.



7. Pre-Operation Inspection

⚠ Warning: Injury/Electric Shock

- Do not operate the equipment with any doors or covers open. There is a danger of hair, body parts and other items being caught up in moving parts such as cooling fans and belts.
- Always be sure to stop the engine before performing any equipment check or maintenance.

⚠ Warning: Fire

- Always be sure to wipe up any spilled fuel or oil.
- Spilled fuel and oil accumulates in the spill containment. Do not operate the equipment with liquid accumulated in the spill containment.
- Absolutely never use the equipment if there is a fuel, oil or cooling water leak, and be sure to always repair the leak before using.
- Absolutely never inspect or perform maintenance to the equipment near fire or other open flame.

⚠ Caution: Burn

- The engine, muffler and similar parts are extremely hot during operation and immediately after stopping the equipment. Never touch hot parts.

7-1. Engine Oil Inspection

⚠ Caution: Burn

- Always be sure to stop the engine and allow it to cool before inspecting or changing the engine oil. Opening the oil gauge or oil plug during operation will result in hot oil spurting out.

Situate the equipment on a level surface and completely insert the oil gauge to inspect the oil level.

Inspect the oil level before starting operation and, if it has decreased, fill with oil until it reaches the maximum level.

<Note>

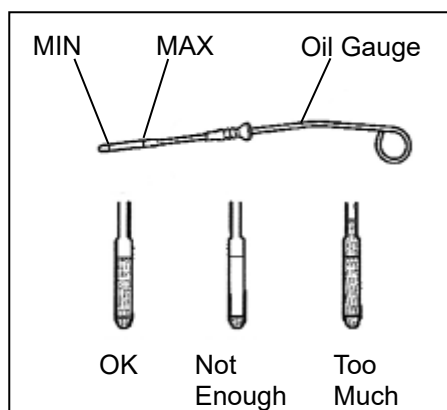
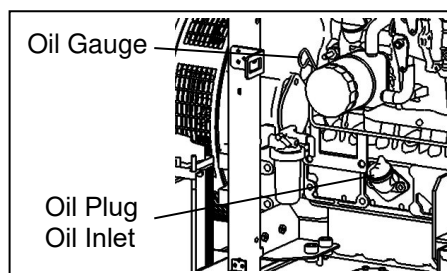
- The oil level cannot be accurately checked if the equipment is at an angle.
- Operating the equipment when the oil has been filled above the maximum level can result in engine cylinder internal damage.

■ Engine Oil Selection

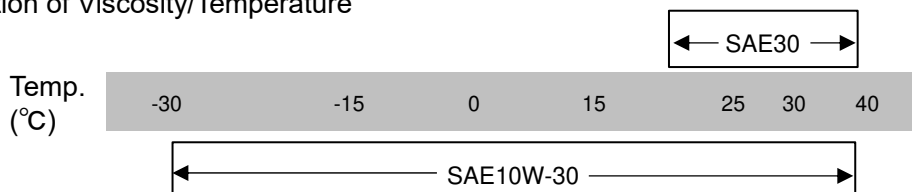
Use a diesel-type engine oil with a viscosity that is appropriate for the outdoor air temperature (refer to the table).

<Note>

- Use oil with a quality of CF class or better (API classification / CJ excluded).



○ Relation of Viscosity/Temperature



7-2. Cooling Water Inspection

⚠ Caution: Burn

- Never open the radiator cap during operation or immediately after stopping the equipment. Hot cooling water and steam will spurt out.

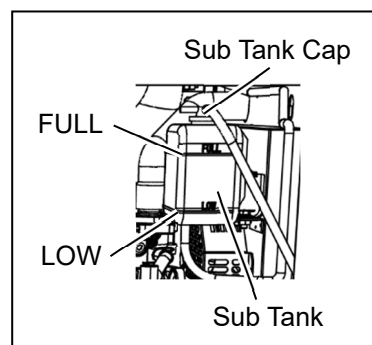
Check that the sub tank cooling water level is within the range of "FULL" and "LOW". If the cooling water level is lower than "LOW", add water to both the sub tank and radiator.

(1) Adding Water to the Sub Tank

- 1) Remove the sub tank cap.
- 2) Pour cooling water into the sub tank until it reaches the "FULL" level.
- 3) Install the sub tank cap.

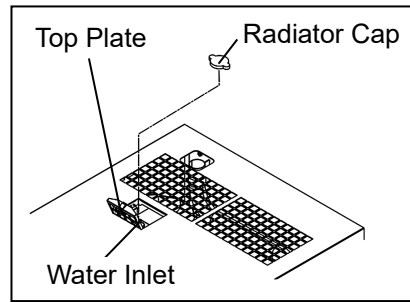
(2) Adding Water to the Radiator

- 1) Open the top plate.
- 2) Remove the radiator cap.
- 3) Pour cooling water into the radiator through the inlet port until it reaches the mouth of the port.
- 4) Tighten the radiator cap.
- 5) Close the top plate.



<Note>

- Use a long-life coolant (LLC) in order to prevent freezing and rust. (An LLC with a 30% mixing ratio is used when shipped from the factory.)
- Use an LLC mixing ratio in the range 30% to 50% in accordance with the outdoor air temperature.
- Change the LLC every 2,000 hours or 1 year.



Mixing Ratio Guide

Min. Temp.	-15°C	-23°C	-35°C
Mixing Ratio	30%	40%	50%

7-3. Fuel Inspection

⚠ Warning: Fire

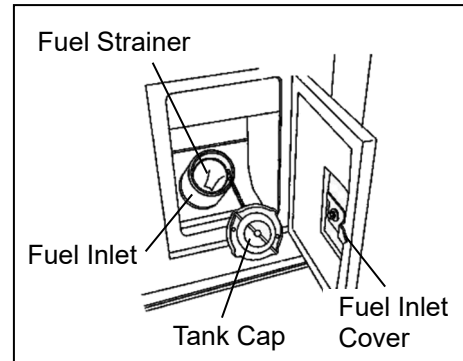
- Always be sure to stop the engine when inspecting fuel or refueling, and absolutely never perform such tasks near fire or other open flame. Wait until the engine has completely cooled before inspecting fuel or refueling.

Check that there is sufficient fuel and add fuel if insufficient.

After refueling, securely tighten the tank cap and close the fuel inlet cover.

<Note>

- Use ASTM D975 No. 2-D diesel fuel. Do not use a substitute fuel of unknown quality as this can negatively affect the engine.
- Use a cold-weather fuel that conforms to ASTM standards if using the equipment in a cold weather region.
- Always be sure to use the fuel strainer attached to the fuel inlet.
- Add fuel until the tank is slightly less than full.



<Note>

Do not use any fuel other than the specified light oil type. Doing so may lead to the problems described below.

- This machine complies with the exhaust gas regulations. If you use any type of fuel other than the specified light oil type, the machine will be a product not conforming to the exhaust gas regulations.
- Using fuel mixed with heavy oil, kerosene or alcohol, or degraded fuel may have negative effect on the machine functions (a decrease in output, start-up performance deterioration) or cause the engine to malfunction (component wear and corrosion, early deterioration of the engine oil, fuel filters or fuel hoses).

7-4. Spill Containment Inspection

⚠ Warning: Fire

- Spilled fuel and oil accumulates in the spill containment. Do not operate the equipment with liquid accumulated in the spill containment.

Open the right door, check inside of the spill containment, and drain any liquid that has accumulated. (Refer to section "12.(8) Draining Liquid from the Spill Containment".)

<Note>

- It is necessary to periodically drain the liquid from within the equipment because any rainwater that leaks into the equipment also accumulates in the spill containment.
- Although the fluids that can leak internally consist of oil, fuel and cooling water, the spill containment does not have a function that can separate rainwater that has leaked into the equipment from these internally leaked fluids. Properly dispose of liquid drained from the spill containment in a manner according to the applicable laws and regulations.

7-5. Inspection for Fuel/Oil/Cooling Water Leakage

⚠ Warning: Fire

- Absolutely never use the equipment if there is a fuel, oil or cooling water leak, and be sure to always repair the leak before using.

Open the right door and check for fuel leakage from fuel line joints and similar components, and check for oil and cooling water leakage. Open the fuel tap to perform inspection and close it after inspection has been completed.

7-6. Battery Inspection

⚠ Warning: Injury to Eyes and Skin

- Use protective gear, such as rubber gloves, when inspecting or replacing the battery due to the dilute sulfuric acid in the battery fluid. Be sure that fluid does not get into eyes, or on skin or clothing.
- If battery fluid gets into the eyes, or on the skin or clothing, immediately wash with a large amount of water, and always be especially sure to seek medical attention if it gets into the eyes.

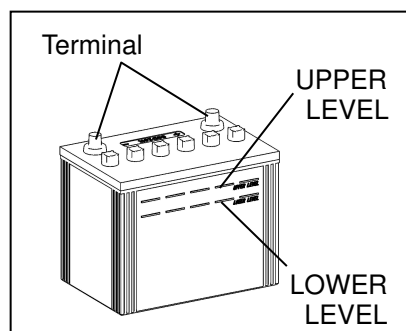
⚠ Warning: Explosion

- Do not operate the equipment or recharge the battery when the battery fluid level is below the lower level.
- Do not generate any sparks near the battery and do not allow any fire or other open flame near the equipment because the battery generates ignitable gas.

- 1) Inspect the battery fluid level. If it is near the lower level, add distilled water until it reaches the upper level.
- 2) Inspect for loose terminals and retighten if loose.

<Note>

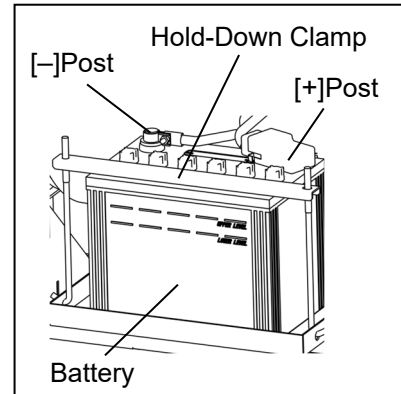
- It is necessary to recharge the battery when the specific gravity of the battery fluid is 1.23 or less. Contact the retail outlet where the equipment was purchased if this occurs.



■ Battery Replacement Procedures

- 1) Remove the " - " (negative) cable.
(Always be sure to first remove the " - " (negative) side.)
- 2) Remove the battery hold-down clamp.
- 3) Remove the "+" (positive) cable.
- 4) Remove the battery.

* Install the battery by performing the above procedures in reverse order.
(Always be sure to first attach the "+" (positive) side.)



<Note>

- Use the specified battery.< 80D26R > (Japanese Industrial Standard)

8. Operating Procedures

⚠ Warning: Suffocation from Exhaust Fume

- Do not operate the equipment in a poorly-ventilated area such as indoors or within a tunnel because the engine exhaust fume includes components that are harmful to humans.

⚠ Warning: Fire

- Keep any ignitable items (such as fuel, gas and paint) or inflammable items away from the equipment because the muffler, exhaust fume and other parts attain high temperatures.
- Provide at least 1 meter (3 feet) of distance between the equipment and walls and other obstacles, and operate the equipment on a flat surface.

⚠ Caution: Suffocation from Exhaust Fume

- Do not direct the engine exhaust towards passersby, private homes or similar persons/locations because the engine exhaust fume includes components that are harmful to humans.

⚠ Caution: Burn

- The engine, muffler and similar parts are extremely hot during operation and immediately after stopping the equipment. Never touch hot parts.

⚠ Caution: Injury

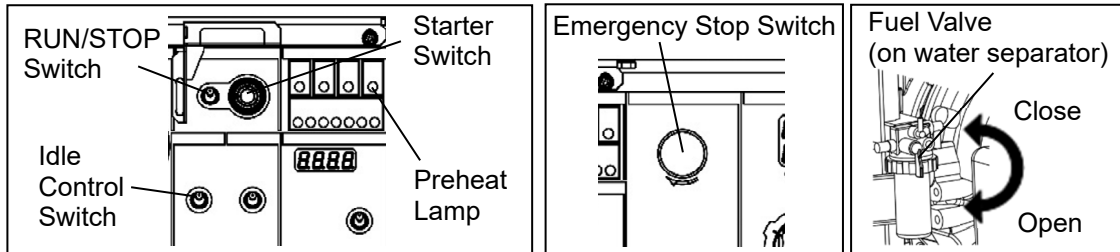
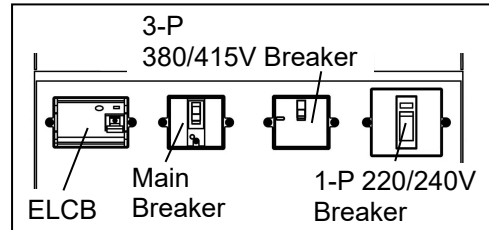
- Use this equipment with it situated on a stable level surface so that it is prevented from moving.
- Do not move the equipment during operation.
- Always be sure to turn off the switches of all devices using the equipment and turn off the equipment breakers before starting the engine.

<Note>

- Check that the surrounding area is safe before starting the engine.
- When there are multiple workers who are working together, they must mutually signal each other before starting the engine.
- Do not use in an area with high temperature or humidity, or an area with a large amount of dust.
- Do not open any doors during operation. Operating with a door open can negatively affect cooling effect, resulting in an equipment malfunction.
- Use ear protection if the level of noise is high. Failure to do so could result in hearing damage.

8-1. Starting the Engine

- 1) Turn all breakers (Main, ELCB, 3-P 380/415V and 1-P 220/240V) to "OFF".
- 2) Turn the fuel valve (on the water separator) to "OPEN".
- 3) Set the idle control switch to "AUTO".
- 4) Check that the emergency stop switch has been released.
- 5) If the temperature is 5°C or less, Set the RUN/STOP switch to the "RUN" position and wait until the preheat lamp turns off.
- 6) Push the starter switch to start the starter motor, which then starts the engine.
- 7) After the engine starts, remove your hand from the starter switch.
- 8) Allow the engine to warm up for approximately 5 minutes.



<Note>

- Do not crank the starter motor for 10 seconds or more continuously.
- If repeating starter switch operation, wait 30 seconds or more between operations.

■ Restarting after Stopping due to Running Out of Fuel

The equipment includes an automatic air-bleeding device. You can easily restart the engine according to the following procedures even if the engine stops due to running out of fuel.

- 1) Turn all breakers (Main, ELCB, 3-P 380/415V and 1-P 220/240V) to "OFF".
- 2) Turn the RUN/STOP switch to the "STOP" position.
- 3) Add fuel to the fuel tank.
- 4) Set the idle control switch to "AUTO".
- 5) Turn the RUN/STOP switch to the "RUN" position and push the starter switch to crank the starter motor for approximately 10 seconds.
- 6) After the engine starts, remove your hand from the starter switch.
- 7) Wait for air to be completely bled from the fuel pipes and engine speed to stabilize (approx. 1 minute).

*Engine speed is not stable until all air is bled from the fuel pipes.

<Note>

- Do not switch the engine to high speed or apply any loads to it until all the air has been bled from the fuel pipes (until speed is stable). Doing so can cause a malfunction.

8-2. Stopping the Engine

- 1) Turn all breakers (Main, ELCB, 3-P 380/415V and 1-P 220/240V) to "OFF".
- 2) Set the idle control switch to "AUTO".
- 3) Allow the engine to cool down for approximately 5 minutes.
- 4) Set the RUN/STOP switch to "STOP".
- 5) After the engine stops, turn the fuel lever to "CLOSE".

<Note>

- Do not stop the engine while welding or using as an AC power source. Doing so can cause a malfunction.
- If the engine does not stop when the RUN/STOP switch is set to "STOP", turn the fuel lever to "CLOSE". The engine will stop a few minutes afterwards. If the engine does not stop by RUN/STOP switch operation, stop using the equipment and request repair at the retail outlet where the equipment was purchased.

8-3. Emergency Stop

The equipment includes an emergency stop device.

Press the emergency stop switch if you want to immediately stop the engine when an emergency occurs in the work area, the equipment suffers an operating fault, and similar circumstances.

<Note>

- After stopping the engine using the emergency stop device, turn the RUN/STOP switch to "STOP".
- Do not strike the emergency stop switch with a hammer or similar tool.
- Only use the emergency stop switch for emergency stop purposes.
- If the engine does not stop when the emergency stop switch is pressed, turn the fuel lever to "CLOSE". The engine will stop a few minutes afterwards.

9. Using as a Welder

9-1. Welding Cable Selection

Use welding cables with a cross-sectional area that is larger than the proper cross-sectional areas indicated in the table below.

Using cable that is less than the proper cross-sectional area reduces the weld output.

<Note>

- Use welding cables when they are completely extended (not coiled). Using a cable that is coiled reduces the weld output.

Proper Cable Cross-Sectional Area (Units: mm²)

Return Length Weld Current	20m	30m	40m	60m	80m	100m
600A	50	80	100	150	200	250
550A	50	80	100	125	200	250
500A	38	60	80	125	200	200
450A	38	60	80	100	150	200
400A	38	50	60	100	125	200
350A	30	50	60	80	125	150
300A	30	38	50	80	100	125
250A	22	30	38	60	80	100
200A	22	30	30	50	60	80
150A	22	22	22	38	50	60
100A	22	22	22	30	30	38

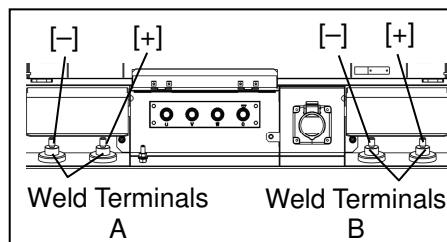
9-2. Welding Polarity

There are "+" (positive) and "-" (negative) weld output terminals.

Refer to the table below to select a polarity corresponding to the work you are performing.

<Note>

- Use the polarity indicated for the welding rods being used if so indicated.
- When welding with 2 persons using different polarities for the same base material, a single worker must not hold 2 holders because the voltage between the 2 holders could become high and there may be a danger.



(1) Shielded Metal Arc Welding, Gouging, Lift Start TIG, Scratch Start TIG

Polarity	Rod Indication	Applications	Connecting Method
Straight Polarity	DC-	- Shielded metal arc welding of structures and similar items - Lift Start TIG Welding - Scratch Start TIG Welding	+ (positive) terminal : Earth (Base material) - (negative) terminal : Holder (welding rod)
Reverse Polarity	DC+	- Shielded metal arc welding of laminates, weld overlays, stainless steel and similar materials - Gouging	+ (positive) terminal : Holder (welding rod) - (negative) terminal : Earth (Base material)

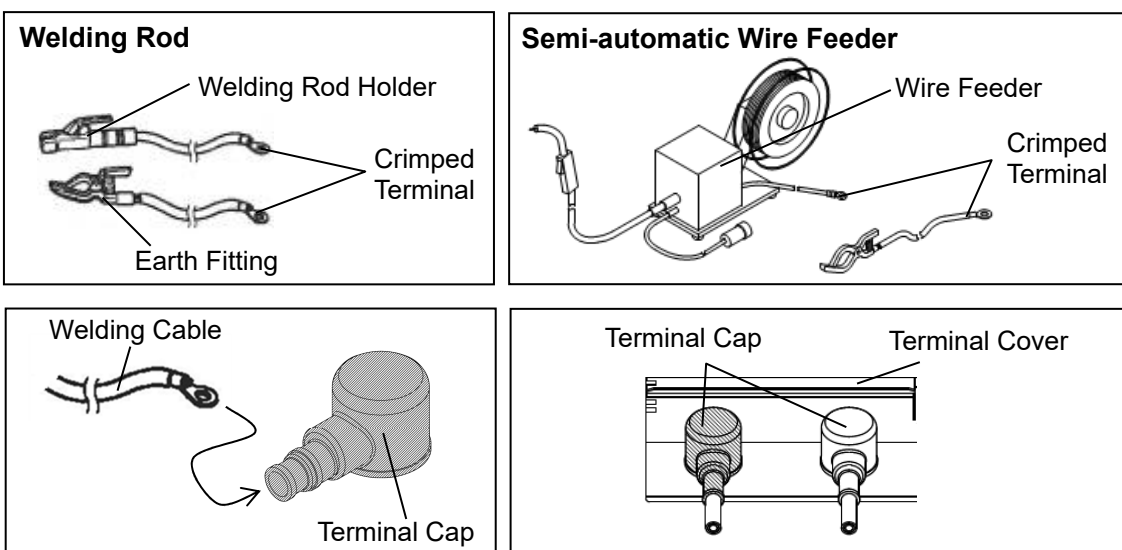
(2) Semi-automatic Arc Welding (MIG, MAG, Self-shielded)

Polarity	Wire Indication	Applications	Connecting Method
Straight Polarity	DC-	Self-shielded Arc Welding	+ (positive) terminal : Earth (Base material) - (negative) terminal : Torch (wire)
Reverse Polarity	DC+	MIG Welding, MAG Welding Self-shielded Arc Welding	+ (positive) terminal : Torch (wire) - (negative) terminal : Earth (Base material)

9-3. Welding Cable Connection

⚠ Warning: Electric Shock

- Be sure to stop the engine whenever touching Weld output terminals such as when installing or removing welding cables.



- Stop the engine.
- Install the welding cables, crimped terminals, welding rod holders (or wire feeder) and earth fittings.
- Pass the welding cables through the terminal caps.
- Connect the welding cables to the weld terminals and cover with the terminal caps. (Refer to the following table explaining the welding cable connection locations.)
- Close the terminal covers.

Amount of Welding Personnel and Welding Cable Connection Locations

Shielded Metal Arc Welding / Gouging		Semi-automatic Arc Welding	
Single	Dual	Single	Dual
Welding Rod φ2.0 - φ8.0	Welding Rod φ2.0 - φ6.0	Welding Wire	Welding Wire
Gouging Rod φ3.2 - φ11.0	Gouging Rod φ3.2 - φ8.0	MIG/MAG : φ0.6 - φ1.2 Self-shielded : φ0.9 - φ2.4	MIG/MAG : φ0.6 - φ1.2 Self-shielded : φ0.9 - φ2.4
Weld Terminals A	Weld Terminals A or B	Weld Terminals A	Weld Terminals A or B

<Note>

- Securely crimp the crimped terminals and securely connect the welding cables. Using insufficiently crimped terminals or loosely connected cables can result in heat generation from poor connection, thereby causing burnout of the weld output terminals. Also do not use iron washers, etc., as it may cause heat generation.
- Be sure to always securely crimp the crimped terminals on the cables connected to the Weld output terminals. Not using crimped terminals and simply wrapping stripped cable around the weld output terminal can result in heat generation from poor connection, thereby causing burnout of the weld output terminals and a short circuit due to contact of the cable core with the equipment body.
- Keep your welding cable and electrode holder in good condition. Repair or replace any damaged insulation.

9-4. Duty Cycle

The duty cycle is the percentage of time the load is being applied in a 10-minute period. For example a 60% duty cycle, represents 6 minutes of load and 4 minutes of no-load in a 10-minute period.

<Note>

- Continuing to weld beyond the rated duty cycle with the rated output can result in equipment overheating and corresponding malfunctions.

9-5. Welding Work

⚠ Warning: Suffocation from Welding Fume

- Always be sure to wear a fume-proof mask when welding as the fumes generated during welding include harmful gases and dust. Also be careful that the wind direction is not such that it will cause fumes to be inhaled and always operate the equipment in a well-ventilated area.

⚠ Warning: Fire

- Keep any ignitable items (such as fuel, gas and paint) or inflammable items away from the work area due to the scattering of weld spatter that occurs during welding.

⚠ Warning: Electromagnetic Interference

- Persons using a heart pacemaker are not allowed near the welder or welding work area while welding is being performed without the permission of a doctor. The welder generates a magnetic field while energized that can negatively affect pacemaker operation.

⚠ Caution: Burn

- Always be sure to wear leather gloves, apron, shoe covers, arc-proof glasses (face shield), safety shoes, hard hat and long-sleeve clothing to protect against the scattering of weld spatter that occurs during welding.

⚠ Caution: Injury to Eyes and Skin

- Always be sure to wear arc-proof glasses (refer to the table below), clothes that completely cover the skin and other protective gear when welding to protect the eyes and skin from harmful light rays generated during welding.

Standards for Arc-Proof Glasses (Japanese Industrial Standard)

Filter No.		7	8	9	10	11	12	13	14	15	16
Weld Current (A)	Shielded metal arc welding	35-75		76-200			201-400		400-	—	
	Gas-shielded arc welding	---	---	100 or less		101-300		301-500		500-	
	Gouging	---	---	---	126-225		226-350		350-		

⚠ Caution: Electric Shock

- If wearing gloves, be sure to always wear gloves with dry insulation properties. Do not wear gloves that are damaged or wet.

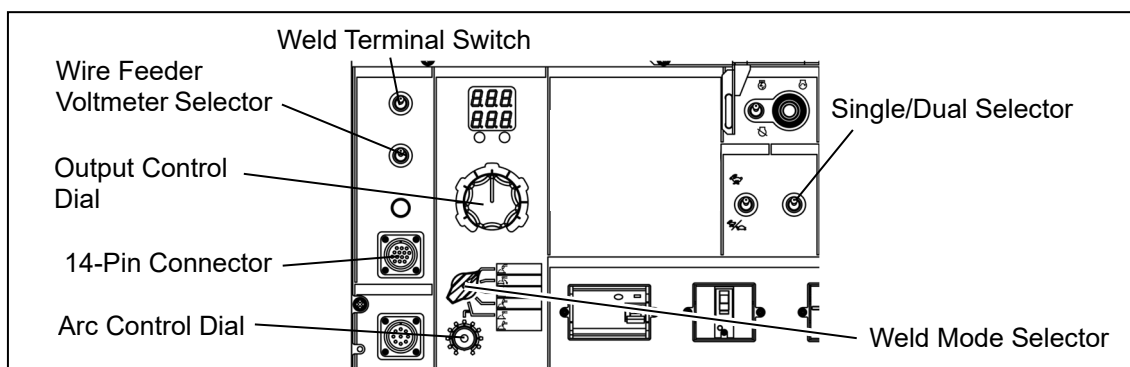
You can select from among five weld modes in accordance with the type of welding being performed. Select a weld mode by referring to the recommended modes in the table below.

Weld Modes Table (Recommended)

Mode Name	Applications	Welding Position
CV-WIRE	○Semi-automatic Arc Welding (MIG, MAG, self-shielded, and similar welding)	All directions
DROOP-STICK	○Welding of pipes, tanks and similar items	Vertical and Upward
GOUGING	○Gouging	
LIFT START TIG	○(DC) TIG welding	Horizontal and Downward
CC-STICK SCRATCH START TIG	○Welding of structures and finishing welding ○Welding of heavy structures and thick plates ○(DC) TIG welding	

<Note>

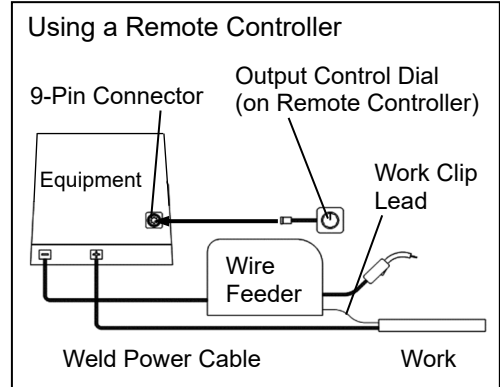
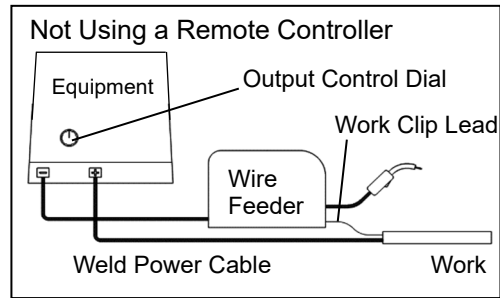
- This equipment allows for 2-person simultaneous welding. For 2-person simultaneous welding, select a weld mode and adjust the weld output in accordance with each type of welding work being performed.
- The range of weld output that can be adjusted using the output control dial varies depending on the positions of the single/dual selector, weld mode selector. (Refer to section "2. Specifications".)



Semi-automatic Arc Welding

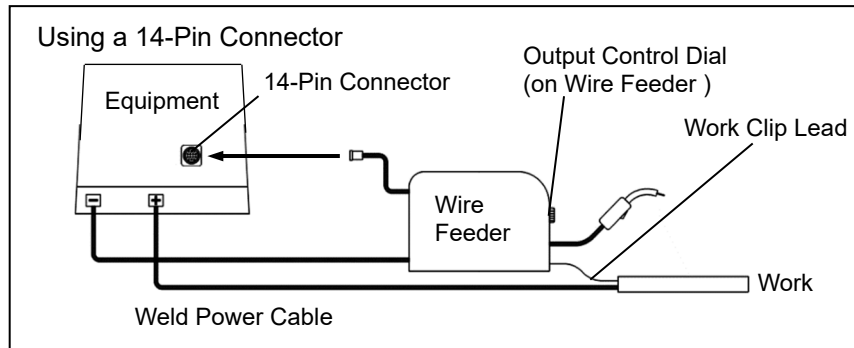
■ Not Using a 14-Pin Connector

- 1) Set the weld mode selector to "CV-WIRE".
- 2) Switch the single/dual selector in accordance with the amount of welding personnel and desired weld output.
- 3) Set the weld terminal switch to "WELD TERMINALS ON".
- 4) Set the output control dial to the desired voltage.
- 5) Start the engine. (Refer to section "8-1. Starting the Engine".)
- 6) Set the wire feed speed of the wire feeder.
- 7) While an arc is being generated, adjust the output control dial of the equipment or remote controller so that the arc is stabilized.



■ Using a 14-Pin Connector

- 1) Connect the 14-pin plug of the wire feeder to the 14-pin connector of the equipment.
- 2) Set the weld mode selector to "CV-WIRE".
- 3) Switch the single/dual selector in accordance with the amount of welding personnel and desired weld output.
- 4) Set the weld terminal switch to "REMOTE CONTROL".
- 5) Switch the wire feeder voltmeter selector in accordance with the polarity of the voltmeter indication of the connected wire feeder.
- 6) Start the engine. (Refer to section "8-1. Starting the Engine".)
- 7) Set the wire feed speed of the wire feeder.
- 8) While an arc is being generated, adjust the output control dial of the wire feeder so that the arc is stabilized.



(1) Shielded Metal Arc Welding, Gouging, Lift Start TIG, Scratch Start TIG

- 1) Set the weld terminal switch to "WELD TERMINALS ON".
- 2) Switch the single/dual selector in accordance with the amount of welding personnel and desired weld output.
- 3) Switch the weld mode selector in accordance with the work being performed.
- 4) Adjust the output current using the output control dial.
- 5) If using "CC-STICK" weld mode, adjust the arc strength using the arc control dial.

<Note>

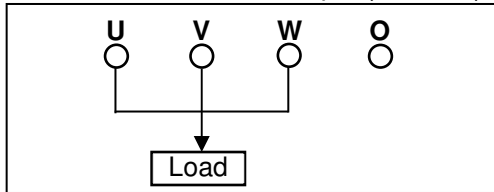
- The value selected using the output control dial is displayed by the DC meter. During welding, both the DC ammeter and voltmeter display the actual output values. When welding is completed, both meters display the actual output values for approximately 8 seconds, after which display returns to the set values.
- The arc control function is only for "CC-STICK" mode. It does not function if using "CV-WIRE", "DROOP-STICK", "GOUGING" or "LIFT START TIG".

10. Using as a Generator

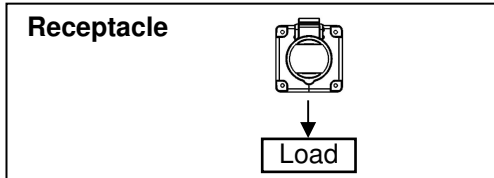
10-1. Output Types and Ranges

(1) Output Types

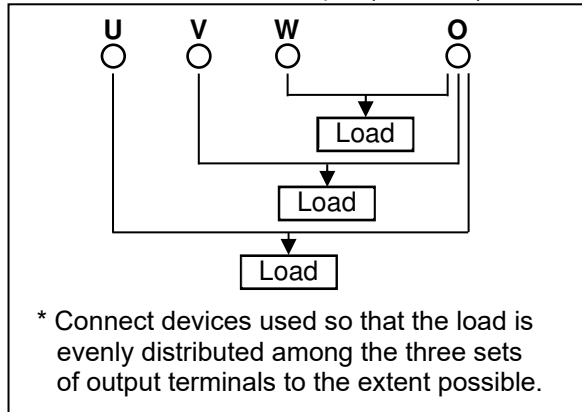
■ 3-Phase 380/415V Output (50/60Hz)



■ 1-Phase 220/240V Output (50/60Hz)



■ 1-Phase 220/240V Output (50/60Hz)



(2) Output Ranges

Devices having up to the following output ranges can be used. (Units: kVA)
(50/60Hz)

3-Phase 380/415V	1-Phase 220/240V			
	Receptacle	U-O	V-O	W-O
18.0 / 21.5	3.2 / 3.6	6.0 / 7.2	6.0 / 7.2	6.0 / 7.2
	total : 6.0 / 7.2			
	total : 14.4 / 17.2			

* The above table indicates the outputs if using only 3-Phase or only 1-Phase.

10-2. Usable Device Capacities

Usable capacity varies depending on the type and performance of the electrical tool or household appliance being used.

Overview of Usable Device Capacities (50/60Hz)

Device Used	Standard Capacities (Units: kW)			
	1-Phase 220/240V			3-Phase 380/415V
	Receptacle	1 Set of Output Terminals	Total of 3 sets of Output Terminals	Output Terminals
Incandescent bulbs, electrical heaters and similar devices	3.3 / 3.6	6.0 / 7.2	14.4 / 17.2	---
Electrical tools (commutator motor) and similar devices	1.7 / 1.8	3.0 / 3.6	7.2 / 8.6	---
Mercury lamps (high power factor types)	1.3 / 1.4	2.4 / 2.9	5.8 / 6.9	---
Submerged pump, compressor and similar devices (Induction motors)	1.3 / 1.4	2.4 / 2.9	5.8 / 6.9	7.2 / 8.6

* Commutator motors: Motors with brushes

* Induction motors: Motors without brushes

* Capacity values are displayed under "OUTPUT" for induction motors and under "POWER CONSUMPTION" for all other devices.

<Note>

- Be sure to use the frequency designated in the equipment incorporated in mercury bulb or induction motor.
- Devices using a motor might require power that is larger than the device rating. In such cases, consult with the retail outlet where the equipment was purchased.
- Do not start up multiple devices simultaneously if using two or more units of devices such as submerged pumps. Start each unit separately.
- Do not light up a mercury lamp again immediately after turning it off. Wait for the lamp to cool down (approximately 15 minutes) after a lamp has been turned off before turning it on again.

10-3. Operation

⚠ Warning: Electric Shock

- Always be sure to turn off all breakers before installing or removing devices using AC output receptacles.
- Always be sure to repair the corresponding earth leakage location when earth leakage circuit breakers operate.

⚠ Caution: Injury

- Always be sure to turn off the power switches of all devices using the equipment when turning on the equipment breakers. Leaving on the power switch of a device using the equipment when the equipment breakers are turned on could result in the sudden operation of the corresponding device.
- Do not leave on the power switch of a device using the equipment and do not connect a device to an AC output receptacle.

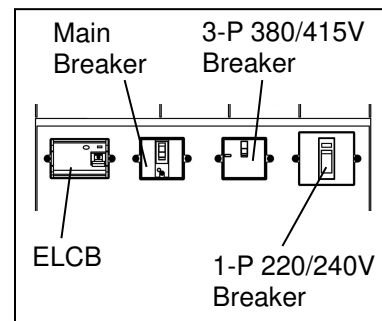
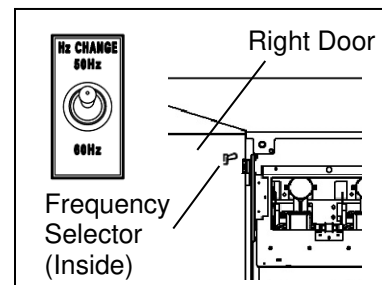
⚠ Caution: Physical and Secondary Damage

- If using the equipment as a power source for medical equipment, you must check with the medical equipment manufacturer, doctor and hospital before using the equipment.

- 1) Select the frequency with the frequency selector in accordance with the devices using the equipment. (Refer to section "5-11. Frequency Selector".)
- 2) Turn off the switches of devices being used.
- 3) Turn all breakers (Main, ELCB, 3-P 380/415V and 1-P 220/240V) to "OFF".
- 4) Start the engine. (Refer to section "8-1. Starting the Engine".)
- 5) Connect the power plug(s) of device(s) being used to the AC output receptacle(s).
- 6) Turn all breakers (Main, ELCB, 3-P 380/415V and 1-P 220/240V) to "ON". (Check that the ELCB lever is set to "ON".)

<Note>

- During operation, the single phase 220/240V output voltage of the AC power source is constantly displayed regardless of whether the breaker is set to "ON" or "OFF".



■ Recovery from Overcurrent Breaker Operation

⚠ Caution: Injury

- Always be sure to turn off the power switches of all devices using the equipment when turning on the equipment breakers. Leaving on the power switch of a device using the equipment when the equipment breakers are turned on could result in the sudden operation of the corresponding device.

Breakers operate when there is excessive current to isolate the corresponding circuit. Inspect the breakers if a device being used stops during equipment operation.

Follow the following procedures to recover operation when breakers operate due to overcurrent.

- 1) Turn off all switches of devices using the equipment as an AC power source.
- 2) Push up the breaker lever that has operated to the "ON" position.

<Note>

- Refer to section "10-2. Usable Device Capacities" and be careful of overloading.

11. Simultaneously Welding and Using as AC Power Source

Due to the fact that breakers only function for AC power output, the engine can become overloaded if simultaneously welding and using the equipment as an AC power source. Refer to the table below and limit the use of AC power accordingly.

Overview of Capacities Usable Simultaneously (50/60Hz)

Weld Output		PLUS	AC Power Output	
Amount of Personnel	Current		3-phase Output (Power factor: 0.8)	1-phase Output (Power factor: 1.0)
Used by 1 Person [SINGLE] or [DUAL]	50A		18.0 / 21.5 kVA	14.4 / 17.2 kW
	100A		18.0 / 21.5 kVA	14.4 / 17.2 kW
	150A		18.0 / 21.5 kVA	14.4 / 17.2 kW
	200A		18.0 / 21.5 kVA	14.4 / 17.2 kW
	250A		18.0 / 21.5 kVA	14.4 / 17.2 kW
	300A		18.0 / 21.5 kVA	14.4 / 17.2 kW
	350A		16.0 / 21.5 kVA	12.0 / 17.2 kW
	400A		12.0 / 20.0 kVA	9.6 / 15.0 kW
	450A		8.5 / 15.5 kVA	6.5 / 12.5 kW
	500A		5.0 / 11.5 kVA	4.0 / 9.5 kW
	550A		0 / 7.5 kVA	0 / 6.5 kW
	600A		0 / 3.5 kVA	0 / 3.0 kW
Used by 2 Persons [DUAL]	50A x2		18.0 / 21.5 kVA	14.4 / 17.2 kW
	100A x2		18.0 / 21.5 kVA	14.4 / 17.2 kW
	150A x2		18.0 / 21.5 kVA	14.4 / 17.2 kW
	200A x2		15.5 / 21.5 kVA	11.5 / 16.5 kW
	250A x2		9.0 / 17.0 kVA	7.5 / 12.5 kW
	300A x2	4.0 / 10.5 kVA	3.5 / 8.5 kW	
	340A x2	0 / 6.0 kVA	0 / 5.0 kW	

*The 1-phase values shown in the table above are the sum of receptacle and output terminals.

<Note>

- Do not use as an AC power source simultaneously with welding if it is necessary to perform high-quality welding.

12. Inspection/Maintenance

Warning: Electric Shock/Injury

- Always be sure to stop the engine before performing any equipment check or maintenance.
- Do not operate the equipment with any doors or covers open. There is a danger of hair, body parts and other items being caught up in moving parts such as cooling fans and belts.
- Do not modify the equipment and do not operate with parts removed.

Warning: Fire

- Always be sure to stop the engine when inspecting fuel or refueling, and absolutely never perform such tasks near fire or other open flame. Wait until the engine has completely cooled before inspecting fuel or refueling.
- Always be sure to wipe up any spilled fuel or oil.
- Spilled fuel and oil accumulates in the spill containment. Do not operate the equipment with liquid accumulated in the spill containment.
- Absolutely never use the equipment if there is a fuel, oil or cooling water leak, and be sure to always repair the leak before using.
- Absolutely never inspect or perform maintenance to the equipment near fire or other open flame.

Warning: Injury to Eyes and Skin

- Use protective gear, such as rubber gloves, when inspecting or replacing the battery due to the dilute sulfuric acid in the battery fluid. Be sure that fluid does not get into eyes, or on skin or clothing.
- If battery fluid gets into the eyes, or on the skin or clothing, immediately wash with a large amount of water, and always be especially sure to seek medical attention if it gets into the eyes.

Warning: Explosion

- Do not operate the equipment or recharge the battery when the battery fluid level is below the lower level.
- Do not generate any sparks near the battery and do not allow any fire or other open flame near the equipment because the battery generates ignitable gas.

Caution: Burn

- The engine, muffler and similar parts are extremely hot during operation and immediately after stopping the equipment. Never touch hot parts.
- Never open the radiator cap during operation or immediately after stopping the equipment. Hot cooling water and steam will spurt out.
- Always be sure to stop the engine and allow it to cool before inspecting or changing the engine oil. Opening the oil gauge or oil plug during operation will result in hot oil spurting out.

<Note>

- Procedures except for pre-operation inspection must be performed by specialized technicians.
- Items indicated by : Contact the retail outlet where the equipment was purchased.
- Always be sure to use genuine parts when replacing parts.
- When removing waste liquid from the equipment, place some container to collect the liquid and prevent it from spilling on the ground. Dispose of such oil, fuel, cooling water (LLC), filters, batteries and other harmful substances as industrial waste in accordance with applicable laws and regulations. Consult with the retail outlet where the equipment was purchased if you have any inquiries regarding proper disposal.
- When performing maintenance with doors or covers open, be sure that no other persons can accidentally come close to the equipment. Close all doors and covers if momentarily leaving the equipment unattended.

Perform periodic inspection and maintenance as indicated by the table below in order to ensure that this equipment can be operated in optimal condition.
Use the hour meter as a general indicator for the operating time.

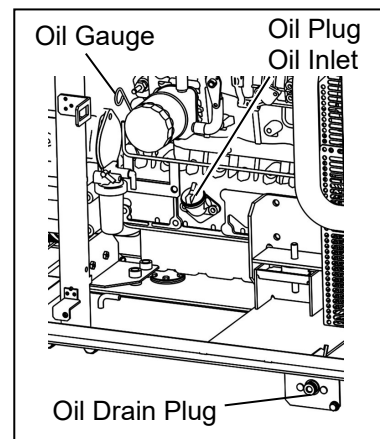
Inspection Item		Pre-Operation Inspection	Inspection Period						
			50th hour	Every 250 hours	Every 500 hours	Every 800 hours	Every 1,000 hours	Every 1,500 hours	Every 2,000 hours
1	Inspect/Add Fuel	○							
2	Inspect/Add Engine Oil	○							
3	Change Engine Oil		1st time ○	2nd time and after ○					
4	Change Oil Filter		1st time ○		2nd time and after ○				
5	Inspect/Add Cooling Water	○							
6	Change Cooling Water								○ or 1 year
7	Water separator (Check/Drain excess water and sediments)	○ (Drain)							
8	Water separator and Gauze filter (Clean)				○				
9	Fuel filter/element Replace				○				
10	Fuel Tank (Drain Water)			○					
11	Fuel tank (Clean)				●				
12	Air cleaner element (Clean)		1st time ○	○					
13	Air cleaner element (Replace)	Once in 6 times cleaning or 1 year							
14	Battery fluid level (Check/Add)	○							
15	Battery gravity (Check)			○					
16	Fan belt tension (Check)		1st time ○	2nd time and after ○					
17	Fan belt (Replace)				or 2 year				
18	Radiator and fins (Clean)				●				
19	Check for leaks (Fuel/Oil/Coolant)	○							
20	Fuel/Cooling Water/Oil Hoses and Anti-Vibration Rubber (Inspect/Replace)				○ or 1 year (Inspect)			● or 2 year	
21	Exhaust color (Check)	○							
22	Valve clearance (Check/Adjust)					●			
23	Fuel injector (Check)						●		
24	Spill containment fluid (Check/Drain)	○							

Inspection Item		Pre-Operation Inspection	Inspection Period						
			50th hour	Every 250 hours	Every 500 hours	Every 800 hours	Every 1,000 hours	Every 1,500 hours	Every 2,000 hours
25	Spill containment (Check/Clean)	○			● or 1year (Clean)				

(1) Changing the Engine Oil

1st time	50th hour
2nd time and after	Every 250 hours

- 1) Remove the oil plug.
- 2) Remove the oil drain plug and drain the engine oil.
- 3) Tighten the oil drain plug.
- 4) Add oil through the oil inlet, while checking the oil level using the oil gauge, until it reaches the maximum level. (Fill with approx. 13.2 L)
- 5) Tighten the oil plug.



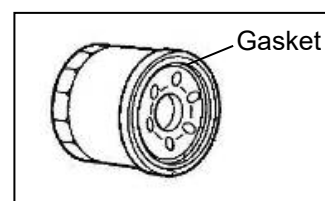
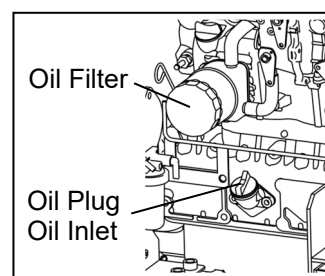
<Note>

- Refer to section "7-1. Engine Oil Inspection" for the types of engine oil.
- Replace the packing of the oil drain plug with a new part each time the oil is changed.
- Packing part no. : V106-000190
- After tightening the oil drain plug, operate the engine for a short period and check that there is no oil leakage. Stop the engine when completed.

(2) Changing the Oil Filter

1st time	50th hour
2nd time and after	Every 500 hours

- 1) Drain the engine oil according to the procedures of "(1) Changing the Engine Oil".
- 2) Remove the oil filter using a filter wrench.
- 3) Apply a thin layer of oil to the gasket of a new oil filter.
- 4) Screw in the oil filter by hand and securely tighten by hand (do not use a filter wrench) after the gasket contacts the seal surface.
- 5) Add engine oil.



<Note>

- Contact the retail outlet where the equipment was purchased if you do not have a filter wrench.
- Oil filter part no. : 1C020-32434 (Kubota part no.)
- After adding engine oil, operate the engine for a short period and check that there is no oil leakage. Stop the engine when completed.

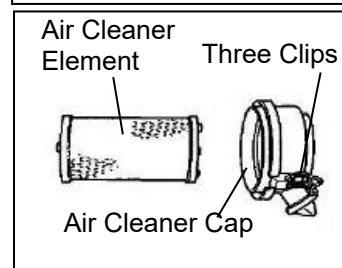
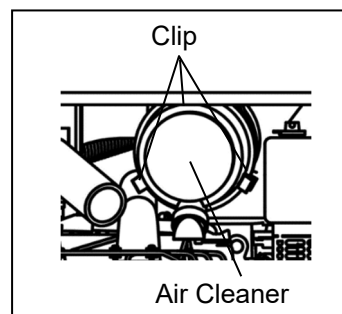
(3) Cleaning/Replacing the Air Element

Cleaning	1st time: 50th hour / 2nd time and after: Every 250 hours
Replacement	Once in 6 times cleaning or 1 year

- 1) Release the air cleaner clips and remove the cleaner cap.
- 2) Clean or replace the air element.
 <If dry dust is adhering>
 Spray compressed air from within the element.
 <If carbon or oily substance is adhering>
 Replace with a new part.
- 3) Install in the reverse order of removal.

<Note>

- Clean sooner than scheduled if using the equipment in a dusty location.
- Element part no. : 59800-26111 (Kubota part no.)

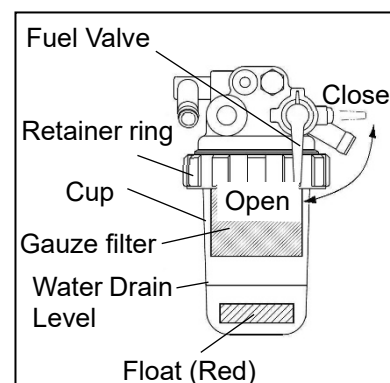


(4) Draining Water from the Water Separator

Check	Daily
Clean	Every 500 hours

Drain water when the float (red) inside the cup floats to the water draining position.

- 1) Close the fuel valve.
- 2) Unscrew the retainer ring counterclockwise, and remove the cup and the gauze filter.
- 3) If foreign material is adhering to the gauze filter in the cup, remove the cup and gauze filter, and clean by blowing compressed air from the inside of the gauze filter.
- 4) Reassemble the gauze filter and cup to their original location.



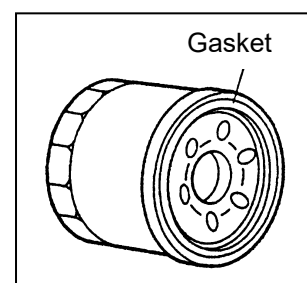
<Note>

- When attaching the cup, check that there is no foreign material adhering to the O-ring.
- After attaching, open the fuel valve, and be sure to always start the engine and check that there is no fuel leakage.
- If water is accumulate in the cup, draining water from the fuel tank.

(5) Fuel Filter Replacement

Replacement	Every 500 hours
-------------	-----------------

- 1) Remove the fuel filter using a filter wrench.
- 2) Spread a thin layer of oil on a new fuel filter gasket.
- 3) Thread the fuel filter by hand, and turn by hand (do not use a filter wrench) from when the gasket contacts the seal surface until it is securely tightened.
- 4) Shortly after starting the engine, always be sure to check that there is no fuel leaking from the seal surface.



<Note>

- Be sure to wipe away any fuel that has spilled out of the piping when removing the filter.
- Fuel filter part no.:16631-43562 (Kubota part no.)

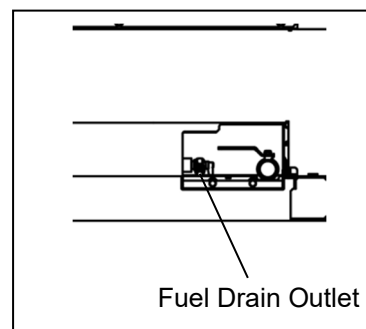
(6) Draining Water from the Fuel Tank

Draining Water	Every 250 hours
----------------	-----------------

- 1) Remove the fuel drain plug (R 3/8") and open the valve lever.
- 2) Close the valve lever after the liquid has been flushed, and apply sealant coating to the plug or wrap it in seal tape.

<Note>

- After reinserting the fuel drain plug, be sure to always check that there is no fuel leakage.

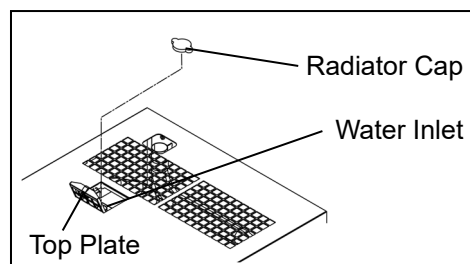


(7) Changing the Cooling Water

Change	Every 2,000 hours or 1 year
--------	-----------------------------

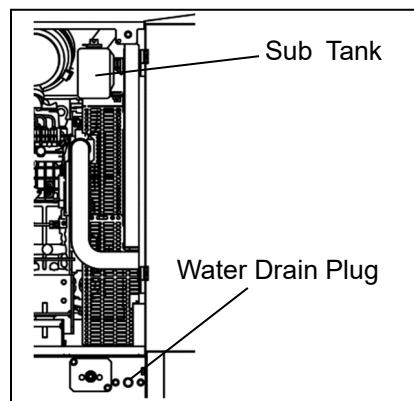
Cooling Water Total Capacity: Approximately 12 L (Including the sub tank capacity of approx. 1.1 L)

- 1) Open the top plate.
- 2) Remove the radiator cap.
- 3) Remove the water drain plug.
- 4) Drain the cooling water and tighten the water drain plug.
- 5) Change the cooling water in the sub tank.
- 6) Pour cooling water into the water inlet until it reaches the mouth of the port.
- 7) Tighten the radiator cap.
- 8) Close the top plate.



<Note>

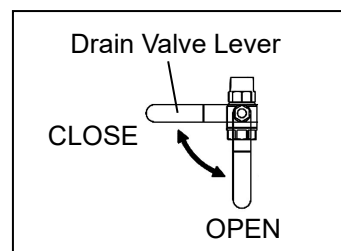
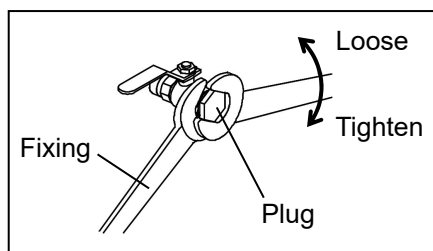
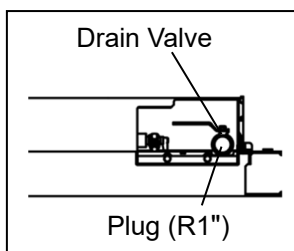
- Replace the packing with a new part each time you change the cooling water.
- Packing part no. : 6C090-58961 (Kubota part no.)
- Operate the engine for a short period and check that there is no cooling water leakage. Stop the engine when completed.



(8) Draining Liquid from the Spill Containment

Drain	Pre-operation
-------	---------------

- 1) Set a receptacle under the drain port of the spill containment to catch the liquid.
- 2) Remove the plug (R 1") of the spill containment drain valve and turn the lever to "OPEN".
- 3) After draining the liquid, turn the lever to "CLOSE", and apply sealing agent to the plug (R 1") or wrap it with sealing tape before tightening the plug.



<Note>

- Secure the drain valve body using a spanner or similar tool so that it does not loosen when removing/installing the plug by turning it.
- It is possible that there is a fuel or oil leak if the drained fluid contains oily components. If this occurs, check for leakage locations.
- Although the fluids that can leak internally consist of oil, fuel, cooling water and battery fluid, the spill containment does not have a function that can separate rainwater that has leaked into the equipment from these internally leaked fluids. Properly dispose of liquid drained from the spill containment in a manner according to the applicable laws and regulations.

(9) Cleaning/Inspecting the Spill Containment

Cleaning	Every 500 hours or 1 year
----------	---------------------------

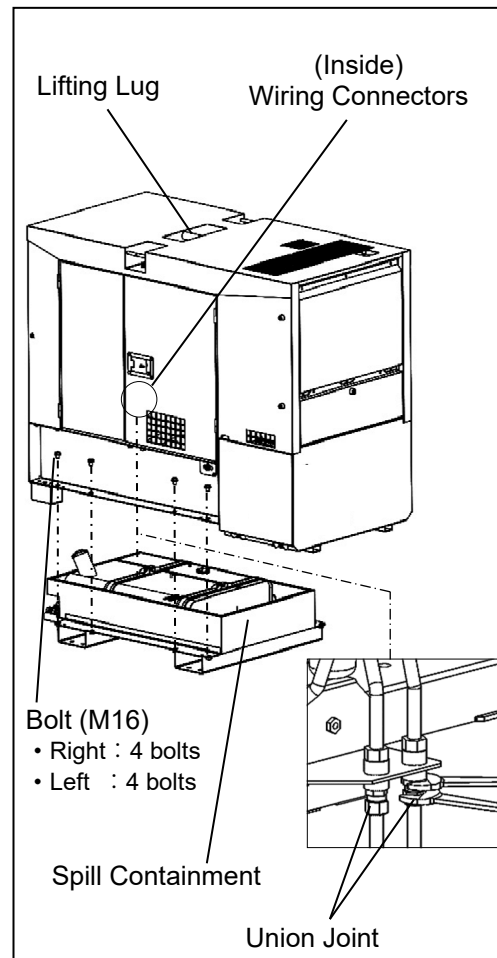
⚠ Caution: Injury

- Always be sure to use the lifting lug when lifting the equipment, and lift slowly and directly straight above.
- Wear a helmet, safety shoes, gloves and similar protective gear when performing lifting work. Do not stand or get under the equipment while it is suspended.
- For cleaning/inspecting the spill containment, set this equipment with it situated on a stable level surface so that it is prevented from moving.

- 1) Drain the liquid from the spill containment.
- 2) Remove the wiring connector.
- 3) Remove the fuel hoses (supply and return sides).
- 4) Remove the eight installation bolts (M16) of the spill containment.

<Note>

- When removing the fuel hoses, hold the union joint fixed using a spanner or similar tool.
 - Prepare a container to receive the fuel remaining in the fuel piping that will flow out of the removed fuel piping.
- 5) Lift up the equipment body to separate the spill containment and set the equipment on a level surface.
 - 6) Clean the inside of the spill containment using a high-pressure washer or similar equipment.
 - 7) Drain the cleaning liquid from the spill containment.
 - 8) Remove any rust that has formed in the spill containment and paint it again.
 - 9) Pour water into the spill containment and check that there is no leakage. (After checking, drain the water you have used.)
 - 10) Install the spill containment to the equipment in the reverse order of removal.



<Note>

- Do not operate the equipment with the spill containment separated.
- If liquid drained from the spill containment during cleaning contains oily components, dispose of it in a manner according to the applicable laws and regulations.
- If the spill containment has a leak, request repair at the retail outlet where the equipment was purchased.

(10) Inspecting/Replacing the Fuel/Cooling Water/Oil Hoses, Anti-Vibration Rubber.

Inspect	Every 500 hours or 1 year
Replacement	Every 1,000 hours or 2 year

If rubber hoses (fuel, cooling water, oil, air, drain, etc.) are hardened or deteriorated, please replace with a new rubber hose.

For rubber hose replacement, please contact the retail outlet where the equipment was purchased.

13. Long-Term Storage

⚠ Warning: Electric Shock/Injury

- Always be sure to stop the engine before performing any equipment check or maintenance.
- Do not operate the equipment with any doors or covers open. There is a danger of hair, body parts and other items being caught up in moving parts such as cooling fans and belts.

⚠ Warning: Fire

- Always be sure to stop the engine when inspecting fuel or refueling, and absolutely never perform such tasks near fire or other open flame. Wait until the engine has completely cooled before inspecting fuel or refueling.
- Always be sure to wipe up any spilled fuel or oil.
- Spilled fuel and oil accumulates in the spill containment. Do not leave the equipment with liquid accumulated in the spill containment.

⚠ Caution: Burn

- The engine, muffler and similar parts are extremely hot during operation and immediately after stopping the equipment. Never touch hot parts.
- Always be sure to stop the engine and allow it to cool before inspecting or changing the engine oil. Opening the oil gauge or oil plug during operation will result in hot oil spurting out.

Perform the following maintenance procedures if not using the equipment for two months or more.

- 1) Remove the battery. (Refer to section "7-6. Battery Inspection".)
- 2) Change the engine oil. (Refer to section "12. (1) Changing the Engine Oil".)
- 3) Drain the fuel from the fuel tank and strainer. (Refer to section "12. (4) Draining Water from the Water Separator", "12. (6) Draining Water from the Fuel Tank".)
- 4) Clean and inspect the spill containment.
(Refer to section "12. (9) Cleaning/Inspecting the Spill Containment".)
- 5) Clean all parts and store the equipment in an area with low humidity and little dust with a cover or similar protection covering it.

<Note>

- Recharge a removed battery approximately once every month.

14. Troubleshooting

Warning: Electric Shock/Injury

- Always be sure to stop the engine before performing any equipment check or maintenance.
- Do not touch the equipment during operation if the equipment or your body is wet.
- Do not operate the equipment with any doors or covers open. There is a danger of hair, body parts and other items being caught up in moving parts such as cooling fans and belts.

Warning: Fire

- This equipment uses diesel fuel. Always be sure to stop the engine when inspecting fuel or refueling, and absolutely never perform such tasks near fire or other open flame. Wait until the engine has completely cooled before inspecting fuel or refueling.
- Always be sure to wipe up any spilled fuel or oil.
- Spilled fuel and oil accumulates in the spill containment. Do not operate the equipment with liquid accumulated in the spill containment.
- Absolutely never use the equipment if there is a fuel, oil or cooling water leak, and be sure to always repair the leak before using.
- Absolutely never inspect or perform maintenance to the equipment near fire or other open flame.

Warning: Injury to Eyes and Skin

- Use protective gear, such as rubber gloves, when inspecting or replacing the battery due to the dilute sulfuric acid in the battery fluid. Be sure that fluid does not get into eyes, or on skin or clothing.
- If battery fluid gets into the eyes, or on the skin or clothing, immediately wash with a large amount of water, and always be especially sure to seek medical attention if it gets into the eyes.

Warning: Explosion

- Do not operate the equipment or recharge the battery when the battery fluid level is below the lower level.
- Do not generate any sparks near the battery and do not allow any fire or other open flame near the equipment because the battery generates ignitable gas.

Caution: Burn

- The engine, muffler and similar parts are extremely hot during operation and immediately after stopping the equipment. Never touch hot parts.
- Never open the radiator cap during operation or immediately after stopping the equipment. Hot cooling water and steam will spurt out. Always be sure to stop the engine before performing any equipment check or maintenance.
- Always be sure to stop the engine and allow it to cool before inspecting or changing the engine oil. Opening the oil gauge or oil plug during operation will result in hot oil spurting out.

Refer to the table on the next page to perform inspection when the equipment is operating poorly.

If you cannot resolve a problem after inspecting the equipment, request repair at the retail outlet where the equipment was purchased.

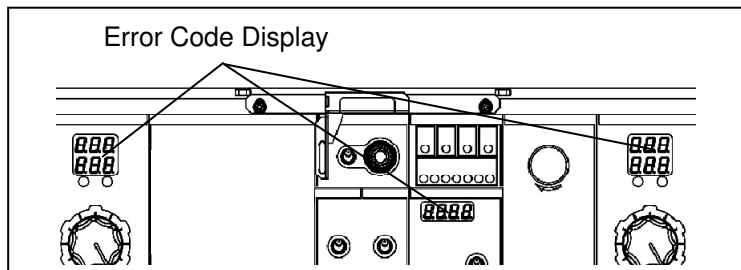
Symptom	Possible Causes	Remedy
Starter motor does not start.	1. Battery has a low charge. 2. Battery is deteriorated.	1. Recharge the battery. 2. Replace the battery.
Engine does not start.	1. Fuel lever is "CLOSE". 2. Emergency stop switch is "ON". 3. No fuel. 4. Water or foreign material is mixed in with the fuel. 5. Blown fuse.	1. Turn the fuel lever to "OPEN". 2. Release the emergency stop switch. 3. Add fuel. 4. Drain water from and clean the fuel tank and fuel strainer. 5. Replace the fuse.
No weld output.	1. Weld terminal switch is set to "REMOTE CONTROL". 2. VRD switch is set to "ON" and "DROOP-STICK" or "GOUGING" weld mode has been selected.	1. Set to "WELD TERMINALS ON". 2. Set to "OFF" or Set to "CV-WIRE", "LIFT START TIG", "CC-STICK".
Engine starts but quickly stops.	1. Insufficient oil. 2. Overheating of water temperature. 3. Battery recharging fault.	1. Add oil. 2. Comply with rated outputs/Add cooling water. 3. Repair.
Black or white smoke is continuously exhausted from the muffler.	1. Overloaded.	1. Comply with the rated outputs.
Engine does not stop.	1. Stop solenoid fault.	1. Turn the fuel lever to "CLOSE" to stop the engine.
Weak welding arc	1. Single/Dual selector is set to "DUAL". 2. Faulty cable connection. 3. Improper cable. (excessively thin) 4. Faulty connection with base material. 5. Using simultaneously as AC power source. 6. Welding cable short circuit. 7. Frequency selector is wrong setting.	1. Set to "SINGLE". 2. Connect securely. 3. Replace with cable according to "Welding Cable Selection". 4. Connect securely. 5. Do not use as AC power source. 6. Remove the cause of the short circuit. 7. Set to proper frequency.
Strong welding arc	1. Single/Dual selector is set to "SINGLE". 2. Arc control setting is excessively strong.	1. Set to "DUAL". 2. Turn the arc control dial to the left.
Wire feeder cannot be used.	1. "DROOP-STICK", "GOUGING", "LIFT START TIG" or "CC-STICK" weld mode has been selected. 2. Poor connection of the wire feeder connector. 3. Circuit protector for the wire feeder has operated.	1. Set to "CV-WIRE". 2. Securely connect the wire feeder connector. 3. Reset the circuit protector for the wire feeder.
Weld output cannot be adjusted.	1. Remote controller is connected.	1. Disconnect the remote controller. Or, adjust using the remote controller.
No AC power output	1. Breaker is "OFF".	1. Turn the breaker to "ON".
AC power output is weak.	1. Frequency selector is wrong setting. 2. The current of devices using the equipment exceed the rated current. 3. Using simultaneously for welding.	1. Set to proper frequency. 2. Refer to "Usable Device Capacities". 3. Stop welding.
Engine cannot obtain high speed.	1. Current of device using the equipment as AC power source is 0.5A or less.	1. Set the idle control switch to "HIGH".
Engine cannot obtain low speed.	1. Idle control switch is set to "HIGH". 2. Welding cable short circuit.	1. Set to "AUTO". 2. Remove the cause of the short circuit.

Symptom	Possible Causes	Remedy
VRD does not work.	1. VRD switch is set to "OFF". 2. "CV-WIRE", "LIFT START TIG" weld mode has been selected.	1. Set to "ON". 2. Set to "CC-STICK".

■ Error Code Display

Error codes are displayed on the DC and AC meters when the control board detects an error.

If the error code is displayed, follow to the procedures in the "Remedy".

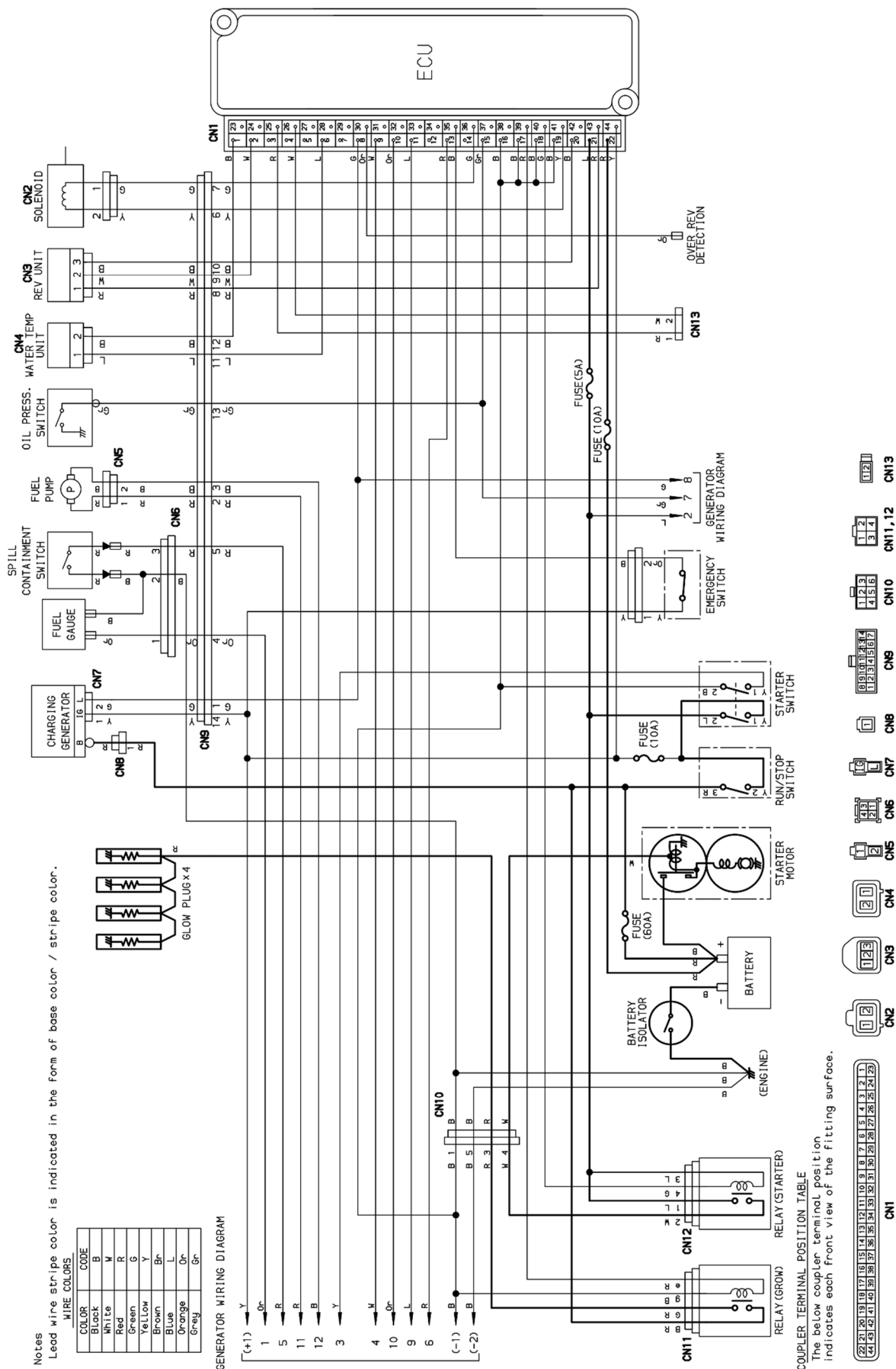


Error Code	Symptom	Remedy
E01	Overheating of control parts for welding	Set the idle control switch to "AUTO". Run the engine to cool it down at idle under no-load until the "E01" display disappears. * This error is automatically resolved when temperature of the control parts lowered to normal.
E02	Fault/Malfunction of control parts for welding	Stop the engine and repair the location of the fault. * DO NOT restart the engine unless the fault is repaired.
E03	Short circuit of the weld output	Stop the engine. Return the short circuit of the weld output and restart the engine.
E07	Overheating of alternator	As the engine continue to run even after "E07" is displayed, remain the engine run for approx. 10 minutes to cool the alternator down. Display will change "E07" to "... " after engine run for approx. 10 minutes. Then, stop and restart the engine. * When the alternator will not cool down insufficiently, "E07" is displayed again and repeat the remedy. * Engine rpm remains the same when this failure happens although position of the idle control switch is changed. The rpm is unchanged after the sensor detects overheat until it is fixed.
. . .	RUN/STOP SWITCH is kept at "RUN".	Set the RUN/STOP switch to "STOP" position. Or restart the engine the starter switch is pushed. * "... " is also displayed when "E07" is displayed and engine run for approx. 10 minutes.

<Note>

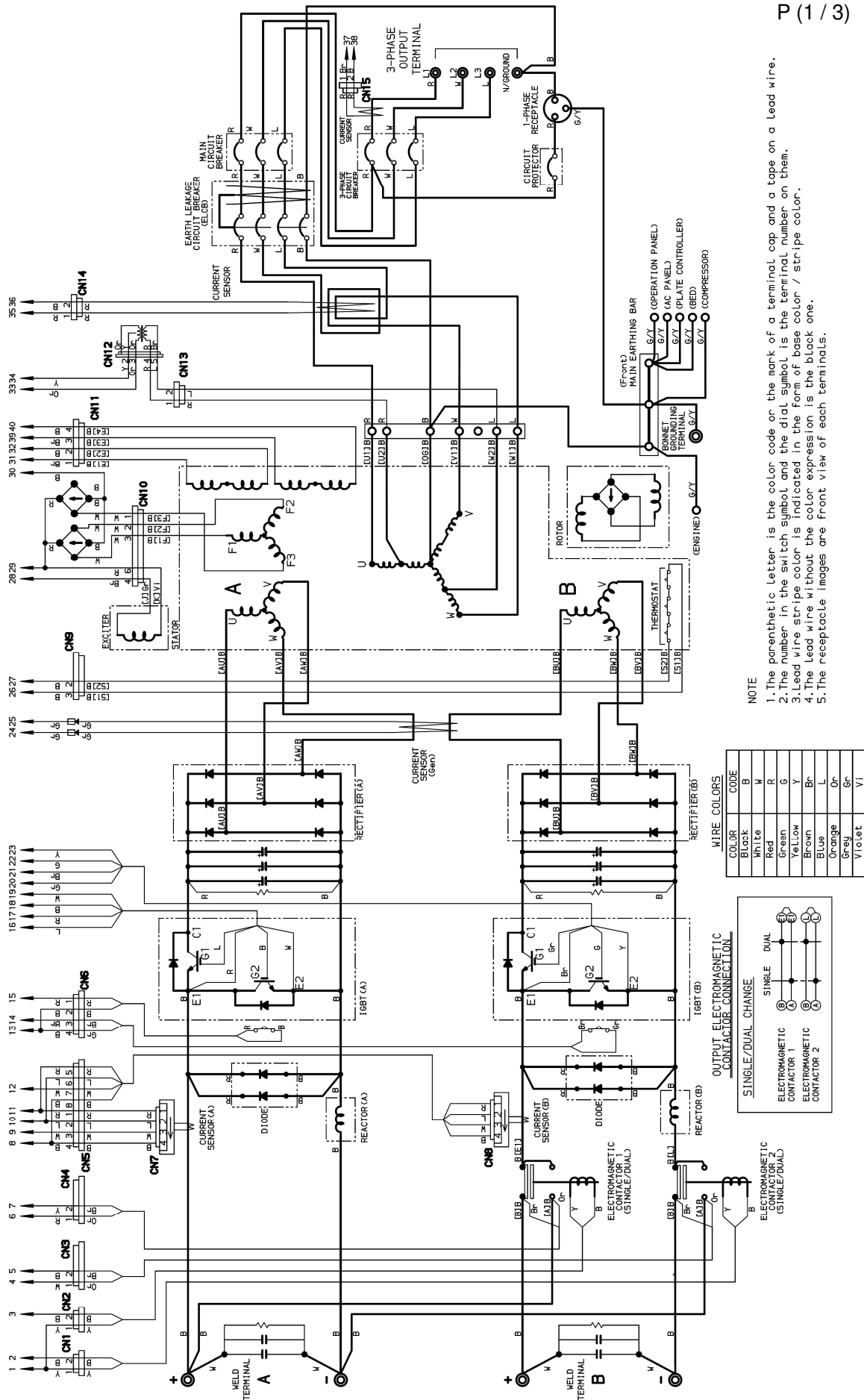
- Maintenance of this equipment must be performed by specialized technicians.
- When performing maintenance with doors or covers open, be sure that no other persons can accidentally come close to the equipment. Close all doors and covers if momentarily leaving the equipment unattended.
- A simple inspection cannot always resolve some problems. If you cannot resolve a problem after inspecting the equipment, request repair at the retail outlet where the equipment was purchased.

15. Engine Wiring Diagram



16. Generator Wiring Diagram

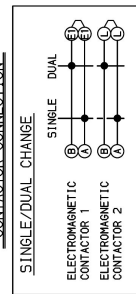
P (1 / 3)

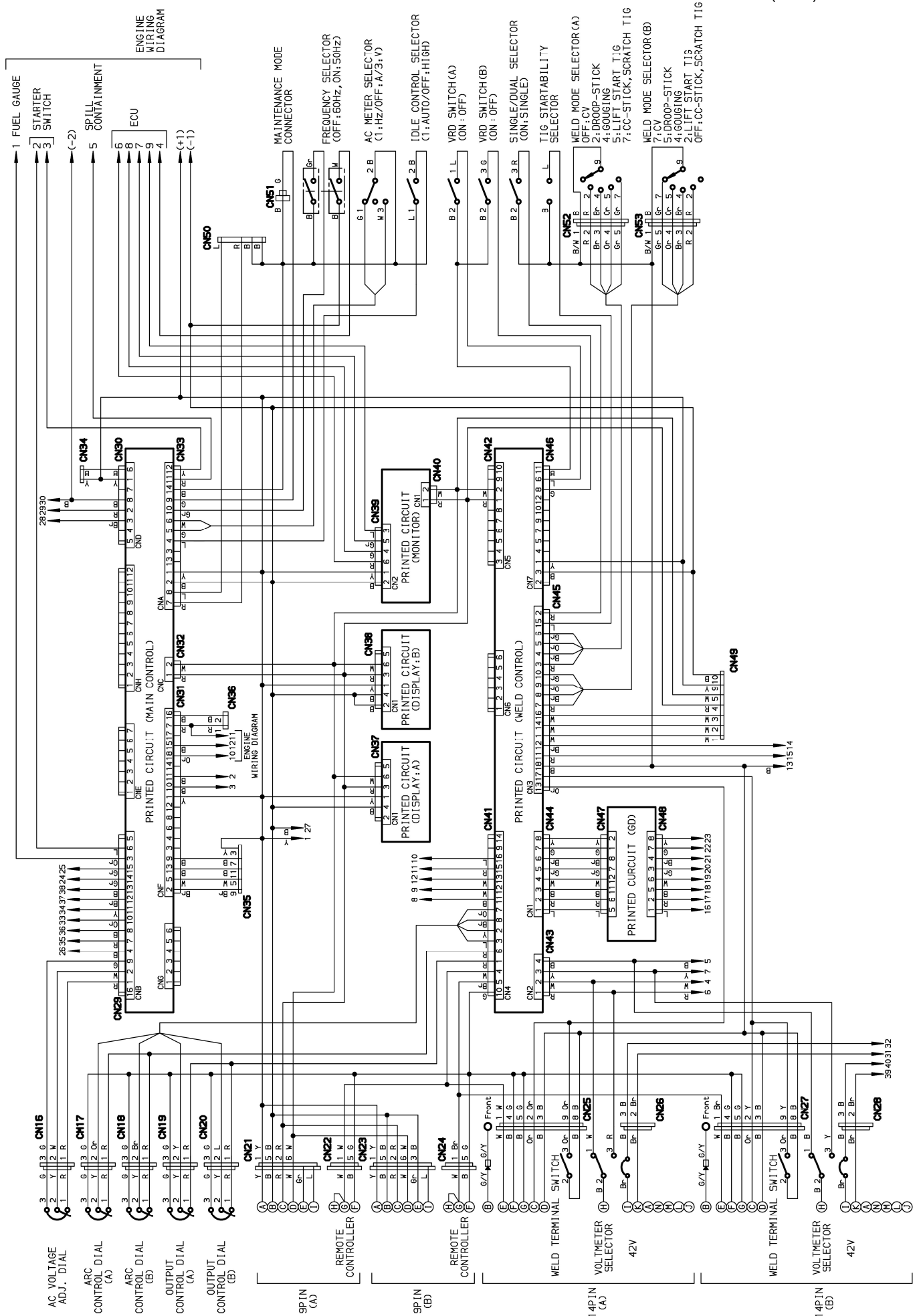


NOTE

1. The parenthetic letter is the color code or the mark of a terminal, cap and a tape on a lead wire.
2. The number in the switch symbol and the dial symbol is the terminal number on them.
3. Lead wire stripe color is indicated in the form of base color / stripe color.
4. The lead wire without the color expression is the black one.
5. The receptacle images are front view of each terminals.

WINE COLOR	COLOR	CODE
	Black	B
	White	W
	Red	R
	Green	G
	Yellow	Y
	Brown	Br
	Blue	L
	Orange	Or
	Grey	Gr
	Violet	Vi





CONNECTOR TERMINAL POSITION TABLE

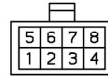
The below connector terminal position indicates each front view of the fitting surface.



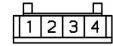
**CN1, 2, 32
36, 40**



**CN3, 4, 6
43, 50**



**CN5, 21, 23
30, 44, 48**



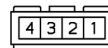
CN7, 8



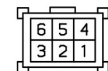
CN9, 26, 28



CN10



CN11



CN12



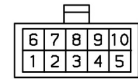
**CN13, 14, 15
34**



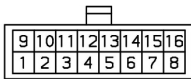
**CN16, 17, 18
19, 20**



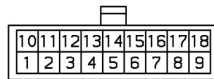
**CN22, 24, 37
38, 39, 52, 53**



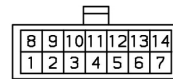
CN25, 27, 42



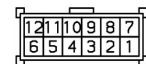
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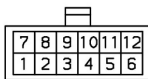
CN31, 45



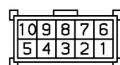
CN33



CN35



CN46, 47



CN49



CN51

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