SECTION 1 – SAFETY PRECAUTIONS – READ BEFORE USING

Protect yourself and others from injury — read, follow, and save these important safety precautions and operating instructions.

1-1. Symbol Usage

DANGER! – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

NOTICE – Indicates statements not related to personal injury.

This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid these hazards.

Indicates special instructions.

1-2. Induction Heating Hazards

The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Principal Safety Standards listed in Section 1-5. Read and follow all Safety Standards.

Only qualified persons should install, operate, maintain, and repair this equipment. A qualified person is defined as one who, by possession of a recognized degree, certificate, or professional standing, or who by extensive knowledge, training and experience, has successfully demonstrated the ability to solve or resolve problems relating to the subject matter, the work, or the project and has received safety training to recognize and avoid the hazards involved.

During operation, keep everybody, especially children, away.

ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The power circuit and output bus bars or connections are electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Enclose any connecting bus bars and coolant fittings to prevent unintentional contact.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings, or scaffolds; when in cramped positions such as sitting, kneeling, or lying; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, see ANSI Z49.1 listed in Safety Standards. And, do not work alone!
- Disconnect input power before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Use only nonconductive coolant hoses with a minimum length of 18 inches (457 mm) to provide isolation.
- Properly install, ground, and operate this equipment according to its Owner’s Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.

- When making input connections, attach proper grounding conductor first – double-check connections.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cord and ground conductor for damage or bare wiring – replace immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or repaired cables.
- Do not drape cables over your body.
- Do not touch power circuit if you are in contact with the work, ground, or another power circuit from a different machine.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Use GFCI protection when operating auxiliary equipment in damp or wet locations.

SIGNIFICANT DC VOLTAGE exists in inverter power sources AFTER removal of input power.

- Turn off unit, disconnect input power, and discharge input capacitors according to instructions in Manual before touching any parts.

FUMES AND GASES can be hazardous.

Induction Heating of certain materials, adhesives, and fluxes can produce fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- Ventilate the work area and/or use local forced ventilation at the arc to remove welding fumes and gases. The recommended way to determine adequate ventilation is to sample for the composition and quantity of fumes and gases to which personnel are exposed.
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer’s instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watchperson nearby. Fumes and gases from heating can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not heat in locations near degreasing, cleaning, or spraying operations. The heat can react with vapors to form highly toxic and irritating gases.
- Do not overheat coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the heated area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if overheated. See coating SDS for temperature information.
FIRE OR EXPLOSION hazard.
- Do not overheat parts.
- Watch for fire; keep extinguisher nearby.
- Keep flammables away from work area.
- Do not locate unit on, over, or near combustible surfaces.
- Do not use unit to thaw frozen pipes.
- Do not install unit near flammables.
- Do not cover an air-cooled blanket with any material that will cause the blanket to overheat.
- Do not operate where the atmosphere can contain flammable dust, gas, or liquid vapors (such as gasoline).
- After completion of work, inspect area to ensure it is free of sparks, glowing embers, and flames.
- Use only correct fuses or circuit breakers. Do not oversize or bypass them.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.
- Wear body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.

INDUCTION HEATING can burn.
- Do not touch hot parts bare-handed.
- Do not touch or handle induction head/coil during operation unless the equipment is designed and intended to be used in this manner as specified in the owner's manual.
- Keep metal jewelry and other metal personal items away from head/coil during operation.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.

1-3. Additional Hazards For Installation, Operation, And Maintenance

FALLING EQUIPMENT can injure.
- Use handle and have person of adequate physical strength lift unit.
- Move unit with hand cart or similar device.
- For units without a handle, use correct procedures and equipment of adequate capacity to lift and support unit.
- Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.
- Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication No. 94−110) when manually lifting heavy parts or equipment.

FLYING METAL OR DIRT can injure eyes.
- Wear approved safety glasses with side shields or wear face shield.

MOVING PARTS can injure.
- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before reconnecting input power.

STEAM AND HOT COOLANT can burn.
Hose may rupture if coolant overheats.
- Never disconnect both ends of hose when installed on hot workpiece.
- If coolant flow stops, leave one end of hose connected to allow coolant to return to cooler and relieve pressure.
- Remove hose from hot workpiece to prevent damage.
- Visually inspect condition of hoses, cords, and cables before each use. Do not use damaged hoses, cords, or cables.
- Allow cooling period before working on equipment.

HIGH PRESSURE FLUIDS can injure or kill.
- Coolant can be under high pressure.
- Release pressure before working on cooler.
- If ANY fluid is injected into the skin or body seek medical help immediately.

OVERUSE can cause OVERHEATING
- Allow cooling period.
- Reduce output or reduce duty cycle before starting to heat again.
- Follow rated duty cycle.

STATIC (ESD) can damage PC boards.
- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.

BATTERY EXPLOSION can injure.
- Do not use induction equipment to charge batteries or jump start vehicles unless it has a battery charging feature designed for this purpose.

ELECTRIC AND MAGNETIC FIELDS (EMF) can affect Implanted Medical Devices.
- Wearers of Pacemakers and other Implanted Medical Devices should keep away.
- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations.
H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified person familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut.

READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform installation, maintenance, and service according to the Owner's Manuals, industry standards, and national, state, and local codes.

1-4. California Proposition 65 Warnings

⚠️ WARNING: This product can expose you to chemicals including lead, which are known to the state of California to cause cancer and birth defects or other reproductive harm.

For more information, go to www.P65Warnings.ca.gov.

1-5. Principal Safety Standards


OSHA Important Note Regarding the ACGIH TLV, Policy Statement on the Uses of TLVs and BELs. Website: www.osha.gov.


Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1 from American National Standards Institute. Website: wwwansi.org.

Applications Manual for the Revised NIOSH Lifting Equation from the National Institute for Occupational Safety and Health (NIOSH). Website: www.cdc.gov/NIOSH.

5. Connect work clamp to workpiece as close to the weld as possible.

6. Do not work next to, sit or lean on the welding power source.

7. Do not weld whilst carrying the welding power source or wire feeder.

For additional information on induction heating and EMF exposure, see the bulletin at this location: https://www.millerwelds.com/-/media/miller-electric/files/pdf/safety/bulletins/bulletin-on-induction-heating-and-emf-exposure-en.pdf

About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, then following the above procedures is recommended.