

PRE-INSTALL DOCUMENT



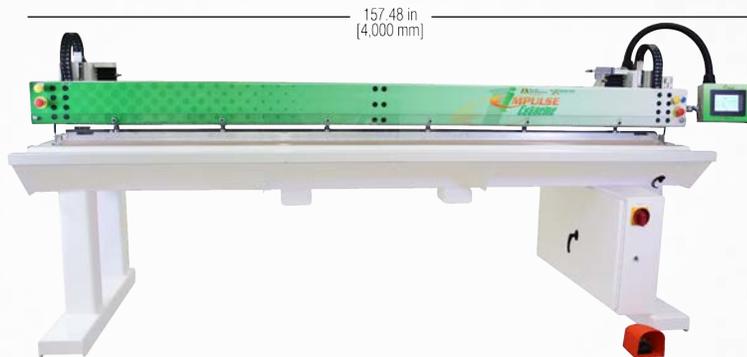
This document is a series of recommendations and specifications for the installation of the Miller Weldmaster Impulse Extreme. To ensure a smooth installation and optimal performance from your machine, please follow the recommendations and specifications precisely. Due to complications that may arise while under warranty, Miller Weldmaster Field Engineers will not install a sealer into a site that is not adequately prepared. To avoid any postponements, please ensure that all requirements specified in this document are met before the Miller Weldmaster Field Engineer arrives.

Selection and preparation of a site suitable for the installation of the client's Miller Weldmaster Seaming system is the sole responsibility of the client. Miller Weldmaster Corp. offers the following advice and specifications as guidelines for site preparation. [The last page of this document is a PRE-SITE survey on page 8 that MUST be completed and signed by the client's authorized rep. and returned before installation can be scheduled.](#) Miller Weldmaster will advise any changes that may be required in your site preparation, and establish an installation schedule. We at Miller Weldmaster look forward to meeting your staff and ensuring a successful installation and training.

customerservice@weldmaster.com
Phone: 330-833-6739

1.0 Specifications

Impulse Extreme 3.0	Machine	Machine crated
Height	1.5M	2.13M - 84in
Width	1.2M	1.40M - 55in
Length	4M	3.78M - 149in
Weight	1.360kg	1.81 metric tons - 4,000lbs



2.0 Installation & Physical Plant Requirements

2.1 Physical Plant

If you would like assistance with the placement of your machine please email customerservice@weldmaster.com or fax to 330-837-2828 your work floor layout with dimensions. Be sure to include in your floor layout other pieces of machinery as well as power and air supply location. This will help with workflow concerns.

2.2 Environment

Because there is no RF energy associated with the IMPULSE EXTREME, the distance specifications to electronics are not prohibitive. The Miller Weldmaster IMPULSE EXTREME comes with built in RF filter protection. However, the potential for RF interference exists in high RF emitting environments.

2.3 Floor Plan

The minimum floor space requirements are the size of the machine. Actual floor space for maximum production capabilities is the desired goal. Most of the additional space should be allocated to an area in front & side of the seamer.



3.0 Power Requirements

The IMPULSE EXTREME can accept the following power sources:
Only a qualified electrician should connect the electrical power. Any local certifications above the normal electrical standards will be added at the expense of the customer.

40 amp Single Phase	208 - 240 voltz, 50-60 Hz
40 amp Three Phase	208 - 240 voltz, 50-60 Hz* if quoted
40 amp Three Phase	308 - 415 voltz, 50-60 Hz* if quoted

The requirement for AMPS may vary depending on machine requirements. Consult your quotation for the exact amount required. If outside of the USA, your power configuration may vary.

The welder is supplied with a suitable 25 AMP cable approximately 13ft (4M) in length. Due to the number of different style outlets available, the cord will not include a plug. You may choose to have your cord hard-wired into your power supply. It is recommended that your electrician use a junction box with an on/off switch and thermal protection.

NOTE: The AC power must be supplied with an independent circuit breaker with the circuit ground isolated from other equipment. The power should be steady, constant and not susceptible to voltage fluctuations. In areas with unstable power sources, it is recommended that a power conditioning system (PCS) with a capacity of 6,500 watts minimum be installed.

4.0 Compressed Air Requirements

120 psi @ 5cfm	8.3 bar @ 141.6 liters
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The Impulse Extreme 3.0 seamers do not need large volumes of compressed air, however some air is required to drive the pneumatics of the seamer. Since these cylinders are activated and de-activated with bursts of air, a continuous volume of air is not needed. The Impulse Extreme includes an in-shop air supply valve that allows for quick connects and disconnects to your shop air supply. Due to the number of different style airline connectors, a male quick connect is not included. You will want to select a male quick connect with a 1/4" ANPT (National Pipe Thread) to match your female quick connect.

NOTE: If you do not already have compressed air, a small portable unit capable of the above pressure and capacity will be satisfactory.



5.0 Water tank/Coolant Requirements

A water tank is located at the rear of the machine. The water tank is used to hold the water circulated through the sealing bars for cooling. For dependable component life a mixture of distilled water and coolant lubricant must be used. Distilled water must be used to insure the water is free of minerals and contaminants. For proper lubrication one gallon of Miller Weldmaster part number IEPOOL should be used with one tank of distilled water.

6.0 Shipping

When the Impulse Extreme arrives at your facility, inspect the welder and crate for signs of any damage that may have occurred during shipping and verify the package count against the packing slip. Look for the Tip n Tell to see if the crate was mishandled. If there is damage file a complaint with the shipper and inform Miller Weldmaster immediately. If a damage situation arises do not sign the shipping receipt of the carrier without documenting the details of the crate, machine etc. FURTHER, it is critical to take photos of the machine for damage compensation. If needed, schedule a freight inspector to be on site when the Miller Weldmaster Field Engineer arrives to install the system.

7.0 Training & Installation

7.1 Committing Time

In order for the training to be of any value, it needs the undivided attention of the operators and the uninterrupted use of the Seamer. This means that the operators must commit all their time during the training session, and not try to do other work on the side. It has been our experience that by designating one or two responsible employees to take an active role in not only training but also learning all aspects of the Seamer will ensure a better production life from your machine. We understand that committing this amount of time can be very difficult in a production environment, but failing to do so can be costly. One full day for installation & training is what is usually required. It is a relatively small investment when compared to the machine down time and product waste that can occur when untrained operators are used.

Therefore, we request that you plan for a minimum of ONE full day when scheduling. The technician installing and training will speak English. The translation to your native language will be the responsibility of the customer.

7.2 Minimum Materials Required for training

The following is a list of materials required so that the maximum benefits of your training and installation can be met.

1. All different types of fabrics you will be seaming or plan to use in the future.
2. Enough material to run one or two hours worth of practice seams.
3. Enough material to make at least one of every product you produce.

7.3 Pre-seaming Considerations

The pre-seaming portion of the seaming process is very important to image quality and your overall profitability. Properly prepared pre-printed images (if you are seaming after printing), and fabrics can improve the quality of the printed material, save time and reduce costly reprints. A properly seamed Awning or Pole Pocketed Banner/Billboard using the IMPULSE EXTREME will provide your customers with a visually pleasing product.

7.4 The Main Operator

The IMPULSE EXTREME requires at least one main operator who will be responsible for the operation and maintenance of the Seamer. The candidate should be a responsible employee and will need certain skills. He/she will be expected to be able to maintain the Seamer and perform a routine maintenance. This person will also be the communication link with our Support Department, and should be capable of phone-assisted problem solving and basic repair.

The main operator will be important to the operation of the Seamer, and should be selected with great care. The MAIN OPERATOR should possess basic hands on mechanical aptitude & some very basic technical background.

7.5 Other Operators

In addition to the main operator, other operators will be required for more than one shift and as helpers. It is not necessary that these operators possess the skill level of the main operator. However, anyone working with the IMPULSE EXTREME should show a mechanical aptitude and have some experience with seaming or sewing. It is important that the person have an eye for distinguishing between good seams and bad seams.

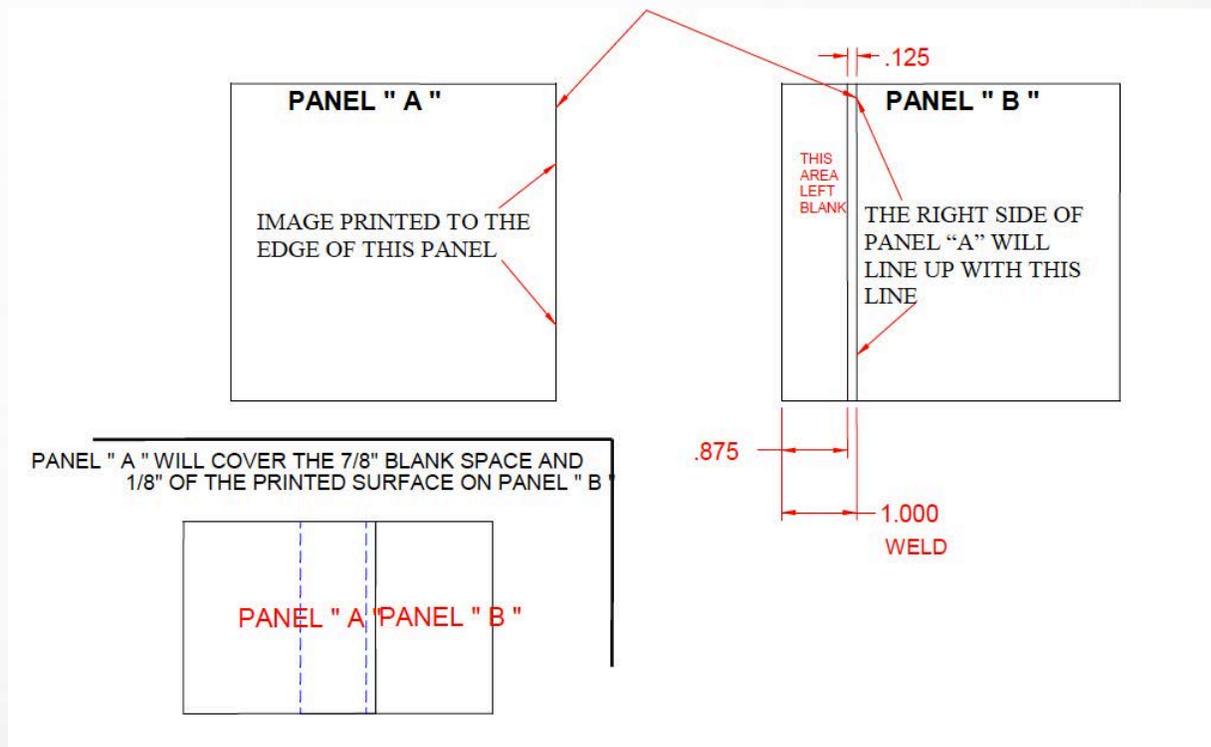
7.6 Goals for the Operators in Training

To understand all the controls and functions on your IMPULSE EXTREME, understand and perform basic maintenance and to understand and be able to achieve a good weld for each type of material & to produce an end product in a timely manner.

8.0 Pre Printed Material

8.1 Overlap welding

Please make sure panels are available during training & installation. This layout below assumes you will be doing a 1 inch overlap weld. There are other means of obtaining an overlap weld on preprinted images in needed.



Guidelines which must be followed to ensure that your Miller Weldmaster welder is installed properly: Adequate power & compressed air must be in place and connected before the arrival of the installing MW eild Engineer & the MAIN operator(s) must be made available for one full day of training with no other commitments or activities during the regular (8 hour) workday.

Pre-Installation Document



Complete this page, sign & return to:
customerservice@weldmaster.com or fax to 330-837-2828

This form must be returned before the welder can be installed. Please return this survey as soon as possible. Please answer the following questions completely and honestly:

Your Name:	Email:
Your Company:	Date:

1. Do you have the applicable power requirements? Please see Serial tag for correct power connection

40 amp – 208v to 240v Single Phase? <input type="checkbox"/> Yes <input type="checkbox"/> No	40 amp – 308v to 415v Three phase? <input type="checkbox"/> Yes <input type="checkbox"/> No
40 amp – 208v to 240v Three phase? <input type="checkbox"/> Yes <input type="checkbox"/> No	

- Is the welder at your facility? Yes No
- Has the welder been removed from the shipping crate? Yes No
- What is the measured incoming voltage of the electrical power source that will be connected to the welder? _____ volts
- Is this power source in place and connected to the welder? Yes No
If not when will it be installed? _____
- Is this air supply in place and connected to the welder? Yes No
- Is the seamer to be installed requiring any special considerations for installation? Yes No
If yes what are they? _____
- Do you have adequate compressed air, as referred to in the guide? Yes No
If NO-when will this be available? _____

REQUIRED for install: Customer to provide 15 gallons/ 56 liters of distilled water (Mineral free) for coolant system on Impulse Extreme.

Who should we contact to schedule our installation/training visit with?

Name:	Position:
Phone:	Email:

Will you be able to provide all of the training fabric & personal needed for proper training?

Yes No If no, please explain:

Employee names/position being trained on MW machine

Name:	Position:
Name:	Position:

Your installation and training time are valuable. If you state that you have a power source, please ensure that it is connected prior to the MW tech scheduled onsite visit. Any extra days required for the installation will be billed at our current shop rate per hour plus additional travel expenses.