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BULLETIN.022

## SYNCHRO-PULSE CDT: CP34 CP34-52 MICROPROCESSOR PCB

For correct welding operation of the Synchro-Pulse CDT, it is important that the maximum wirefeed motor speed be calibrated correctly. This procedure, which is fully described in the product manual, involves selecting a weld schedule with a programmed maximum speed of 126 rpm.

The schedule for 0.9mm Mild Steel is usually quoted as recommended schedule to select, however, this may not be present in all eproms.

An alternative programme is available in all CP34 eproms; it is programme #13 which is a test schedule (will not weld), but which has a programmed maximum motor speed of 126 rpm. (For reference, the programmed 'descriptive signal' pulse width is 1ms).

Programme #13 is selected when plug P2 (Programme selector switch) is removed, ie. LEDS 4-9 all OFF.

Note that Programme #13 is therefore also selected if the selector switch develops dirty contacts.

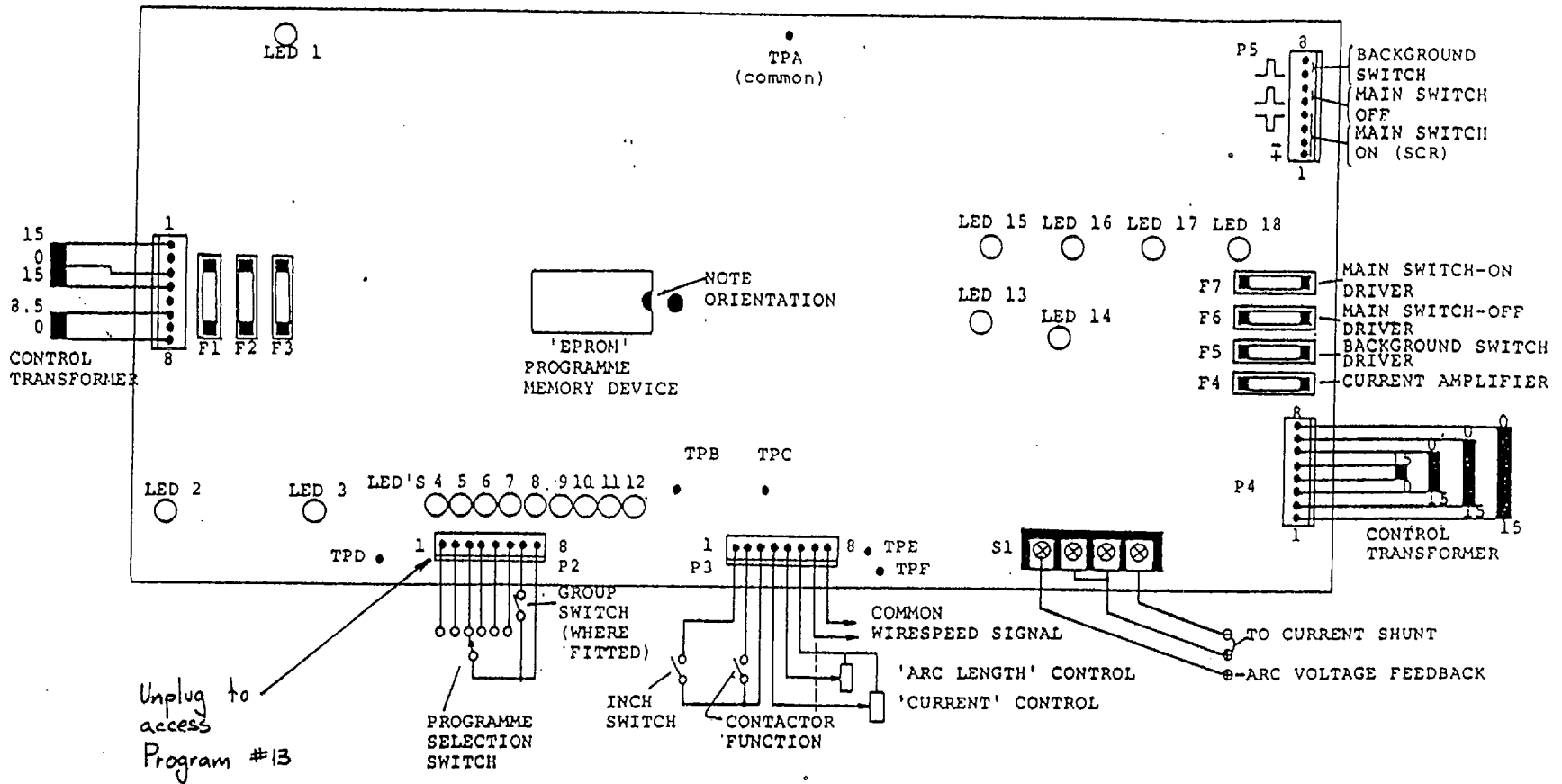


FIGURE 10. MAIN CONTROL BOARD OVERLAY