

16 JUNE, 1994

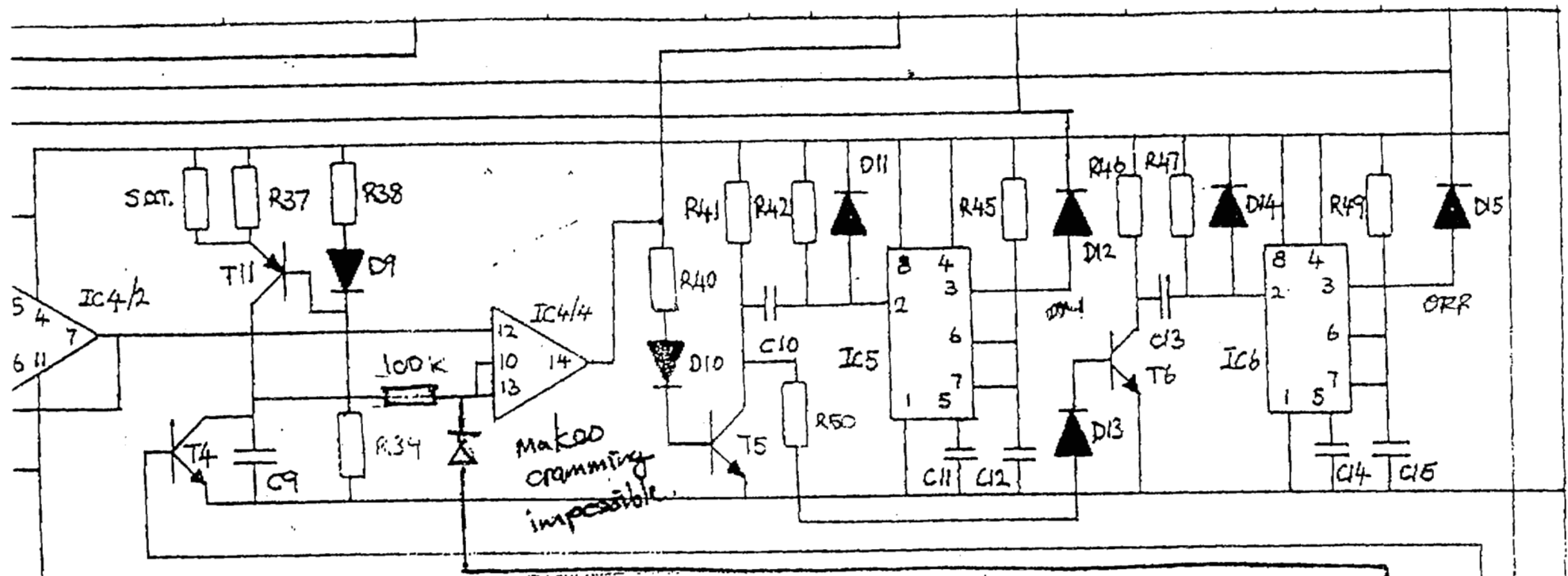
BULLETIN.043

**SYNCHRO-PULSE CDT: CP34**  
**ANALOG MODEL**  
**CP34-29 FUNCTION PCB**

When using an Aluminium consumable wire, it is possible at the beginning of a weld to experience an 'explosion' of the wire until the arc stabilises. This is caused by the output pulses 'cramming'. To prevent this, the following modifications to the Function PCB can be performed.

Cut the track between the collector of transistor T4, and IC4/4 Pins 13 and 10, and insert a 100K resistor. Also connect a 1N4004 diode from IC4 Pins 13 and 10, to the anode of diode D8.

Refer to the attached drawings for more details.



- CUT TRACK FROM T4 COLLECTOR TO IC4/4 PIN 13.
- INSERT 100K RESISTOR
- CONNECT DIODE FROM DB ANODE TO IC4/4 PIN 13.

CP34-29. 