

18 NOVEMBER, 1994

BULLETIN.119

CP34 SYNCHRO-PULSE CDT CP34-52 MICRO-PROCESSOR BOARD UNCONTROLLED WELD CURRENT

During the time of production of the CP34, a particular software feature was introduced which improved the starting characteristics of the machine, particularly with aluminium consumables.

This feature was called "Raise", and eproms employing it were often known as "hot start chips".

After some time, it was noted that use of "Raise" caused an unwanted side effect, which was the occasional total loss of control of the arc current during starting. As a consequence, use of "Raise" was eventually discontinued.


A small hardware modification has now been successfully tested which allows the safe use of "Raise". The modification is to insert a 2K2 resistor into the pcb track leading from PIN 12 of U10 to the junction of PIN 3 of U19 and C18. This is shown in the circuit diagram and pcb layout attached.

This modification can be carried out where "Raise" eproms are still in use and causing occasional uncontrolled weld current problems, or where it is desirable to access the improved starting characteristics available.

"Raise" was applied to aluminium schedules in eproms from No. 52792 to 52007, with the following exceptions:

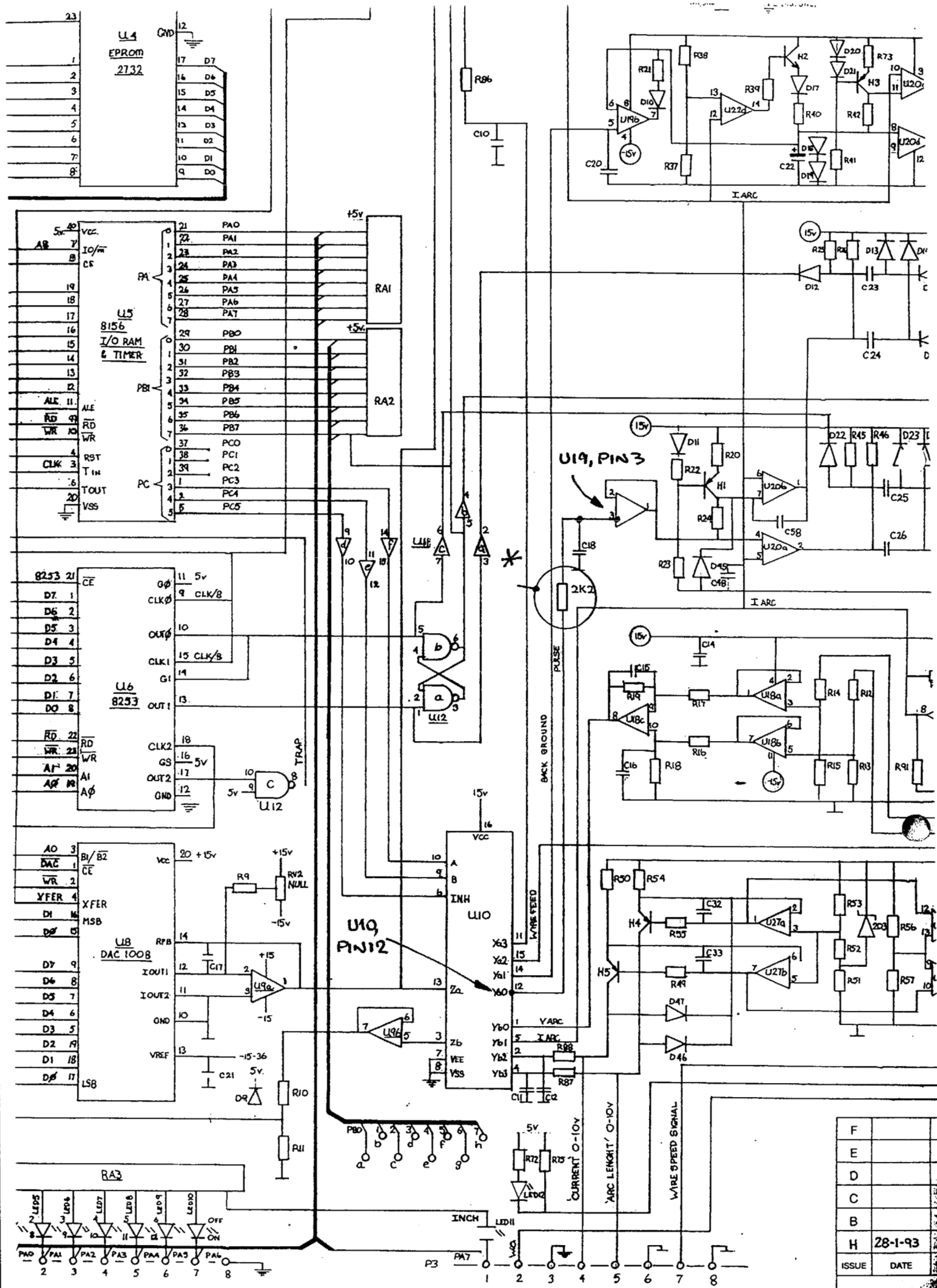
X52918, X52978, 52001, 52003

For reference, eprom 52900 contains the standard mix of mild steel, stainless steel and aluminium schedules, with "Raise" applied to the aluminums.



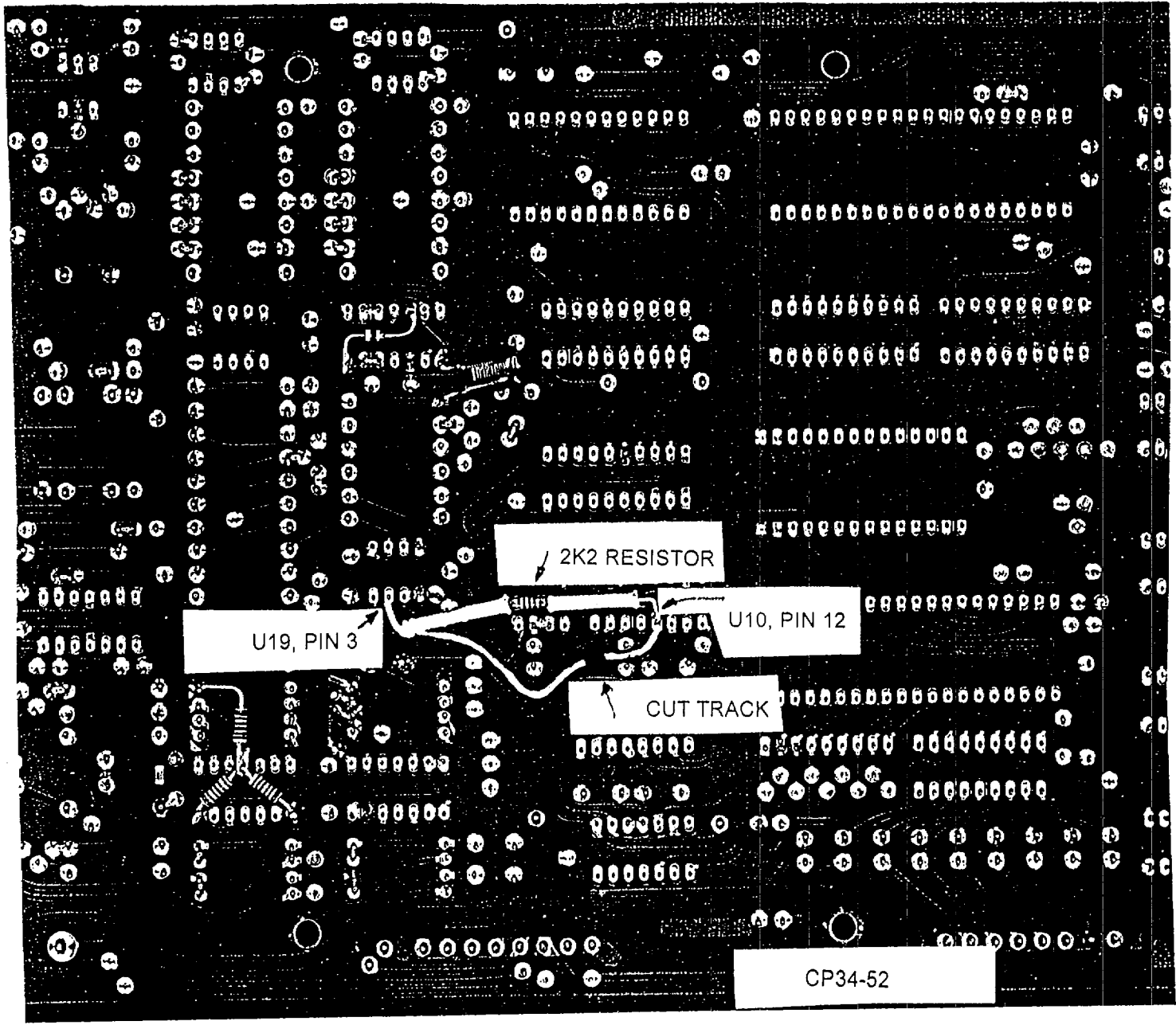
GARY CHEESMAN
MARKETING MANAGER - EQUIPMENT

QUALITY WELDING PRODUCTS, SYSTEMS & SERVICE



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THIS DRAWING IS AND MUST NOT BE



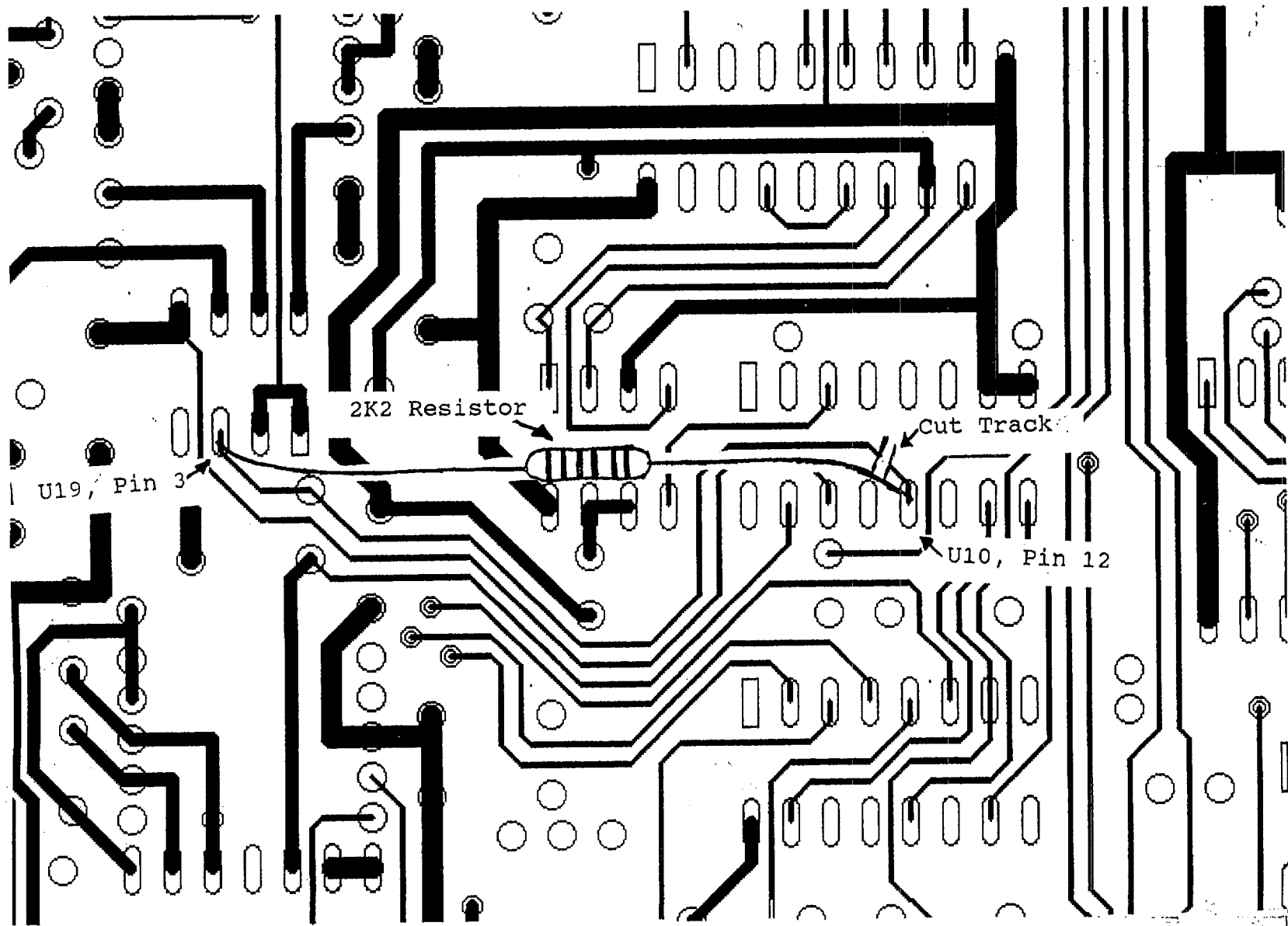
2K2 RESISTOR

U19, PIN 3

U10, PIN 12

CUT TRACK

CP34-52



2K2 Resistor

U19, Pin 3

Cut Track

U10, Pin 12