

8 August, 2000

BULLETIN #164

WELDMATIC 395

CP43-0/4 COARSE SWITCH

This is to advise the 3 position coarse switch, WIA part number CP43-0/4, that was used in the early model Weldmatic 395 (Revision A) is still available as a spare part. However, the list price for this 3 position coarse switch has risen substantially as a result of low usage of this item and this has led to a large increase in cost from the manufacturer.

The alternative is to use a 4 position switch that is currently fitted to production machines. The switch is cheaper and offers a power off feature in the extra position. WIA part number for this 4 position coarse switch is CP43-0/8.

Instructions for replacing a 3 position coarse switch CP43-0/4 with a 4 position coarse switch CP43-0/8 in an early model Weldmatic 395 machine are as follow:

- 1) Check that all transformer wires are connected to the terminals of the 3 position coarse switch CP43-0/4 as shown in Table 1 below.

TABLE 1

Transformer wire	CP43-0/4 Switch terminal no.
No. 7 red wire	9
No. 8 red wire	5
No. 9 red wire	1
No. 7 black wire	11
No. 8 black wire	7
No. 9 black wire	3
No. 7 blue wire	17
No. 8 blue wire	15
No. 9 blue wire	13

Note : Refer to attached circuit diagram CP43-0 Rev. A

- 2) Remove all transformer wires from the 3 position coarse switch.
- 3) Connect transformer wires to the terminals of the new 4 position switch CP43-0/8 as shown in Table 2 below.

TABLE 2

Transformer wire	CP43-0/8 Switch terminal no.
No. 7 red wire	7
No. 8 red wire	1
No. 9 red wire	5
No. 7 black wire	11
No. 8 black wire	3
No. 9 black wire	9
No. 7 blue wire	15
No. 8 blue wire	17
No. 9 blue wire	13

Note : Refer to attached circuit diagram CP43-0 Rev. C

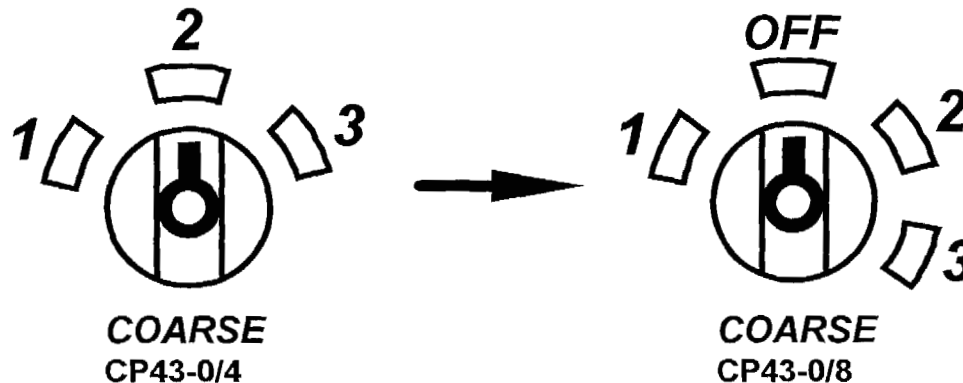
- 4) Disconnect red & blue 415V control transformer wires from L1 & L3 of input terminal block.
- 5) Disconnect brown & blue 415V fan wires from L1 & L3 of control transformer.
- 6) Connect control transformer wires and fan wires to the terminals of the 4 position switch CP43-0/8 as shown in Table 3 below.
- 7) Connect new L1 & L3 phase wires from input side of the welding contactor to the terminals of the 4 position switch CP43-0/8 as shown in Table 3 below.

TABLE 3

	CP43-0/8 Switch terminal no
1 red phase	21
L3 blue phase	23
Brown fan wire	22
Blue fan wire	24
Red control t/f wire	22
Blue control t/f wire	24

Note : Refer to attached circuit diagram CP43-0 Rev. C

- 8) Relabel the course adjustment settings on the front panel to show the new settings as shown below.



- 9) Using the voltmeter on the front of the Weldmatic 395 , check that the open circuit output voltage is increasing in an ascending order when the coarse and fine switches are varied from Coarse 1 / Fine 1 to Coarse 3 / Fine 10. The open circuit voltage should range from 20V to 50V in 30 steps.

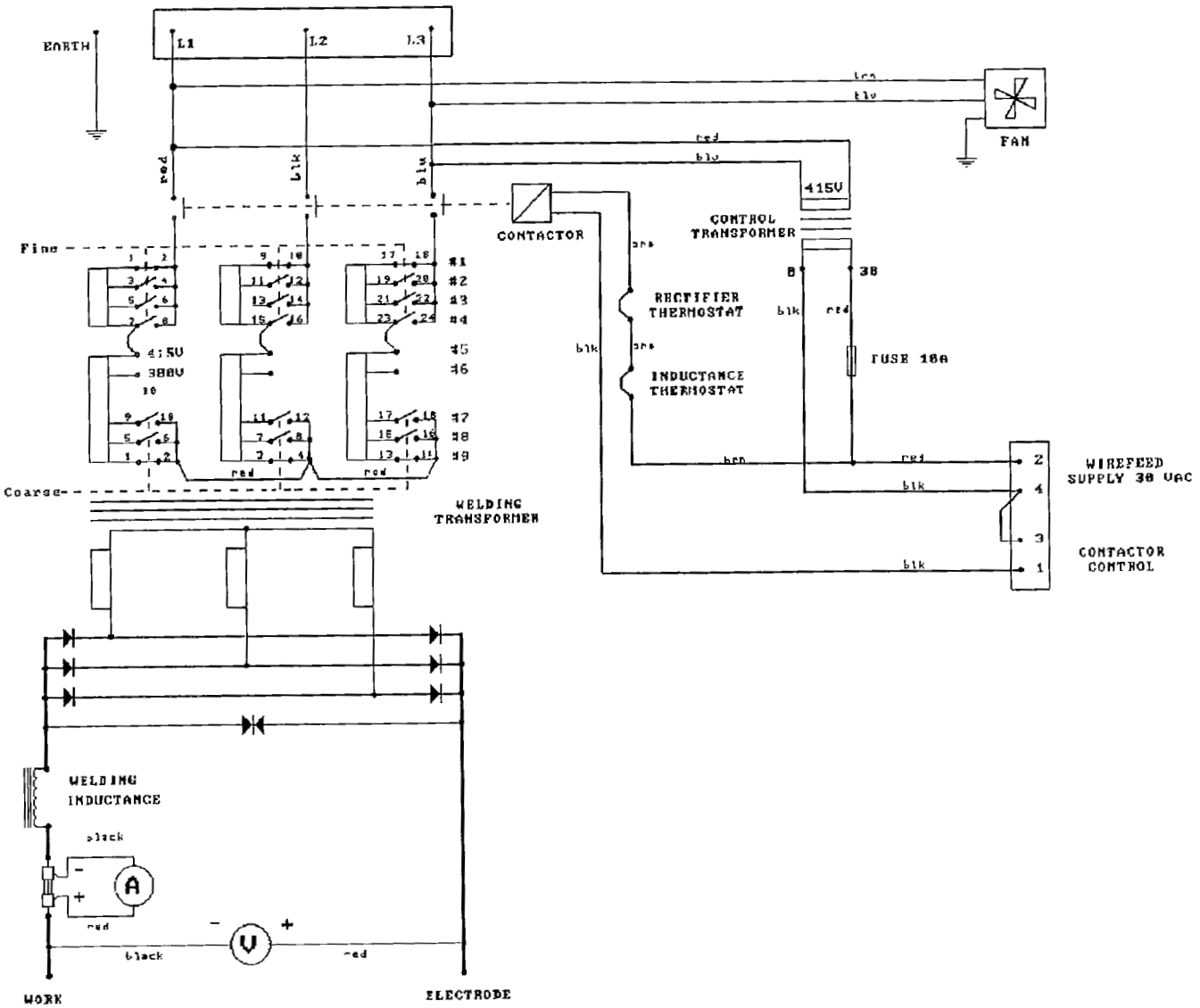

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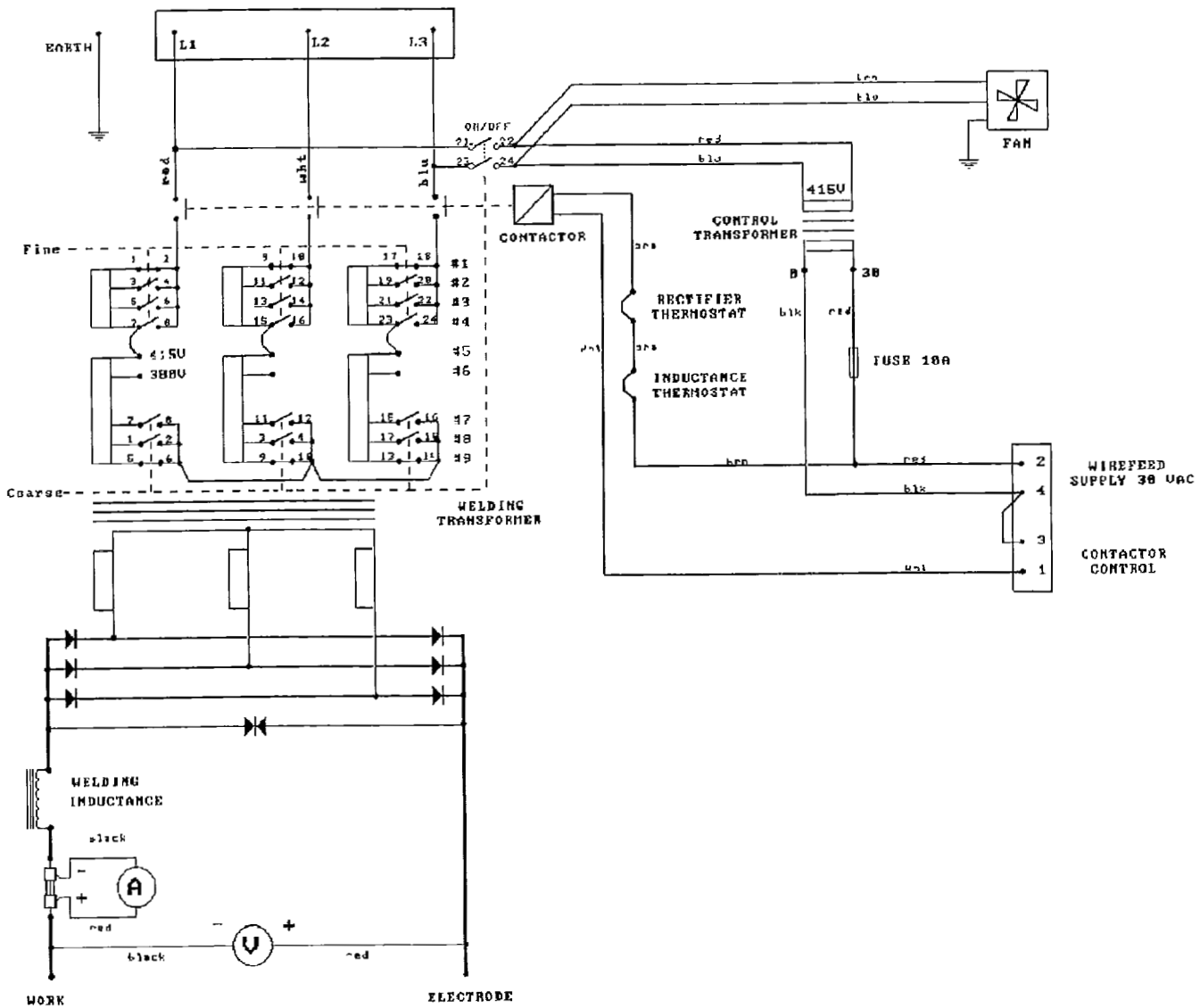
Circuit Diagram CP43-0 REV.A using 3 position switch



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Circuit Diagram CP43-0 REV.C using 4 position switch



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