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BULLETIN #172

## W41 WIREFEEDERS

### NEW PCB & EPROM SOFTWARE

Wirefeeders W41-0 (2 roll drive) and W41-1 (4 roll drive) are now fitted with a current relay to provide a "Creep" mode as well as "Normal" start speed mode.

In Creep mode, a current relay is used to detect the wire touching the work, which in turn ramps the wire up to full running speed.

The W41-0 and W41-1 use the same PCB, and the various versions are listed below:

Part N°	Description	Where Used
W41-10	Wirefeed Control PCB	Original PCB - "Normal" & "Reduced" setting
W41-11N	Wirefeed Control PCB	Later design PCB, for use in machine fitted with current relay
W41-10NC	Wirefeed Control PCB W41-11 plus current relay	Replacement PCB and current relay for an early machine without a current relay

The W41-11 PCB was introduced together with software change to improve arc starts. However some users found that the arc start time was too long, so the software has now been modified to correct this.

The software used on these PCB's is summarised below.

Software Version	Software Description	Characteristics	Comments
48002	Original Software	Harsh starts	Use with original W41-10 PCB only
48005a	"Special" – limited number		
48003	Used on Miller robot interface with Yaskawa wire feeder motor		
SW000101	Original Software for W41-11 PCB	Too long to establish the arc	Use with W41-11 PCB only
F0010102	Variation of SW000101 introduced to overcome problem in "Cycle" mode	Too long to establish the arc	
F0010103	Introduced to overcome problem of slow starts	Perfect starts	

The new EPROM code has been fitted in all W41-0 and -1 models produced since the beginning of July, starting with serial numbers: W410C070106800 (2RD) & W411C070111 00 (4RD)

If you have a customer with a W41 with current relay who complains of slow arc starts, you can update the EPROM to correct the problem.

Order part number W41-50/1, which refers to the latest version EPROM with F0010103 software. Use anti static precautions when fitting this static sensitive device.



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