

Date 16/7/2003

BULLETIN # 177

WELDMATIC 215S

NEW WIREFEED PCB

The wirefeed pcb on the Weldmatic 215S has been changed. The CP109-11 pcb has been replaced by the CP109-12 pcb, and the CP109-11 pcb is no longer available.

The CP109-12 pcb is available in two forms.

1. **CP109-11N** is a service kit to replace either a **CP109-10** or **CP109-11** pcb. This kit includes a CP109-12 pcb, an extra wire which is required for the CP109-12 pcb and a 0.82 ohm, 50 watt resistor, together with fitting instructions.
2. **CP109-12N** is a replacement for a **CP109-12** pcb, and contains a CP109-12 pcb plus fitting instructions.

ADDITION OF LIMITING RESISTOR

To limit the amount of current available to the wirefeed pcb, a 0.82 ohm, 50 watt resistor has been added to Weldmatic 215S in production from July 2002. This addition has improved the reliability of the wirefeed pcb in this machine.

It is important that if the wirefeed pcb fails in a Weldmatic 215S, this resistor is added when a new pcb is fitted.

It is recommended that the resistor be fitted to a machine even if the pcb has not failed, as this may protect the pcb from possible future failure. It is available as WIA part number CP38-31/3, and can be used to protect the older style CP109-10 or CP109-11 pcb.

The resistor is automatically included when the service kit CP109-11N is used, as explained above.

The complete instructions for fitting a CP109-11N or CP109-12N are included in the respective kits, so the instructions are not duplicated in this bulletin. However some important points are noted here.

Fig 1 shows the location of the 0.8 ohm, 50watt resistor. To fit the resistor:

1. Locate the two orange power supply wires which lead to pins 9 & 10 on the wirefeed pcb.
2. Cut one of these orange wires midway between the two cooling fans.
3. Drill two holes and use self tapping screws to secure the resistor to the horizontal shelf between the two fans.
4. Prepare the cut ends of the orange wire and solder one to each end of the resistor as shown.
5. Use cable ties to secure the power supply cables.

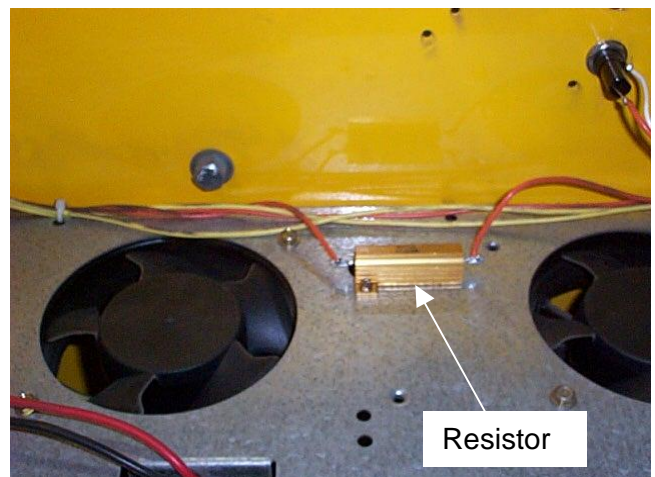


Fig 1 Resistor Location

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It is vital that the connections between the SCR module and wirefeed pcb are correct, **as incorrect connections will damage the pcb.**

Be aware that the pin numbering for the SCR gate connection is different between CP109-11 and CP109-12 pcb

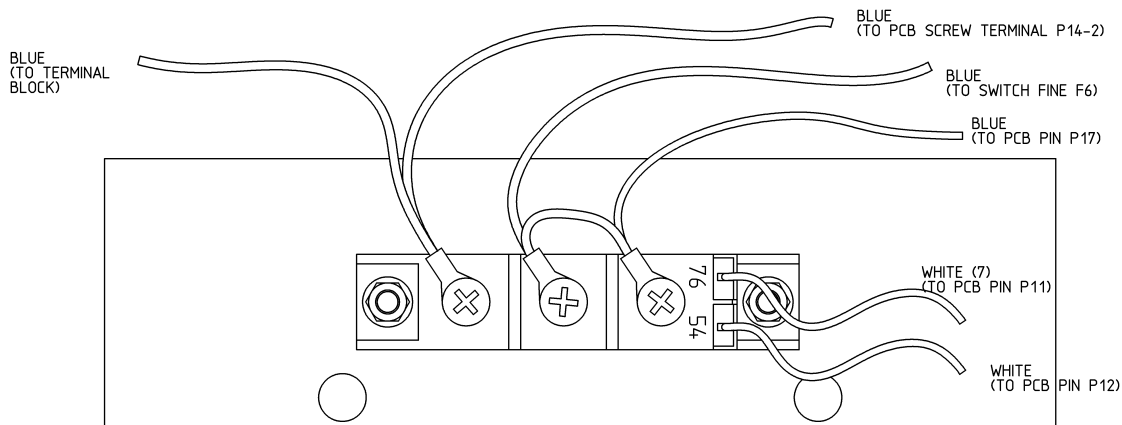


Fig 2 Connection of **CP109-12** pcb to SCR module
(note, no snubber assembly on the SCR module when used with **CP109-12** pcb)

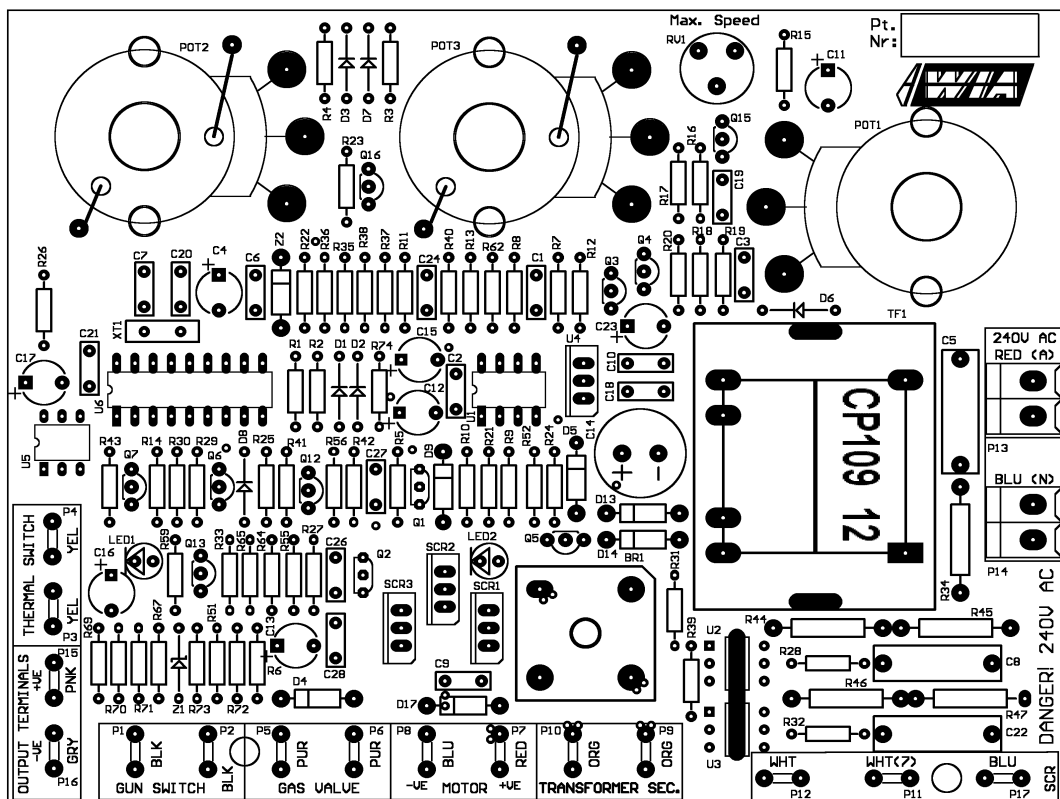
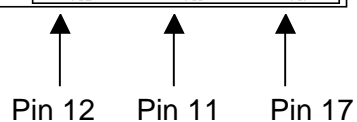


Fig 3 Pin location on **CP109-12** pcb



regards,
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