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BULLETIN # 192

## W41/W55/W56

### NEW WIREFEED PCB

The W41-11 wirefeed pcb used on W41-0, W41-1, W55-0 and W56-0 has been replaced by the W41-12 pcb. This new pcb has been modified to give improved reliability, and has additional filtering to make it less vulnerable to interference from HF noise. It is a direct replacement for the W41-11 pcb.

W55 and W56 wirefeeders will have the W41-12 fitted in the factory from mid March 2005, and will be labelled as Issue B. Their serial numbers will start with:

W550B0305..... for the W55 (2RD) and

W560B0305..... for the W56 (4RD).

Old Part No	Description	Replacement Part No
<b>W41-10</b>	Original wirefeed pcb fitted to W41-0 or W41-1.	<b>W41-12N</b> plus <b>AM 298</b> , current sensor (only if required)
<b>W41-10NC</b>	Replacement Part No for early series W41-0 or W41-1. This part included a current sensor to update early machines.	<b>W41-12N</b> plus <b>AM298</b> , current sensor (only if required)
<b>W41-11</b>	Updated pcb for W41-0, W41-1, W55 and W56. Includes a connection for a current relay to ramp up wire speed at arc initiation when in "Creep Mode".	<b>W41-12N</b>
<b>W41-50/1</b>	<b>EPROM</b> with vers F0010103 software suitable for <b>W41-11</b> pcb only	<b>W41-50/1</b> (unchanged)
N/A	<b>EPROM</b> with vers F0010201 software suitable for <b>W41-12</b> pcb only	<b>F00102</b>

The W41-12 pcb is calibrated at the factory to run at the correct maximum speed (190 rpm) when fitted to a **W41-0, W41-1 and W56-0** wirefeeder.

However, if the pcb is fitted to a **W55-0** wirefeeder (which uses a different wirefeed motor) the maximum speed will be incorrect. To correct this, adjust RV1 on the W41-12 Wirefeed PCB until the speed of the drive roller is 190 rpm when measured with a tachometer. The motor must be running with the speed dial set to maximum, and the pressure lever released.

An approximate maximum speed can be achieved by adjusting RV1 until the voltage measured at the wirefeed motor terminals measures between 20.0 and 20.5 volts dc.

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