

16 June 2005

BULLETIN # 196

SYNCHROPULSE CDT450, CP38 WITH W37

WIRE DRIVE SPEED IRREGULARITY

There have been some instances reported recently where the wire drive suffers from inconsistent speed. This problem has been traced to electrical noise which may be generated by the wire drive motor used on the W37 wirefeeder. This electrical noise can disrupt the speed control system of the CP38-52 wire/gas board, causing speed irregularity. The following circuit and instruction details a modification which prevents any noise of this type from causing speed irregularities.

A 1N4004 diode has been added to the CP38-52 pcb. Fig 1 shows the location of D7 in the CP38-52 circuit, and Fig 2 shows where D7 is located on the solder side of the pcb. A suitable alternative to the 1N4004 diode would be 1N4005, 1N4006 or 1N4007.

All new CP38-52 pcb's will have this diode added, and be labelled as Issue C.

New CP38-3 machines starting from serial number CP383H0605163001 will have this modification.

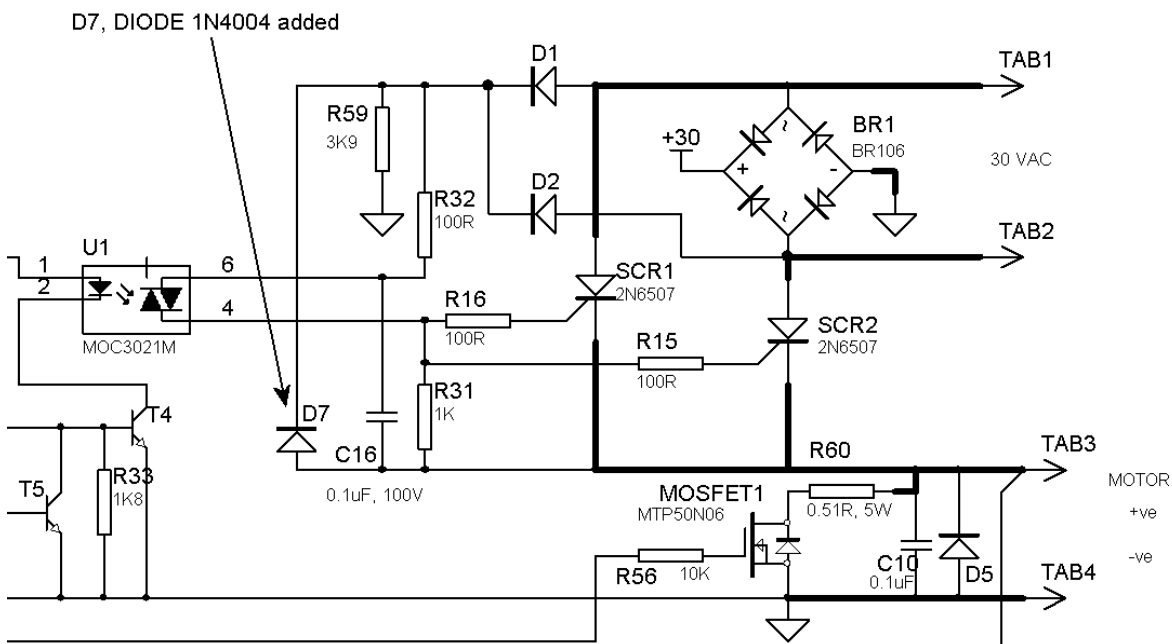
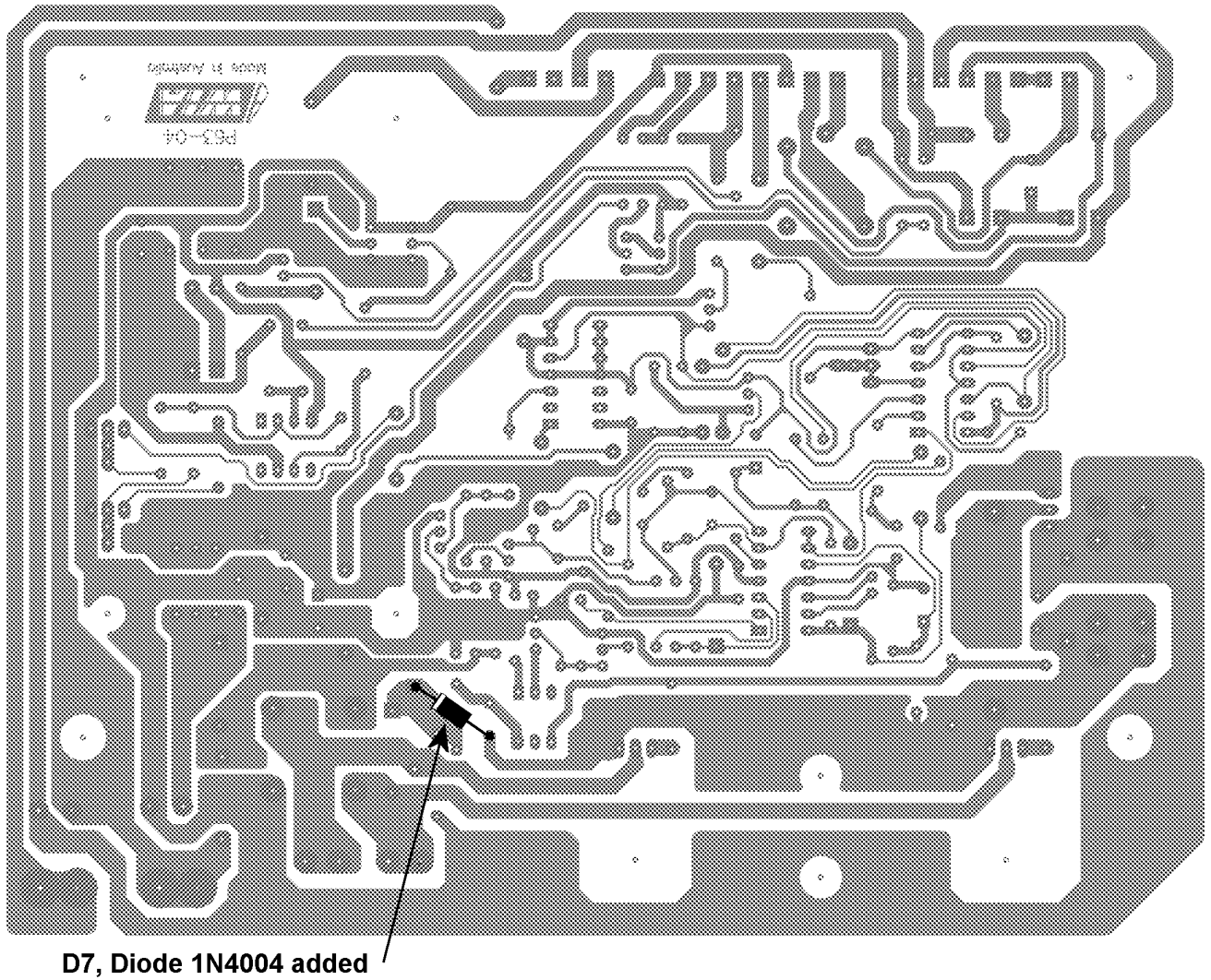


Fig 1, CP38-52 Circuit Showing Addition of D7

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D7, Diode 1N4004 added

Fig 2, Location of D7 on Solder Side of PCB

Hugh Stewart,
Technical Service Coordinator