

08 December 2006

BULLETIN #213

## W19

### OPTIONAL FAST WIREFEED START SPEED ADDED

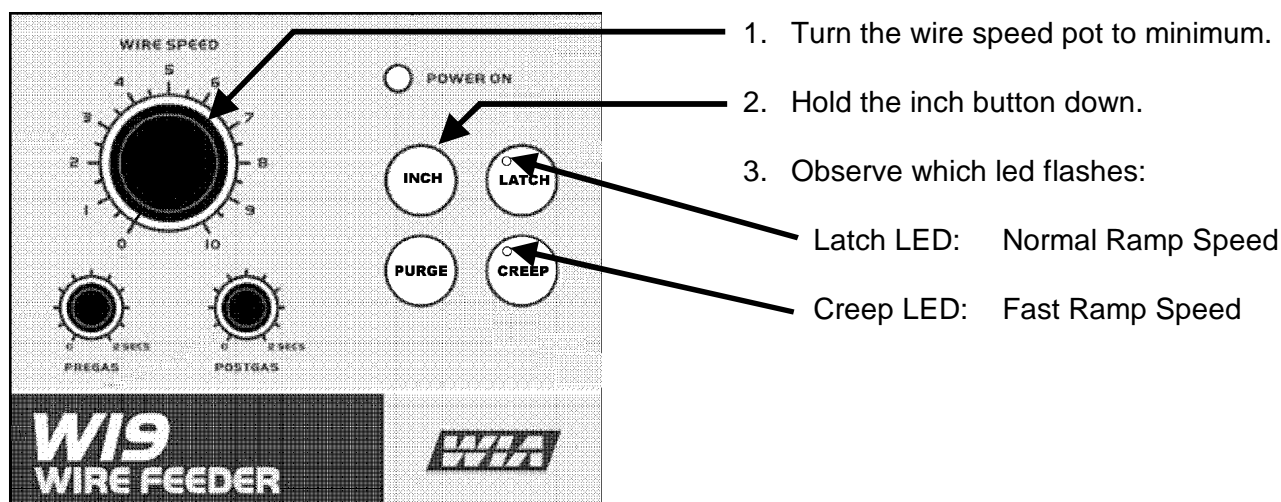
In order to meet a request from some customers for a very fast wirefeed start speed, a "Fast Ramp Speed" mode has been added. There are now two different ramp speeds available for selection on W19-11 wirefeed pcb.

Mode 1: Standard Ramp Speed (Default mode)

Mode 2: Fast Ramp Speed.

#### Mode Identification

In order to be able to identify which mode the controller is in, follow this sequence.



#### Mode Change

The mode can be changed via the following procedure.

1. Switch off power to the wirefeeder.
2. Turn the wire speed pot to minimum
3. Hold the Inch button down while switching on the wirefeeder.
4. Press the Inch button 3 times (within 8 seconds).
5. The operation mode is changed to the next Mode (1 to 2, or 2 to 1).

Please be aware that this option is only a recent addition to the W19-11 pcb, and may not be available on W19-11 pcb's used in W19 production before October this year. Use the mode identification procedure outlined above to determine whether mode selection is available. If neither Creep or Latch led flashes, then the software will be locked in standard ramp speed mode.

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