



Service Bulletin



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BULLETIN # 262

CP114, CP117, CP126, CP127, CP134, CP135

Calibration of Weldmatic Fabricator CP135 Output

CAUTION: The following information is intended for use by qualified service personnel. When the unit is energised LETHAL VOLTAGES are present on the electrical and electronic components. It is not intended that persons without suitable training and knowledge attempt to perform service tasks on the components of welding equipment.

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CALIBRATION OF WELDMATIC FABRICATOR CP135 OUTPUT**1. Access to the inside of the machine****1.1 Notes**

None

1.2 Tools required

Socket set (specific sizes 8mm , 13mm, 19mm) and Ratchet Handle

1.3 Procedure

Removal of the machine top cover panel is straight forward and no specific instruction is required.

2. Calibration and Adjustment**2.1 Notes**

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Adjustment is to be carried out whilst measuring machine output at the output terminals. Adjustment whilst measuring on the work piece will calibrate only to that specific process and all other settings will be inaccurate.

2.2 Tools required

Potentiometer adjustment tool (blade)

2.3 Procedure – Voltmeter calibration

- a) With the machine connected as if ready to weld, align a voltmeter to read voltage across output terminals.
- b) Remove any wire that may feed through the system.
- c) Turn on the output power by activating the trigger, this should bring output volts to the terminals.
- d) Ensure the output voltage on the test voltmeter is the same reading as the display.
- e) Adjustment is carried out at the voltage potentiometer on the rear of the display card AM272-11 (refer to figure 1)

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2.4 Procedure – Ammeter calibration

- a) With the machine connected as if ready to weld, align a clamp ammeter to read amps from the positive output.
- b) Remove any wire that may feed through the system.
- c) Turn on the output power by activating the trigger, this should bring output volts to the terminals.
- d) Ensure the output amps on the test ammeter is the same reading as the display.
- e) Adjustment is carried out at the voltage potentiometer on the rear of the display card AM272-11 (refer to figure 1)

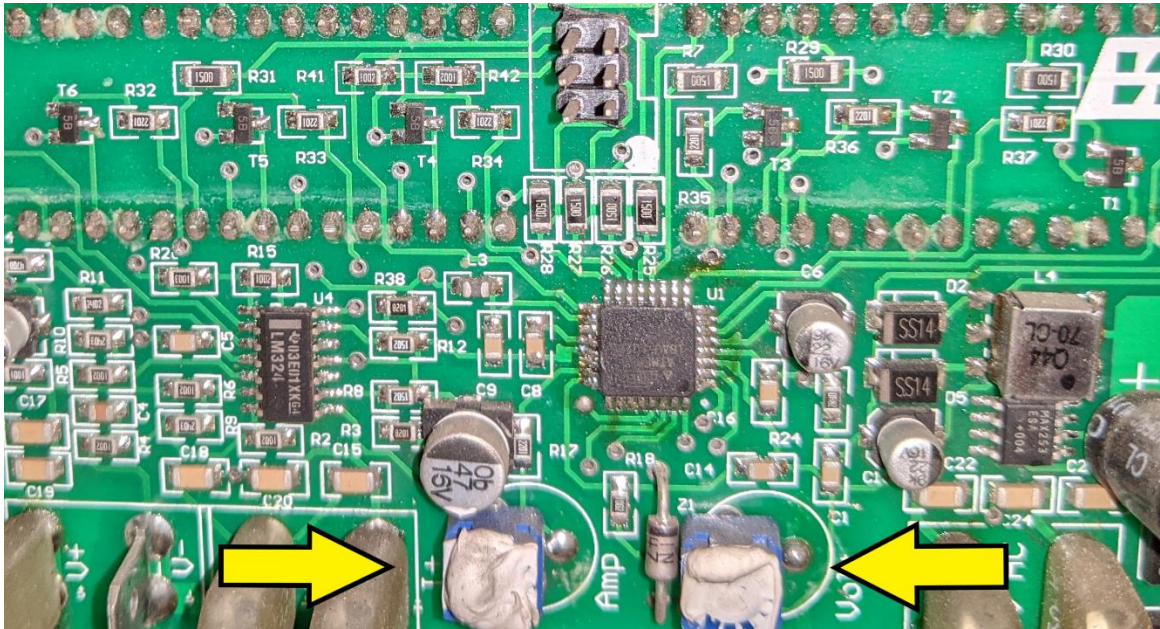


Figure 1

3. Testing

A full functional test of the machine is to be carried out upon completion of any adjustment to ensure accuracy of the meter.

Once considered serviceable, the machine top cover panel is to be refitted in a reverse of the removal procedure.

Andrew Stanley,
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