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UNITORTM
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UWI 203TP





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**Make sure that the machine is
disconnected from the main line
before removing the cover.**





According to the diagnosis of fault as per Troubleshooting Manual, to replace the necessary components accordingly or replace all.

Steps section:

- Section 1: Steps for Replacing Power Board.
- Section 2: Step for Replacing Diode Isotope.
- Section 3: Step for Replacing TP Board (Three Phase Supply Protection Board).



Section 1: Steps for Replacing Power Board.



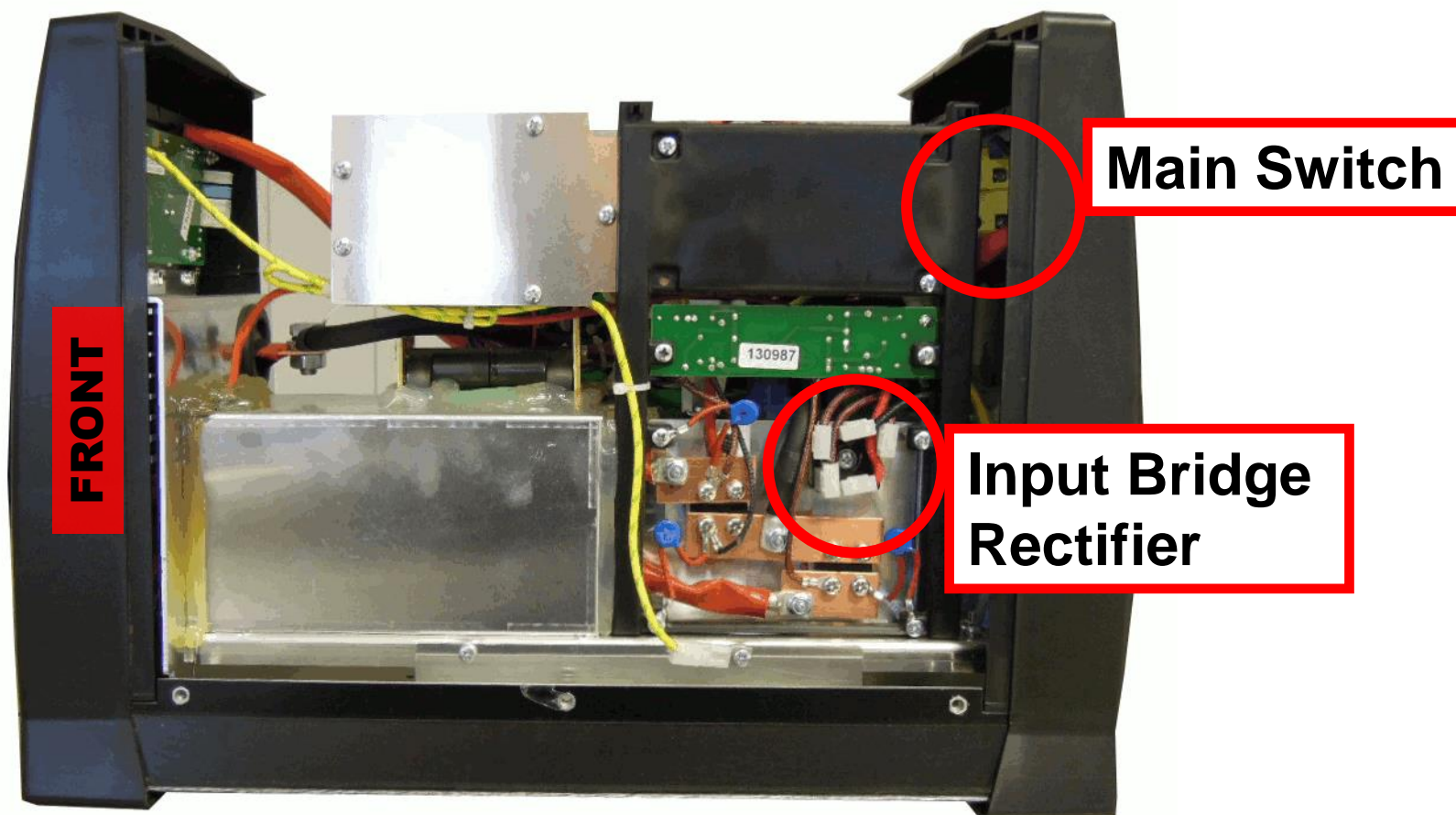
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- **Step 1: Remove the cover (10 Philips screws).**





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- **Step 2: Disconnect the Input Bridge Rectifier Wires:**





- **Step 3: Disconnect the Input Power Cables from the Main Switch:**





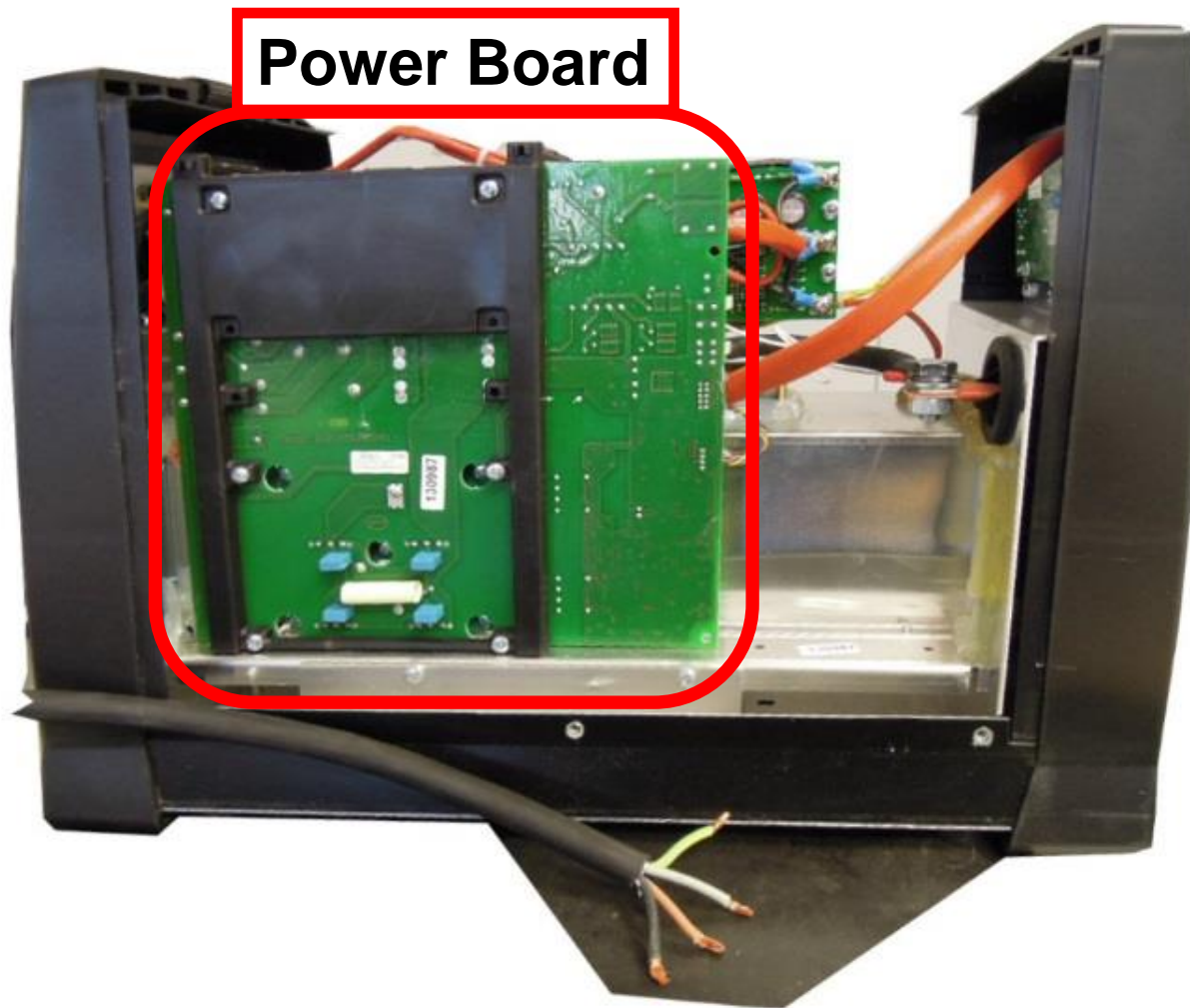
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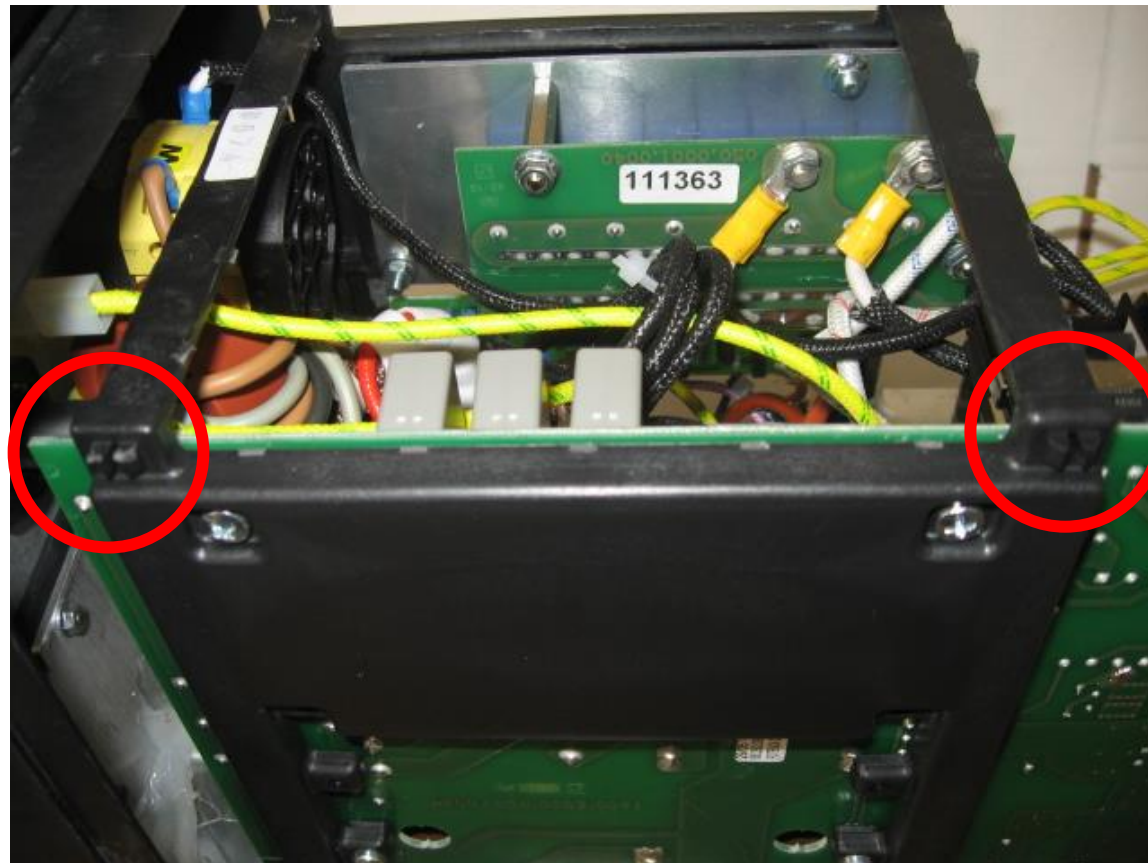
Power Board



FRONT

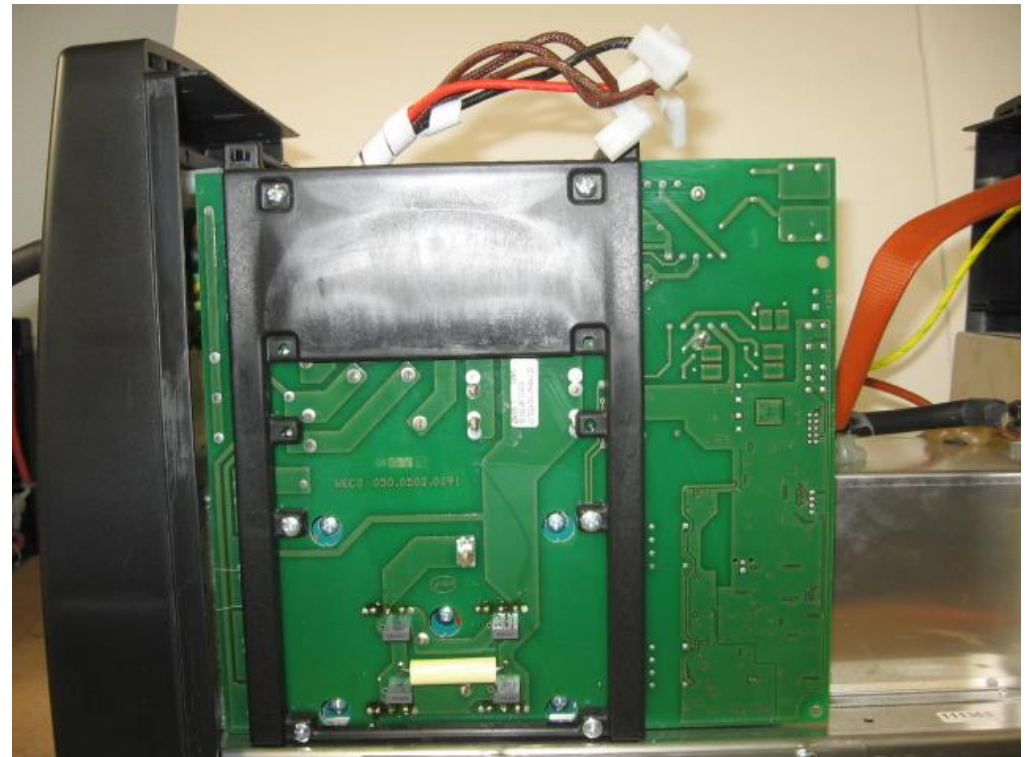
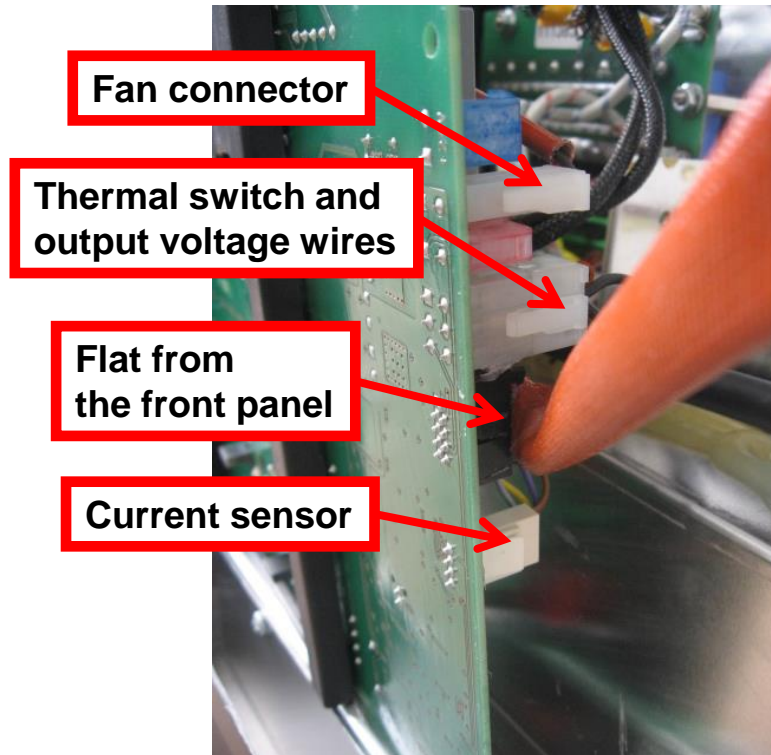


- **Step 4: Extract the plastic spacers with a tong.**



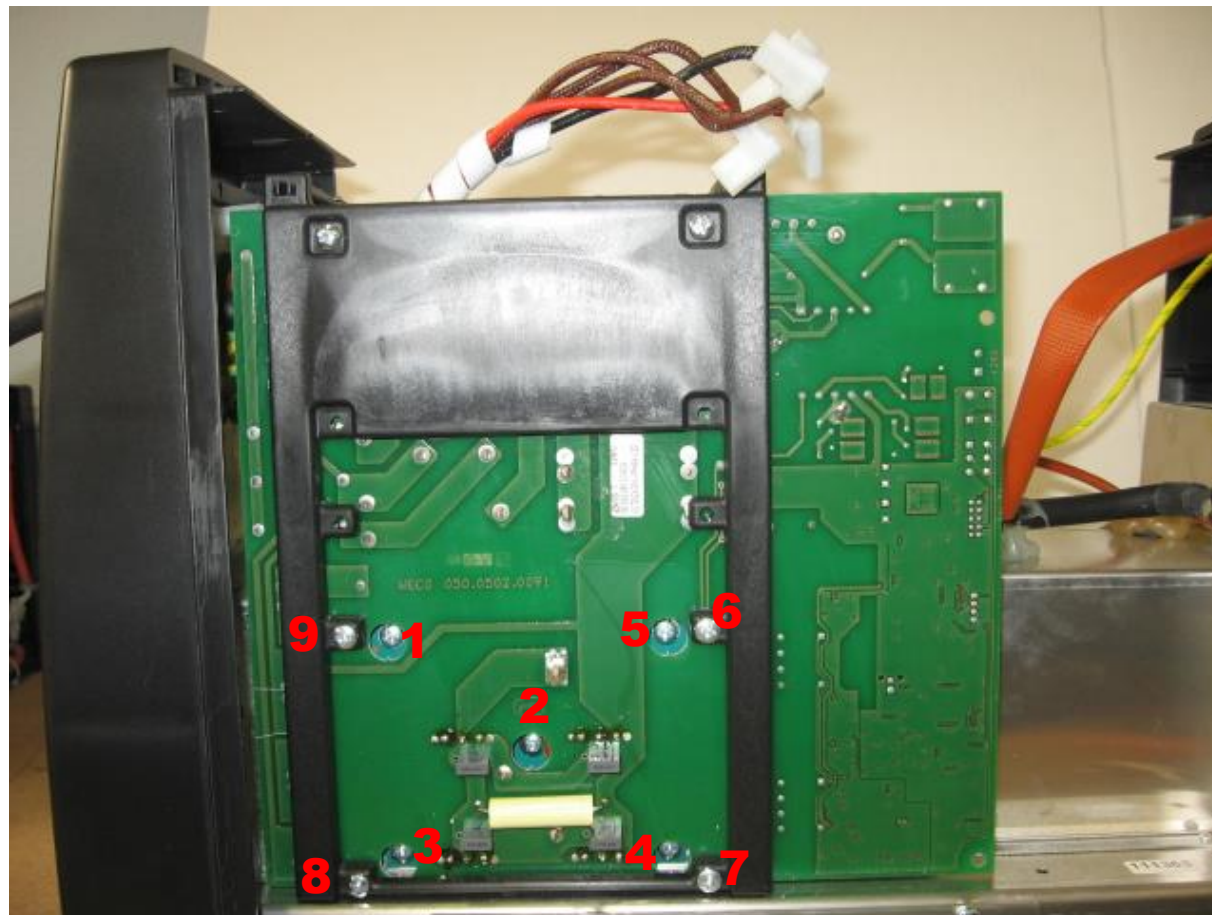


- **Step 5: Remove the connector from the Power Board and the wire from the Input Bridge Rectifier and from the switch.**



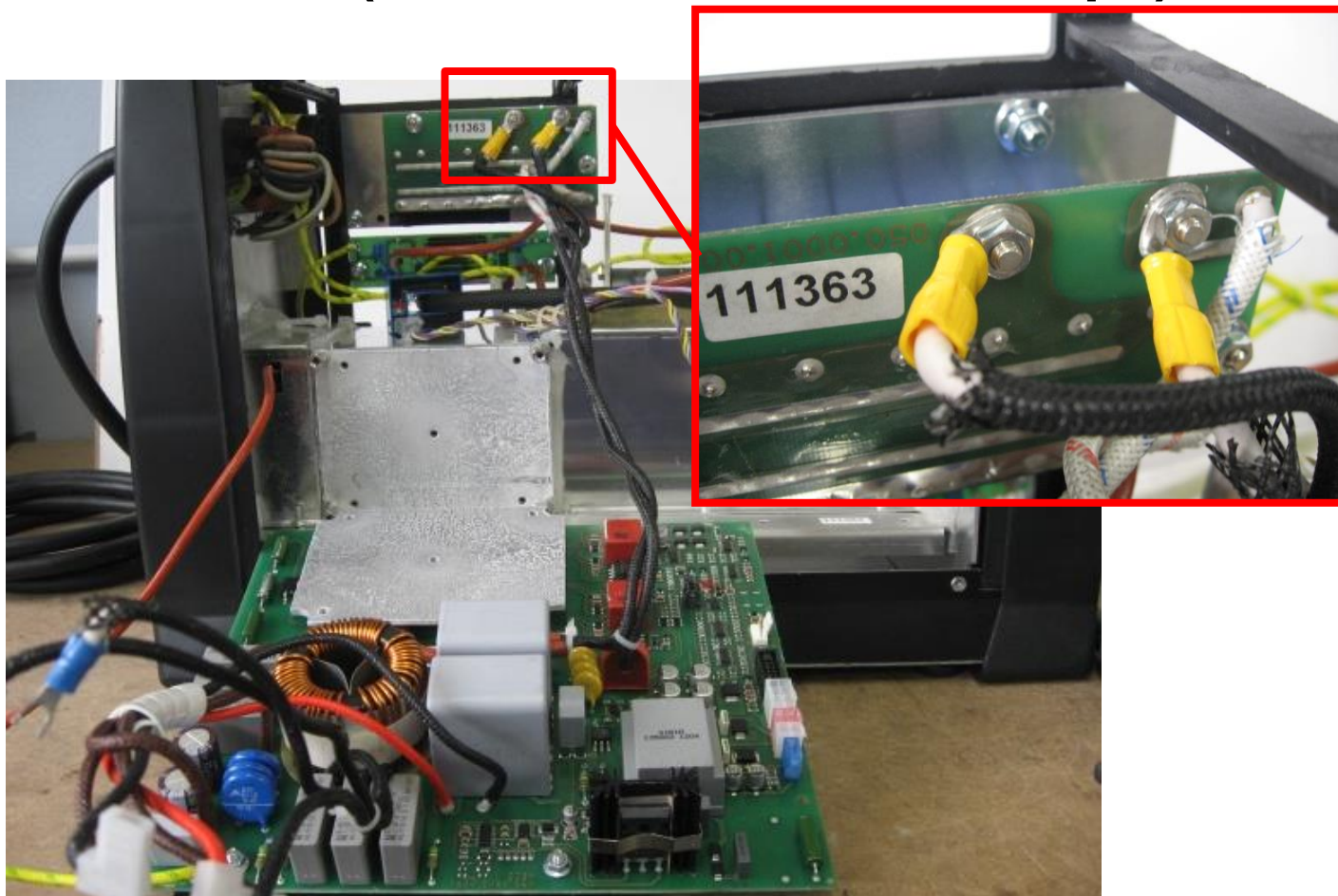


- **Step 6: Remove the screws from the Power Board in the sequence indicated.**



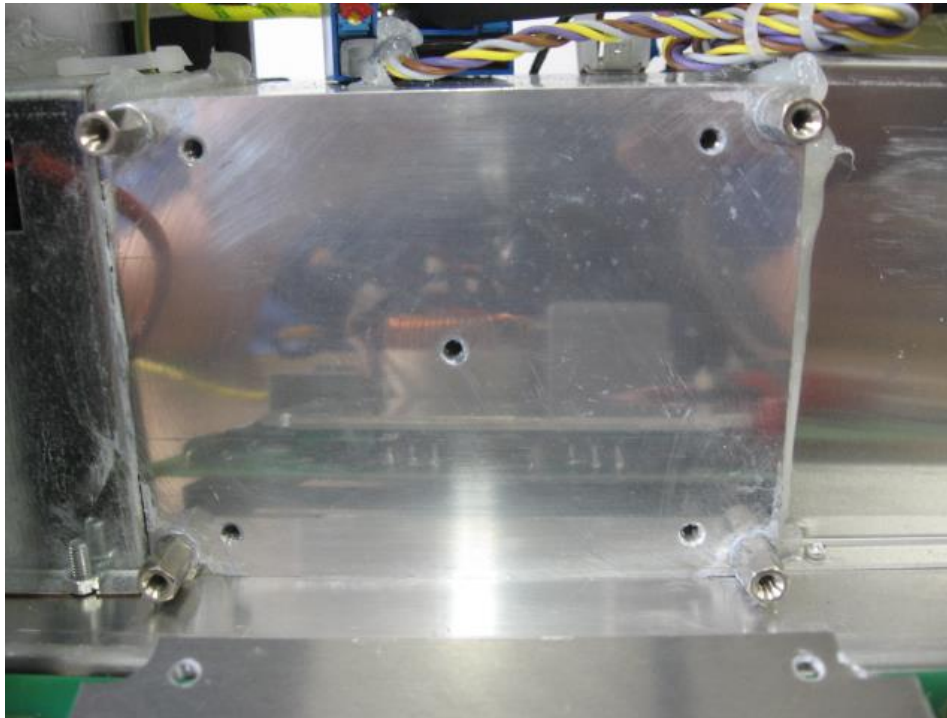


- **Step 7: Remove the primary wires of the power transformer (the 2 nuts inside the shape).**





- **Step 8: Clean the heatsink with alcohol.**

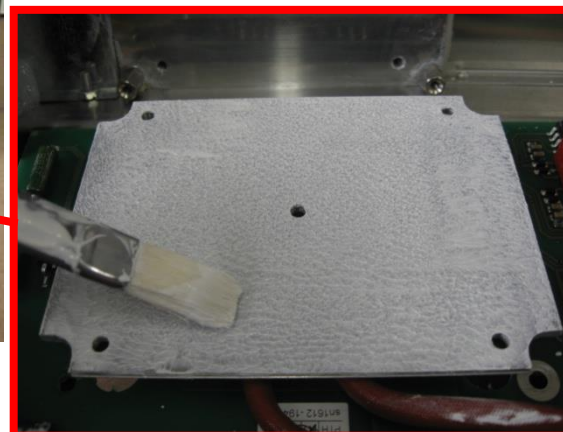
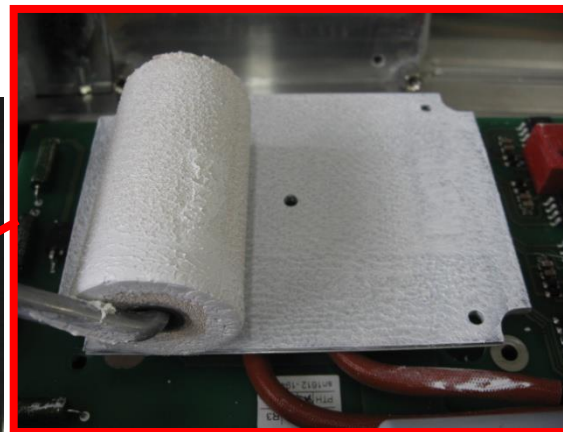
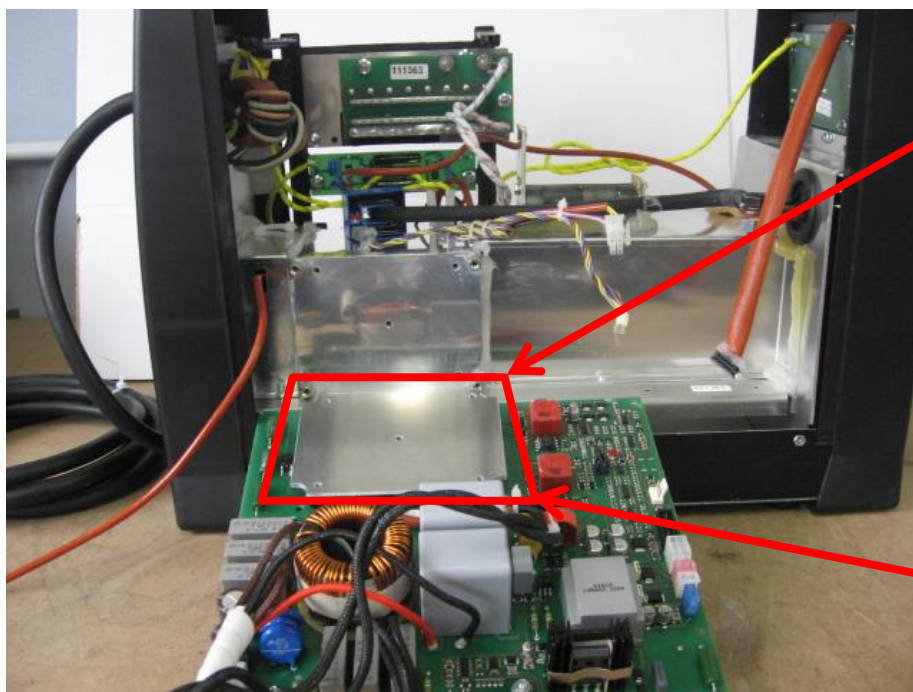


- **Now, you are ready for connecting the new Power Board.**



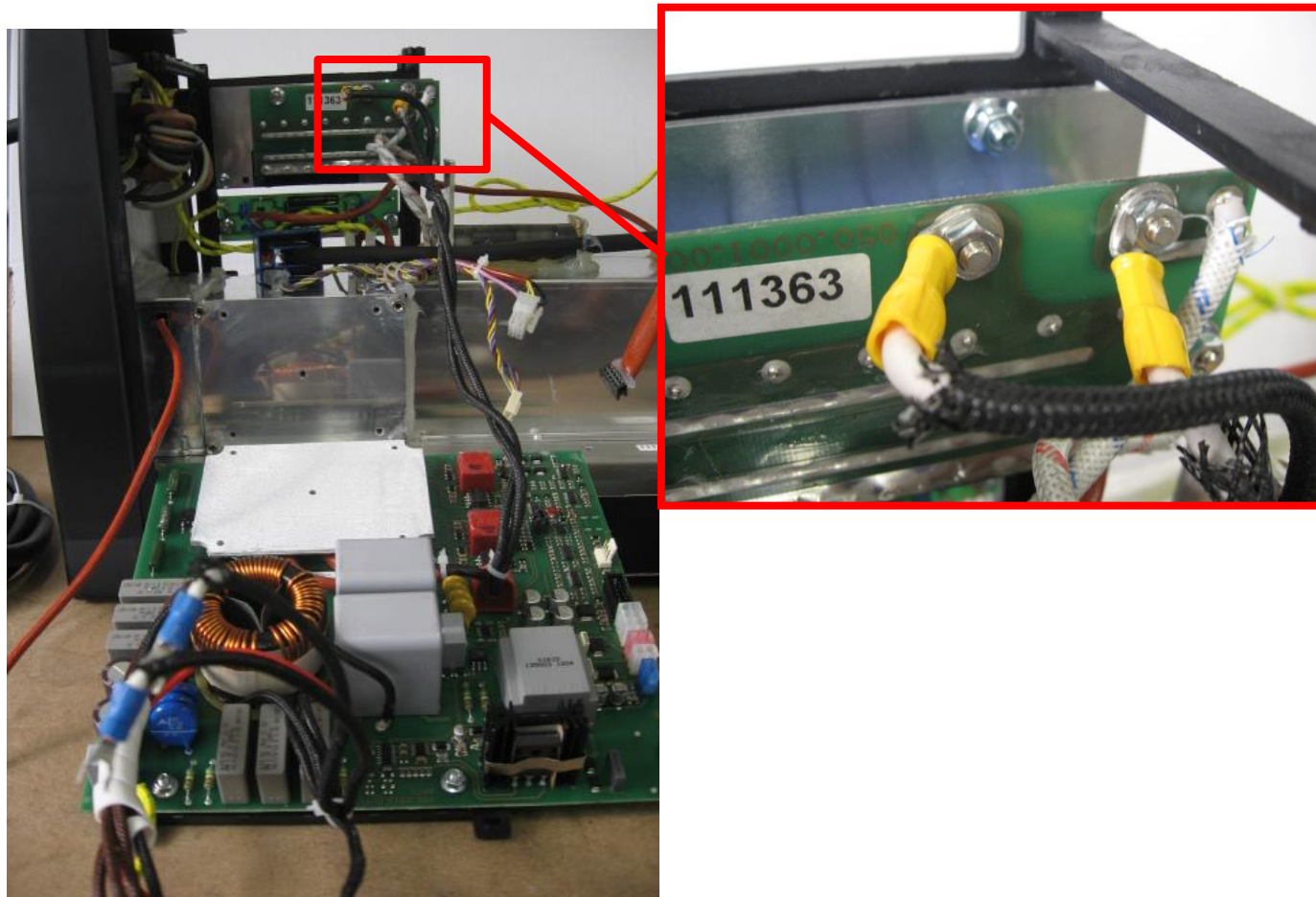
- **Step 9: Put the thermal grease on the Power Module**

(The grease must be fluid neat like a cream and a thiny film; we suggest to use a sponge roller for painting or a paintbrush; it possible to add a very little quantity of diesel fuel to soften up the grease).



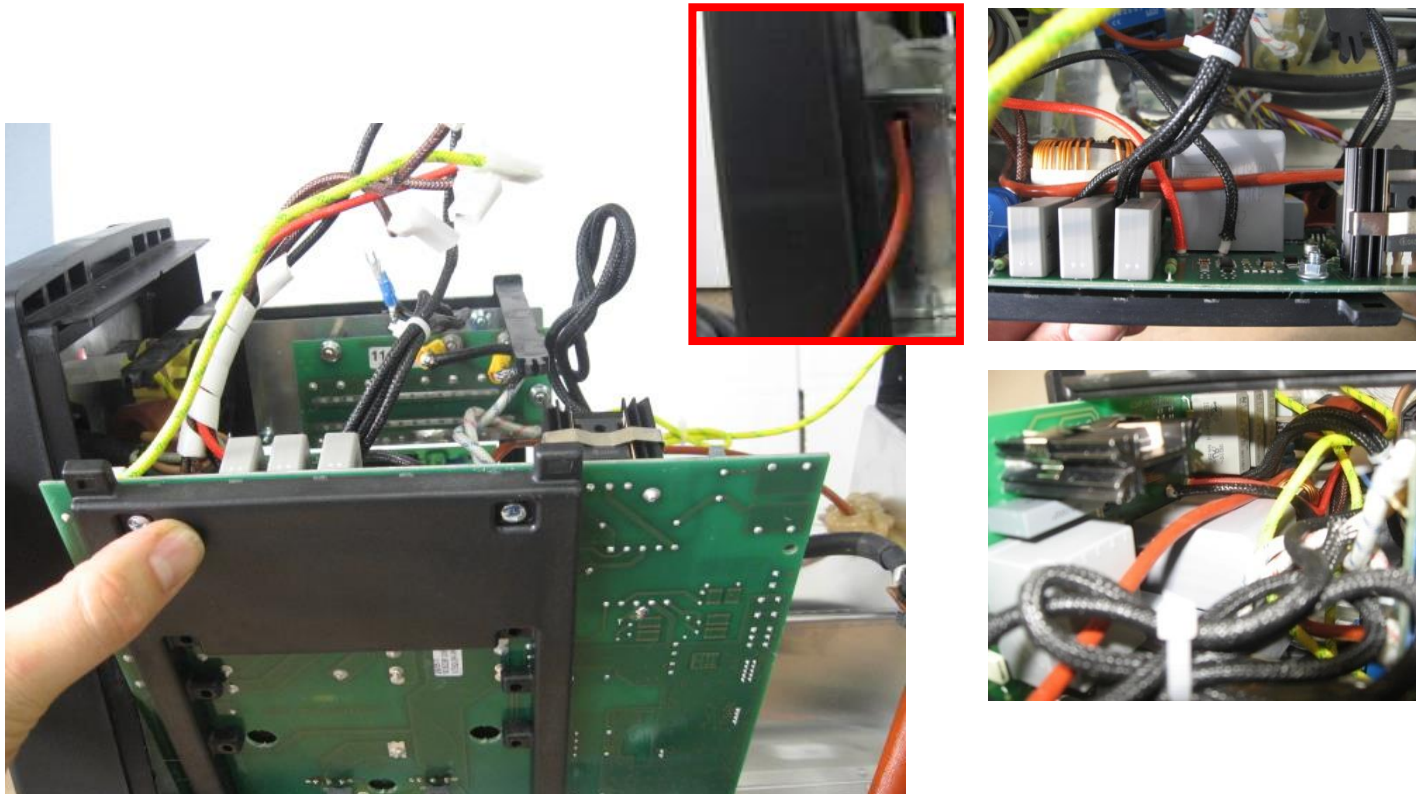


- **Step 10: Fix the primary wires of the power transformer (the 2 nuts inside the shape).**





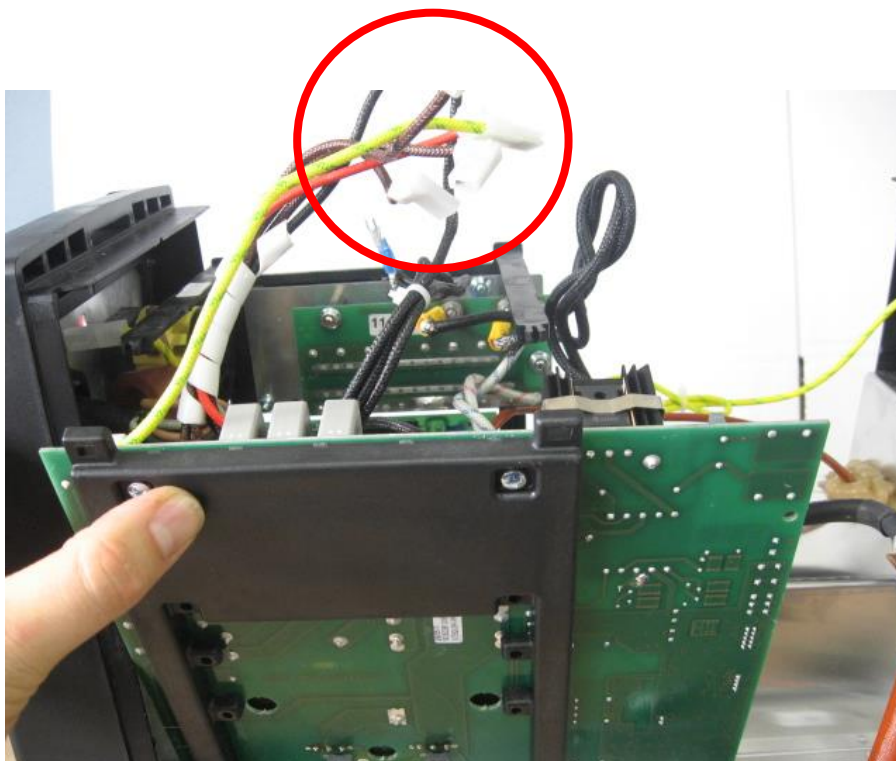
- **Step 11-1: With the Power Board in this position, put the wires and the connectors in the correct position.
FAN CABLE**





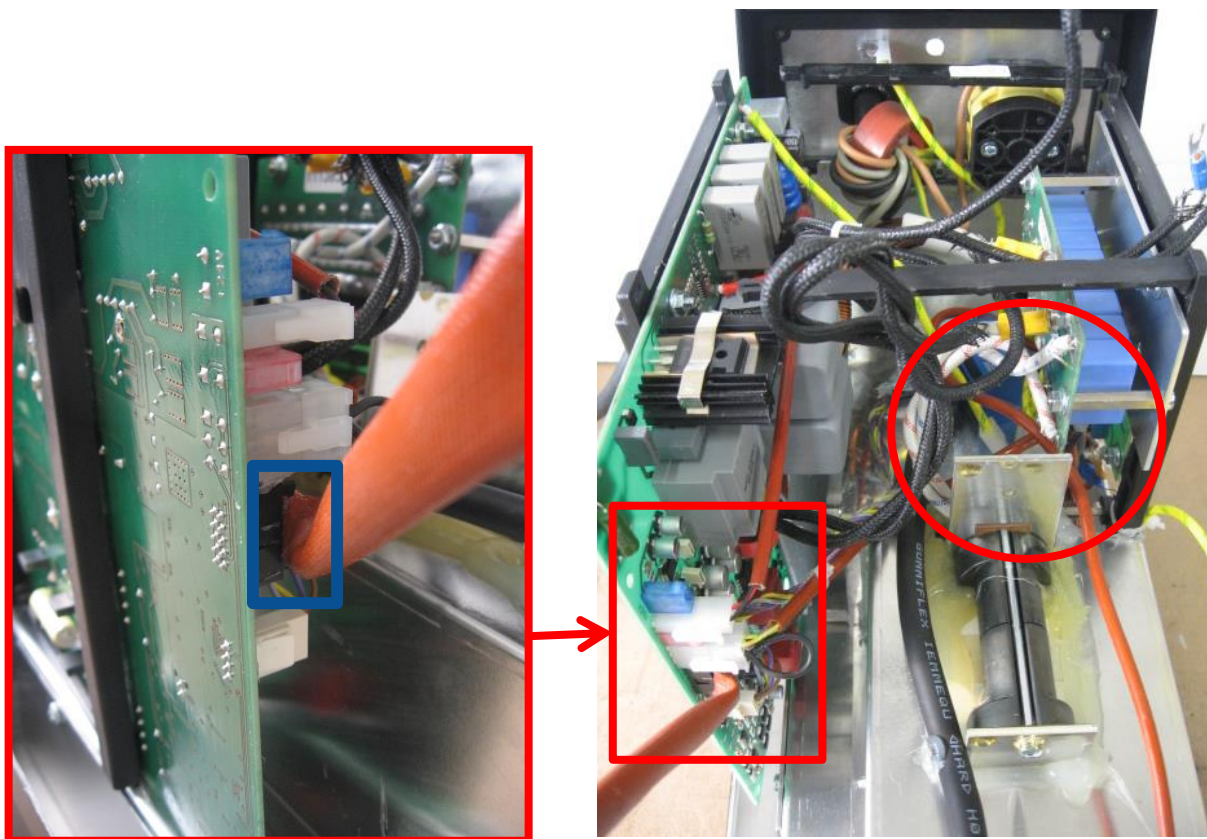
- **Step 11-2: With the Power Board in this position, put the wires and the connectors in the correct position.**

INPUT BRIDGE WIRES



- **Step 11-3: With the Power Board in this position, put the wires and the connectors in the correct position.**

**PUT THE CONNECTORS IN THE RIGHT POSITION AND THE YELLOW-GREEN WIRE
Block the Flat of front panel with silicone or hot glue (Blue shape).**





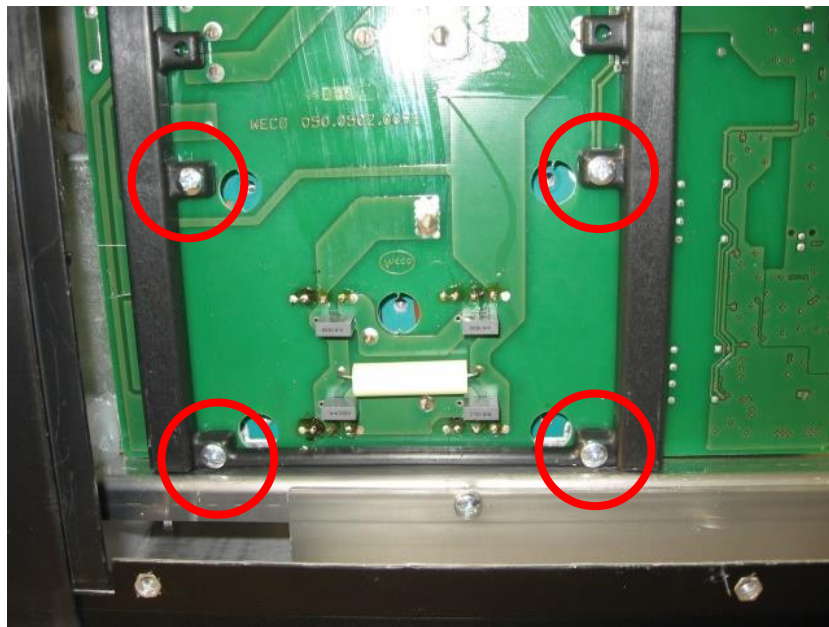
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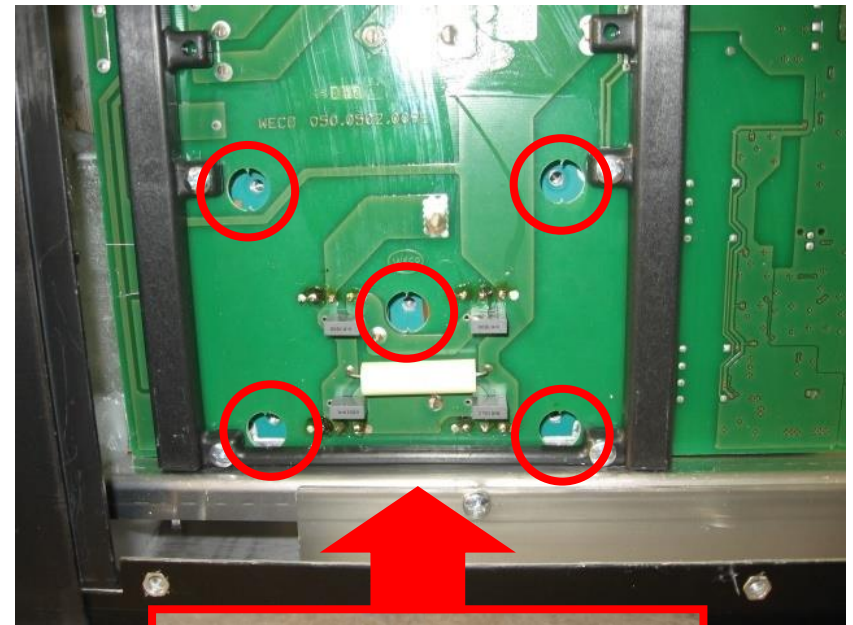
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- **Step 12: Fix the Power Board to the heatsink.**

First step



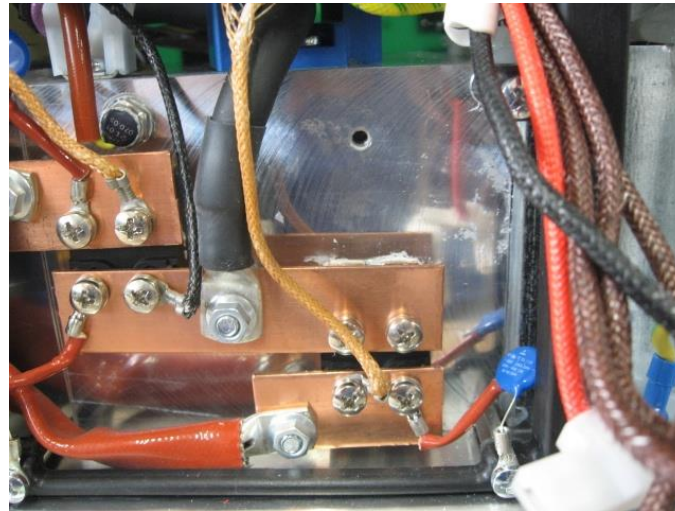
Second step



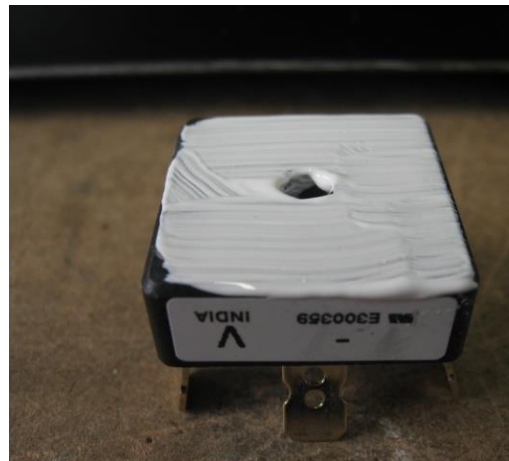


- **Step 13: Change the Input Bridge Rectifier.**

**Remove it and
clean the part with alcohol**

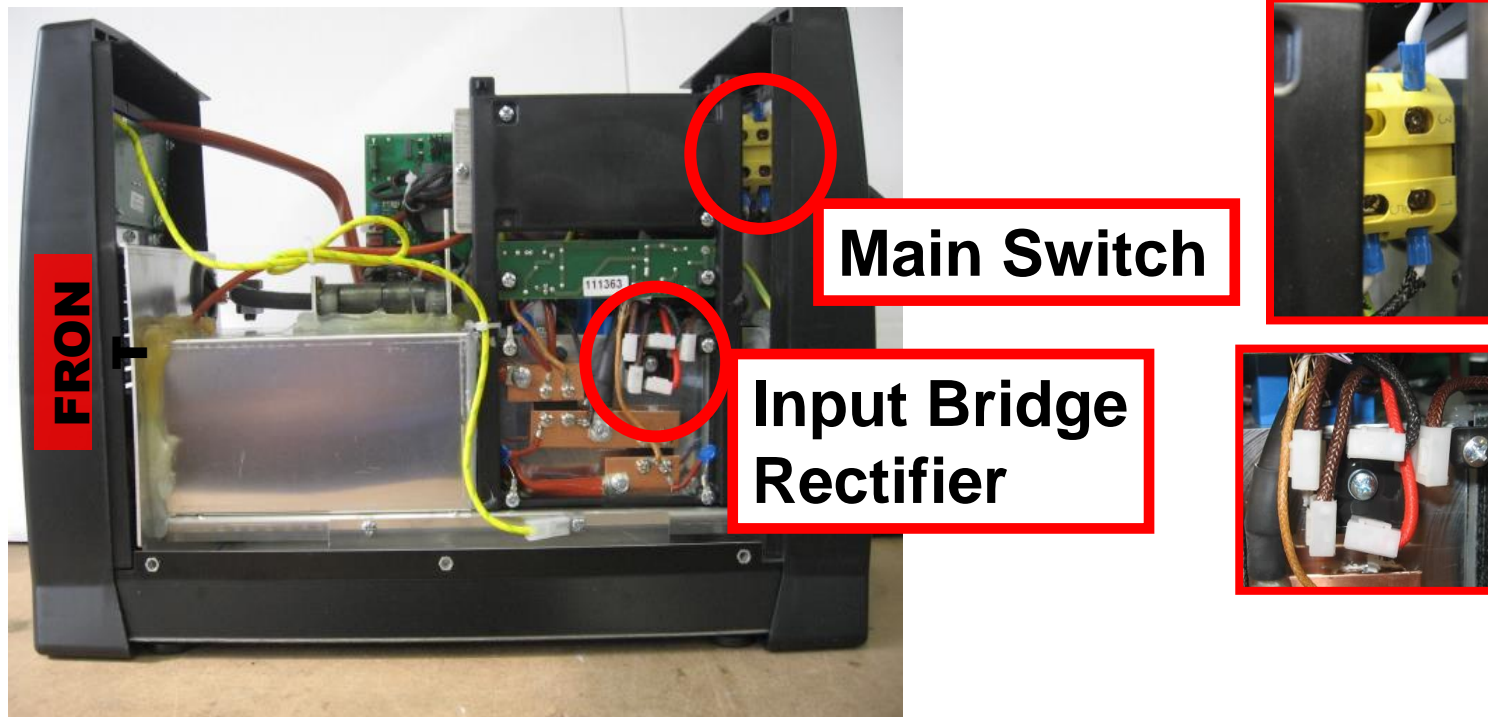


**Put the thermal grease
on the Input Bridge
Rectifier a fix it
on the heatsink**





- **Step 14: Connect the wires of Power Board to the Input Bridge Rectifier and to the Main Switch.**



If the repair is finished, jump to step 21st.



Section 2: Step for Replacing Diode Isotope.



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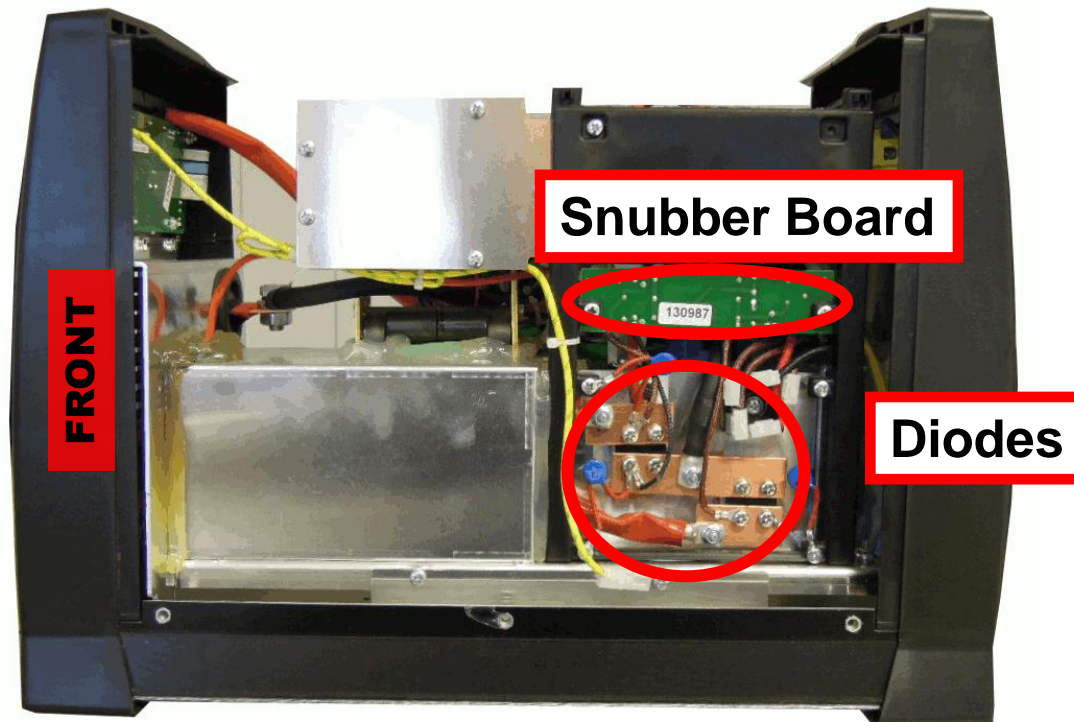
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- Step 15: Remove the cover (10 Philips screws).





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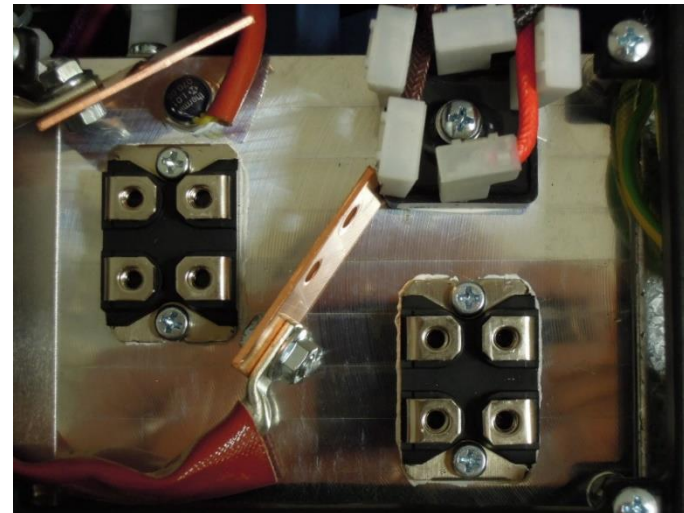
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- **Step 16: Remove the screws on the copper bars.**





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- **Step 17: Remove the DIODES and clean the heatsink with alcohol.**





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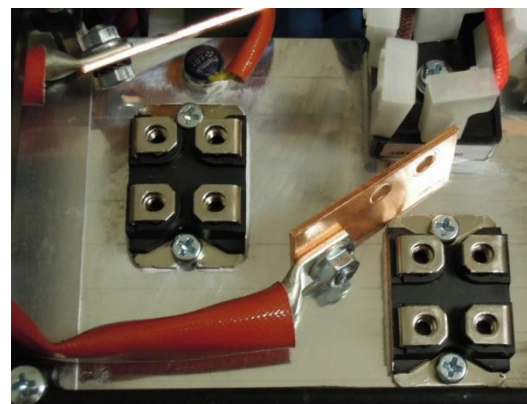
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Step 18: Put the thermal grease on the Diodes and fix it on the heatsink

(the grease must be fluid neat like a cream and a thiny film; we suggest to use a sponge roller for painting or a paintbrush; it possible to add a very little quantity of diesel fuel to soften up the grease).





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- **Step 19: Fix the wires from the Snubber Board to the Diodes.**



If the repair is finished, jump to step 21st.



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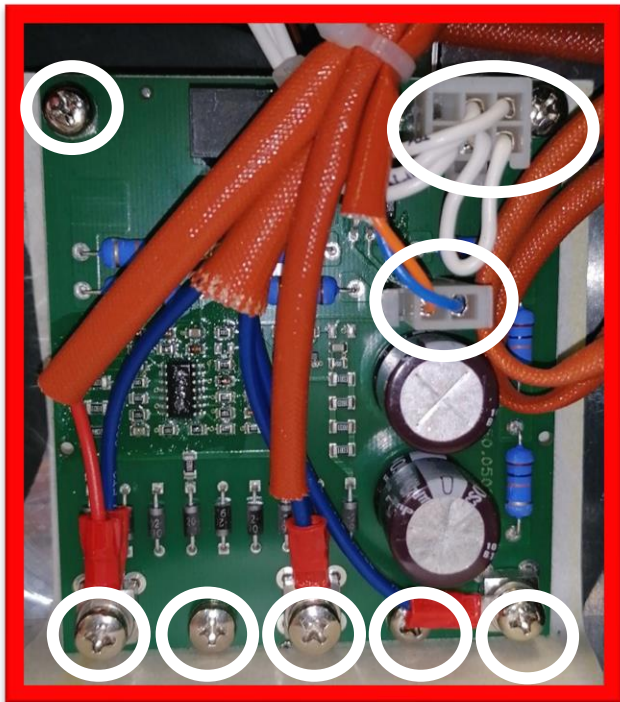
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Section 3: Step for Replacing TP Board (Three Phase Supply Protection Board).



- **Step 20: Replace the three phase supply protection board, 050.xxxx.0057**
 - Disconnect the Wirings and remove all screws.
 - Replace the PCB.
 - Connect the wirings on the PCB.



**If the repair is finished,
jump to step 21st.**



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- **Step 21: Test the machine!**
Weld an electrode with 70 A and 160 A current!



Attention

Please use these Unitor products exclusively for the purpose indicated by WSS and only if the operator fully understands current practices and procedures. If any further information or assistance is required please contact your local WSS specialist.