

UWI 320TP



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



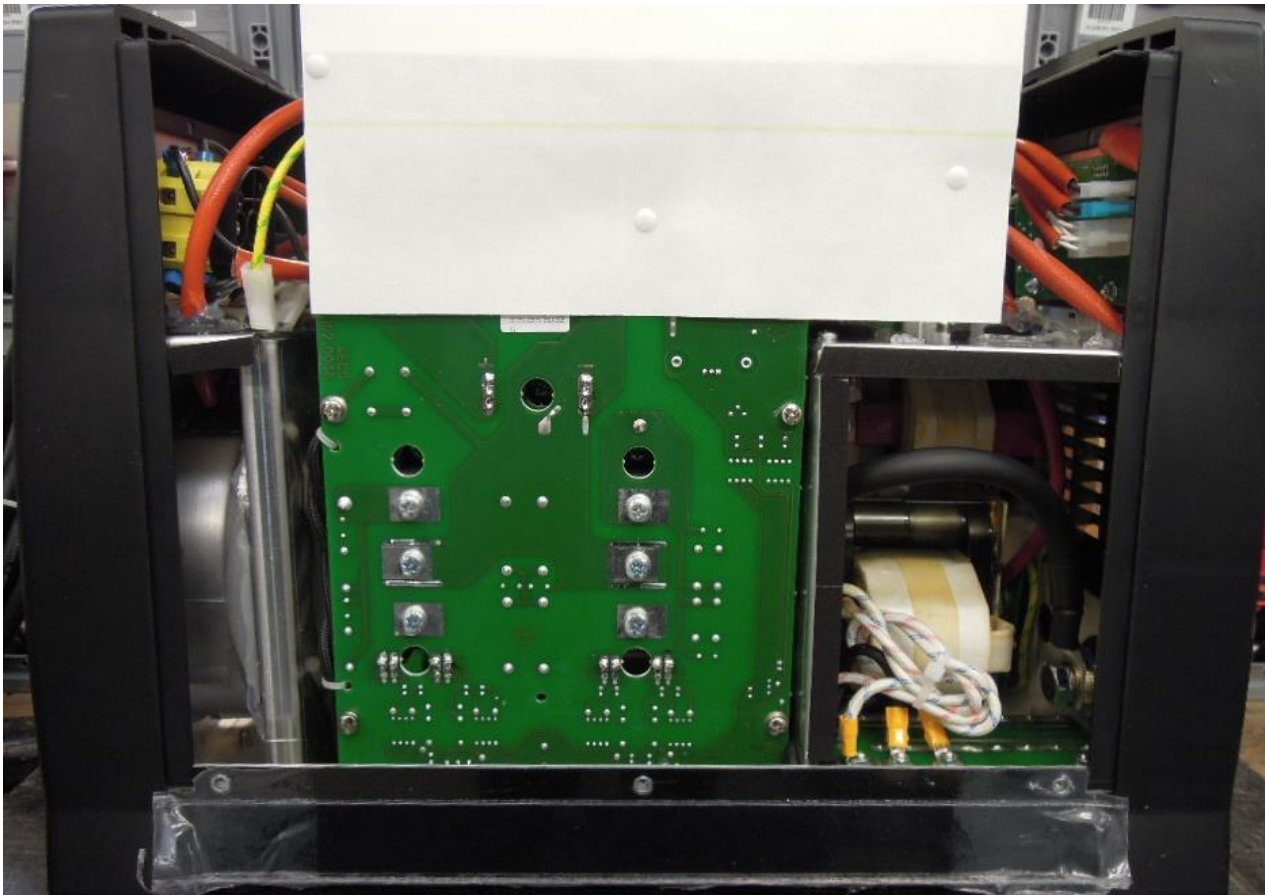
According to the diagnosis of fault as per Troubleshooting Manual, to replace the necessary components accordingly or replace all.

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).

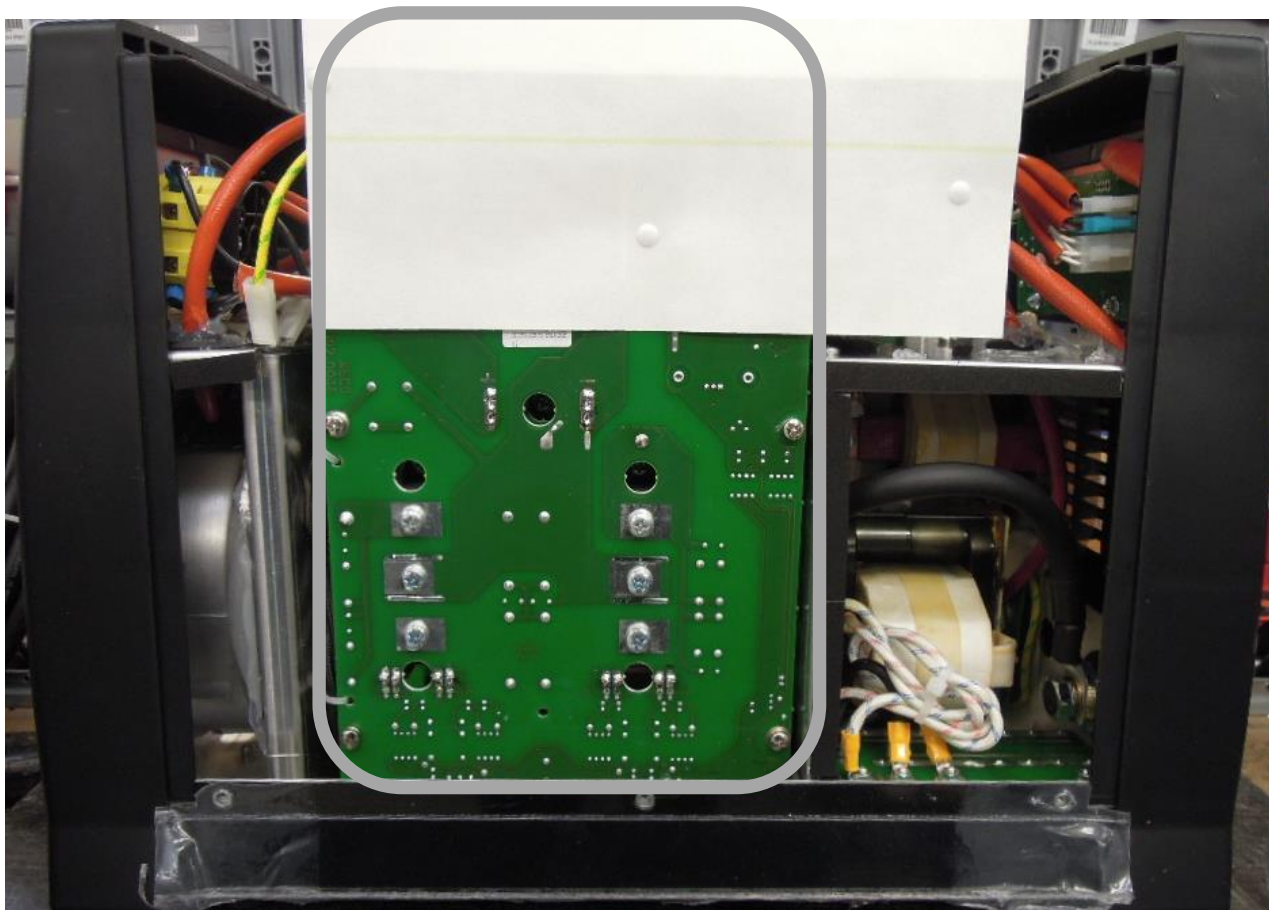
Section 1: Steps for Replacing Power Board.

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

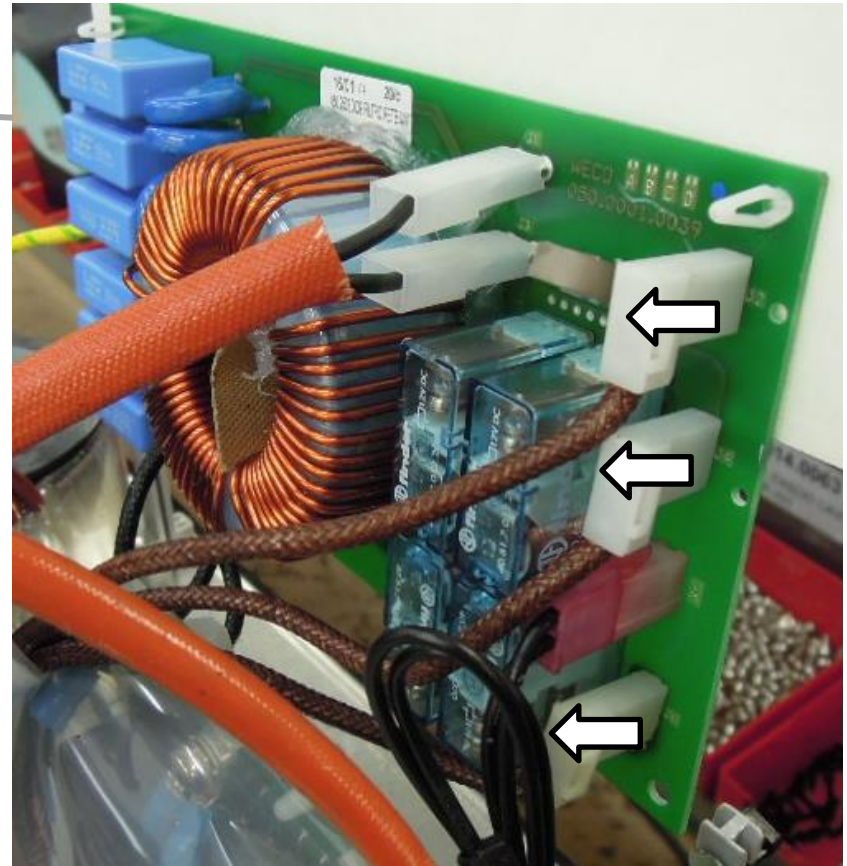
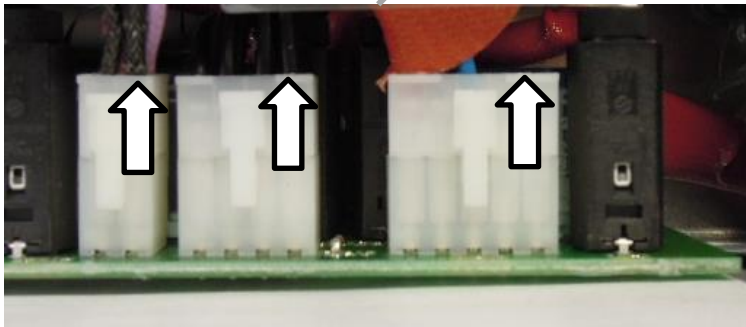
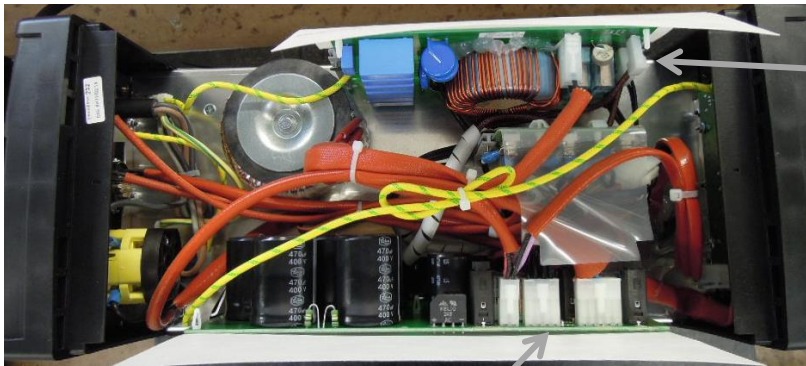


FRONT

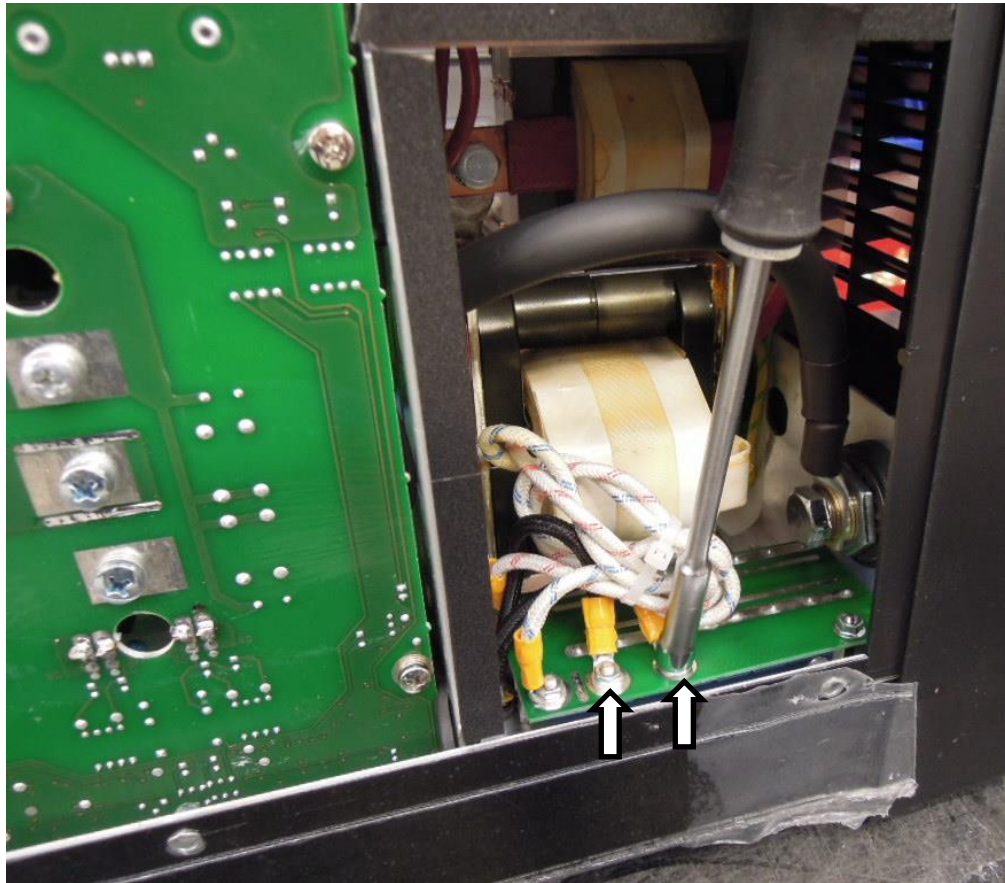
Power Board



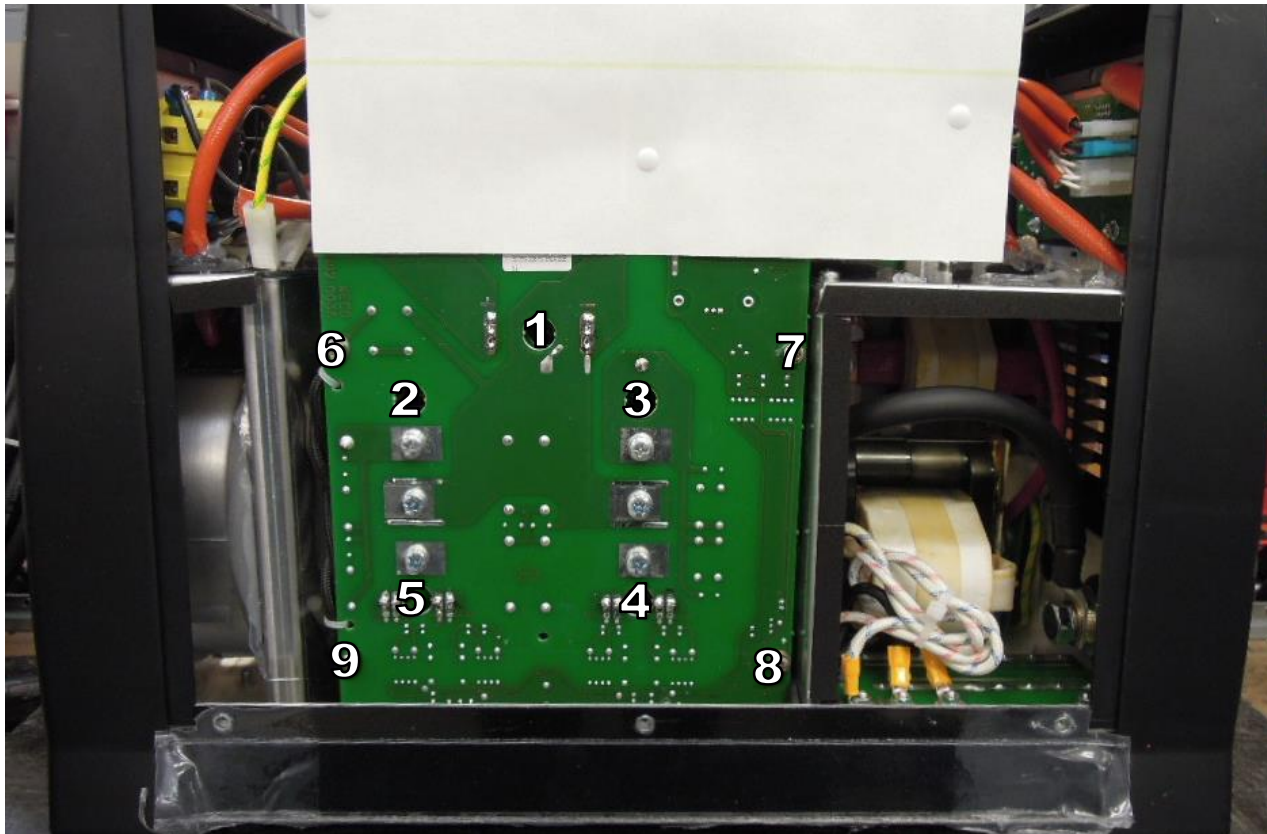
- **Step 2: Disconnect the connectors from the power board and filter board.**



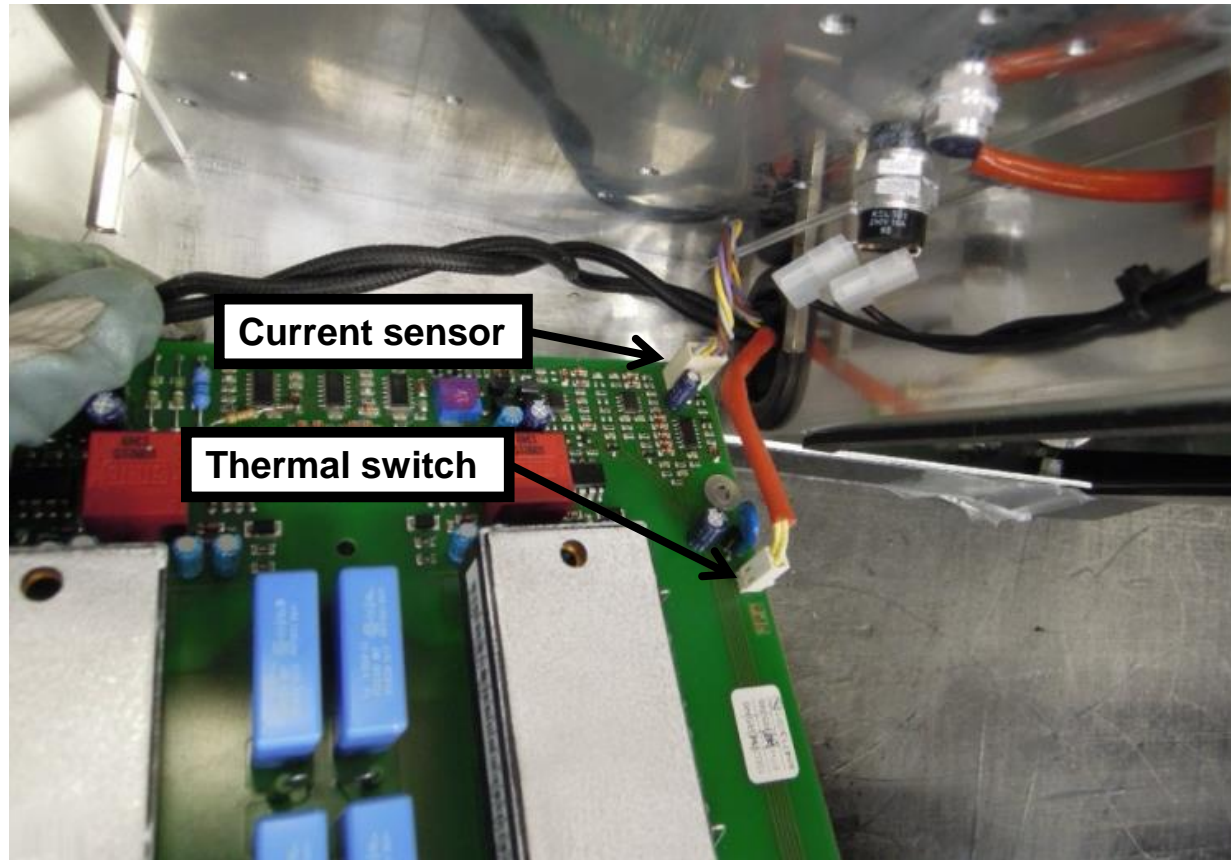
- **Step 3: Remove the primary wires of the power transformer (the 2 nuts).**



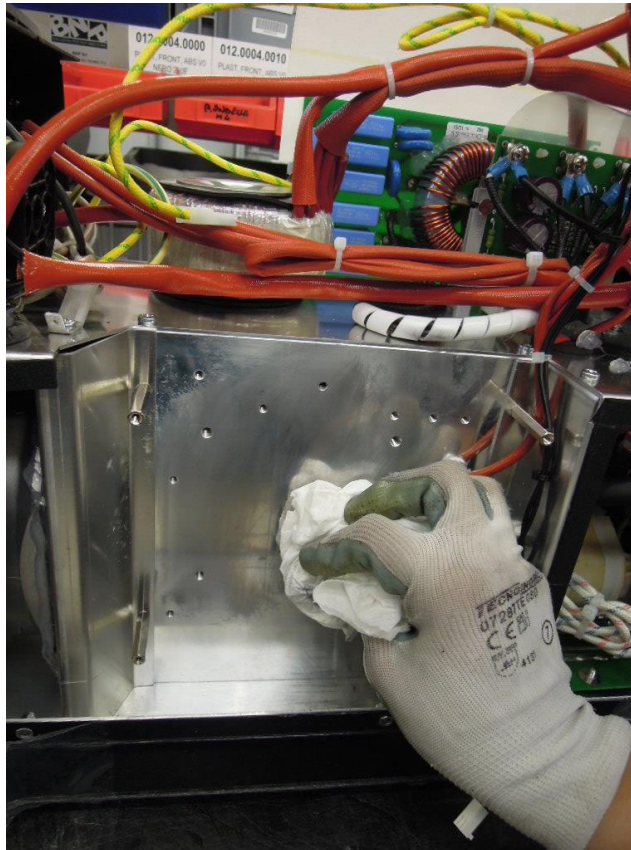
- **Step 4: Remove the screws from the Power Board in the sequence indicated.**



- **Step 5: Remove the connectors from the Power Board.**

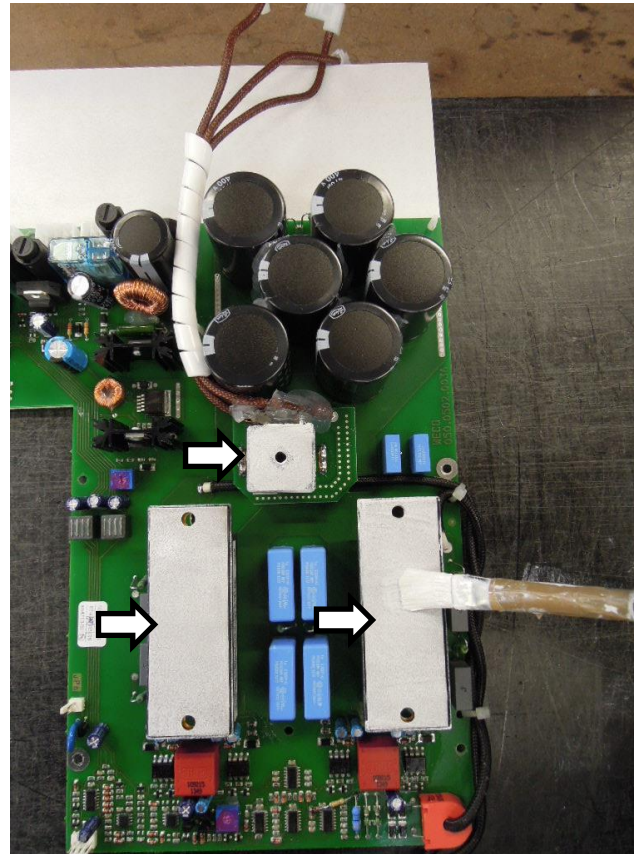


- **Step 6: Clean the heat sink with alcohol.**

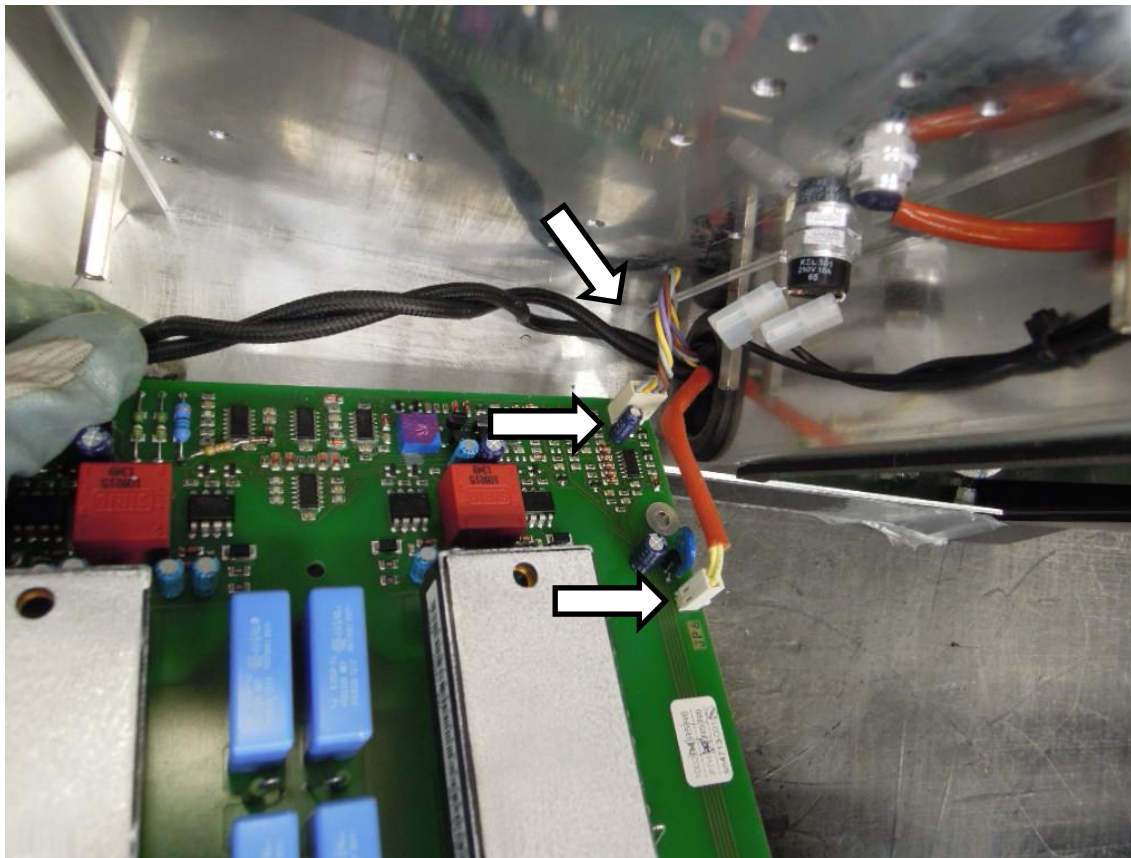


- **After this you are ready for putting in the new Power Board.**

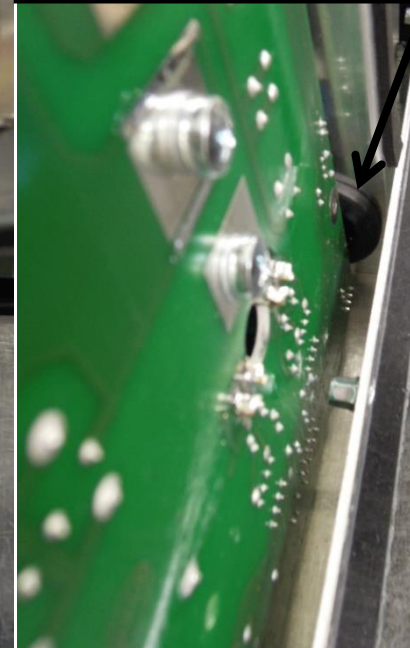
- **Step 7: Put the thermal grease on the Power Module and Input Bridge Rectifier of the new power board** (the grease must be fluid neat like a cream and a thiny film; we suggest to use a sponge roller for painting or a paintbrush; it possible to add a very little quantity of diesel fuel to soften up the grease).



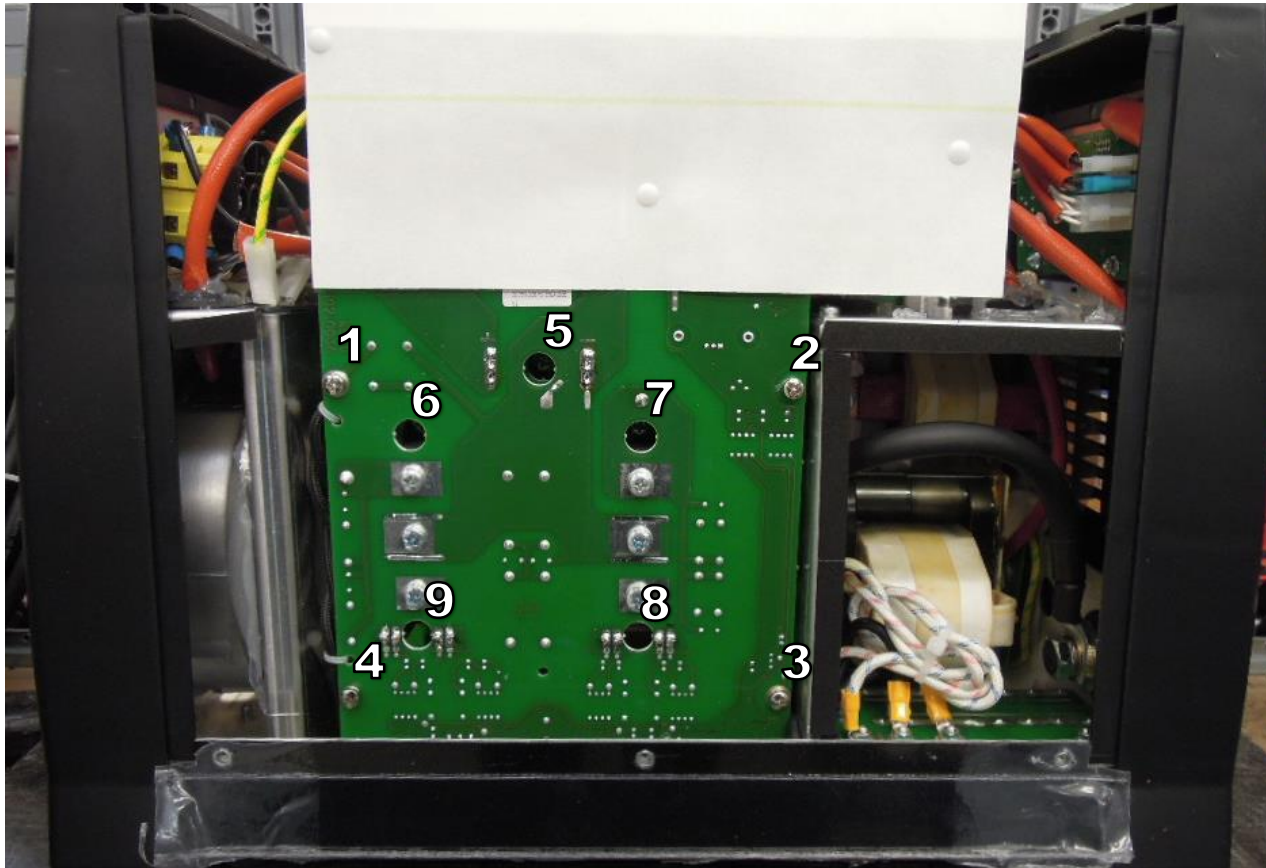
- **Step 8: With the Power Board in this position, put the wires and the connectors in the correct position.**



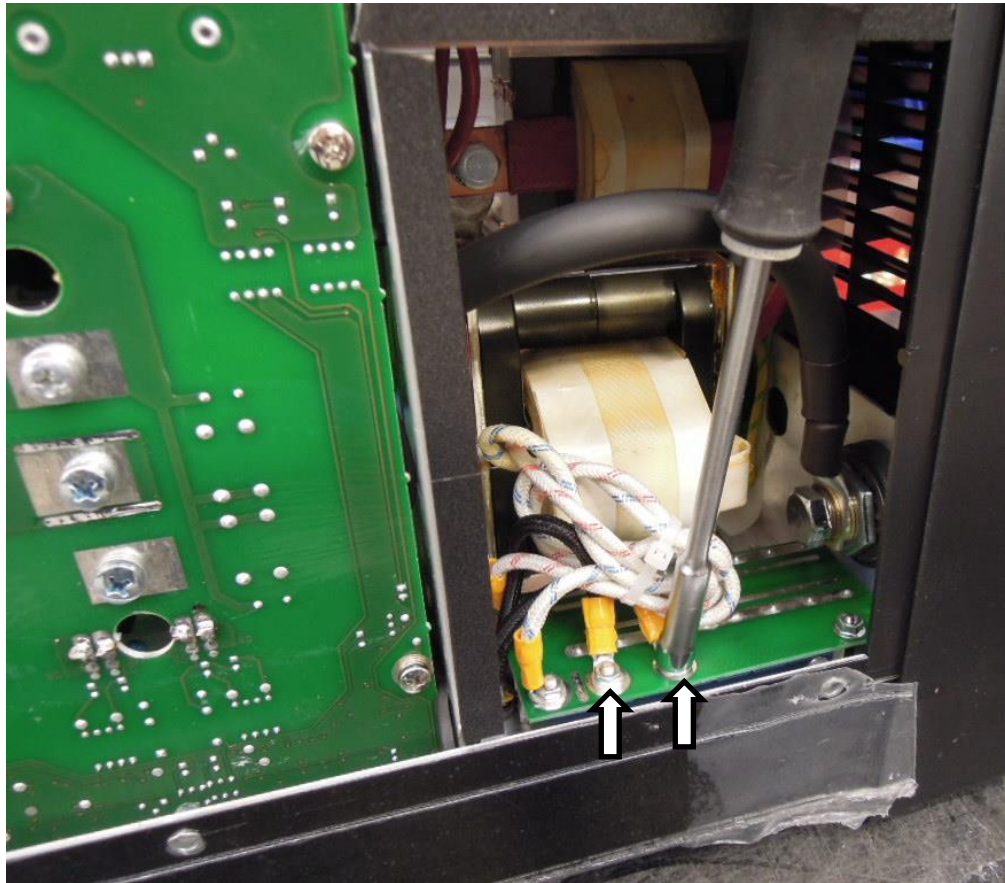
The wires are
between the heat
sink and the power
board



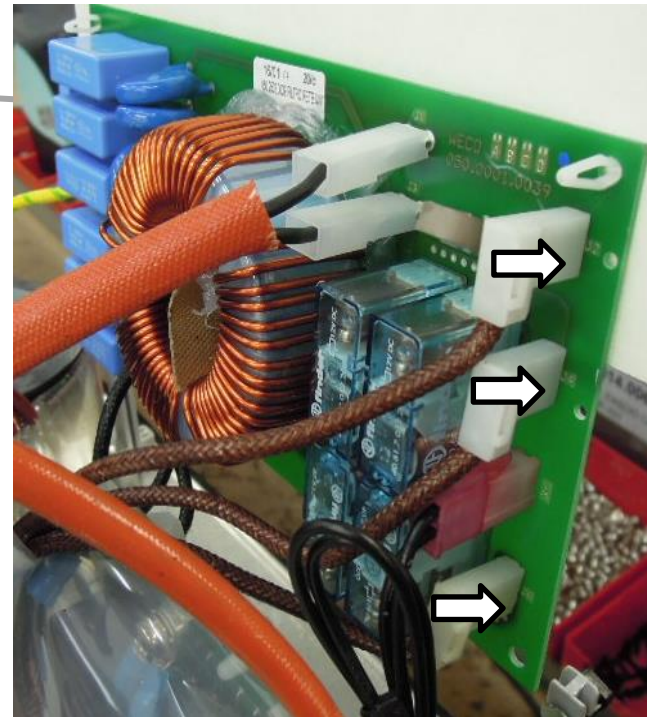
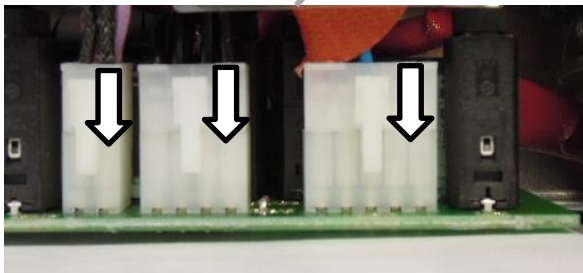
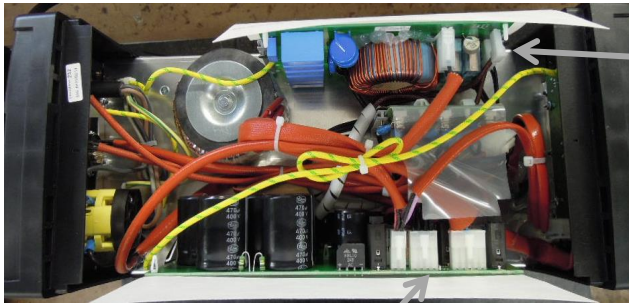
- **Step 9: Fix the Power Board to the heat sink in the sequence indicated.**



- **Step 10: Fix the primary wires of the power transformer with the 2 nuts.**



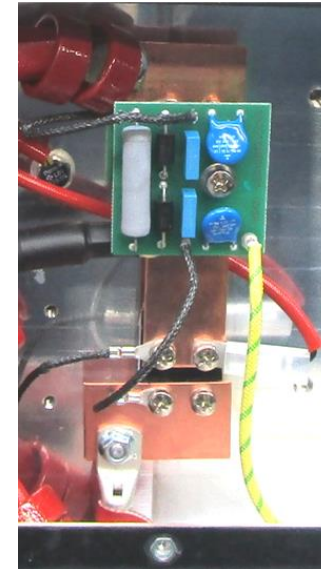
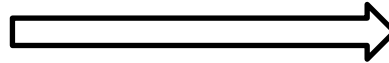
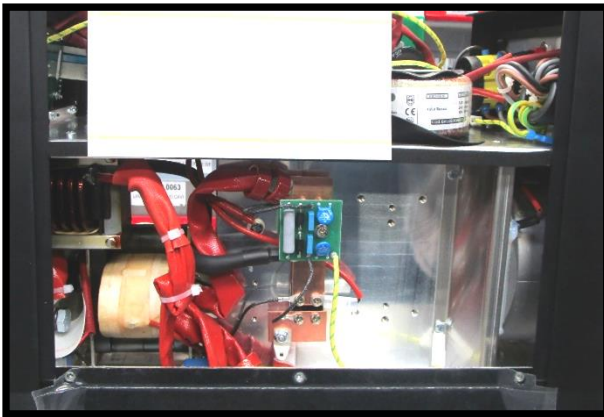
- **Step 11: Connect the connectors of the power board and filter board.**



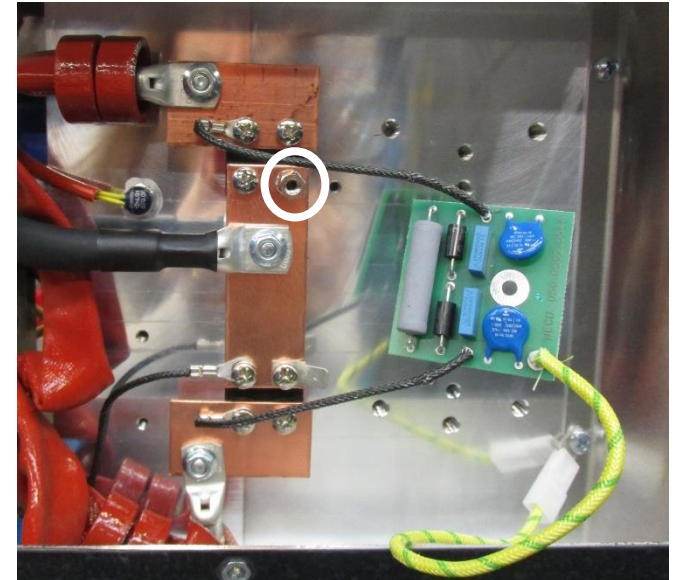
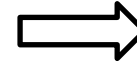
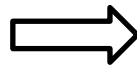
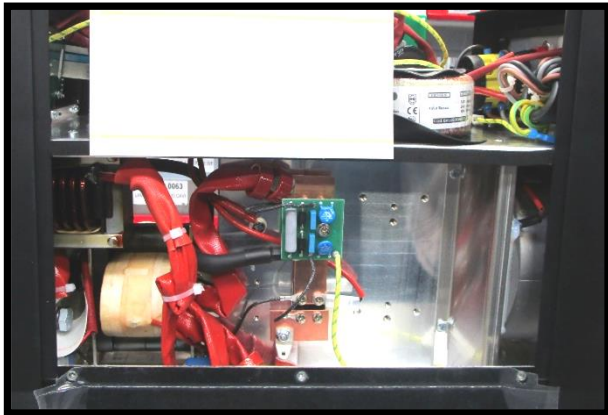
If the repair is finished, jump to step 17th.

Section 2: Step for Replacing Diode Isotope.

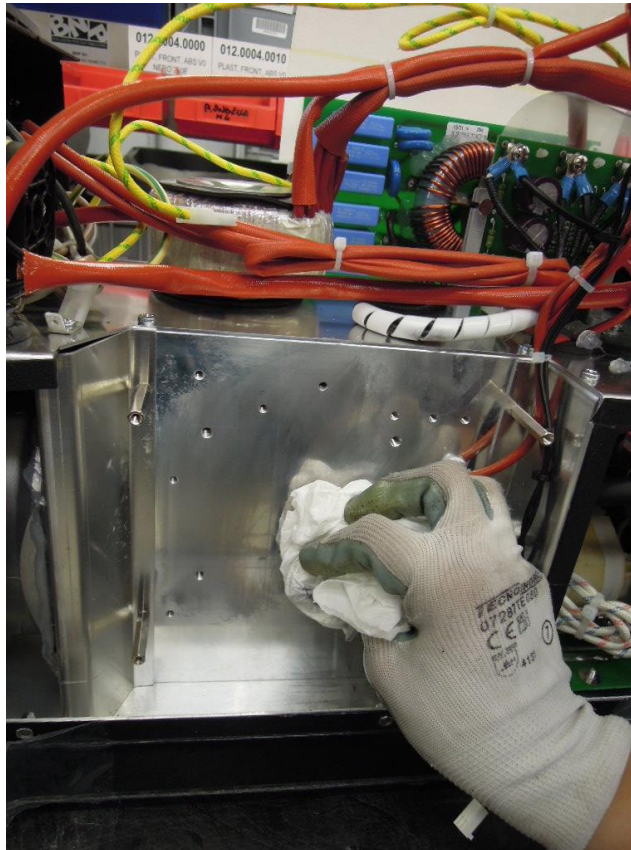
- **Step 12: Remove the snubber board and the screws on the copper bars.**



- **Step 13: Remove the snubber board and the screws on the copper bars.**

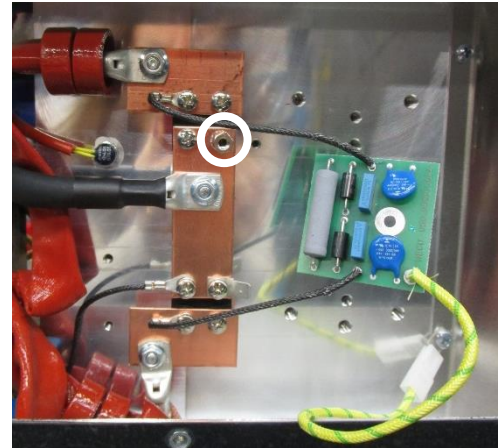
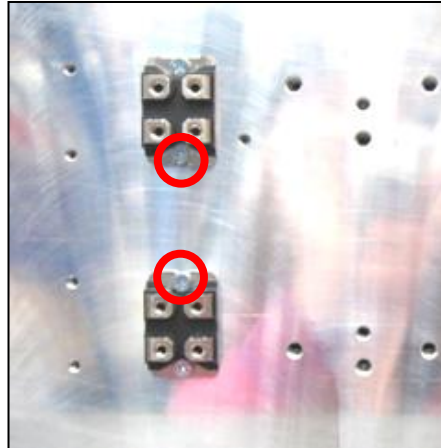


- **Step 14: Clean the heat sink with alcohol.**



- **Step 15: Put the thermal grease on the DIODES ISOTOPE**
(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).

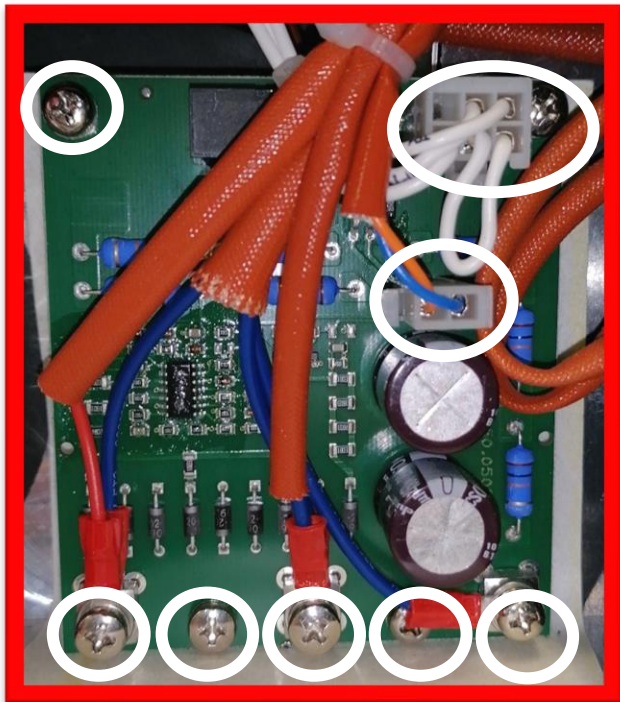
Connect the copper bars and Snubber board.



If the repair is finished, jump to step 17th.

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

- **Step 16: 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 17th.**

- **Step 17: Test the machine!**

Weld an electrode with 70 A and 230 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.

