

Service Notice N°: ESN0074 Rev. 00

Date: 20MAR2019

Elimination of switch off the working machine or no possibility to turn machine on

Product	K Number	Code Number	Serial Numbers
POWERTEC i250C STD	K14157-1	50430	P1190302027 and below
POWERTEC i250C ADV	K14157-2	50431	P1190302027 and below
POWERTEC i320C STD	K14158-1	50432	P1190302027 and below
POWERTEC i320C ADV	K14158-2	50433	P1190302027 and below
DIGISTEEL 255 AC	W000404101	50437	P1190302027 and below
DIGISTEEL 255 PRO AC	W000404103	50436	P1190302027 and below
DIGISTEEL 325 AC	W000404102	50435	P1190302027 and below
DIGISTEEL 325 PRO AC	W000404104	50434	P1190302027 and below
CITOSTEEL 255 AC	W000404105	50441	P1190302027 and below
CITOSTEEL 255 PRO AC	W000404107	50440	P1190302027 and below
CITOSTEEL 325 AC	W000404106	50439	P1190302027 and below
CITOSTEEL 325 PRO AC	W000404108	50438	P1190302027 and below



WARNING

Be sure that only qualified individuals perform all installation, operation, maintenance and repair procedures. Lincoln Electric is not responsible for damages caused by improper installation, improper care or abnormal operation.

Before opening or disassembling any parts of the product, the power must be turned OFF and the product must be disconnected from the input power source. Only Lincoln trained service technicians are authorized to perform these modifications.

Explanation of the Problem

Symptom: The machine switches off during working or does not run after switch on (power switch lights green, interface on the front panel does not light up).

Cause: The Y047 board does not work properly.

Verification of the Problem

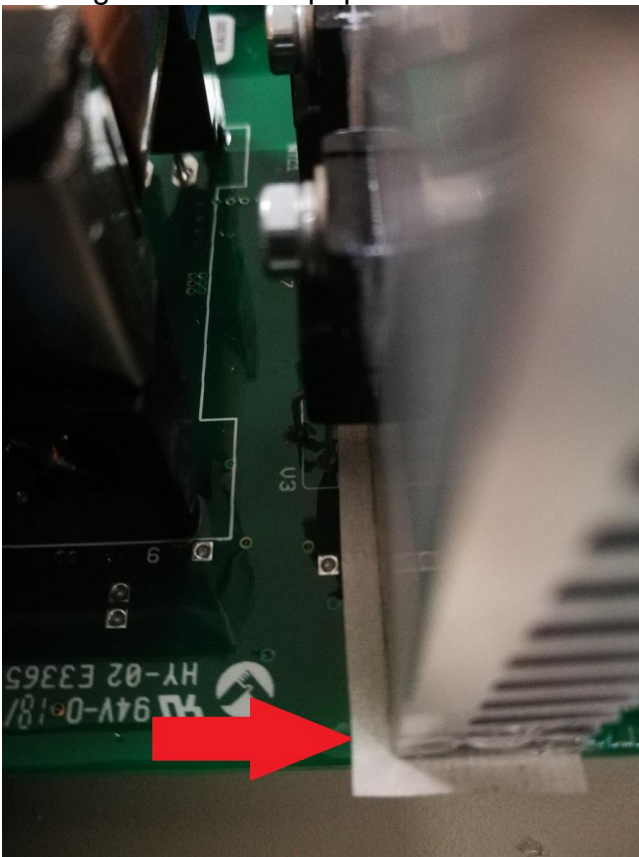
All PTi250C/i320C machines with serial numbers prior to those listed above are susceptible to this problem. Machine that will be modified will have the Y047 supply board (index: R-6042-081-1) assembled **without** additional element showed on the pictures below:

Y047-1

Check absence of component placed in red rectangle:



Missing an insulation paper under H1 heatsink:



Correction of the Problem

The elimination of this problem can be achieved by ordering and replacing the Y047 board with a proper one. Now, all boards available on the stock are already modified to avoid described problem.

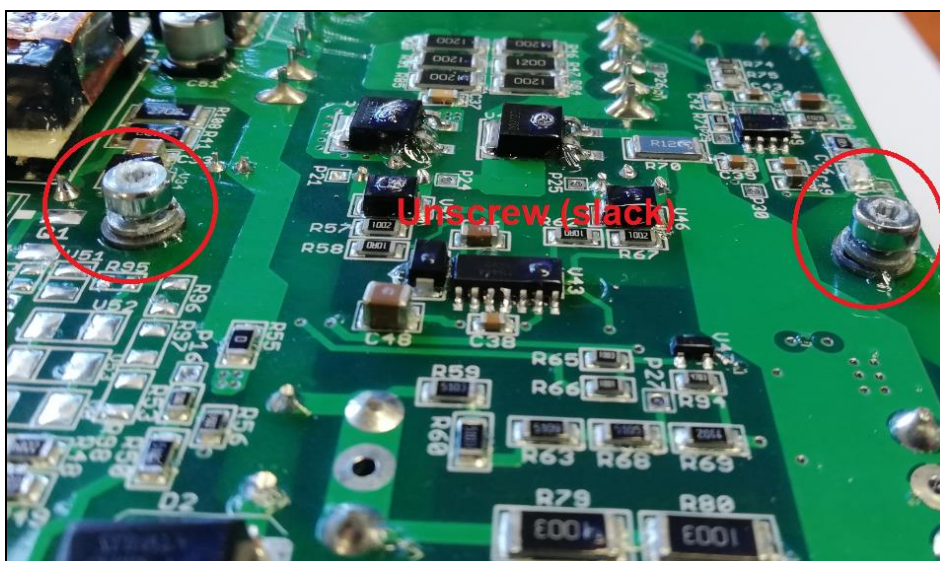
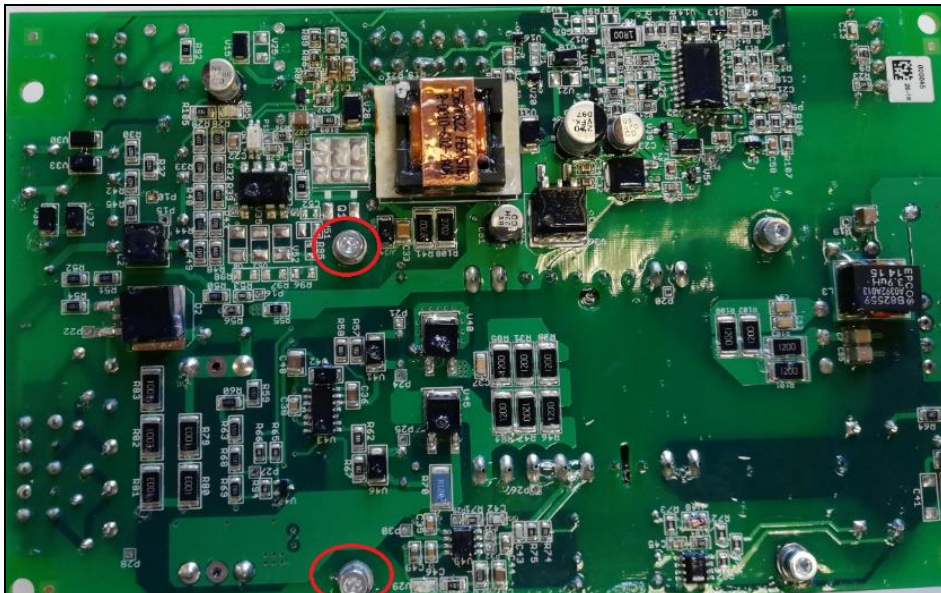
The right PC boards numbers to order is:

R-6042-081-1R

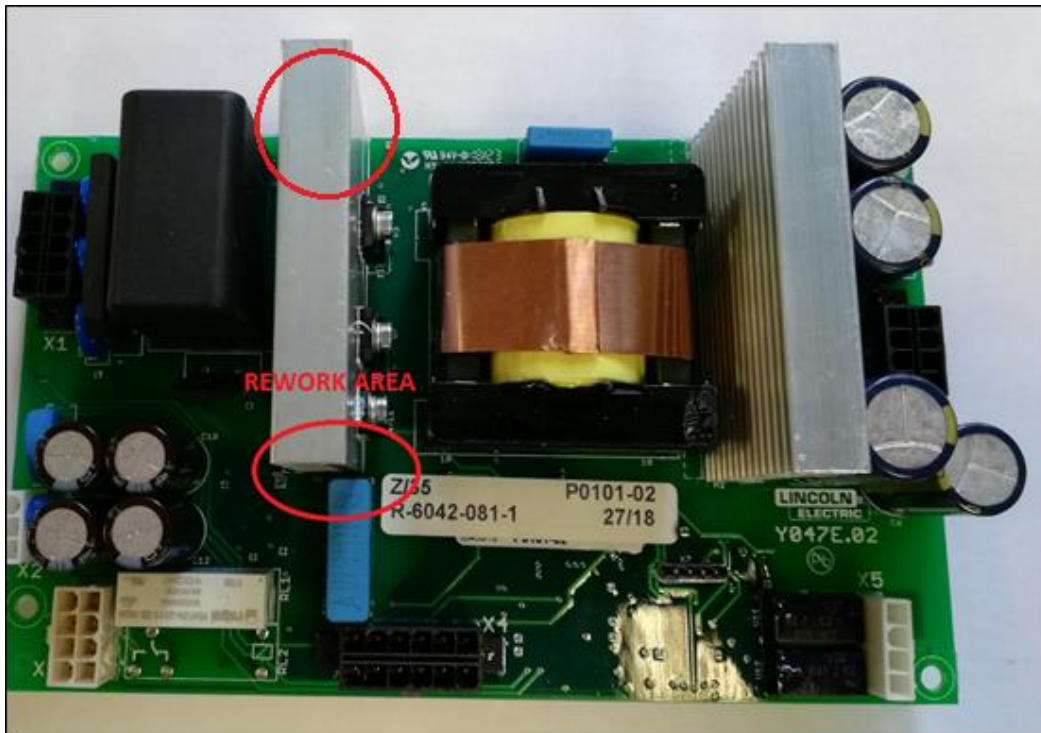
Another way to eliminate this problem is to modify not working board. **But that operation is not easy to perform without a specialist knowledge and tools.**

In that case follow the instructions below:

1. Unscrew (slack) 2 screws that were used to assembled H1 heatsink:



2. Find rework area:

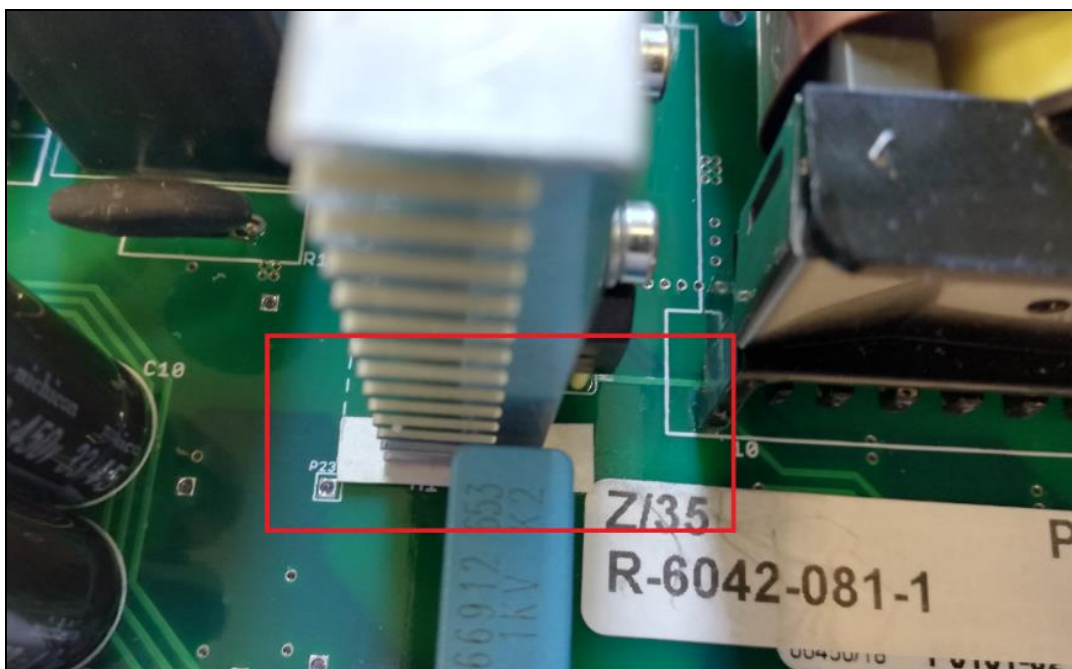


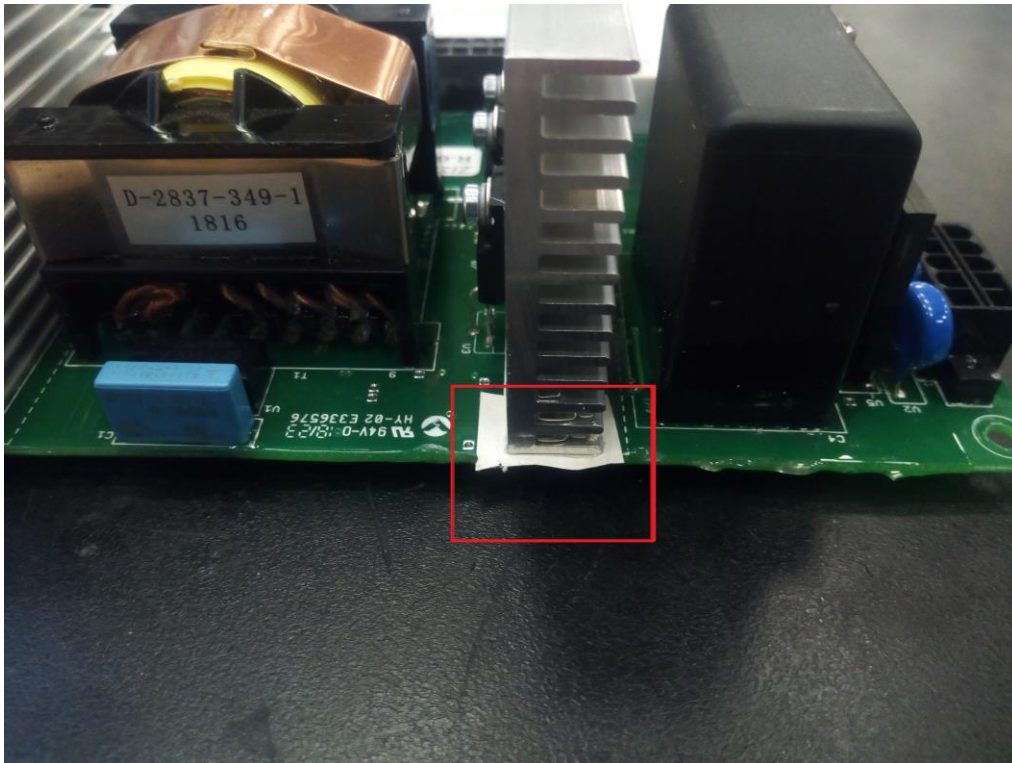
3. Uplift H1 heatsink slightly with a flat screwdriver – heatsink will tilt to right side (to transformer T1).

Warning!

Be careful, do not damage the components assembled to heatsink.

4. Place two pieces of insulation paper (c.a. Nomex, index NNX0830250 20x5mm, 0,25-0,3mm thickness) under both side of H1 heatsink as is shown on the pictures below:





5. Tighten 2 screws to H1 heatsink:

