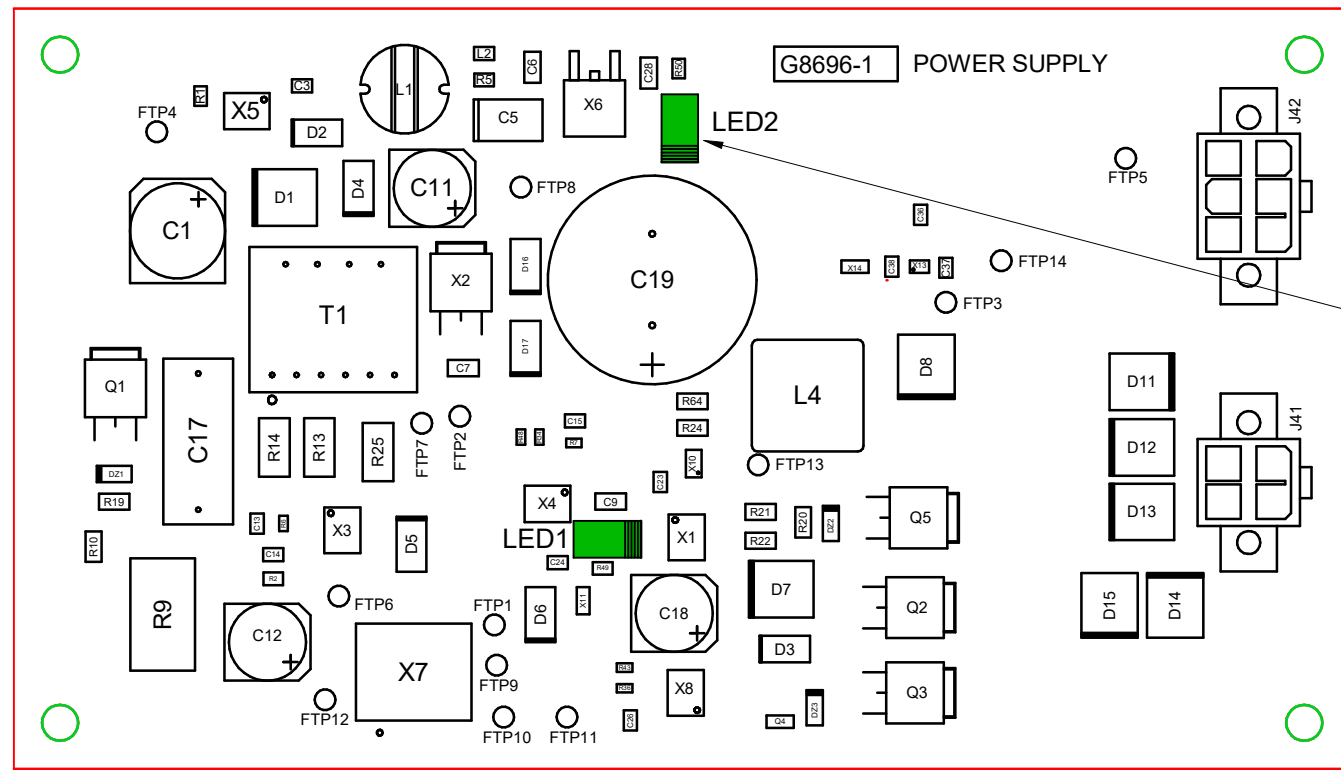


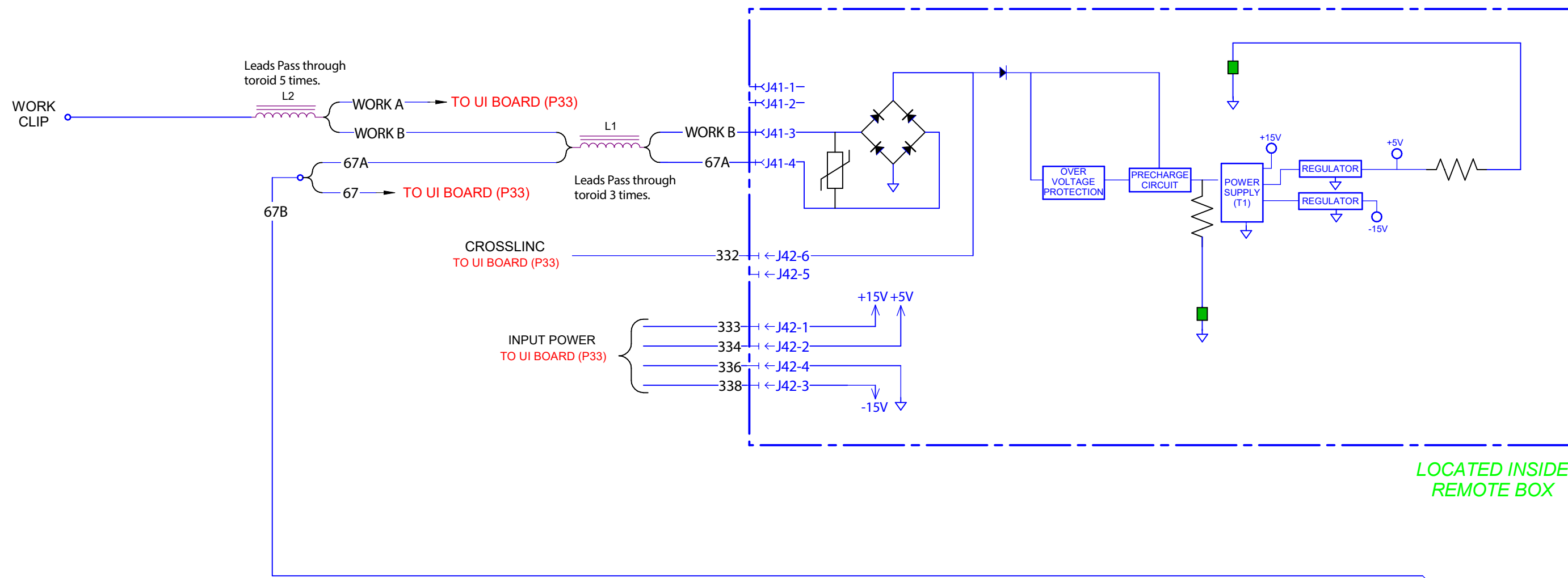
CROSSLINE REMOTE MACHINE SCHEMATIC L17201 REV: A



POWER SUPPLY P. C. BOARD

SCHEMATIC = G8695

SEE NOTES FOR LED'S



Flexible Power Board Summary

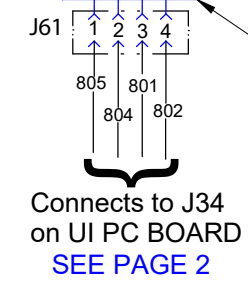
- Converts arc power to a usable control circuit voltage.
- Startup Voltage= 15-110VDC, Operating Voltage= 8-110VDC.
- Shut down Voltage= 141VDC.
- Serial number is located on plastic tray.

NOTE: THERMAL INDICATOR IS LOCATED ON THE UI BOARD.

LOCATED INSIDE REMOTE BOX

"To Power Source"
LC-40HD (TWECCO)
Male Connection

case strain relief



Connects to J34
on UI PC BOARD
SEE PAGE 2

CURRENT TRANSDUCER
(LEM)

INSULATION PIERCING CLAMP

67B

weld cable

case strain relief

"To Electrode"
LC-40HD (TWECCO)
Female Connection

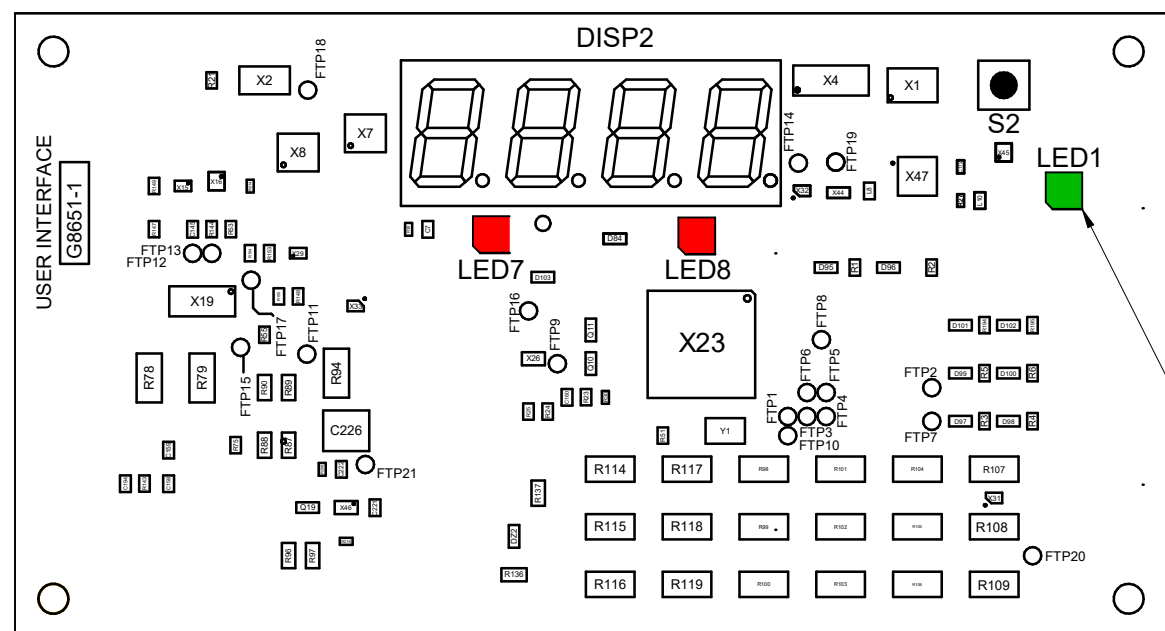
NOTES:

LED Definitions

- LED1 GREEN indicates precharge voltage is OK.
- LED2 GREEN indicates the +5Volt power is present.

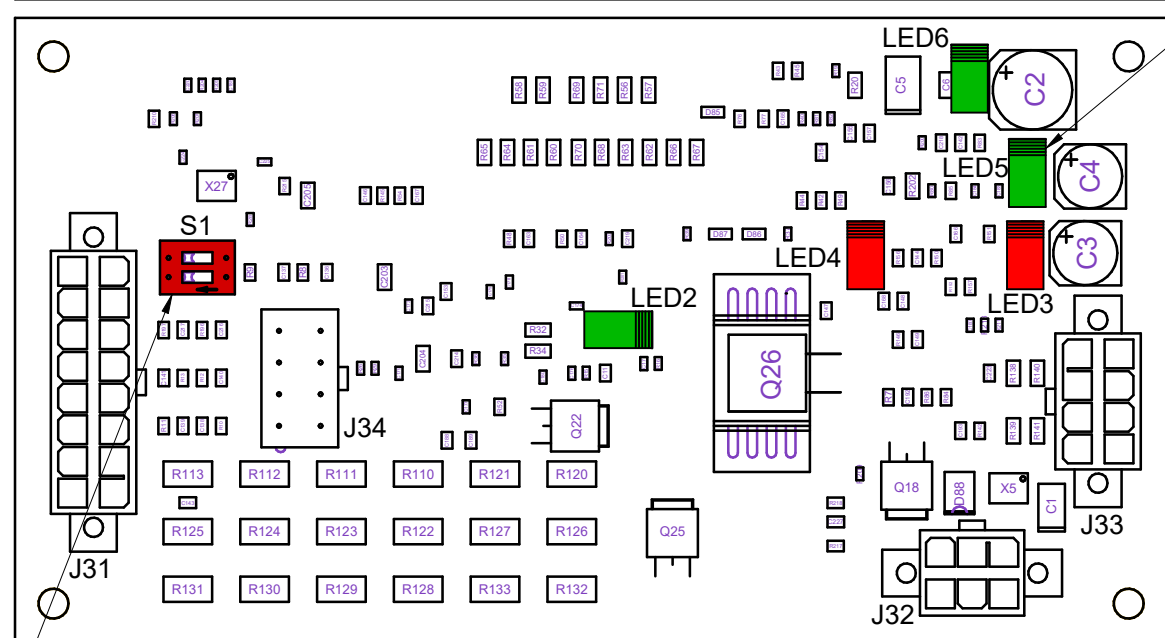
LEAD COLOR CODE:	COMPONENT VALUE UNITS:
B-BLACK OR GRAY	CAPACITOR: MFD/VOLTS
G-GREEN	RESISTOR: OHMS/WATTS
O-ORANGE	
R-RED OR PINK	CONNECTOR PIN NUMBERS:
U-BLUE	EX. 12 PIN CONNECTOR
W-WHITE	1 2 3 4 5 6
Y-YELLOW	7 8 9 10 11 12
LABELS:	VIEW OF CONNECTOR ON PC BOARD
⏏ COMMON	
⏏ FRAME GROUND	
⏏ EARTH GROUND	

UI P. C. BOARD SCHEMATIC = G8650
SEE PAGE 2 FOR MORE DETAILS



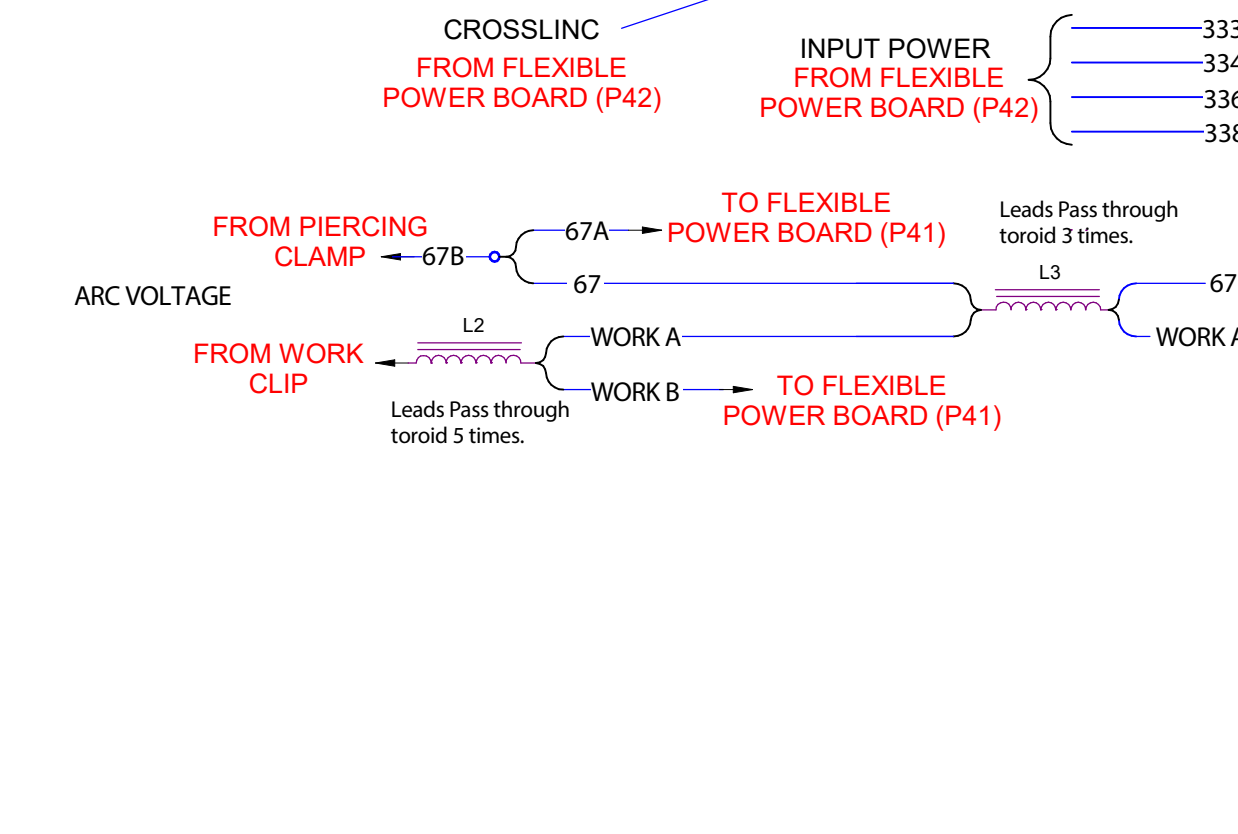
UI P. C. BOARD

SCHEMATIC = G8650



SEE NOTES FOR ALL LED'S

DIP SWITCH
S2 (UPPER SWITCH) ON = CROSSLINC ON
S1 ON or OFF = NORMAL MODE



LED DISPLAYS DIM DURING LOW POWER CONDITIONS.

AT IDLE:
-SHOWS PRESET IF CONNECTED TO CROSSLINC.
-SHOWS "----" IF NOT CONNECTED TO CROSSLINC.
WHILE WELDING:
-SHOWS ACTUAL VOLTAGE OR CURRENT. A (MINUS) "-" INDICATES NEGATIVE POLARITY.

VOLTS / AMPS DISPLAY

"AMPS" "VOLTS"

CROSSLINC LED IS GREEN WHEN COMMUNICATION IS ESTABLISHED, ORANGE ON THERMAL FAULT.

VOLTS OR AMPS ENCODER (ONLY ACTIVE WHEN CROSSLINC IS CONNECTED)

UI Board Summary

Polarity Indicator

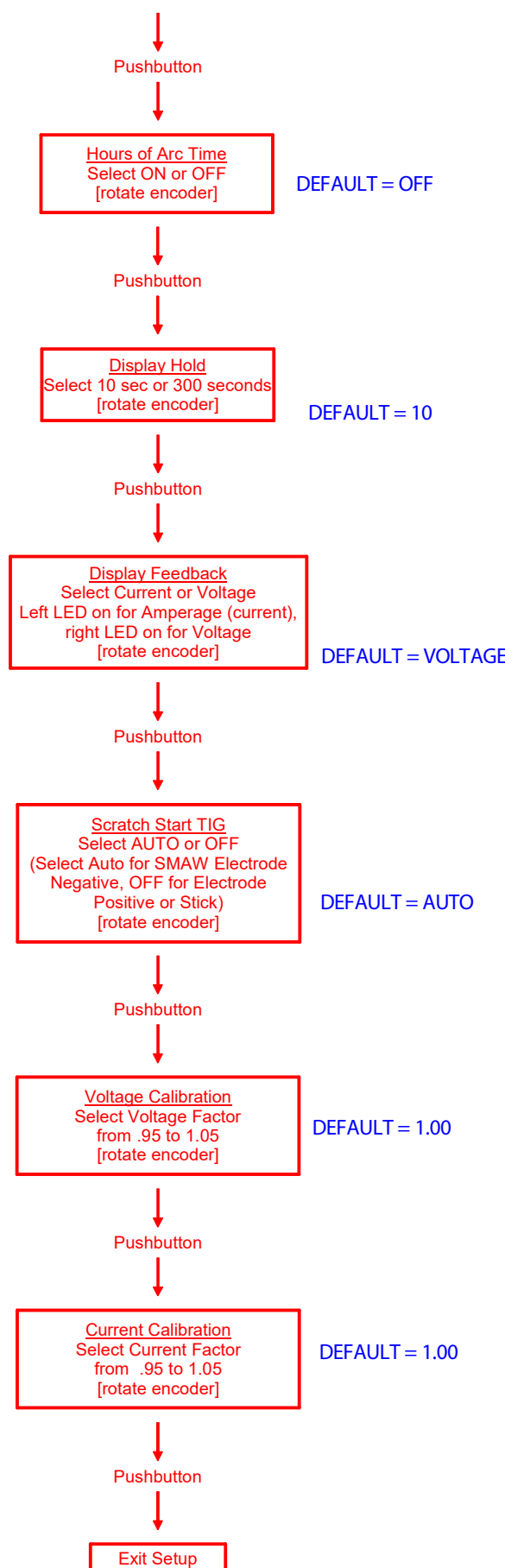
When operating in negative polarity, a "-" (minus) sign will appear in the volt or current display. This is true when preset is displayed, as well as actual.

Communications

The Green LED1 indicates that communication has been established between the Crossline Remote and power source. Communication string will appear to be a 2.5 Amp current pulse train, approximately every 1 to 3 seconds. When an arc has been established, the pulses will end. It can take up to one second for the power source to respond when the setpoint is changed at the remote.

SETUP MENU

Gain access to Setup Menu by pressing the board mounted pushbutton using a paper clip inserted in the .09" nameplate hole. Press pushbutton, then release when Setup Menu appears. Failure to release after 5 seconds will reset unit to Factory Defaults.



NOTES:

LED Definitions (Front of Board)

- LED1 GREEN indicates CROSSLINC has established communication with Power Source, ORANGE indicates Thermal fault.
- LED7 RED indicates Amps is displayed
- LED8 RED indicates Volts is displayed

LED Definitions (Back of Board)

- LED2 Flashing GREEN indicates microcontroller is operating.
- LED3 Solid RED indicates resistor sensor thermal fault.
- LED4 Solid RED indicates transistor sensor thermal fault.
- LED5 Solid GREEN indicates CROSSLINC communication is commanded on.
- LED6 Solid GREEN indicates the +5V power is present.

POWER SUPPLY P.C. BOARD
SCHEMATIC = G8695
SEE PAGE 1 FOR MORE DETAILS