



Weldtron Products

PO Box 30

Alice, Texas 78333

Telephone: (361) 664-4413

Fax: (361)-664-9135

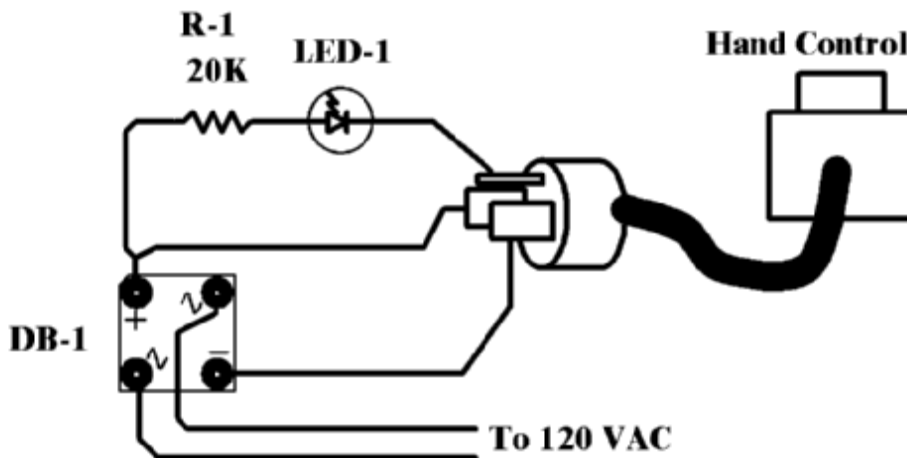
Email: manager@weldtron.com

Manufacturer of electronic circuits for welding machinery and associated apparatus.



Testing the hand control unit.

Testing the Pipeliner hand control unit



Connect as shown.

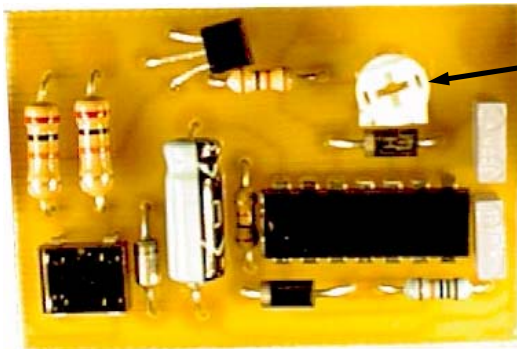
Apply 60 to 120 VAC to the bridge assembly and turn the hand control knob from 0 to 100%.

The brightness of LED-1 should vary from full off to full on and increase or decrease with movement of the hand control knob.

If LED-1 is fully on or off and does not change with movement of the hand control knob then the hand control unit is defective and should be repaired.

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Adjustment of the hand control circuit board.



Adjustment pot

This test is performed with the small circuit board installed within the hand control unit.

To calibrate the hand control follow the instructions below precisely and in the order described.

Set up the hand control as shown on the hand control test circuit page.

Open the hand control case and locate the small adjustment pot on the small circuit board within the unit.

Minimum setting calibration.

Apply power to the test circuit and turn the hand control main knob control to 0%. The test LED should be out. If it is not, adjust the Printed Circuit Board (PCB) adjustment pot clock-wise (CW) until the led just turns off. If this test and adjustment cannot be made the hand control PCB is defective and needs to be returned for repair.

Once this test has been performed move the main control pot to 10 or 15%. You should be able to see the LED just turning on at these settings. If not, adjust the PCB adjustment pot counter clock-wise (CCW) until the LED just starts to turn on. This will complete the minimum adjustment calibration.

Checking the main control pot.

Once the minimum setting has been completed slowly turn the main control pot from 0% to 100% while watching the LED. The LED should go from off to maximum brightness in a smooth and consistent manner. If it blinks on or off while turning the main control pot the main 2 watt pot is either dirty or defective and requires replacement.

Once the calibration is complete place the lid back on the hand control and remove power.