PLASTICWELD SYSTEMS, INC.

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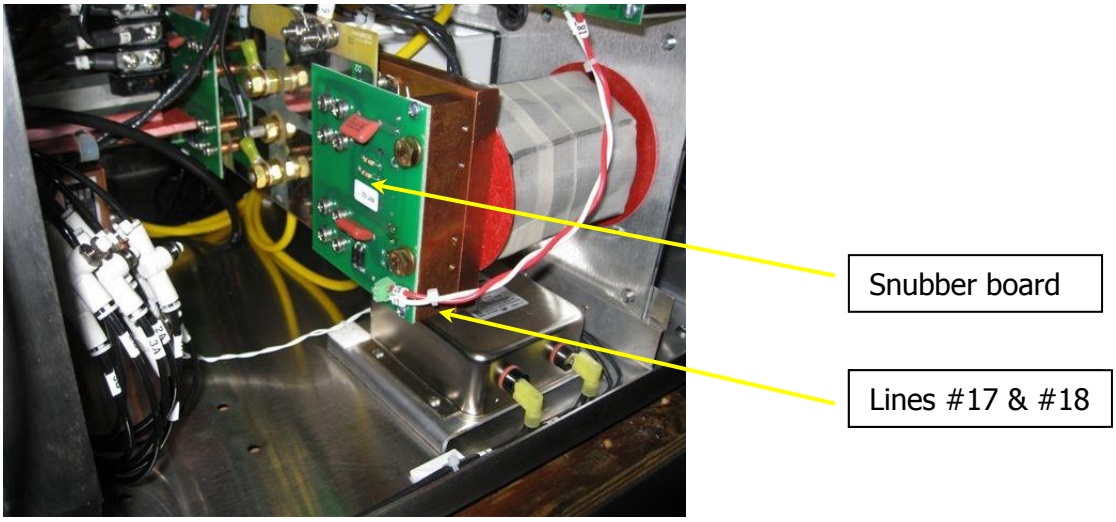
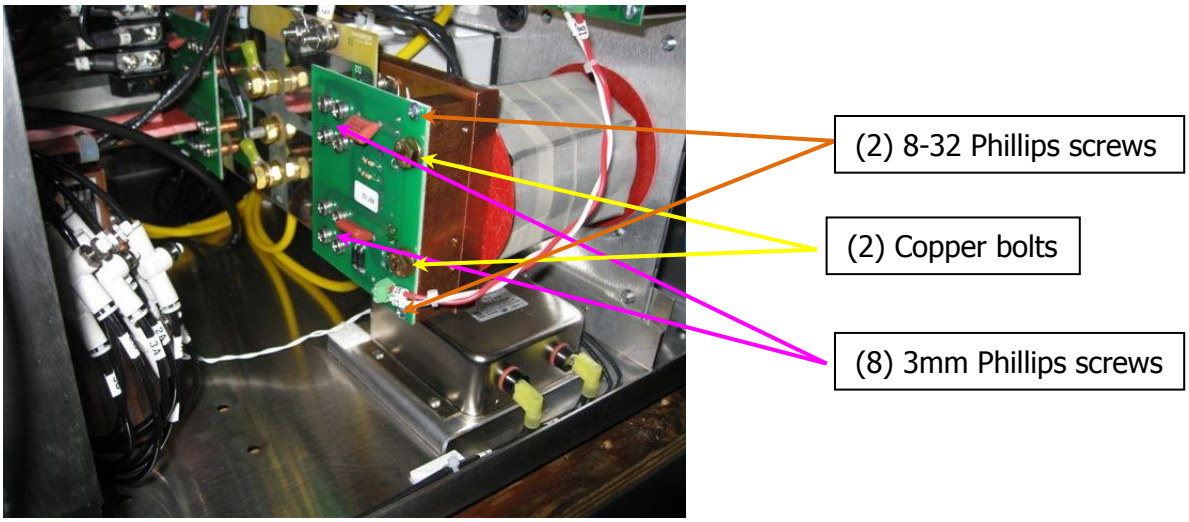
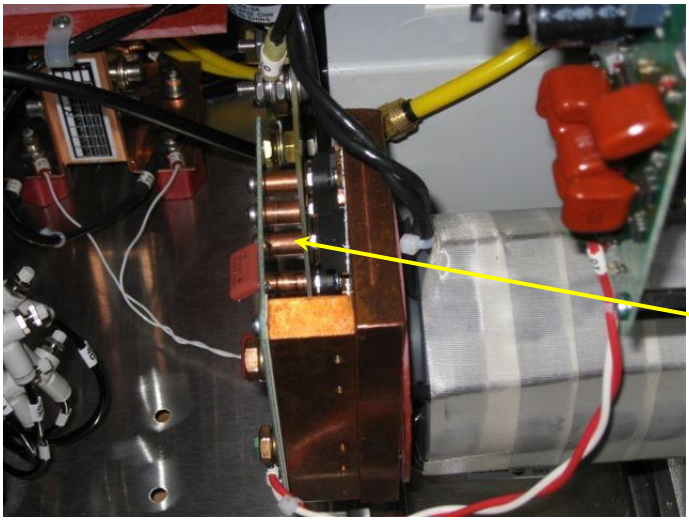
Instructions for changing the “snubber board”:

1. Turn unit on and measure voltage across wires #17 & #18 attached to the snubber board. This is the small circuit board where the electrical short occurred. All wires are labeled with tags. Voltage should be 12 VDC. If it does NOT read 12 VDC, then STOP AND CALL US.

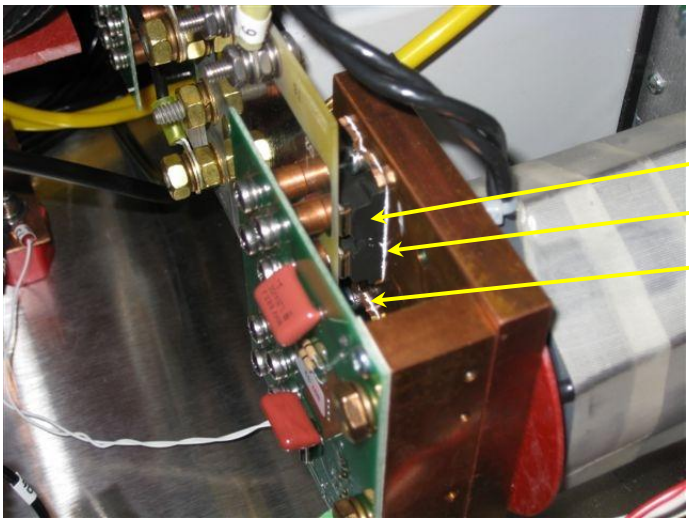


2. If the voltage reads approximately 12 VDC, turn off the machine and DISCONNECT THE POWER CORD.
3. Remove the (8) – 3mm Phillips screws, (2) – ¼-20 copper screws and (2) 8-32 Phillips screws holding the snubber board in place. MAKE SURE you collect all (8) brass spacers that the 3mm Phillips screws pass through.

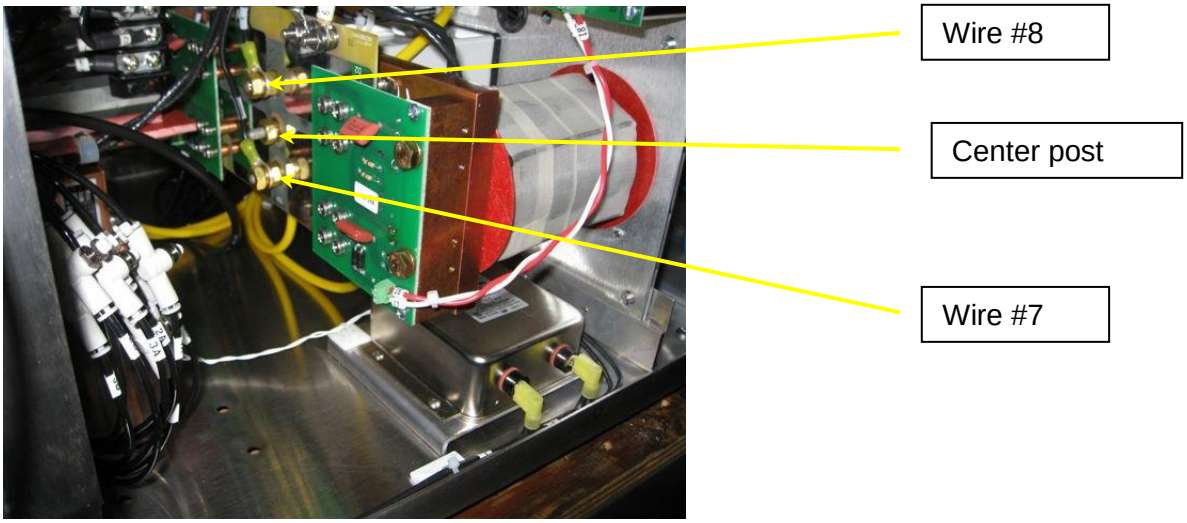




4. Replace upper DSE 12X61 diode and bottom IXFN80N50 Mosfet.
   Make sure to replace them exactly like the old ones were oriented and positioned. Remove some of the white heat sink grease from the old diode and Mosfet and wipe onto the correct side of the new diode and Mosfet.



5. Replace snubber board using (8) – 3mm Phillips screws, (2) – ¼-20 copper screws, (2) 8-32 Phillips screws and (8) copper spacers.
6. Connect wires #17 & #18. MAKE SURE #17 white is attached to the bottom terminal and #18 red is attached to the top terminal.
7. Reconnect power cord and turn on power.
8. Check voltage across wires #17 & #18. It should be approximately12 VDC.
9. Check voltage across 3 terminals as shown in picture below.
   - Voltage across wires #7 and #8 should be approximately 335 VDC
   - Voltage across wire #7 and center post should be approximately 168 VDC
   - Voltage across wire #8 and center post should be approximately 168 VDC



10. If all voltages are correct, the machine is repaired.