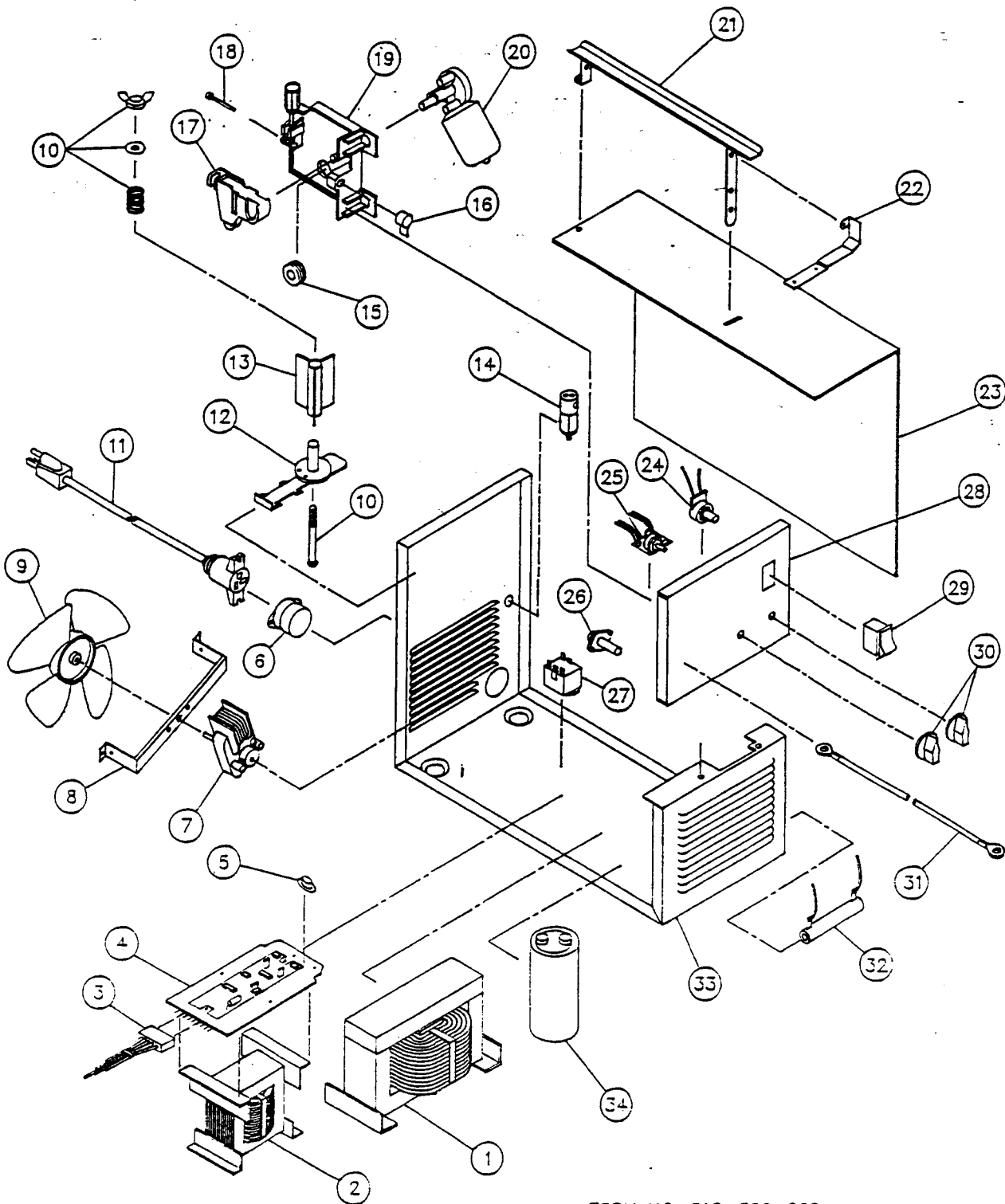




FORM NO. 812-522-000
REV. A

117-055 (WFFC)

117-055 (WFFC), 105 Amp Mig

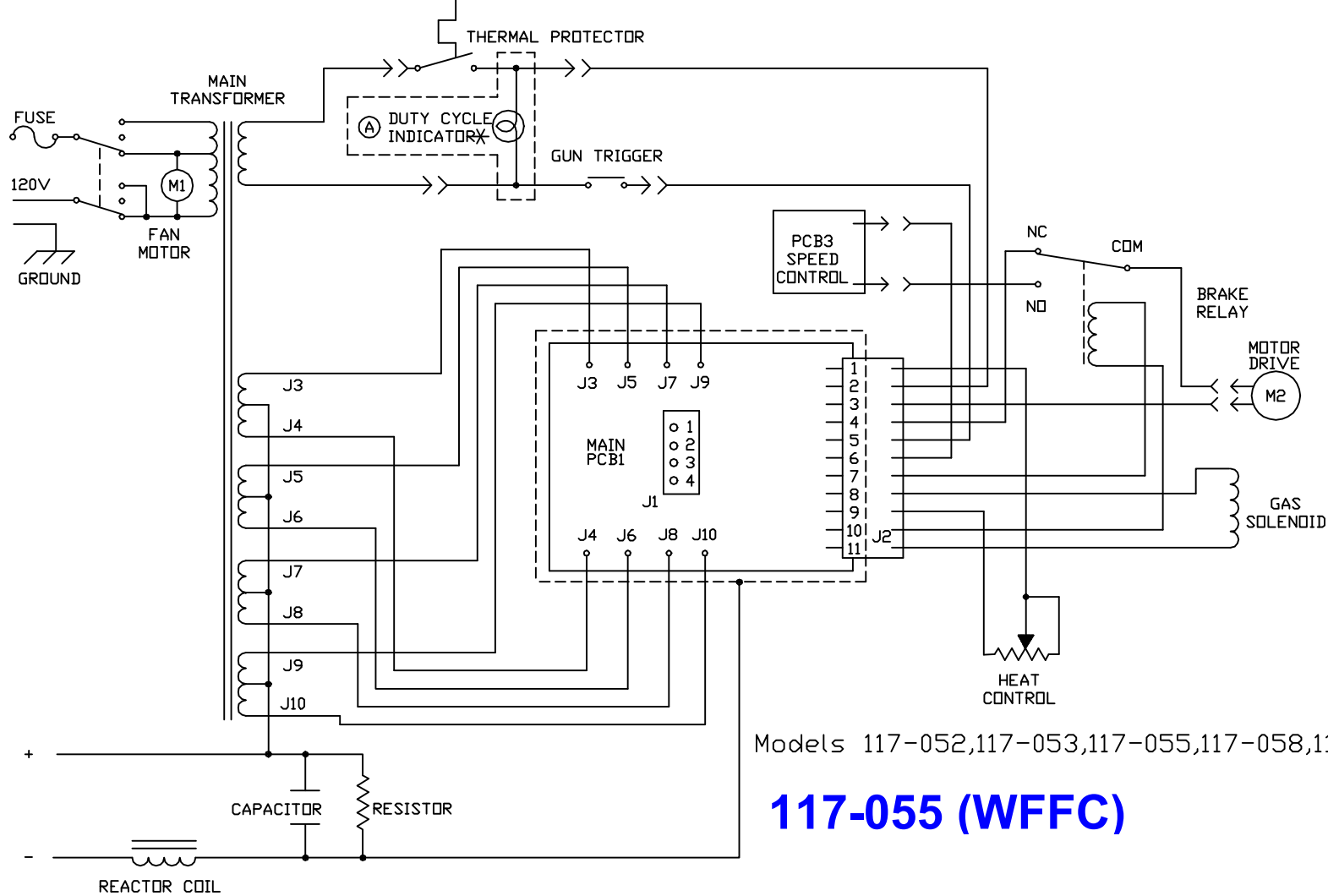
Item	Lincoln Stock #	Customer #	Description
1	Repair	880-188-888	Main weld transformer
2	NLA	880-215-888	Reactor Coil w/ thermostat
3		880-225-666	Wire harness
4	880-217-666	880-217-666	Circuit board
5	216-053-666	216-053-666	Thermostat
6	S18414-1	239-159-666	Power receptacle
7	216-087-666	216-087-666	Fan motor
8	NLA	412-375-000	Fan motor bracket
9		316-009-000	Fan blade
10	131-419-000	131-213-000	Tension hardware
11	S18475	248-226-000, 248-227-100 (4040)	Power cord
12	312-076-666	312-076-666	Spindle
13	312-110-666	312-077-666	Spindle adapter
14	246-086-666	246-212-666	Gas solenoid
15	310-122-500	4323	Drive roller, 0.024 / 0.030 / 0.035
16		412-280-666	Copper ring
17	Included with #19	880-111-666, 312-107-000	Tension arm only
18	Included with #19	239-123-666, 239-208-000	Inlet guide tube
19	880-130-666	880-130-666	Drive base with arm
20	S27985-4 with 880-130 base hole enlarged & terminals changed	216-089-666, 216-079-666	Drive motor
21	NLA	880-012-010	Handle assembly
22	NLA	412-278-010	Hood hinge

Item	Lincoln Stock #	Customer #	Description
23	NLA	410-586-020	Right side panel
24		245-108-666	Heat potentiometer
25	880-219-666	880-219-666	Wire speed pcb
26		246-116-666	Fuse holder cap
		245-060-666	Fuse only, BAN30 or BLN30
27	246-258-666	246-258-666	Relay, 24Vdc coil
28	NLA	410-665-024	Front panel
29	246-259-666	246-259-666	90 / 110 Amp Rocker Switch
30	246-041-666	246-041-666	Knob
31	S11609-18	238-216-666	Ground cable only, 9' w / lugs
	M12033	239-010-102	Ground clamp only(not shown)
32		860-523-666	Bleeder resistor assy.
33	NLA	410-639-010	Base
34	S13490-109	213-035-666	Capacitor
Not Shown			
36	238-155-000	238-155-000	10' Mig Gun
37	334-221-000	334-221-000	Trigger
38	KP45-40-15	KP1937-1, 4331	Steel liner, 15'
39	KP1959-1	4325	Teflon liner
40	334-303-001	334-286-666	Mig regulator
41	059-245-666		Gas hose

2/16/2010

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
117-055	120V, 20 amp	15A	20%

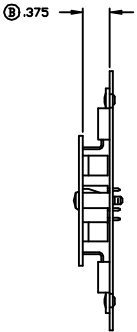
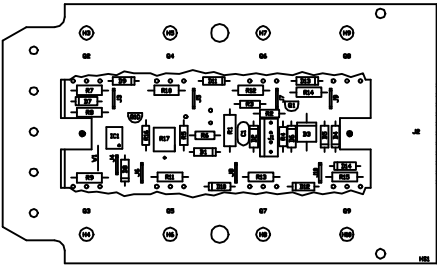
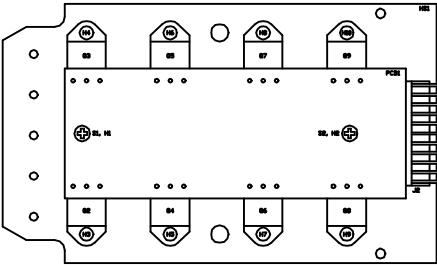
Rated Output	Voltage Settings	Agency Listing	Max Output
90 amps	Infinite	CSA	105 amps



610-120-000

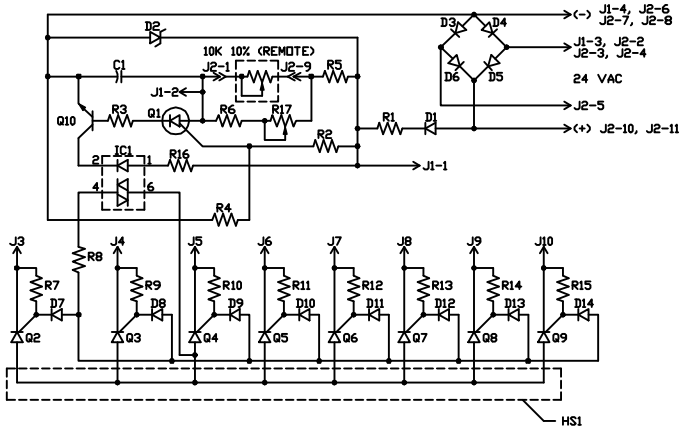
Models 117-052,117-053,117-055,117-058,117-061,117-064

117-055 (WFFC)



NOTES:

- 1. SOLDERING AND GENERAL WORKMANSHIP TO COMPLY WITH IPC-CM-770B.
- 2. TRIM EXCESS COMPONENT LEAD LENGTH TO .125" MAX.
- 3. CONFORMAL COAT PER QC PROCEDURE #QCP 98050. DO NOT CONFORMAL COAT POTENTIOMETER (R17). MATERIAL: DOW CORNING 1-2577 .002 - .006 THICK HUMISEAL 1A27 .002 - .004 THICK
- 4. KNOB OF POTENTIOMETER (R17) TO BE SEALED TO PREVENT ROTATION AFTER CALIBRATION OF CIRCUIT BOARD.
- 5. ENTIRE CONTACT SURFACE OF SCR'S (Q2 THRU Q9) TO HAVE THERMAL GREASE, GE #G64L OR EQUAL, APPLIED PRIOR TO RIVETING TO HEATSINK.
- 6.
- 7. BOARD TO BE SHIPPED IN BULK PACKING TO PROTECT FROM DAMAGE.



SCHEMATIC DIAGRAM

J10	TERMINAL, .250 x .031 TAB, AMP #62650-1, AUTOSPLICE #7-13330-8	8
J9	TERMINAL, .250 x .031 TAB, AMP #62650-1, AUTOSPLICE #7-13330-8	9
J8	TERMINAL, .250 x .031 TAB, AMP #62650-1, AUTOSPLICE #7-13330-8	8
J7	TERMINAL, .250 x .031 TAB, AMP #62650-1, AUTOSPLICE #7-13330-8	8
J6	TERMINAL, .250 x .031 TAB, AMP #62650-1, AUTOSPLICE #7-13330-8	8
J5	TERMINAL, .250 x .031 TAB, AMP #62650-1, AUTOSPLICE #7-13330-8	8
J4	TERMINAL, .250 x .031 TAB, AMP #62650-1, AUTOSPLICE #7-13330-8	8
J3	TERMINAL, .250 x .031 TAB, AMP #62650-1, AUTOSPLICE #7-13330-8	8
J2	CONNECTOR, 11-PIN, AMP #1-640389-1	8
J1	CONNECTOR, 4-PIN, AMP #640388-4	
IC1	INTEGRATED CIRCUIT MOC 3021	
HS1	HEATSINK CENTURY #412-374-001	A
H10	RIVET, SEMITUBULAR, .120 DIA x .218 L (CENTURY #077-056-000)	
H9	RIVET, SEMITUBULAR, .120 DIA x .218 L (CENTURY #077-056-000)	
H8	RIVET, SEMITUBULAR, .120 DIA x .218 L (CENTURY #077-056-000)	
H7	RIVET, SEMITUBULAR, .120 DIA x .218 L (CENTURY #077-056-000)	
H6	RIVET, SEMITUBULAR, .120 DIA x .218 L (CENTURY #077-056-000)	
H5	RIVET, SEMITUBULAR, .120 DIA x .218 L (CENTURY #077-056-000)	
H4	RIVET, SEMITUBULAR, .120 DIA x .218 L (CENTURY #077-056-000)	
H3	RIVET, SEMITUBULAR, .120 DIA x .218 L (CENTURY #077-056-000)	
H2	SPACER D.D. 1/4", LENGTH .375 CLEARANCE #6 SCREW	8
H1	SPACER D.D. 1/4", LENGTH .375 CLEARANCE #6 SCREW	8
D14	DIODE, 1N4002 THRU 1N4006	
D13	DIODE, 1N4002 THRU 1N4006	
D12	DIODE, 1N4002 THRU 1N4006	
D11	DIODE, 1N4002 THRU 1N4006	
D10	DIODE, 1N4002 THRU 1N4006	
D9	DIODE, 1N4002 THRU 1N4006	
D8	DIODE, 1N4002 THRU 1N4006	
D7	DIODE, 1N4002 THRU 1N4006	
D6	DIODE, 1N4002 THRU 1N4006	
D5	DIODE, 1N4002 THRU 1N4006	
D4	DIODE, 1N4002 THRU 1N4006	
D3	DIODE, 6A MR754 OR 6A4	
D2	DIODE, ZENER 5.1V 1N4733A	
D1	DIODE, 1N4002 THRU 1N4006	
C1	CAPACITOR, .47UF 50V 5% PANASONIC V-SERIES	
SYM	DESCRIPTION	

V1	WIRE, 22GA TINNED COPPER CONDUCTOR	
S2	SCREW #6-32 x 11/16" P.P.H. EXTENDED STAR WASHER	8
S1	SCREW #6-32 x 11/16" P.P.H. EXTENDED STAR WASHER	8
R17	POTENTIOMETER, CERMET 50K, SEALED	8
R16	RESISTOR, 100Ω 1/4W 5%	
R15	RESISTOR, 100Ω 1/2W 5%	
R14	RESISTOR, 100Ω 1/2W 5%	
R13	RESISTOR, 100Ω 1/2W 5%	
R12	RESISTOR, 100Ω 1/2W 5%	
R11	RESISTOR, 100Ω 1/2W 5%	
R10	RESISTOR, 100Ω 1/2W 5%	
R9	RESISTOR, 100Ω 1/2W 5%	
R8	RESISTOR, 18Ω 1/2W 5%	
R7	RESISTOR, 100Ω 1/2W 5%	
R6	RESISTOR, 13K 1/4W 5%	
R5	RESISTOR, 4.3K 1/4W 5%	
R4	RESISTOR, 15K 1/4W 1%	
R3	RESISTOR, 33Ω 1/4W 5%	
R2	RESISTOR, 10K 1/4W 1%	
R1	RESISTOR, 330Ω 1W 5%	
Q10	TRANSISTOR, 2N3904, MPS3904 OR PN3904	
Q9	SCR (CENTURY #244-073-000)	
Q8	SCR (CENTURY #244-073-000)	
Q7	SCR (CENTURY #244-073-000)	
Q6	SCR (CENTURY #244-073-000)	
Q5	SCR (CENTURY #244-073-000)	
Q4	SCR (CENTURY #244-073-000)	
Q3	SCR (CENTURY #244-073-000)	
Q2	SCR (CENTURY #244-073-000)	
Q1	TRANSISTOR, 2N6027	
PCB1	PRINTED CIRCUIT BOARD (CENTURY #510-095-000)	8
SYM	DESCRIPTION	

(B) EN 11877 5-21-91 LRB	
(A) EN 11694 3-22-91 CEA	
STN REVISION DATE BY	
DO NOT SCALE UNLESS SPECIFIED DIMENSIONS ARE IN INCHES	
CENTURY MFG CO	
DATE 11-14-90	
TOLERANCES UNLESS SPECIFIED	
DFT GR	
ENG GR	
END APPV JCW	
3-13-91	
PREVIOUSLY RELEASED AS	
REV 11	
SCALE 1:1	
RELEASE 11438	
DATE 11-14-90	
BY P.74	
CIRCUIT BOARD ASSEMBLY	
880-550-000	