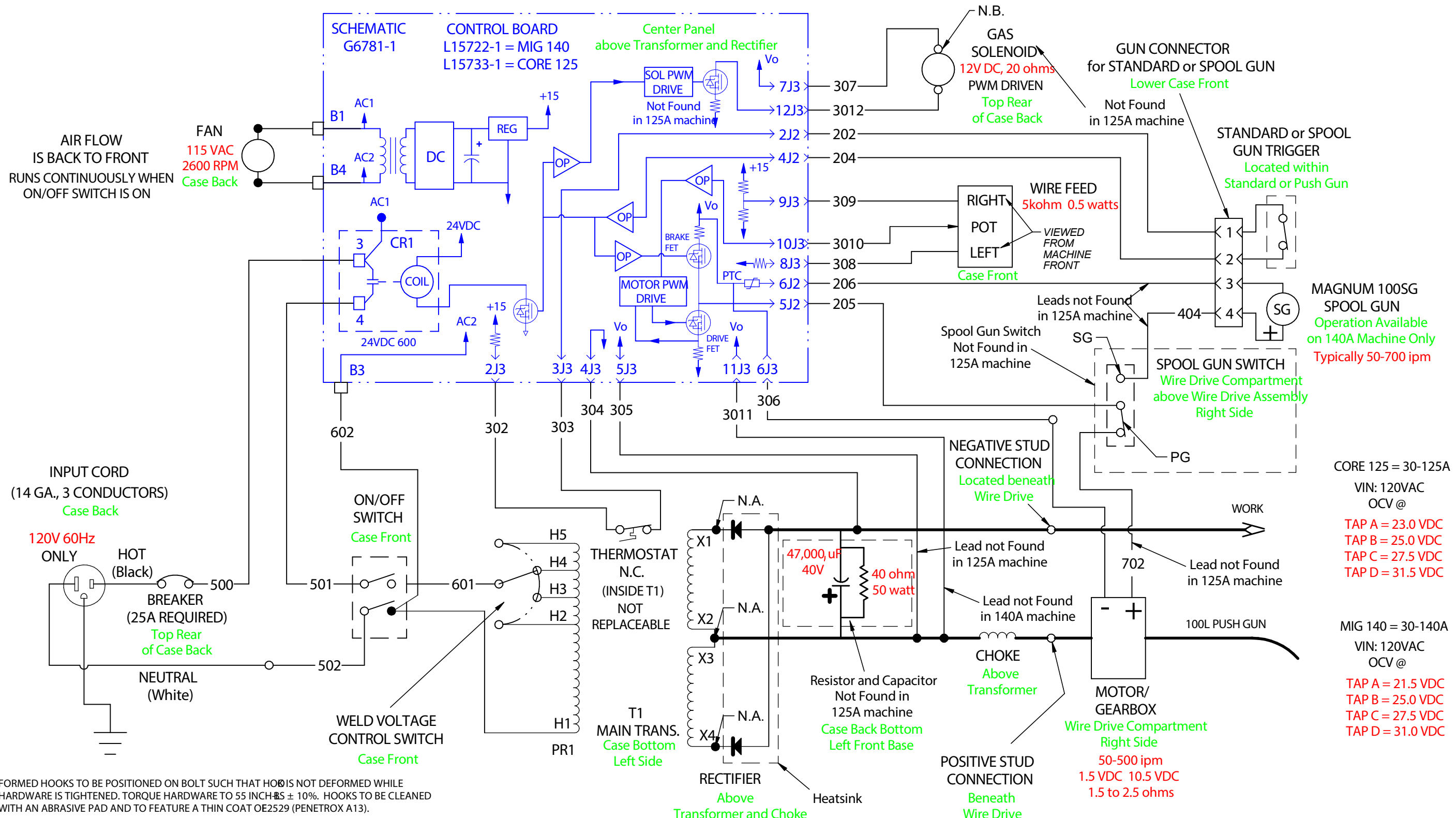


SMALL WIRE FEEDER WELDERS MACHINE SCHEMATIC M22435 REV:A



MAGNUM 100SG SPOOL GUN
 Operation Available on 140A Machine Only
 Typically 50-700 ipm

CORE 125 = 30-125A
 VIN: 120VAC
 OCV @
 TAP A = 23.0 VDC
 TAP B = 25.0 VDC
 TAP C = 27.5 VDC
 TAP D = 31.5 VDC

MIG 140 = 30-140A
 VIN: 120VAC
 OCV @
 TAP A = 21.5 VDC
 TAP B = 25.0 VDC
 TAP C = 27.5 VDC
 TAP D = 31.0 VDC

N.A. FORMED HOOKS TO BE POSITIONED ON BOLT SUCH THAT HOLES IS NOT DEFORMED WHILE HARDWARE IS TIGHTENED. TORQUE HARDWARE TO 55 INCH-BS ± 10%. HOOKS TO BE CLEANED WITH AN ABRASIVE PAD AND TO FEATURE A THIN COAT OE2529 (PENETROX A13).

N.B. PARALLEL TERMINALS ON SOLENOID TO BE CONNECTED TO 307 AND 3012 LEADS. GROUND TERMINAL TO BE UNUSED. VOLTAGE BETWEEN DISCONNECTED 307 AND 3012 LEADS WILL MATCH THE O.C.V. PRESENT AT THE OUTPUT STUDS.