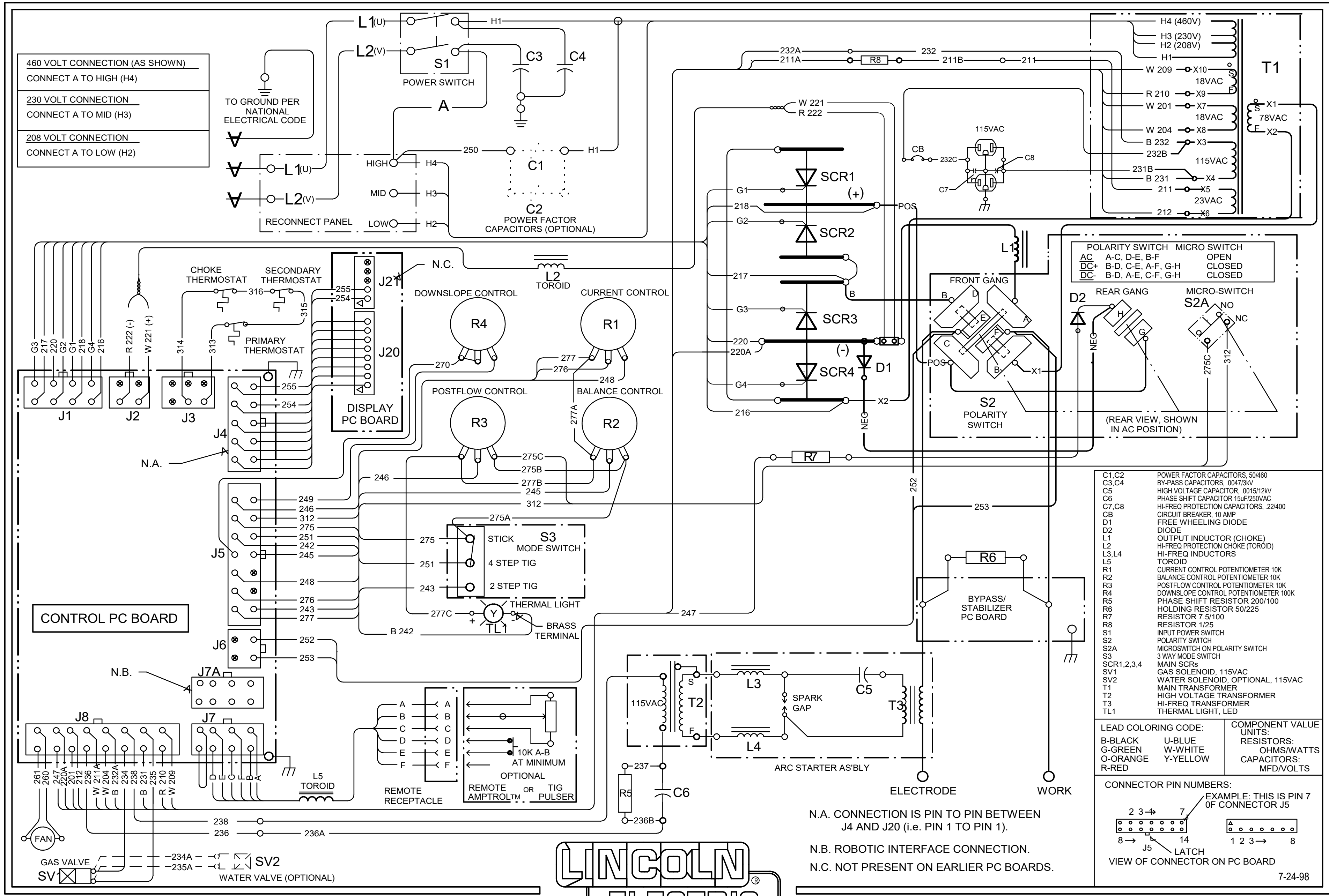


SQUARE WAVE TIG 275 (208/230/460/1/60) WIRING DIAGRAM L10747 REV: D



460 VOLT CONNECTION (AS SHOWN)
CONNECT A TO HIGH (H4)

230 VOLT CONNECTION
CONNECT A TO MID (H3)

208 VOLT CONNECTION
CONNECT A TO LOW (H2)

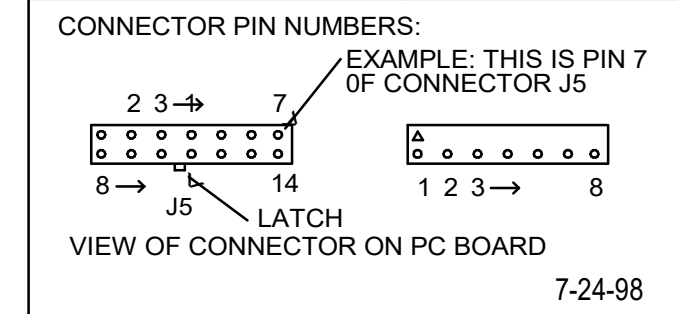
TO GROUND PER NATIONAL ELECTRICAL CODE

RECONNECT PANEL

AC	A-C, D-E, B-F	MICRO SWITCH	OPEN
DC+	B-D, C-E, A-F, G-H		CLOSED
DC-	B-D, A-E, C-F, G-H		

- C1, C2 POWER FACTOR CAPACITORS, 50/460
- C3, C4 BY-PASS CAPACITORS, .0047/3KV
- C5 HIGH VOLTAGE CAPACITOR, .0015/12KV
- C6 PHASE SHIFT CAPACITOR 15uF/250VAC
- C7, C8 HI-FREQ PROTECTION CAPACITORS, .22/400
- CB CIRCUIT BREAKER, 10 AMP
- D1 FREE WHEELING DIODE
- D2 DIODE
- L1 OUTPUT INDUCTOR (CHOKE)
- L2 HI-FREQ PROTECTION CHOKE (TOROID)
- L3, L4 HI-FREQ INDUCTORS
- L5 TOROID
- R1 CURRENT CONTROL POTENTIOMETER 10K
- R2 BALANCE CONTROL POTENTIOMETER 10K
- R3 POSTFLOW CONTROL POTENTIOMETER 10K
- R4 DOWNSLOPE CONTROL POTENTIOMETER 100K
- R5 PHASE SHIFT RESISTOR 200/100
- R6 HOLDING RESISTOR 50/225
- R7 RESISTOR 7.5/100
- R8 RESISTOR 1/25
- S1 INPUT POWER SWITCH
- S2 POLARITY SWITCH
- S2A MICROSWITCH ON POLARITY SWITCH
- S3 3 WAY MODE SWITCH
- SCR1,2,3,4 MAIN SCRs
- SV1 GAS SOLENOID, 115VAC
- SV2 WATER SOLENOID, OPTIONAL, 115VAC
- T1 MAIN TRANSFORMER
- T2 HIGH VOLTAGE TRANSFORMER
- T3 HI-FREQ TRANSFORMER
- TL1 THERMAL LIGHT, LED

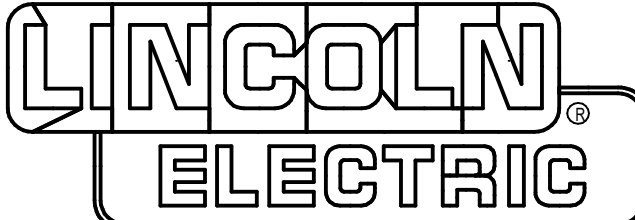
LEAD COLORING CODE:		COMPONENT VALUE UNITS:	
B-BLACK	U-BLUE	RESISTORS:	OHMS/WATTS
G-GREEN	W-WHITE	CAPACITORS:	MFD/VOLTS
O-ORANGE	Y-YELLOW		
R-RED			



N.A. CONNECTION IS PIN TO PIN BETWEEN J4 AND J20 (i.e. PIN 1 TO PIN 1).

N.B. ROBOTIC INTERFACE CONNECTION.

N.C. NOT PRESENT ON EARLIER PC BOARDS.



CLEVELAND, OHIO U.S.A.