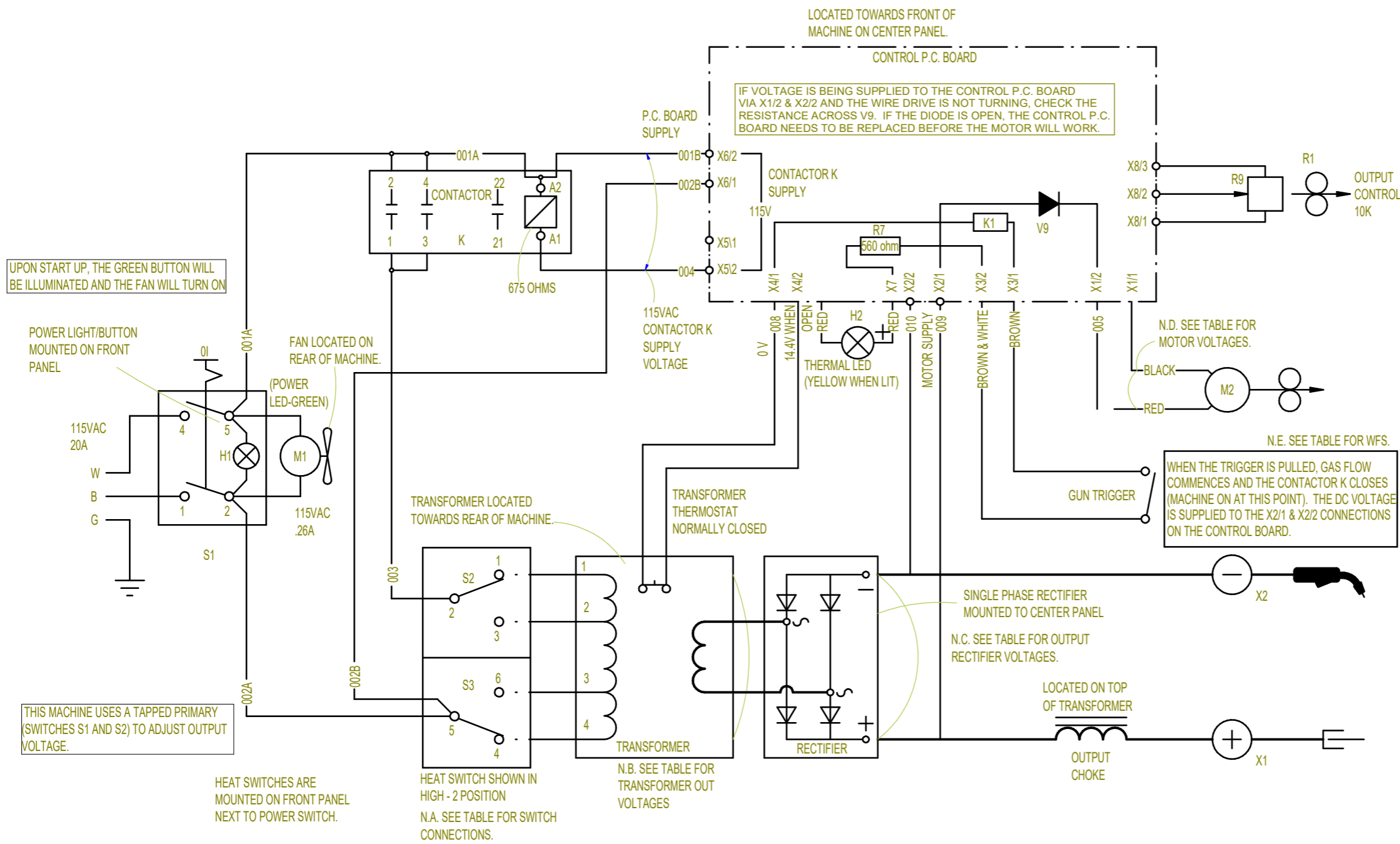


QUICK WELD MACHINE SCHEMATIC M20299 REV: A



MEASUREMENT	P.C. BOARD CONNECTION TO POT					
	X8/1-X8/		X8/2-X8/		X8/1-X8/	
OUTPUT CONTROL	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.
RESISTANCE VALUES IN OHMS	10K	0	0	2.5K	10K	2.5K
DC VOLTAGE VALUES IN VOLTS	2.8	0	0	1	2.8	1

N.A.		N.B.		N.C.		N.D.		N.E. **		
VOLTAGES WERE TAKEN AT MAXIMUM POTENTIOMETER SETTING										
HEAT SETTINGS	SWITCH S2 AND S3 CONNECTIONS	CONNECTION - OUT OF TRANSFORMER (RMS VALUES)	CONNECTION - OUT OF RECTIFIER (RMS VALUES)	DISCONNECTED FROM RECTIFIER (RMS VALUES)	VOLTAGE INTO WIRE DRIVE MOTOR	TENSION ARM AT MINIMUM SETTING *	TENSION ARM AT RECOMMENDED SETTING	* MINIMUM SETTING IS DEFINED AS THE LIGHTEST SPRING FORCE THAT WILL FEED WIRE WITHOUT RESULTING IN SLIPPAGE AT THE DRIVE ROLLS		
HIGH	2	2-1	32VAC	31.07VDC	39VDC	22.75VAC	230-260	200-250	** VALUES MAY VARY FROM VALUES IN THE CHART DEPENDING ON THE METHOD OR WFS MEASUREMENT AND WIRE FEEDER SETUP. FRICTIONAL DRAG RESULTING FROM WIRE FEED TENSION SETTING, CONDITION OF LINER, KINKS OR LOOPS IN GUN CABLE OR WIRE FEED SPEED METER WILL AFFECT THE WFS VALUE.	
		5-4								
HIGH	1	2-1	28.45VAC	27.55VDC	34.5VDC	19.90VAC	180-210	130-190		
		5-6								
LOW	2	2-3	25.52VAC	24.5VDC	30.75VDC	17.35VAC	130-160	125-145		
		5-4								
LOW	1	2-1	23.14VAC	22.VDC	27.85VDC	14.8VAC	110-130	200-250		
		5-6								
LISTED VOLTAGES REFLECT AN INPUT VOLTAGE OF 115.0 VAC										

LEAD COLOR CODE:
 B-BLACK
 G-GREEN
 O-ORANGE
 R-RED
 U-BLUE
 W-WHITE
 Y-YELLOW

COMPONENT VALUE UNITS:
 CAPACITOR: MFD/VOLTS
 RESISTOR: OHMS/WATTS

CONNECTOR PIN NUMBERS:
 EX. 12 PIN CONNECTOR

LABELS:
 COMMON
 FRAME GROUND
 EARTH GROUND

VIEW OF CONNECTOR ON PC BOARD