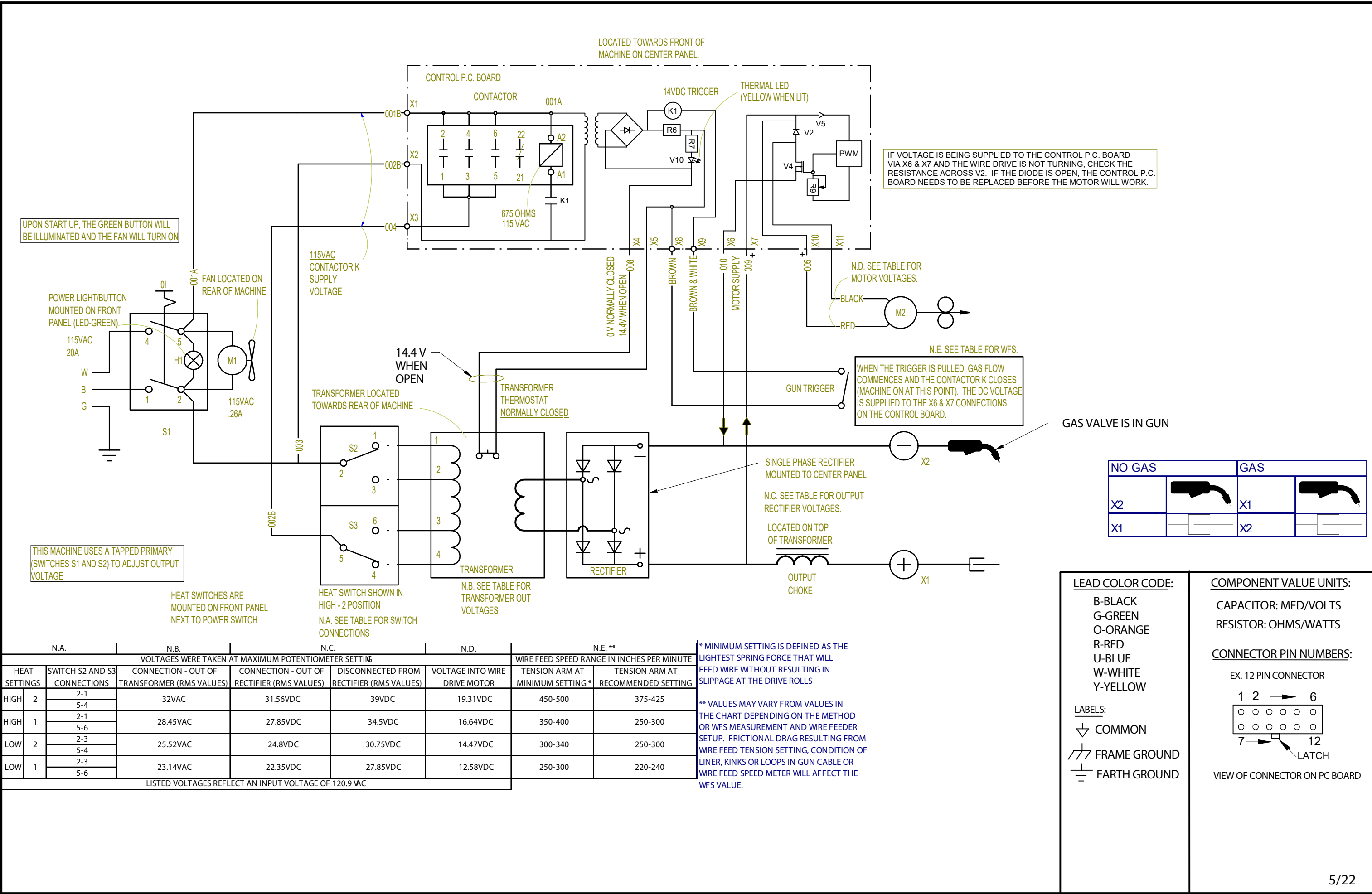


BESTER GMAW MACHINE SCHEMATIC M20126-1 REV: A



NO GAS		GAS	
X2		X1	
X1		X2	

N.A.		N.B.		N.C.		N.D.		N.E. **	
HEAT SETTINGS		SWITCH S2 AND S3 CONNECTIONS		CONNECTION - OUT OF TRANSFORMER (RMS VALUES)		CONNECTION - OUT OF RECTIFIER (RMS VALUES)		TENSION ARM AT MINIMUM SETTING *	
HIGH	2	2-1	32VAC	31.56VDC	39VDC	19.31VDC	450-500	375-425	
HIGH	1	5-4	28.45VAC	27.85VDC	34.5VDC	16.64VDC	350-400	250-300	
LOW	2	2-1	25.52VAC	24.8VDC	30.75VDC	14.47VDC	300-340	250-300	
LOW	1	5-6	23.14VAC	22.35VDC	27.85VDC	12.58VDC	250-300	220-240	

LISTED VOLTAGES REFLECT AN INPUT VOLTAGE OF 120.9 VAC

* MINIMUM SETTING IS DEFINED AS THE LIGHTEST SPRING FORCE THAT WILL FEED WIRE WITHOUT RESULTING IN SLIPPAGE AT THE DRIVE ROLLS

** 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.

LEAD COLOR CODE:

B-BLACK
G-GREEN
O-ORANGE
R-RED
U-BLUE
W-WHITE
Y-YELLOW

LABELS:

COMMON
FRAME GROUND
EARTH GROUND

COMPONENT VALUE UNITS:

CAPACITOR: MFD/VOLTS
RESISTOR: OHMS/WATTS

CONNECTOR PIN NUMBERS:

EX. 12 PIN CONNECTOR

1 2 3 4 5 6
7 8 9 10 11 12

LATCH

VIEW OF CONNECTOR ON PC BOARD