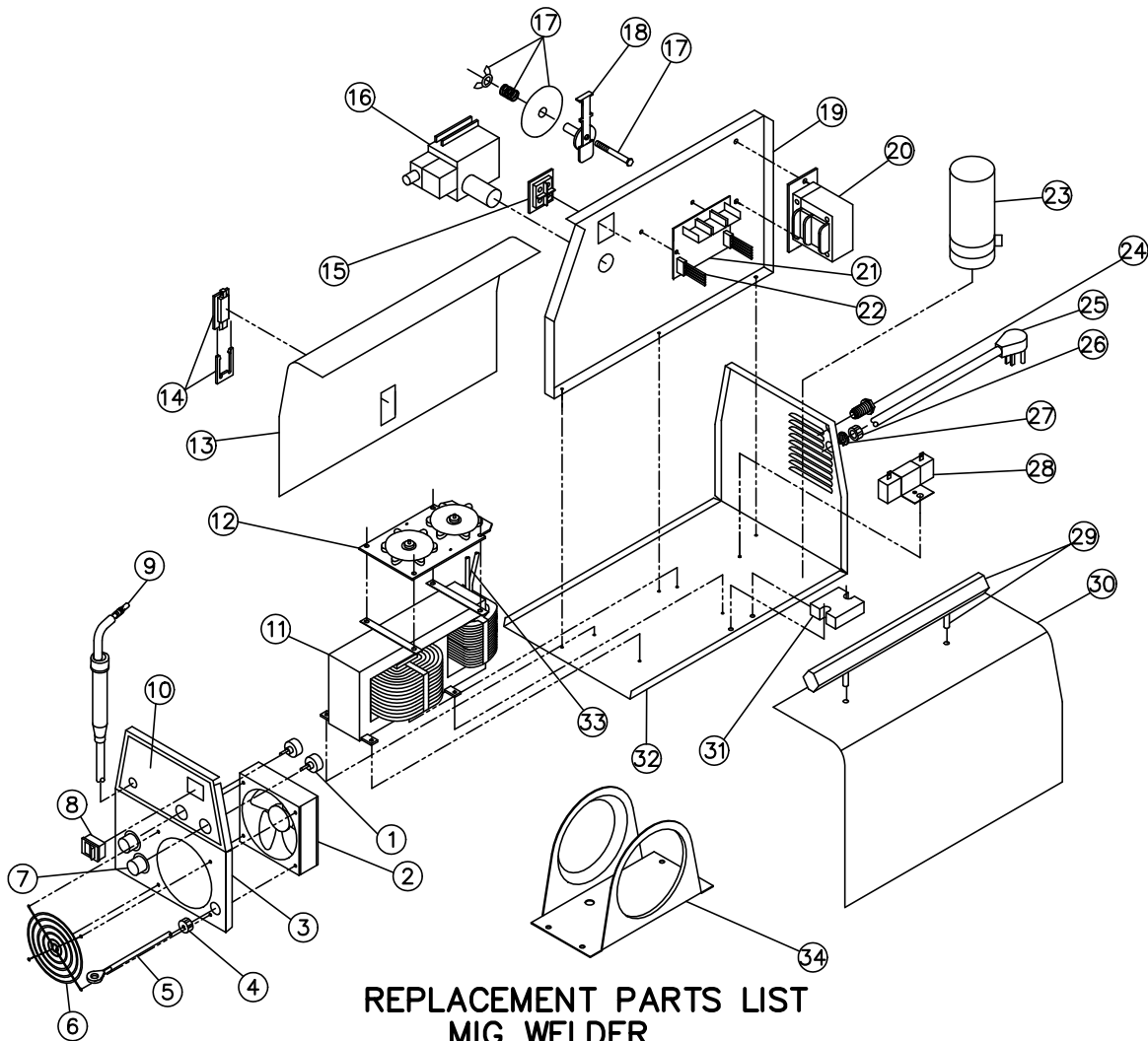




REPLACEMENT PARTS LIST MIG WELDER

117-079, 2185, 83170, 83171, M02185, 170 GL/GS

117-079, 2185, 83170, 83171, M02185, 170 GL/GS

Item	Lincoln Stock #	Customer #	Description
1	880-052-666	880-052-666	Heat & wire speed controls w/potentiometers
2	S18977-5	216-101-000	Fan motor
3	NLA	410-924-XXX	Front panel
4		541-057-000	Strain relief
5		238-159-666	Cable assy.
6	NLA	412-641-666	Fan guard
7	246-041-666	246-107-000	Knob
8		246-424-666	Switch
9	238-593-000	238-593-000	10' mig gun (used on units built after 1-1-01, RED trigger)
	NLA	238-566-000	10' mig gun (used on units built from 5-2-99 to 12-31-00, BLACK trigger)
	238-507-000	238-507-000	10' mig gun (used on units built before 5-2-99, RED trigger, gas diffuser has left-hand threads)
10	NLA	410-869-XXX	Control panel
11	880-416-888	880-416-888	Transformer
12		880-327-666	Rectifier
13	NLA	410-869-XXX	Left side panel
14	NLA	312-295-666	Slide latch w/clip
15		246-414-000	Terminal block
16	880-406-001	880-406-666	Drive motor / gear box
		310-187-000	Steel drive roller, (0.024/0.030/0.035)
	880-427-666	880-427-666	Neoprene drive roller for aluminum
	S24355-6		Idle roller (C609Z)
	S24355-9		Wire feed tension knob (smaller)
	S24355-10		Wire feed tension spring
	334-627-000		Inlet Guide tube (cut to length (2.75"))
17	131-419-000		Tension kit less 312-110-666
18	312-076-666		Spindle
19	NLA	410-867-XXX	Center panel

Item	Lincoln Stock #	Customer #	Description
20		880-233-888, 880-041-888	Drive Transformer
21	880-428-000	880-428-666	Circuit board w/heat sink
22		880-425-666	Wire harness
23		213-041-000	Capacitor, 98,000mf, 40 Vdc
24	253-333-000	253-333-666	Push in union fitting (5/32")
25	S15599-2	248-330-666	Power cord, 12-3, 6' w/ 6-50 plug
26		512-215-666	Bushing
27		239-074-666	Strain relief
28		245-145-666	25Ω, 50 Watt Resistor
29		312-296-666	Handle
30	NLA	410-864-XXX	Right side panel
31	216-055-666	216-055-666	Triac Relay
32	NLA	880-431-000	Base
33		246-428-000 , 880-426-000	Thermal protector
34	NLA	412-635-010	Tank bracket

Not Shown

34	334-468-666	334-468-666	Liner for mig gun with RED trigger
35	KP1937-3	334-476-666	Liner for mig gun with BLACK trigger
36	334-460-001	334-460-001	Regulator
37	S26399-28	059-217-040	5/32" gas hose
38	KP11-25, KH710	43090, 334-203-300, KP2039-1B1, M15522	0.025 Contact Tips
39	KP11-30, KH711	43100, 334-160-300, KP2039-2B1, M15523	0.030 Contact Tips
40	KP11-35, KH712	43110, 334-161-300, KP2039-3B1, M15524	0.035 Contact Tips
41	KP21T-50	43480, 334-203-300, KP1942-1, M15578	Steel welding nozzle
42	312-110-666	312-110-666	Wire spool adapter
43	K910-1	41007, 239-292-666	Ground Clamp
44	KH600		Helmet

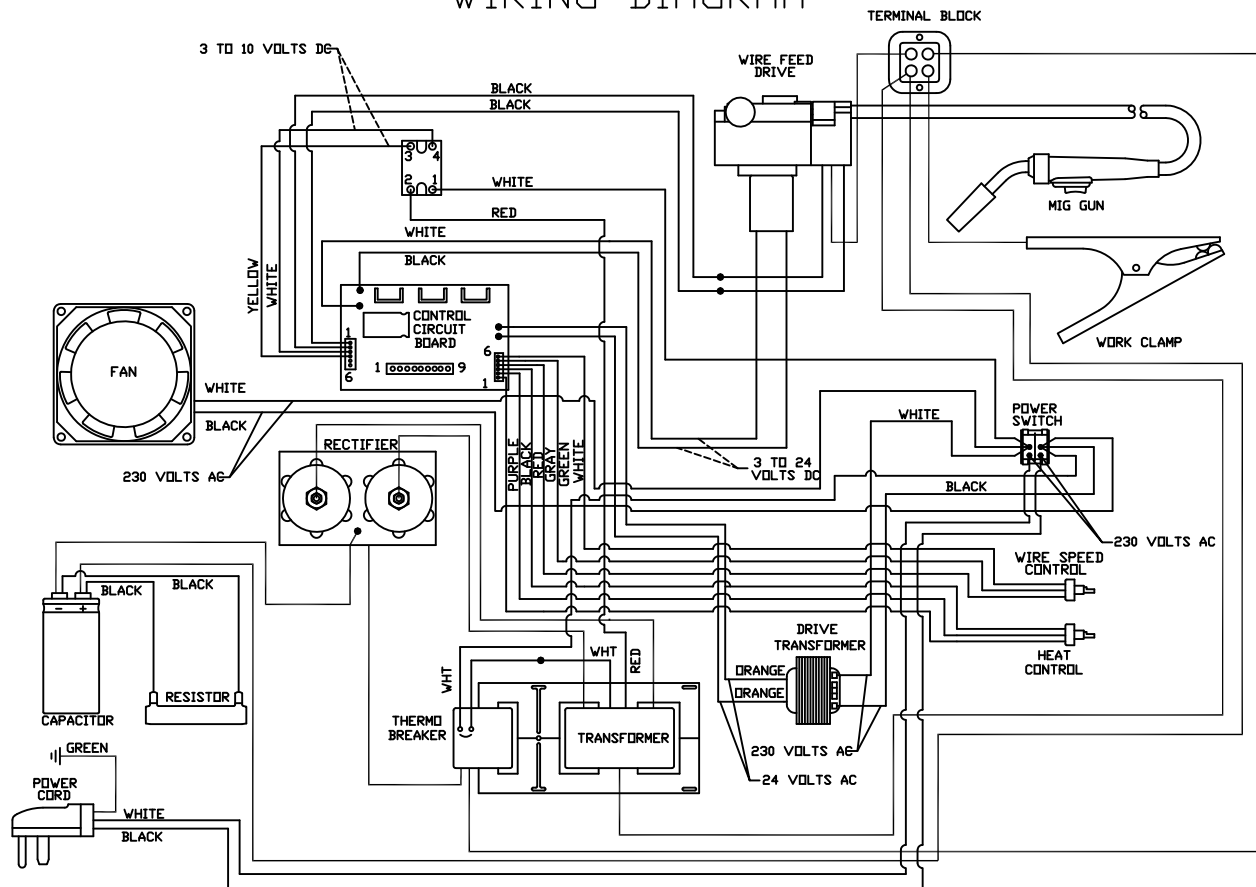
9/8/2010

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
117-079	230V	50A	30%

Rated Output	Voltage Settings	Agency Listing	Output
130 amps	Infinite	Cul	30-170 amps

117-079,2185,83170,83171, M02185, 170 GL/GS

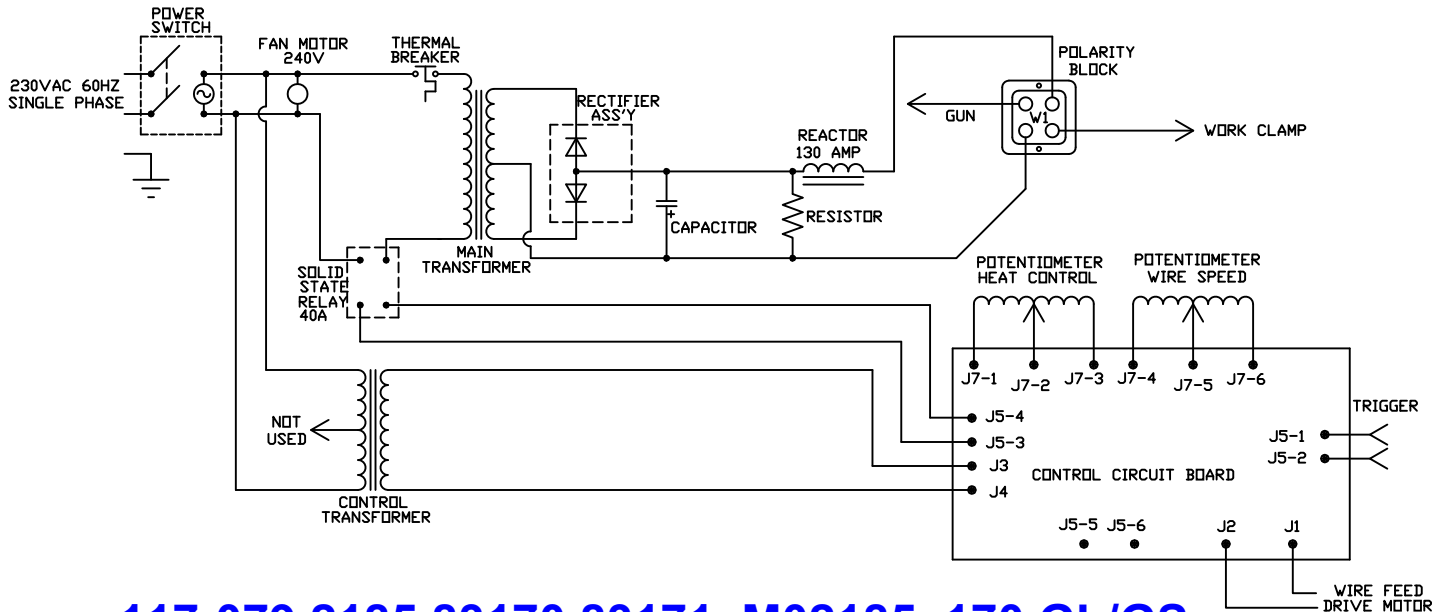
WIRING DIAGRAM



NOTES:

-----: VOLTAGES ARE PRESENT ONLY WHEN TRIGGER IS PULLED.

-----: VOLTAGES ARE PRESENT WHEN MAIN POWER IS ON.



117-079,2185,83170,83171, M02185, 170 GL/GS

RECOMMENDED WELDING SETTINGS

These are recommendations only - variations in input power, welding positions, wire, and gas will affect the weld characteristics. Thicker metals can be welded with beveling and multiple passes. Use the voltage setting indicated as a starting point - then tune in the wire speed to give a smooth welding arc.

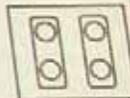
PROCESS	WELDING WIRE TYPE	SHIELDING GAS	WIRE DIAMETER	Steel Thickness (see Operating Guide for other metals)						
				VOLTAGE SETTING						
				24 ga. .024 in. .6 mm	22 ga. .030 in. .8 mm	18 ga. .048 in. 1.2 mm	14 ga. .075 in. 2.0 mm	3/16 in. 5.0 mm	1/4 in. 6.0 mm	5/16 in. 8.0 mm
MIG* GMAW DC+	Solid Steel E70S-6	C-25 25% CO ₂ 75% Argon	.024 in. .6 mm	1-2	2	2				
			.030 in. .8 mm			2	3	4		
			.035 in. .9 mm				3	4	6	8
GASLESS FLUX CORED FCAW DC-	Self Shielding Flux Cored E71T-GS	None	.030 in. .8 mm			2	3	5	5	7
			.035 in. .9 mm			2	3	5	5	7

* MIG welding requires the use of a compressed gas regulator (optional on some models)

Metal Thickness

To change the welder polarity set jumpers as shown below:

DC+
MIG



DC-
Flux
Cored



Read all instructions and warnings supplied with this welder before attempting to use or service it. Also read all warnings and cautions on the welder.
If you need assistance, call MIG Welder Service at 1-800-328-2921.

CAUTION:

- Pinch points exist around the edge of the welder hood, use caution when hood is raised.
- Make sure welding wire is installed completely into gun liner.



Proper wire direction from spool

170GL

CENTURY 170GL

WIRE FEED WELDER PART NO. 83171

- ✓ Welds from 18 gauge steel up to 5/16 inch on a single pass - thicker with multiple passes.
- ✓ Infinite voltage control selection - pick any heat needed for the job.
- ✓ Uses flux cored steel welding wire for welding without shielding gas - can be converted to gas shielded (MIG) welding with optional kit.
- ✓ Handles .030 or .035 inch welding wires.

MODEL 117-079	SPECIFICATIONS
OUTPUT	130 ADC, 20.5 VDC, 30% DUTY CYCLE, MAX OCV 34 VDC
INPUT	230VAC, 20 AAC, 1Ø, 60 Hz.





POWER

OFF



ON



WIRE SPEED



VOLTAGE

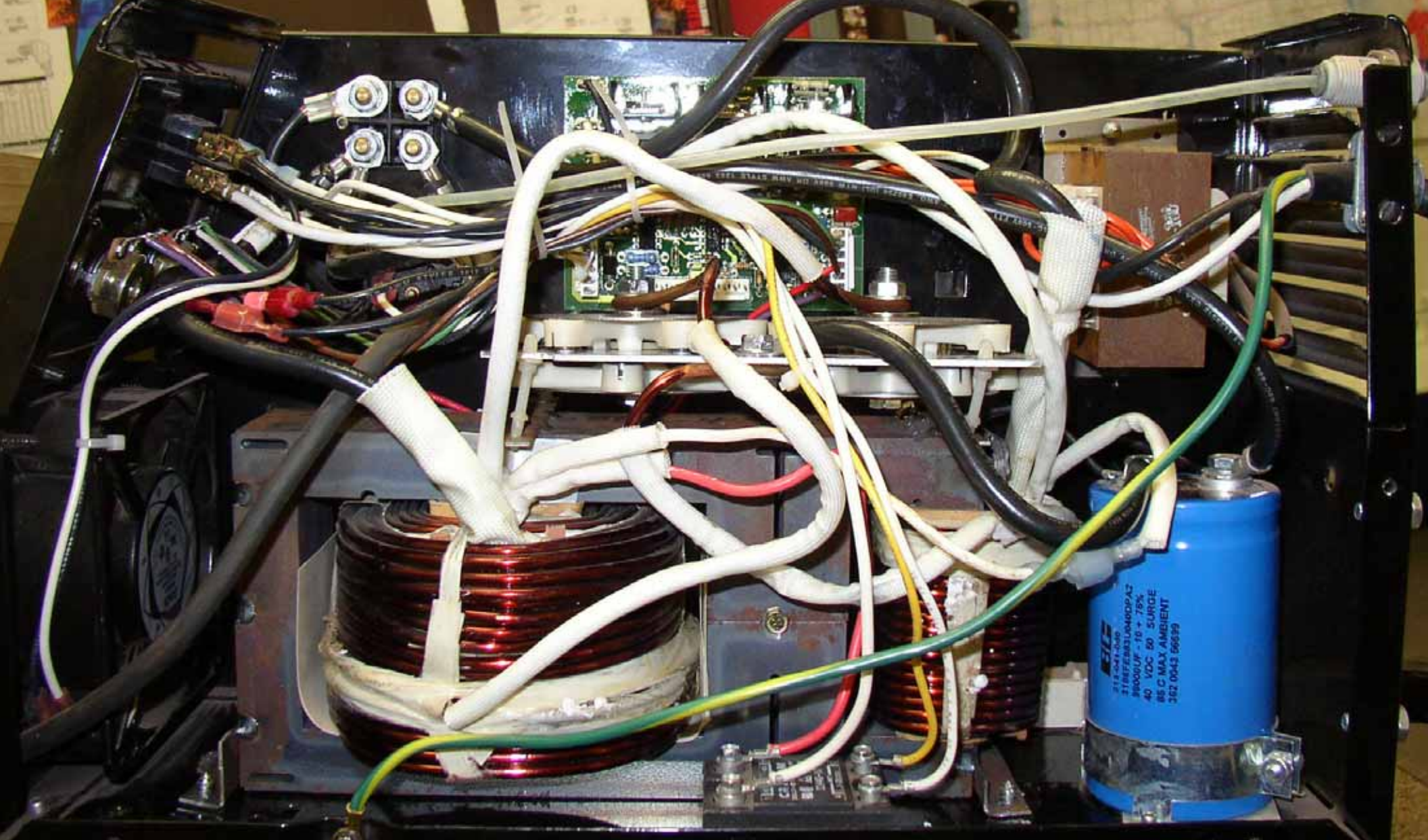
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117-079,2185,83170,83171, M02185, 170 GL/GS





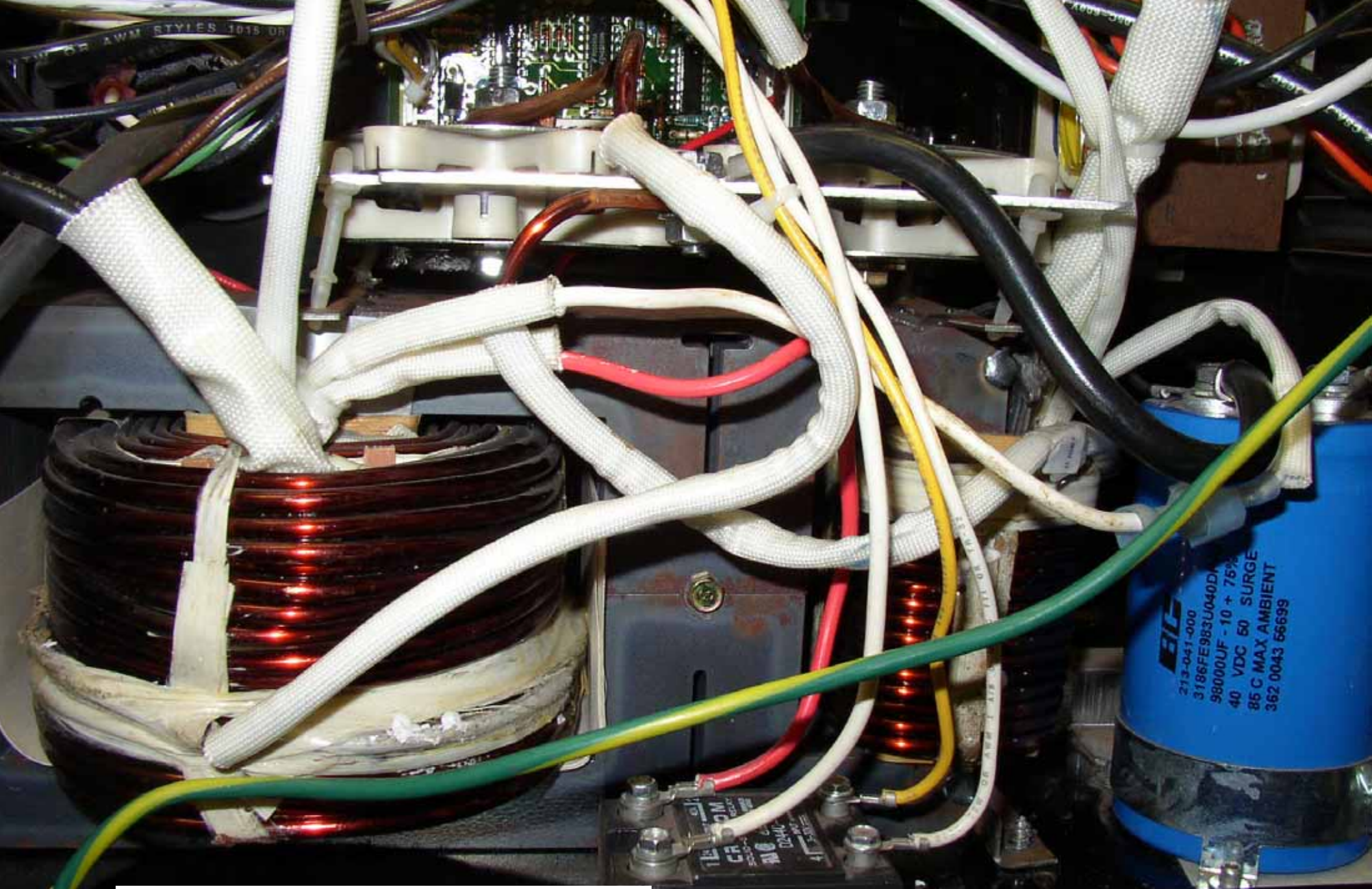
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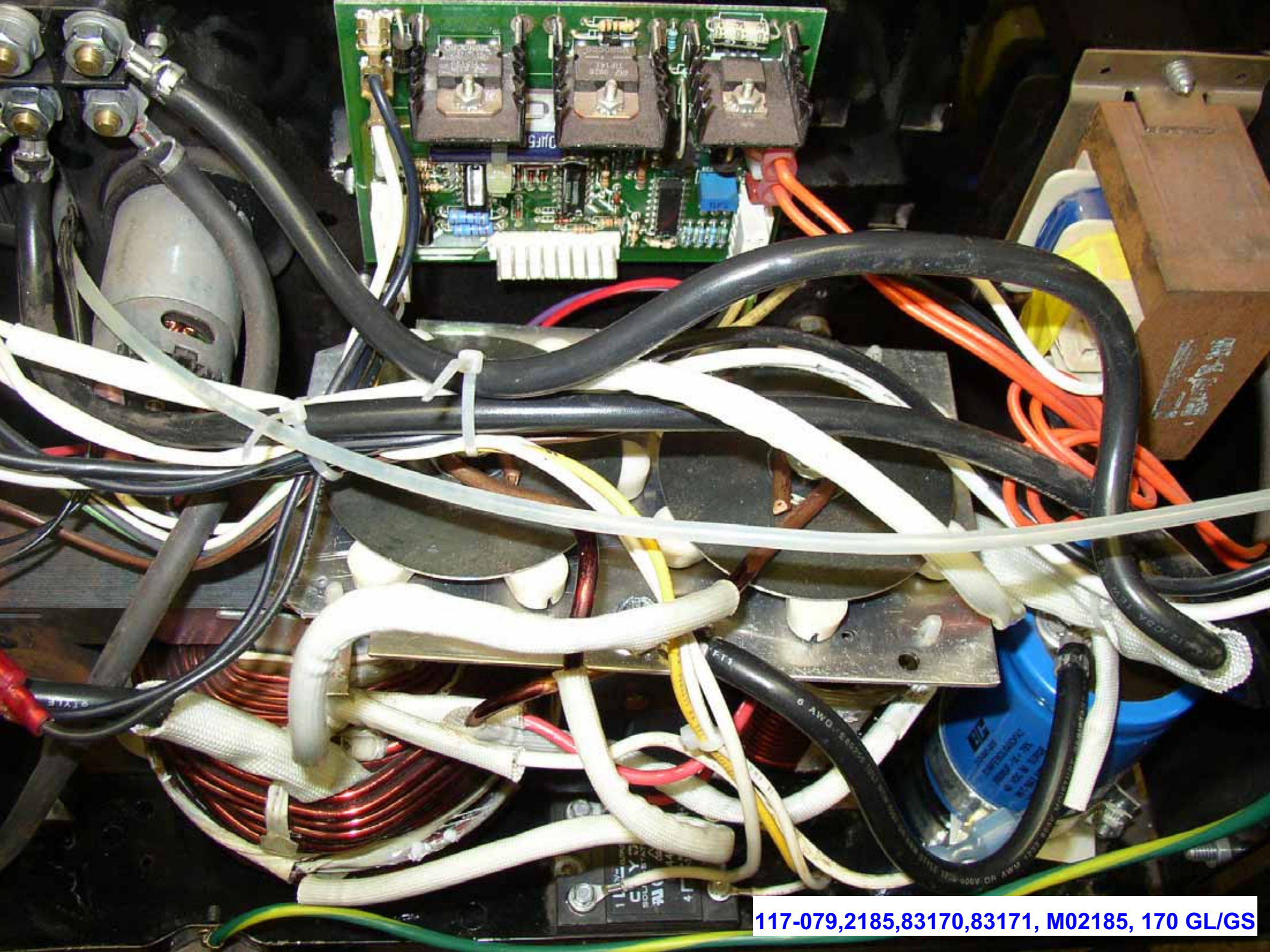
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