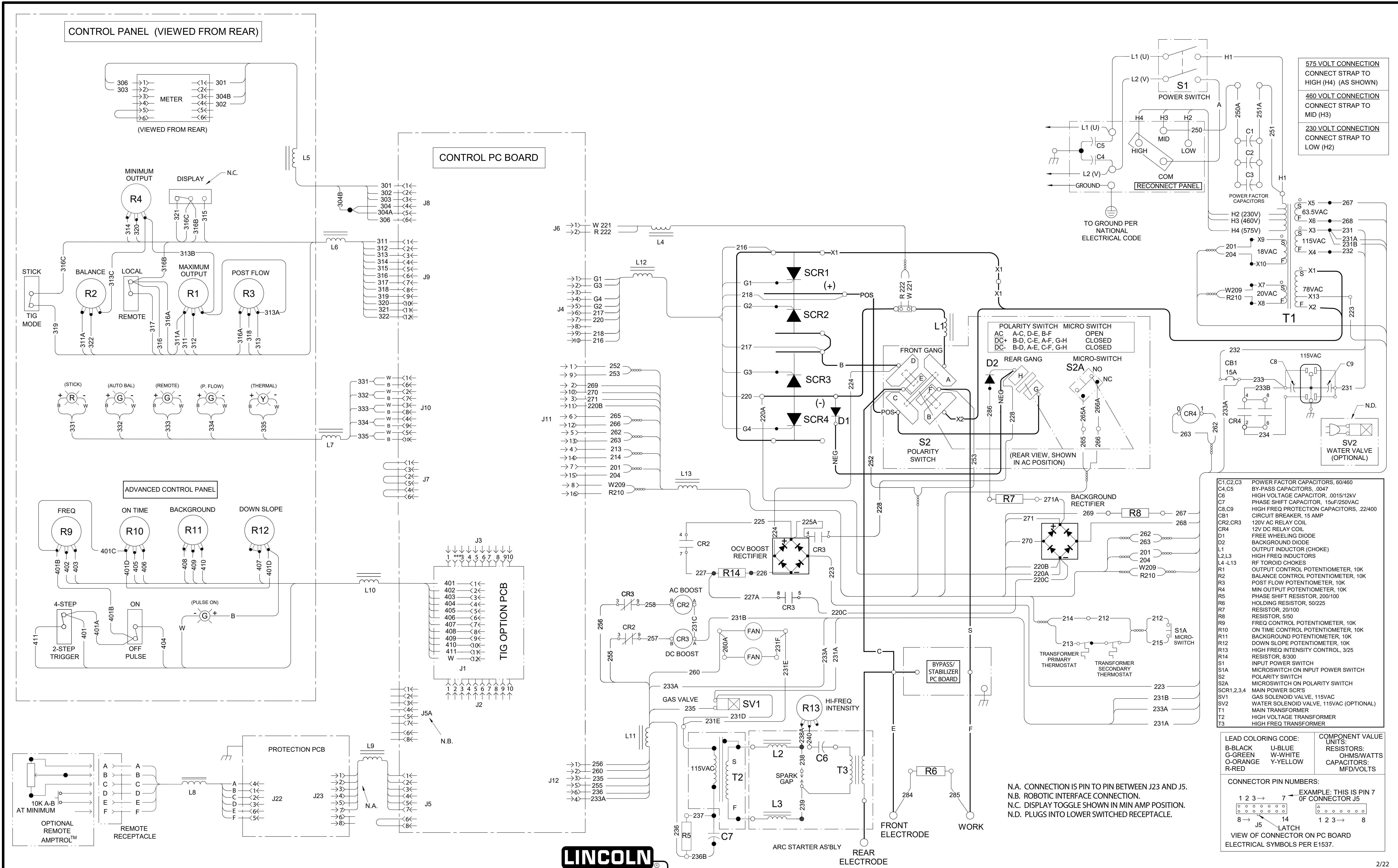


PRECISION TIG 375 WIRING DIAGRAM G4047-1 REV: A



575 VOLT CONNECTION  
CONNECT STRAP TO HIGH (H4) (AS SHOWN)

460 VOLT CONNECTION  
CONNECT STRAP TO MID (H3)

230 VOLT CONNECTION  
CONNECT STRAP TO LOW (H2)

- C1, C2, C3 POWER FACTOR CAPACITORS, 60/460
- C4, C5 BY-PASS CAPACITORS, .0047
- C6 HIGH VOLTAGE CAPACITOR, .0015/12KV
- C7 PHASE SHIFT CAPACITOR, 15uF/250VAC
- C8, C9 HIGH FREQ PROTECTION CAPACITORS, 22/400
- CB1 CIRCUIT BREAKER, 15 AMP
- CR2, CR3 120V AC RELAY COIL
- CR4 12V DC RELAY COIL
- D1 FREE WHEELING DIODE
- D2 BACKGROUND DIODE
- L1 OUTPUT INDUCTOR (CHOKE)
- L2, L3 HIGH FREQ INDUCTORS
- L4 - L13 RF TOROID CHOKES
- R1 OUTPUT CONTROL POTENTIOMETER, 10K
- R2 BALANCE CONTROL POTENTIOMETER, 10K
- R3 POST FLOW POTENTIOMETER, 10K
- R4 MIN OUTPUT POTENTIOMETER, 10K
- R5 PHASE SHIFT RESISTOR, 200/100
- R6 HOLDING RESISTOR, 50/225
- R7 RESISTOR, 20/100
- R8 RESISTOR, 5/50
- R9 FREQ CONTROL POTENTIOMETER, 10K
- R10 ON TIME CONTROL POTENTIOMETER, 10K
- R11 BACKGROUND POTENTIOMETER, 10K
- R12 DOWN SLOPE POTENTIOMETER, 10K
- R13 HIGH FREQ INTENSITY CONTROL, 3/25
- R14 RESISTOR, 8/300
- S1 INPUT POWER SWITCH
- S1A MICROSWITCH ON INPUT POWER SWITCH
- S2A POLARITY SWITCH
- S2 MICROSWITCH ON POLARITY SWITCH
- SCR1, 2, 3, 4 MAIN POWER SCRS
- SV1 GAS SOLENOID VALVE, 115VAC
- SV2 WATER SOLENOID VALVE, 115VAC (OPTIONAL)
- T1 MAIN TRANSFORMER
- T2 HIGH VOLTAGE TRANSFORMER
- T3 HIGH FREQ TRANSFORMER

LEAD COLORING CODE:

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

COMPONENT VALUE UNITS:  
RESISTORS: OHMS/WATTS  
CAPACITORS: MFD/VOLTS

CONNECTOR PIN NUMBERS:

EXAMPLE: THIS IS PIN 7 OF CONNECTOR J5

VIEW OF CONNECTOR ON PC BOARD  
ELECTRICAL SYMBOLS PER E1537.

N.A. CONNECTION IS PIN TO PIN BETWEEN J23 AND J5.  
N.B. ROBOTIC INTERFACE CONNECTION.  
N.C. DISPLAY TOGGLE SHOWN IN MIN AMP POSITION.  
N.D. PLUGS INTO LOWER SWITCHED RECEPTACLE.

