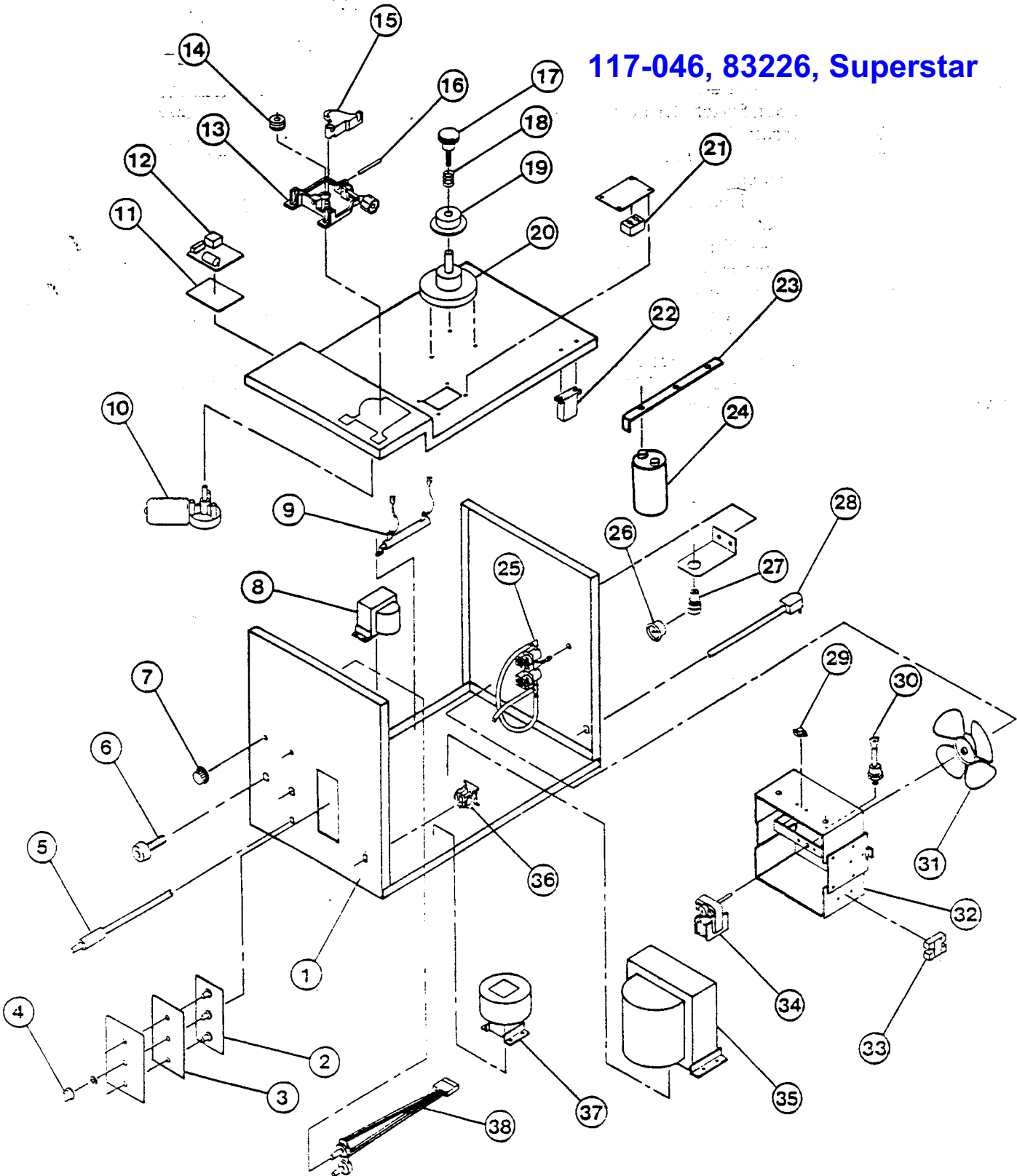


117-046, 83226, Superstar



117-046, 83226, Superstar, Cutting Mig

Item	Lincoln Stock #	Customer #	Description
1	NLA	410-604-076	Front panel
2	880-114-666	880-114-666	Spot-Stitch circuit board
3	NLA	512-106-666	Insulation
4		246-094-000	Knob, 1"
5		238-193-000	Jumper assy.
6	312-045-666	312-045-000	Receptacle, panel mount
7		246-095-000	Knob, 1.5"
8		880-041-888	Control Transformer, 230Vac to 24Vdc, 6 amp
9		880-158-666	Bleeder Resistor
10		216-079-666	Drive Motor w/gearbox
11	NLA	512-041-666	Insulation
12	880-113-666	880-292-008	Main Circuit Board
13	880-130-666	880-130-666	Drive base assembly (includes 13,15 & 16)
14	310-122-500	4323, 33805071	0.025 / 0.030 / 0.035 Steel Drive Roller
	541-276-666	33805005	0.040 / 0.045 Steel Drive Roller
		310-154-000	Drive roller 0.045 serrated
15	Included with #13	312-107-000	Tension arm only
16	Included with #13	239-208-000	Inlet guide tube
17	Included with #20	246-215-666	Tensioner knob only (no spring or washer)
18	Included with #20	330-029-000	Spool Tensioner Spring
19	312-110-666	541-083-000	Spool adapter
20	312-066-666	860-575-100	Spindle
21		239-057-000	Terminal Block
22		246-216-666	Relay
23	NLA	412-202-666	Buss Bar
24	213-018-666	213-018-666	Capacitor, 45,000mf, 45Vdc
25	Order Individual Solenoids	880-121-666	Solenoid Valve Assy. (includes (2) 246-086-666 solenoids)
	246-086-666	246-086-666	Solenoid only
26		251-002-666	Air Pressure Gauge
27	254-004-666	254-003-666	Air Regulator
28	S13699-8	248-178-666, 248-289-000	Power Cord, 8/3, 8.5' w #10 Spade(2) & #10 Ring Term.

Item	Lincoln Stock #	Customer #	Description
29	216-053-666	216-053-666	Thermostat
30	244-070-666	244-070-666	Diode
31	316-010-000	316-010-000	Fan blade
32	NLA	860-039-000	Fan shroud/heat sink assy.
33	216-062-666	216-062-000	Triac Relay, 75 amp
34	216-099-666	216-085-666	Fan motor
35		880-040-888	Main weld transformer
36	216-010-666	216-010-666	Power switch
37		860-772-888	Reactor coil
38	880-052-666	880-052-666	Heat & wire speed harness w/ potentiometers

Not Shown

39	238-393-000	4365	12' Mig Gun
40	238-296-666		15' Mig Gun
41	KP21T-50	43480, 334-203-300, KP1942-1, M15578	Steel welding nozzle
42	KP21T-62	43300, 334-210-300, KP1942-3	Aluminum welding nozzle
43	KP21-62-FAS	43290, 334-211-300, KP1956-1, M15577	Spot welding nozzle
44	KP1939-1, KH726		Flux Core Nozzle
45	KP11-25, KH710	43090, 334-203-300, KP2039-1B1, M15522	0.025 Contact Tips
46	KP11-30, KH711	43100, 334-160-300, KP2039-2B1, M15523	0.030 Contact Tips
47	KP11-35, KH712	43110, 334-161-300, KP2039-3B1, M15524	0.035 Contact Tips
48	KP11-45, KH713	43390, 334-202-300, KP2039-4B1, M57242	0.045 Contact Tips
49	334-363-000	90708	Gas Diffuser
50	334-255-000	96KL-R	Trigger
51	KP44-3545-15	334-375-000, 4370, KP1933-1	Steel Liner
52	KP42N-3545-15	334-376-000, 4368, KP1955-1	Teflon Liner
53			
54		238-009-500	Ground cable w/plug & clamp, 12'
55	239-292-666	41001	Ground clamp
56		246-103-000	Hood handle
57	334-303-001	334-286-666	Regulator
58	059-245-666		Gas hose

Made from 9-8-88 (C733177) until 7-15-91 (D289854) - 884

12/31/2008

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
117-046	208/230V, 44A/40A	50A	60%

Rated Output	Voltage Settings	Agency Listing	Max Output
225 amps	Infinite	CSA	250 amps

Model 117-046 (83226) Super Star

Quick Reference Guide for Cutting

DO NOT ATTEMPT TO CUT OR GOUGE UNTIL READING THE SAFETY INSTRUCTIONS AND CUTTING INSTRUCTIONS SECTIONS OF THE OPERATORS MANUAL. THIS IS A QUICK REFERENCE GUIDE AND IS NOT INTENDED TO REPLACE THE NEED TO READ THE OPERATOR'S MANUAL

SET-UP

1. Provide clean, dry compressed air to the air regulator on the welder; a minimum of 7.8 CFM at 60 PSI with a maximum pressure to the air regulator of 120 PSI. Then connect the quick-coupler, on the short hose on the air regulator, to the air fitting on the rear of the welder.
2. Install the special cutting nozzle, tapered contact tip, teflon gun liner, 0.045" drive roller, and 0.045 self-shielding flux core wire.
3. Pull the gun trigger, and set the air pressure on the air regulator to between 60 and 75 PSI.

SETTINGS

DO NOT CONTINUE UNLESS YOU AND ALL BYSTANDERS HAVE ALL NECESSARY PROTECTIVE DEVICES FOR EYES, HEARING, AND CLOTHING (as outlined in the SAFETY INSTRUCTIONS section of the operator's manual) in place.

1. Set the MODE switch to CONTINUOUS and the HEAT SELECTOR to the appropriate setting on the cutting range scale for the thickness of metal to be cut, and the WIRE SPEED control to the center of the CUTTING RANGE scale.
2. Fine-Tune the wire speed and heat settings according to the procedure detailed under OPERATING in the CUTTING INSTRUCTIONS section of the manual.
3. Bring nozzle in contact with the work piece and hold the gun so the nozzle is at a 45 degree angle to the work piece.
4. Start the cut at the point farthest away from you and PULL the gun towards you while cutting.
5. Travel at the fastest speed that still allows the arc time enough to burn through the entire thickness of the work piece.
6. Example: Making an 8" cut on 18 to 22 gauge sheet metal takes about 2 - 3 seconds.

SETTINGS (Metals heavier than 1/8")

Method #1

1. Set the MODE switch to STITCH, WELD TIME control to #4 and STITCH-OFF TIME control to #2.
2. Change the angle of the nozzle to the work piece to between 75 and 80 degrees up from the work piece.
3. Try to maintain a gap of about 1/4" between the nozzle and work piece, and travel at a slower speed than when cutting sheet metal.

Method #2

1. Set the MODE switch to CONTINUOUS.
2. Use a nozzle angle to the work piece of 75 to 80 degrees up from the work piece and drag the nozzle along the work piece.
3. Travel at a slow rate of speed, but rock the gun up and down while traveling to vary the nozzle to work piece angle from 70 to 85 degrees.

SETTINGS (for gouging metal)

1. Set the MODE switch to CONTINUOUS, the WIRE SPEED to 2 1/2 or 3, and the HEAT to maximum.
2. Decrease the air pressure to about 30 PSI.
3. Use a gun angle of about 30 degrees up from the work piece. Start gouging closest to you and use a PUSHING direction of travel. Keep the top of the arc slightly higher than the top surface of the metal being gouged.