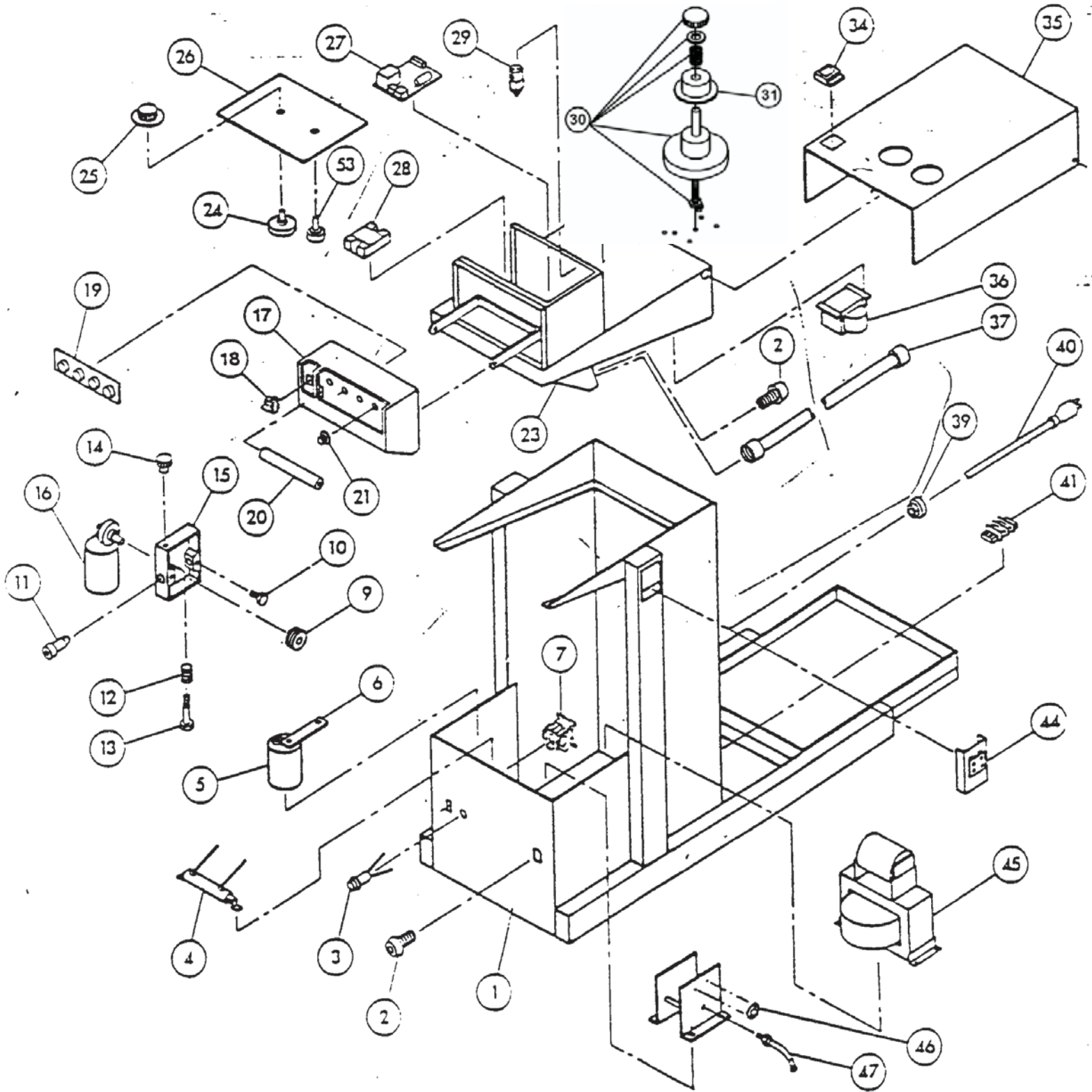


117-012, YA205



117-012, YA205

Item	Lincoln Stock #	Customer #	Description
1	NLA	410-746-010	Front panel
2	312-045-666	312-045-000	Receptace, panel mount
3		245-078-666	Indicator light, 230Vac, amber
4		860-523-000	Resistor assy., 25Ω, 50 watt
5	213-018-666	213-018-200	Capacitor, 45,000mf, 45Vdc
6	Use 5", #3 cable w/ 9/32" Lugs	410-190-000	Buss bar
7	216-042-666	216-042-000	Power Switch, 230Vac, 40a
9	310-122-500	4323	Drive roller, 0.024 / 0.030 / 0.035
	860-616-002	4324	Drive roller, neoprene
10	Std. Hdwe.	083-107-000	Screw, M6-1 x 3/4" hex head
11	NLA	410-325-000	Inlet guide tube
12	NLA	330-025-000	Drive tension spring
13	NLA	246-114-000	Drive tension screw
14	NLA	246-160-000	Drive tension knob
15	NLA	860-803-666	Drive assembly
16		216-079-666, 860-581-100	Drive motor, 24Vdc
17	NLA	860-673-000	Plastic nose
18	NLA	216-077-000	Momentary paddle switch
19	860-489-666	860-489-000	Spot stitch board
20	NLA	246-161-666	Handle
21		246-127-666	Knob, 1"
23	NLA	860-644-000	Undercarriage w/connections
24		246-052-666	Switch, 9 position
25		246-158-666	Knob, 2.75"
26	NLA	410-404-020	Drive box top
27	860-614-666	860-614-666	Main circuit board w/ transistor
28	216-055-666	216-055-666	Triac Relay, 40 amp
29	246-212-666	246-212-666	Gas solenoid
30	312-066-666	312-066-666	Spindle assy. less spool adapter
31	312-110-666	312-110-666	Spool Adapter
34	NLA	312-042-666	Slide latch

Made from 7-18-83 to 4-28-86 - 8021

Item	Lincoln Stock #	Customer #	Description
35	NLA	860-984-666	Hood w/latch & labels
36		880-041-888	Drive transformer 230Vac - 24Vac
37		860-871-000	Umbilical cord, 3'
39	NLA	541-020-000	Strain relief
40		248-164-000	Power cord, 30'
41	NLA	239-094-000	Terminal block
44	NLA	860-627-666	Drive head lock assy.
45	NLA	830-639-888	Main weld transformer
46	NLA	246-121-666	Thermostat, stemco 402, open 200F, close 180F
47	214-004-666	214-004-666	Diode

Not Shown

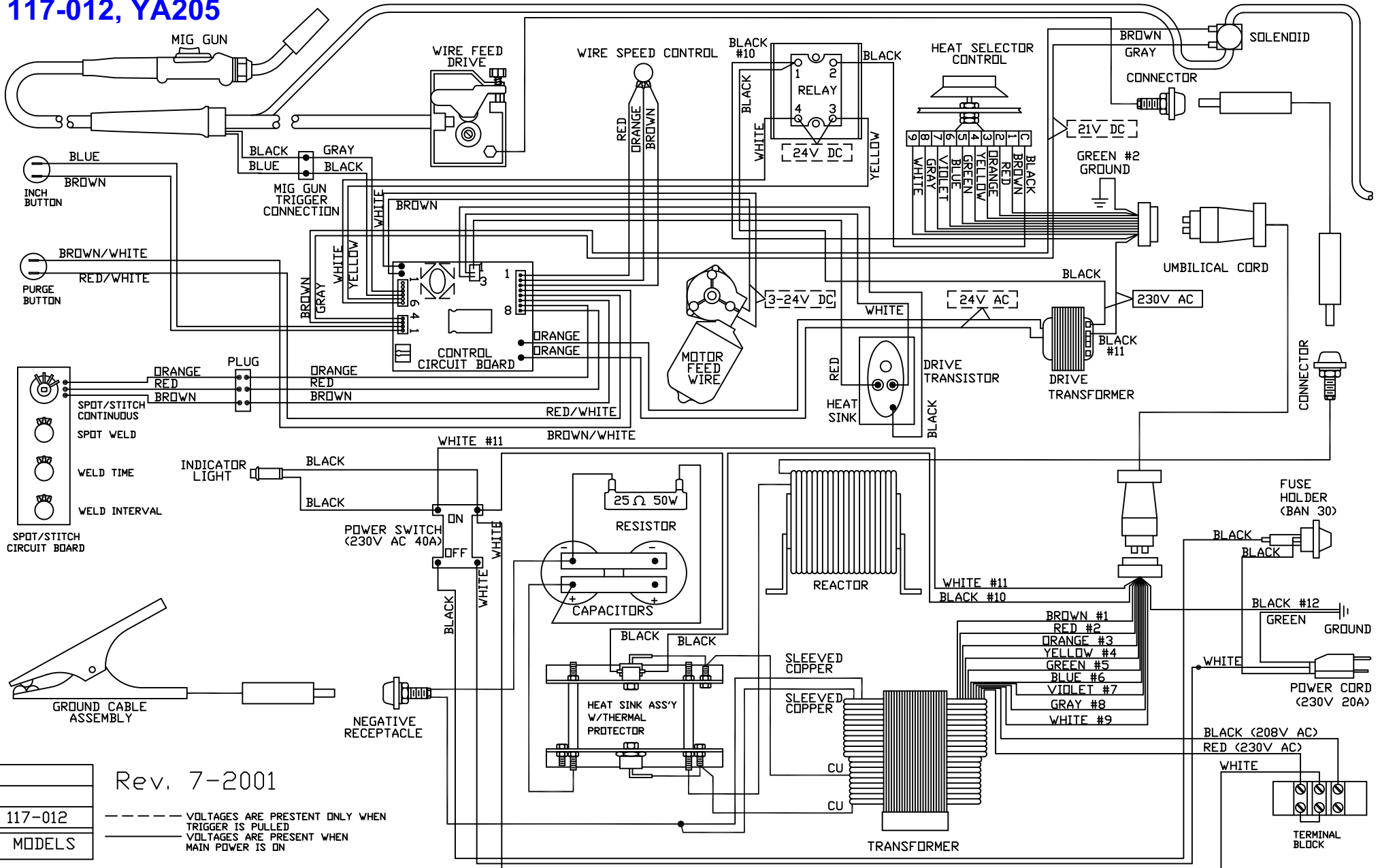
48a		238-009-500	Ground cable w/plug & clamp, 12'
48b	239-052-908	40310	Male Plug for Ground Cable only
48c	239-292-666	4100	Ground Clamp only
50	NLA	512-046-666	Rubber mat
51		245-060-000	Fuse, BAN30 or BLN30
53		246-120-000	Potentiometer, 5k, 1/4 watt
54		860-870-100	Umbilical cord, 20'
55	238-155-000	4320	Mig gun assembly, 10'
56	KP21T-50	43480, 334-203-300, KP1942-1, M15578	Steel welding nozzle
57	KP21T-62	43300, 334-210-300, KP1942-3	Aluminum welding nozzle
58	KP21-62-FAS	43290, 334-211-300, KP1956-1, M15577	Spot welding nozzle
59	KP11-25, KH710	43090, 334-159-300, KP2039-1B1, M15522	0.025 Contact Tips
60	KP11-30, KH711	43100, 334-160-300, KP2039-2B1, M15523	0.030 Contact Tips
61	KP11-35, KH712	43110, 334-161-300, KP2039-3B1, M15524	0.035 Contact Tips
62	334-303-001	334-286-666	Gas regulator
63	059-245-666	059-089-000	Gas hose
64		079-127-000	Base socket
65		079-136-666	Pins for base socket (13)
66		079-140-000	Keying pins (need 2)
67		860-647-666	Head harness

1/27/2011

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
117-012	230V, 20A	NEMA 6-15P	20%

Rated Output	Voltage Settings	Agency Listing	Max Output
130 amps	9	CSA	130 amps

117-012, YA205

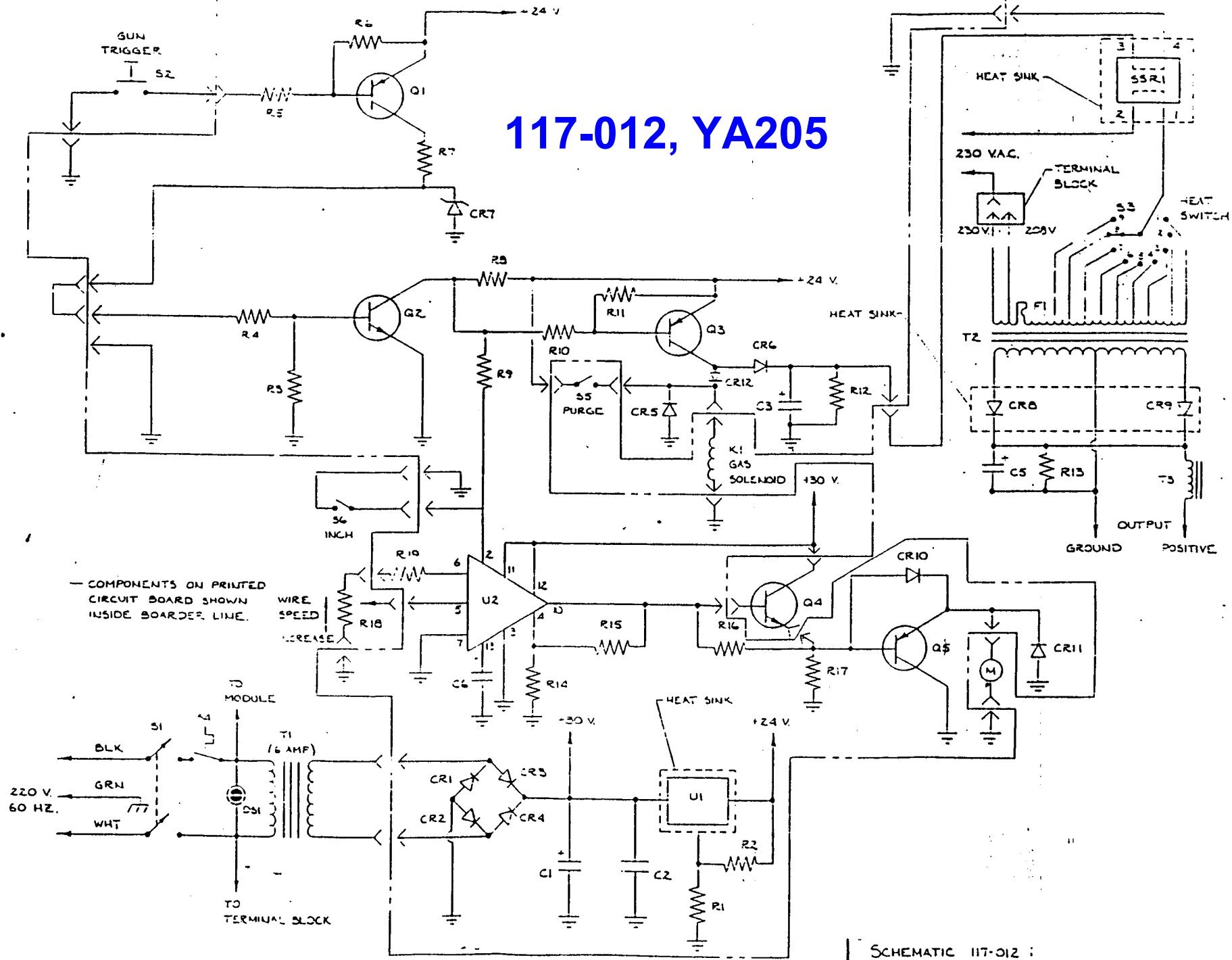


Rev. 7-2001

117-012
MODELS

--- VOLTAGES ARE PRESENT ONLY WHEN TRIGGER IS PULLED
 — VOLTAGES ARE PRESENT WHEN MAIN POWER IS ON

117-012, YA205



117-012, YA205 Schematic Legend

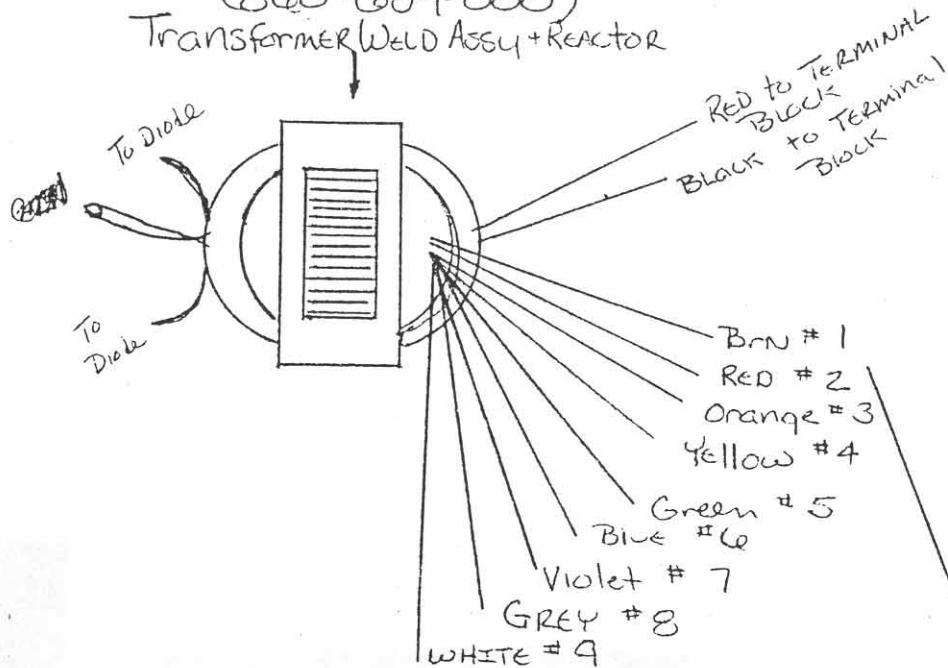
Symbol Description

C1	3,500 μ f, 50v, Electrolytic Capacitor
C2	0.01 μ f, 50v, Disc Capacitor
C3	47 μ f, 50v, Electrolytic Capacitor
C5	90,000 μ f, 45v, Electrolytic Capacitor
C6	0.01 μ f, 50v, Disc Capacitor
CR1	4004
CR2	4004
CR3	4004
CR4	4004
CR5	1N4006
CR6	1N4006
CR7	Zener Diode, 6V
CR8	Diode, 150 amp, 300PIV
CR9	Diode, 150 amp, 300PIV
CR10	4004
CR11	MR502
CR12	1N4006
DS1	220v neon light
F1	One shot, 240 degrees celsius open
K1	Gas Solenoid, 24vdc coil
Q1	2N5193 Transistor
Q2	2N2222 Transistor
Q3	2N5193 Transistor
Q4	2N3055 Transistor
Q5	MJ900 or MJ901 Transistor
R1	Resistor, 3.9K Ω , 1/2 watt
R2	Resistor, 220 Ω , 1/2 watt
R3	Resistor, 470 Ω , 1/2 watt

Symbol Description

R4	Resistor, 1K Ω , 1/2 watt
R5	Resistor, 1K Ω , 1/2 watt
R6	Resistor, 47 Ω , 1/2 watt
R7	Resistor, 1.2K Ω , 1/2 watt
R8	Resistor, 2.2K Ω , 1/2 watt
R9	Resistor, 56K Ω , 1/2 watt
R10	Resistor, 1K Ω , 1/2 watt
R11	Resistor, 47 Ω , 1/2 watt
R12	Resistor, 1.5K Ω , 1/2 watt
R13	Resistor, 25 Ω , 50 watt
R14	Resistor, 1K Ω , 1/2 watt
R15	Resistor, 4.7K Ω , 1/2 watt
R16	Resistor, 47 Ω , 1/2 watt
R17	Resistor, 4.7 Ω , 1/2 watt
R18	5K Ω , 1W potentiometer
R19	Resistor, 2.7K Ω , 1/2 watt
S1	DPST, Main Power Switch
S2	SPST, Gun Trigger
S3	9 Pole Rotary Switch
S4	Thermal Breaker, 200 degrees Celsius open
S5	SPST, Momentary Gas Purge
S6	SPST, Momentary Inch
SSR1	Triac Relay, D2440, 40 amp
T1	Control transformer, 230Vac to 24vac, 6 amp
T2	Weld transformer
T3	Reactor coil
U1	LM317T
U2	LM723CN

(860-639-888)
Transformer (WELD ASSY + REACTOR)



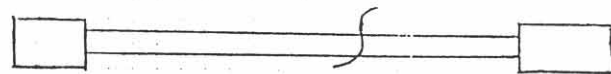
SNAPON
YA205

117-012, YA205 (Head Harness)

PIN #	COLOR
1	BRN
2	RED
3	ORG
4	YEL
5	GRN
6	BLU
7	VIO
8	GRY
9	WHT
10	BLK
11	WHT/BLK GRN/BLK

TO LOWER SOCKET
(079-127-000)

3F+ Umbilical Cord



860-647-000

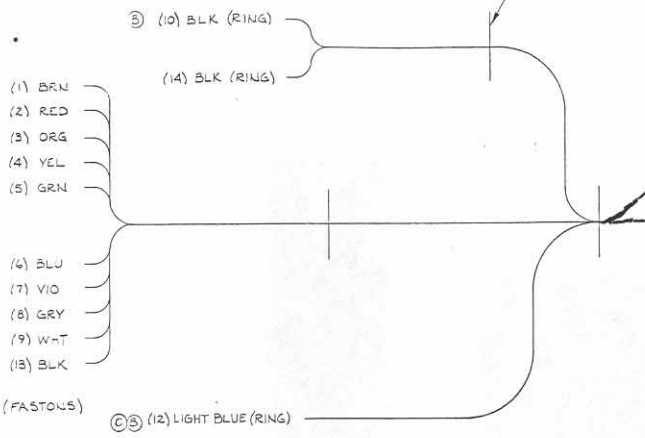
NOTE: NOS. CORRESPOND TO CONNECTOR POSITIONS.

- (1) BRN
- (2) RED
- (3) ORG
- (4) YEL
- (5) GRN
- (6) BLU
- (7) VIO
- (8) GRY
- (9) WHT
- (10) BLK
- (11) PINK
- (12) LIGHT BLUE

(B)(C)

079-126-000

(13) BLK (RING) (A)



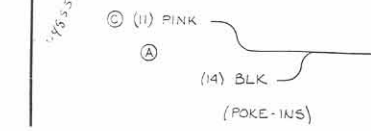
NO.	PART NUMBER	COLOR	SIZE	LENGTH
1	218-460-000	BRN	16 GA.	18"
2	218-461-000	RED	16 GA.	18"
3	218-462-000	ORG	16 GA.	18"
4	218-463-000	YEL	16 GA.	18"
5	218-464-000	GRN	16 GA.	18"
6	218-465-000	BLU	16 GA.	18"
7	218-466-000	VIO	16 GA.	18"
8	218-467-000	GRY	16 GA.	18"
9	218-468-000	WHT	16 GA.	18"
10	218-471-000	BLK	16 GA.	16"
11	218-470-000	PINK	18 GA.	21"
12	218-469-000	LIGHT BLUE	16 GA.	16"
13	218-472-000	BLK	16 GA.	15"
14	218-473-000	BLK	18 GA.	25"

117-012, YA205 (Head Harness)

SYM.	REVISION	DATE	BY
(C)	EN 11583	2-14-91	CEA
(B)	EN 5442	7-8-83	GD
(A)	EN 5438	7-8-83	AD

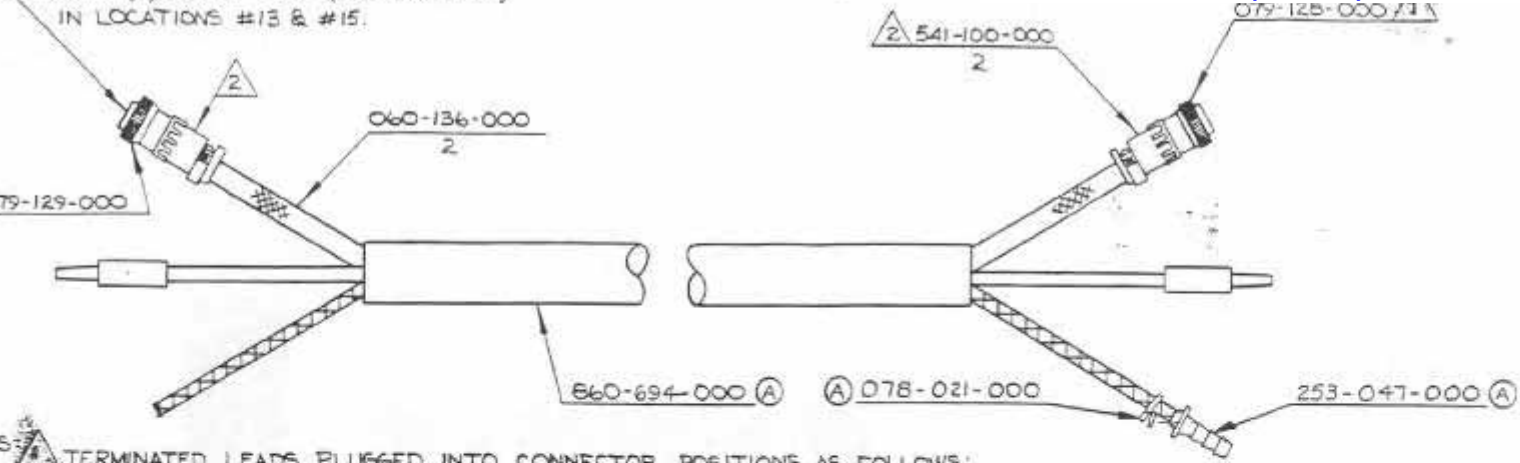
DO NOT SCALE
 USE DIMENSIONS SHOWN
 TOLERANCE UNLESS SPECIFIED:
 2 PLACE DECIMALS ± 0.10"

CENTURY MFG. CO. 9231 PENN AVE. SO. MINNEAPOLIS, MN 55431



860-870-000 (20') & 860-871-000 (3')
Used on 117-012 (YA205)

INSERT (2) KEYING PINS (079-140-000)
IN LOCATIONS #13 & #15.



NOTES: TERMINATED LEADS PLUGGED INTO CONNECTOR POSITIONS AS FOLLOWS:

CONN POSN.	COLOR
1	BROWN
2	RED
3	ORANGE
4	YELLOW
5	GREEN
6	BLUE
7	VIOLET
8	GRAY
9	WHITE
10	BLACK
11	PINK
12	LT. BLUE

(B)

SLEEVING TO BE FLUSH WITH CONNECTOR BEFORE TIGHTENING STRAIN RELIEF. STRAIN RELIEF MAY BE #3 OR #4.

M	(B)	EN 11588	2-25-91	CEA
M	(A)	EN 757G	3-10-86	SMM
	SYM.	REVISION	DATE	BY

DO NOT SCALE USE DIMENSIONS SHOWN TOLERANCES UNLESS SPECIFIED		CENTURY MFG. CO. 9231 PENN AVE. SO. MINNEAPOLIS, MN 55431	
DRW BY	MFF	DATE	12-5-85
CHK'D BY	SOB S.	DATE	12-6-85
APP'D BY	WJL	DATE	12-6-85
PTN CHG BY		SCALE	7337
TITLE		DRAWING NUMBER	
UNIVERSAL Core Ass'y. 20FT.		860-870-000	

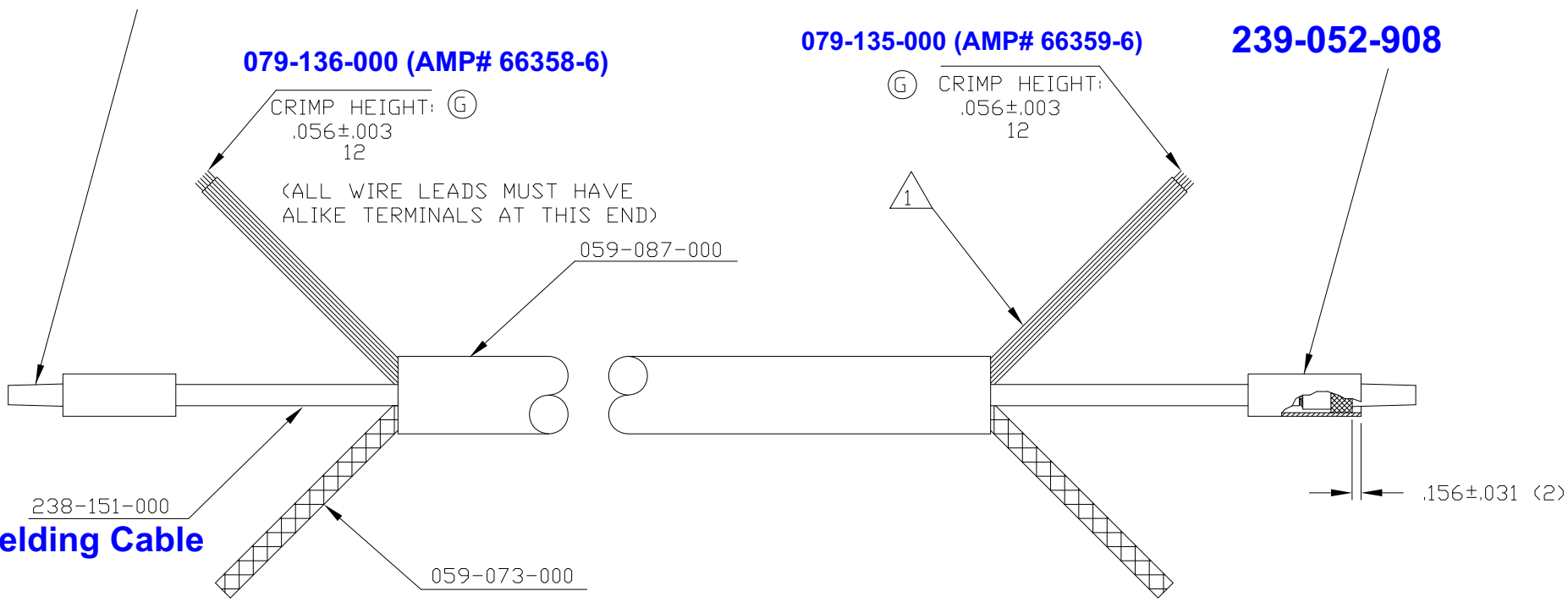
Used in 860-870-000 & on 117-012 (YA205)

239-052-908

079-136-000 (AMP# 66358-6)

079-135-000 (AMP# 66359-6)

239-052-908



#4 Welding Cable

3/16" ID braided gas hose (used on 860-870-000 (20' assy. only))

NOTE:

- 1 WIRE LEADS (12): 218-627-000, 218-628-000, 218-629-000, 218-630-000, 218-631-000, 218-632-000, 218-633-000, 218-634-000, 218-635-000, 218-636-000, 218-637-000, 218-638-000.

2. COIL AND WIRE TIE.

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		(F)	REDRAWN EN 12059	9-4-91	CEA
		SYM	REVISION	DATE	BY
DO NOT SCALE UNLESS SPECIFIED DIMENSIONS ARE IN INCHES	CENTURY MFG CO		9231 PENN AVE SD MPLS, MN 55431		
TOLERANCES UNLESS SPECIFIED DECIMALS: ±.015 FRACTIONS: ±1/64 ANGLES: ±0.5°	DWN BY CEA	DATE 9-4-91	MAT'L		
	DFT CHK				
	ENG CHK				
	ENG APPV JCW	9-16-91			
PREVIOUSLY RELEASED AS	APPV BRP	9-16-91	MAT'L NO		
P - REV -	SCALE NONE	RELEASE NO 5723	DATE ISSUED	DEPT CODE	
TITLE UMBILICAL CORD ASS'Y-20FT			DWG NO 860-694-000		

CONTINUOUS
SPOT **STITCH**

MODE

WELD TIME

4 **5** **6**

3

7

2

8

1

9

SPOT

WELD TIME

4 **5** **6**

3

7

2

8

1

9

STITCH

WELD INTERVAL

4 **5** **6**

3

7

2

8

1

9

STITCH