

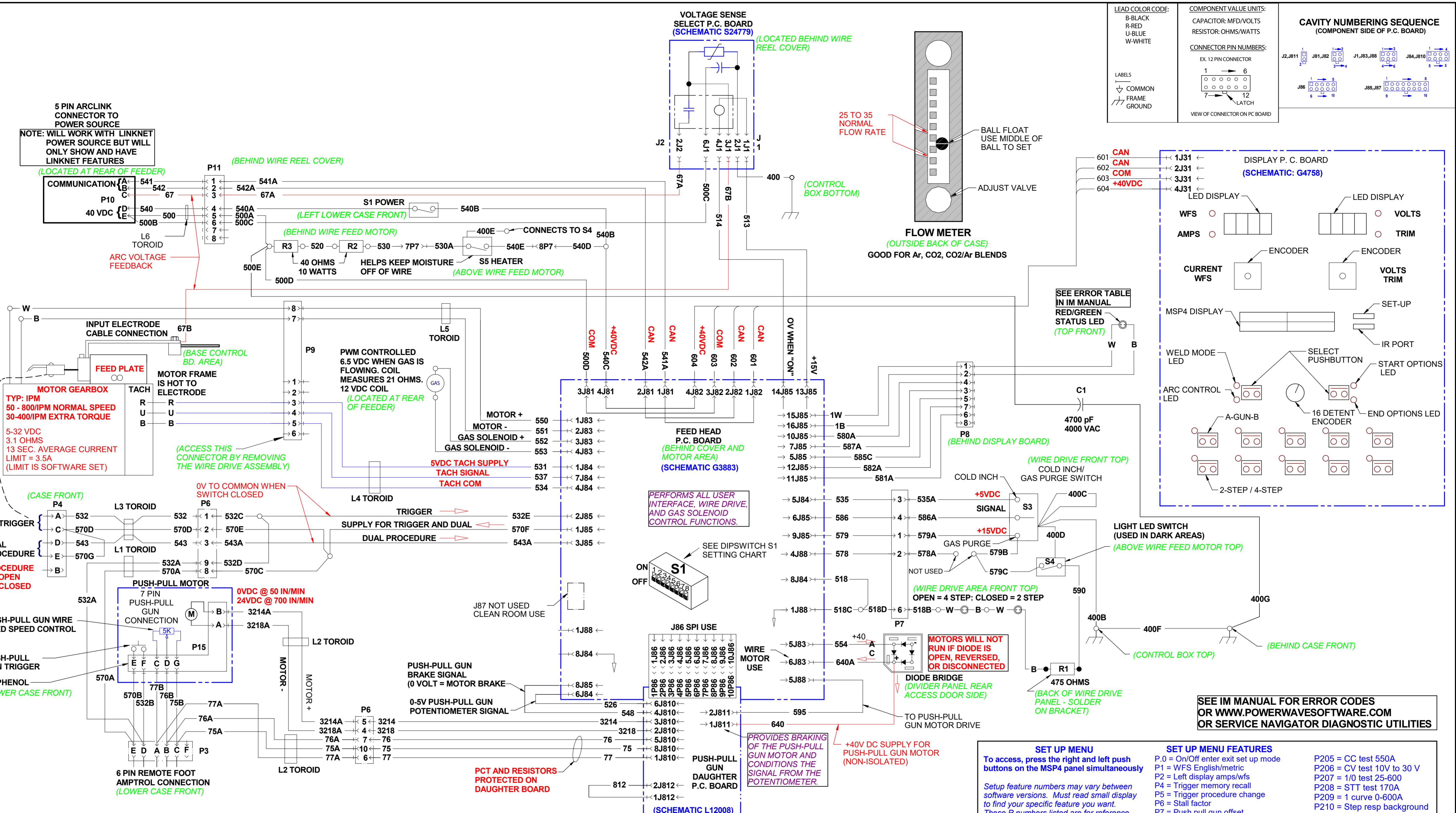
# POWER FEED 25M MACHINE SCHEMATIC G5638-1 REV: B

**LEAD COLOR CODE:**  
 B-BLACK  
 R-RED  
 U-BLUE  
 W-WHITE

**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  
 VIEW OF CONNECTOR ON P.C. BOARD

**CAVITY NUMBERING SEQUENCE (COMPONENT SIDE OF P.C. BOARD)**



**WELD MODES MAY VARY BASED UPON POWER SOURCE AND SOFTWARE**

GENERAL	STEEL	STAINLESS																																																																						
<table border="1"> <tr><td>STICK</td><td>SOFT (7018)</td><td>1</td></tr> <tr><td>STICK</td><td>CRISP (6010)</td><td>2</td></tr> <tr><td>CC TIG</td><td>TOUCH START</td><td>3</td></tr> <tr><td>GOUGE</td><td>---</td><td>9</td></tr> </table>	STICK	SOFT (7018)	1	STICK	CRISP (6010)	2	CC TIG	TOUCH START	3	GOUGE	---	9	<table border="1"> <tr><td>CO2</td><td>---</td><td>10</td><td>20</td><td>24</td></tr> <tr><td>Ar (MIX)</td><td>94</td><td>11</td><td>21</td><td>25</td></tr> <tr><td>PULSE (CRISP)</td><td>95</td><td>12</td><td>22</td><td>26</td></tr> <tr><td>PULSE (SOFT)</td><td>---</td><td>14</td><td>19</td><td>28</td></tr> <tr><td>STT (NO TAIL OUT)</td><td>109</td><td>109</td><td>125</td><td>125</td></tr> <tr><td>STTII</td><td>110</td><td>110</td><td>126</td><td>126</td></tr> </table>	CO2	---	10	20	24	Ar (MIX)	94	11	21	25	PULSE (CRISP)	95	12	22	26	PULSE (SOFT)	---	14	19	28	STT (NO TAIL OUT)	109	109	125	125	STTII	110	110	126	126	<table border="1"> <tr><td>Ar (MIX)</td><td>61</td><td>31</td><td>41</td></tr> <tr><td>Ar/He/CO2</td><td>63</td><td>33</td><td>43</td></tr> <tr><td>PULSE Ar/CO2</td><td>66</td><td>36</td><td>46</td></tr> <tr><td>PULSE Ar/O2</td><td>62</td><td>32</td><td>42</td></tr> <tr><td>PULSE Ar/He/CO2</td><td>---</td><td>34</td><td>44</td></tr> <tr><td>STT Ar/He/CO2</td><td>109</td><td>109</td><td>125</td></tr> <tr><td>STTII Ar/He/CO2</td><td>110</td><td>110</td><td>126</td></tr> </table>	Ar (MIX)	61	31	41	Ar/He/CO2	63	33	43	PULSE Ar/CO2	66	36	46	PULSE Ar/O2	62	32	42	PULSE Ar/He/CO2	---	34	44	STT Ar/He/CO2	109	109	125	STTII Ar/He/CO2	110	110	126
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**DIP SWITCH S1 SETTING CHART**

TOGGLE NO.	FUNCTION	OFF DEF.	ON DEF.
1	SPARE		
2	SPARE		
3	SPARE		
4	SPARE		
5	SPARE		LINCNET
6	SPARE		
7	POLARITY	POS	NEG
8	FEED SPEED GEAR	LOW SPEED EXTRA TORQUE	NORMAL SPEED

**SERIAL NUMBER AND CODE NUMBER LOCATED BELOW WIRE FEED DRIVE ROLL AREA**