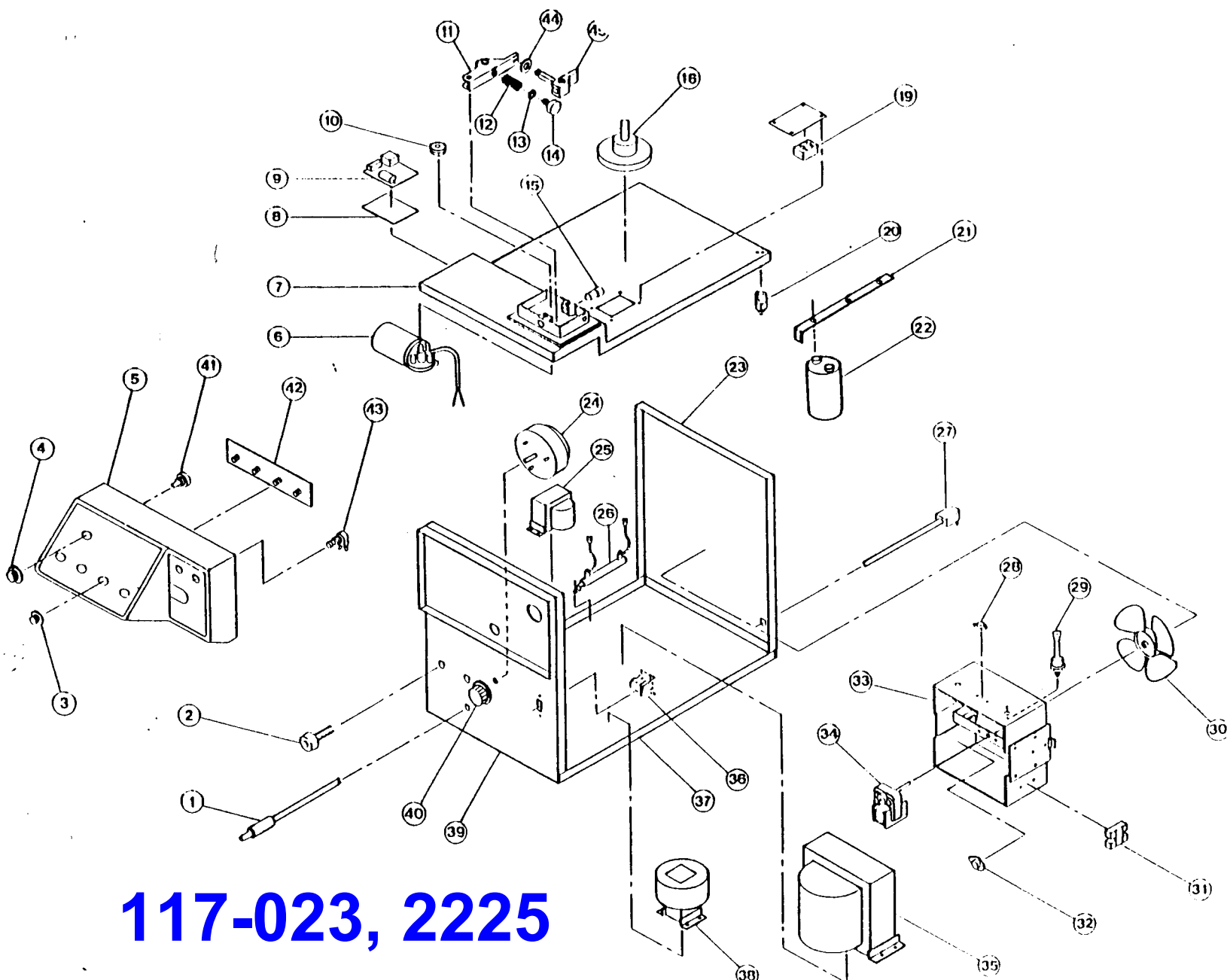




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Item	Stock #	Customer #	Description
1		238-193-000	Cable assy.
2	312-045-666	312-045-000	Receptace, panel mount
3		246-139-000	Knob, 1 3/16"
4		246-140-000	Knob, 1 1/2"
5		312-061-000	Nose
6	216-079-666	860-581-100	Drive motor
7		410-389-020	Drive deck
8		512-041-000	Insulation
9	860-614-666	860-614-666	Main circuit board w/ transistor
10	310-122-500	4323	Drive roller, 0.024 / 0.030 / 0.035
		4347, 310-154-000	Drive roller, 0.045 serrated
11		310-123-000	Tension bar w/bearing
12		330-025-000	Tension spring
13		310-144-000	Bearing washer
14		246-160-000	Tension knob
15		410-325-000	Inlet guide tube
16	312-066-666	860-575-100	Spindle
19		239-057-000	Terminal block
20	246-086-666	246-212-666	Gas solenoid, 24Vdc
21		412-202-000	Buss bar
22	213-018-666	213-018-666	Capacitor, 45,000mf, 45Vdc
23		860-778-030	Back panel
24		246-149-000	Heat switch, 9 position
25		860-623-000, 880-041-888	Control Transformer, 230Vac to 24Vdc, 6 amp
26		860-784-000	Resistor assy.

Made from 12-9-85 (C060175) to 7-14-87 (C421744) (732)

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
117-023	230V, 44A	50A	60%

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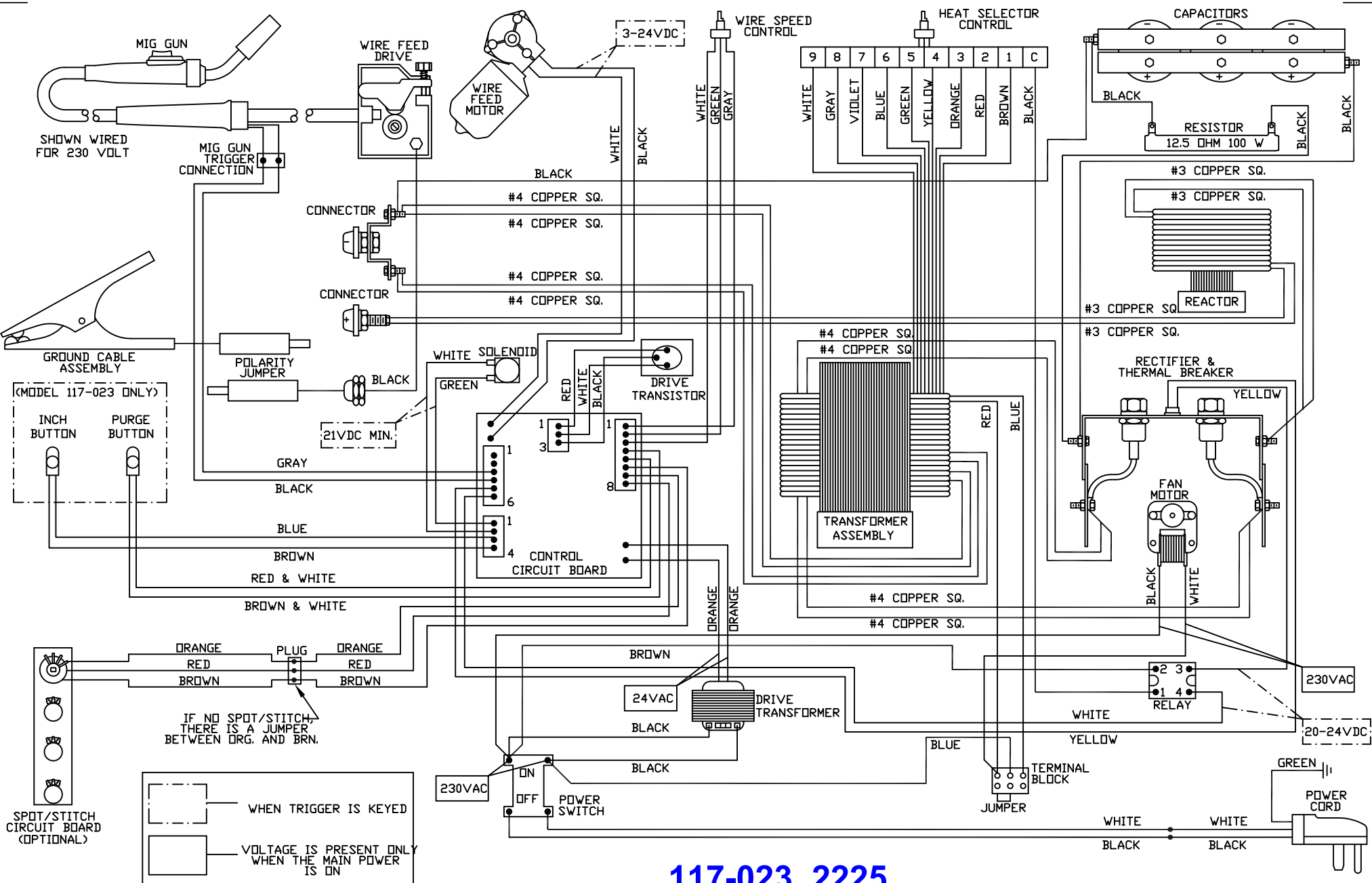
Item	Stock #	Customer #	Description
27		248-178-000	Power cord
28	216-053-666	216-053-000	Thermostat
29	244-070-666	244-070-666	Diode
30	316-010-000	316-010-000	Fan blade
31	216-062-666	216-062-000	Triac Relay, 75 amp
32		221-006-000	Drive transistor
33		860-773-000	Fan shroud/heat sink assy.
34	216-099-666	216-067-000	Fan motor
35		860-771-888	Main weld transformer
36	216-010-666	216-010-666	Power switch
37		410-436-030	Base
38		860-772-888	Reactor
39		410-444-020	Front panel
40		246-154-000	Knob, 3"
41		246-120-000	Potentiometer, 5k, 1/4 watt
42	860-489-666	860-489-666	Spot stitch pcb
43		216-058-000	Momentary switch
44		091-040-000	Flatwasher
45		246-114-000	Drive tension toggle stud

Not Shown

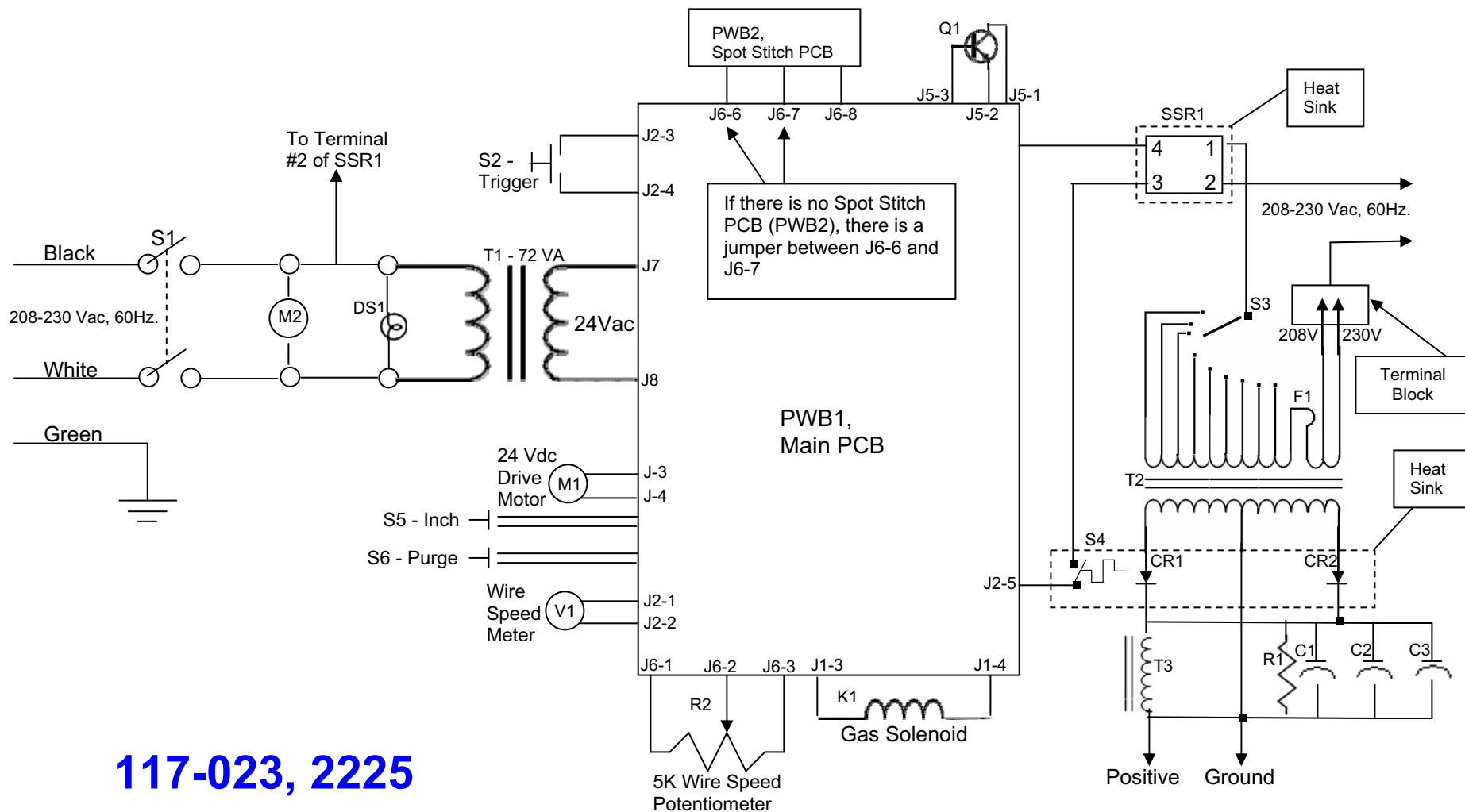
46		238-009-500	Ground cable w/plug & clamp, 12'
47	238-393-000	238-191-100	Mig gun assembly, 12'
48	238-296-666		Mig gun assembly, 15'
49	KP45-40-15	KP1937-1, 4331	Steel liner for original gun (238-191)
50	KP1959-1	4325, 334-374-000	Teflon liner for original gun (238-191)

8/21/2007

Rated Output	Voltage Settings	Agency Listing	Max Output
225 amps	9	CSA	250 amps



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C1, C2 & C3 - 45,000µf, 45V, Electrolytic Capacitor	PWB2 - Spot Stitch Circuit Board	S5 - Momentary Inch Button
CR1 & CR2 - Diode, 250 Amp, 300 PIV	Q1 - MJ15015 Drive Transistor	S5 - Momentary Gas Purge Button
DS1 - 220V Neon Lamp	R1 - Resistor, 12.5Ω, 100 Watt	SSR1 - Triac Relay, 75 Amp
F1 - Thermal One Shot, 240° Celsius Open	R2 - 5kΩ, ½ W Potentiometer	T1 - Control Transformer, 230 Vac to 24 Vac
K1 - Gas Solenoid, 24 Vdc Coil	S1 - Power Switch, DPST, 60 Amp	T2 - Transformer, Main Weld
M1 - Drive Motor, 24 Vdc	S2 - Gun Trigger, SPST	T3 - Reactor Coil
M2 - Fan Motor, 230 Vac	S3 - Switch, Rotary 9 Position	V1 - Wire Speed Meter (not on all models)
PWB1 - Main Circuit Board	S4 - Thermal Breaker, 175° Celsius Open	

117-023, 2225 Schematic Legend

Symbol Description

C1	45,000 μ f, 45v, Electrolytic Capacitor
C2	45,000 μ f, 45v, Electrolytic Capacitor
C3	45,000 μ f, 45v, Electrolytic Capacitor
CR1	Diode, 1N3737, 250 Amp, 300 PIV
CR2	Diode, 1N3737, 250 Amp, 300 PIV
DS1	220v neon light
F1	One shot, 240 degrees celsius open
K1	Gas Solenoid, 24vdc coil
M1	Wirefeed motor, 24vdc
M2	Fan Motor, 230vac
PWB1	Control circuit board
PWB2	Spot-stitch circuit board

Symbol Description

Q1	2N3055 Drive Transistor
R1	Resistor, 12.5 Ω , 100 watt
R2	5K Ω , 1W potentiometer
S1	Power switch, DPST
S2	Gun trigger, SPST
S3	9 position rotary heat switch
S4	Thermal breaker, 175 degrees Celsius open
SSR1	Triac Relay, D2475, 75 amp
T1	Control transformer, 230Vac to 24vac, 6 amp
T2	Weld transformer
T3	Reactor coil
V1	Wire Speed Meter