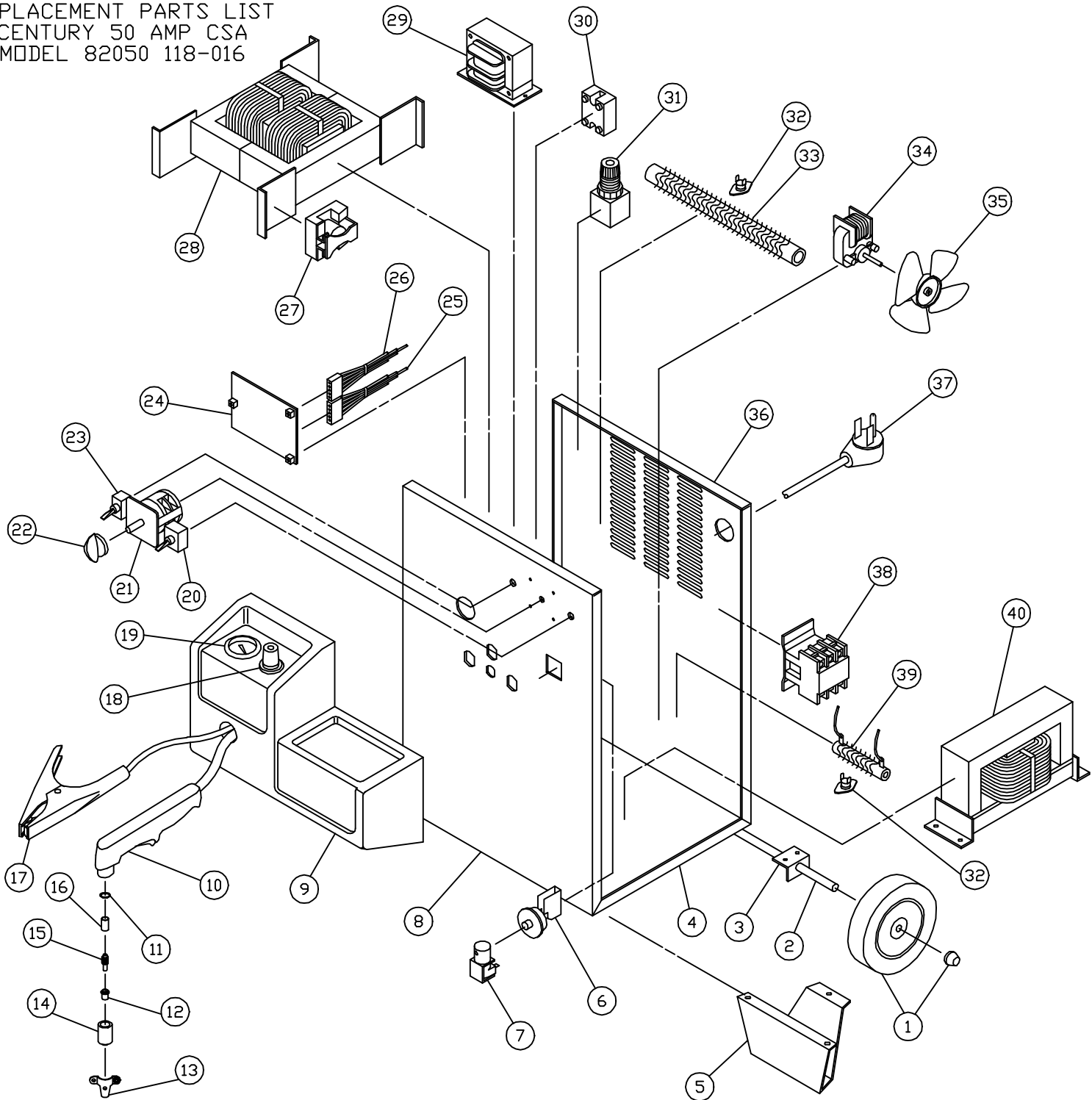


REPLACEMENT PARTS LIST
CENTURY 50 AMP CSA
MODEL 82050 118-016



118-016, 82050

118-016, 82050, 5Z031A,B

Item	Lincoln Stock #	Customer #	Description
1		413-030-666	Wheel with Hub
2		068-024-666	2 Hubs
3	NLA	412-329-016	Wheel Mtg. Brackets
4	NLA	410-617-016	Base
5	NLA	412-328-016	Foot
6		252-004-666	Pressure Switch
7	246-086-666	246-206-666	Solenoid
8	NLA	410-621-110	Front Panel
9	NLA	312-117-666	Nose
10	238-456-000	238-285-100	Torch Assembly
11	512-087-908	44050	O-Rings
12	334-289-908	44510	High Current Nozzles (5)
13		4416, 44160	Standoff
14	334-290-908	44530	Nozzle Cap
15	334-287-908	44500	Electrodes (3)
16	334-288-908	44520	Swirl Ring
17		238-228-666	Ground Cable Assy.
18	254-004-666	254-004-666	Regulator
19		251-003-666	Pressure Gauge
20		246-225-666	Power Switch
21		246-222-666	Amperage Switch
22		246-224-666	Knob
23		246-226-666	Run/Setup Switch

Item	Lincoln Stock #	Customer #	Description
24	880-102-666	880-102-666	Circuit Board
25	NLA	880-181-666	10 Pin Wire Harness
26	NLA	880-139-666	9 Pin Wire Harness
27	246-199-666	246-199-666	Pilot Arc Relay
28	NLA	880-141-888	Transformer
29		880-106-888	Control Transformer 230Vac to 20Vac & 24Vac
30	244-080-666	244-080-666	Rectifier
31	254-005-666	254-005-666	Pre-Regulator (set at 105PSI)
32	216-053-666	216-053-666	Thermostat
33	245-105-666	245-105-666	2Ω, 420 Watt Resistor
34	216-086-666	216-086-666	Fan Motor, 230Vac
35	316-007-300	316-007-666	Fan Blade
36	NLA	410-629-016	Back Panel
37	S13699-8	248-178-666, 248-289-000	Power Cord, 8/3, 8.5' w #10 Spade(2) & #10 Ring Term.
38	246-165-666	246-165-666	Contactora, 40A, 24 Vac coil voltage
39	880-134-666	880-134-666	1.5Ω, 160 Watt Resistor
40		880-137-888	Reactor with thermostat
		246-187-000	Thermostat only Klixon 7am038a5-296
41	NLA	412-332-110	Handle (Not Shown)
42	NLA	410-630-076	Cover w/access Panel (Not Shown)
43	NLA	410-530-016	Access Panel (Not Shown)
44		059-214-032	1/4" OD tubing X 32"

This unit came with a one year warranty

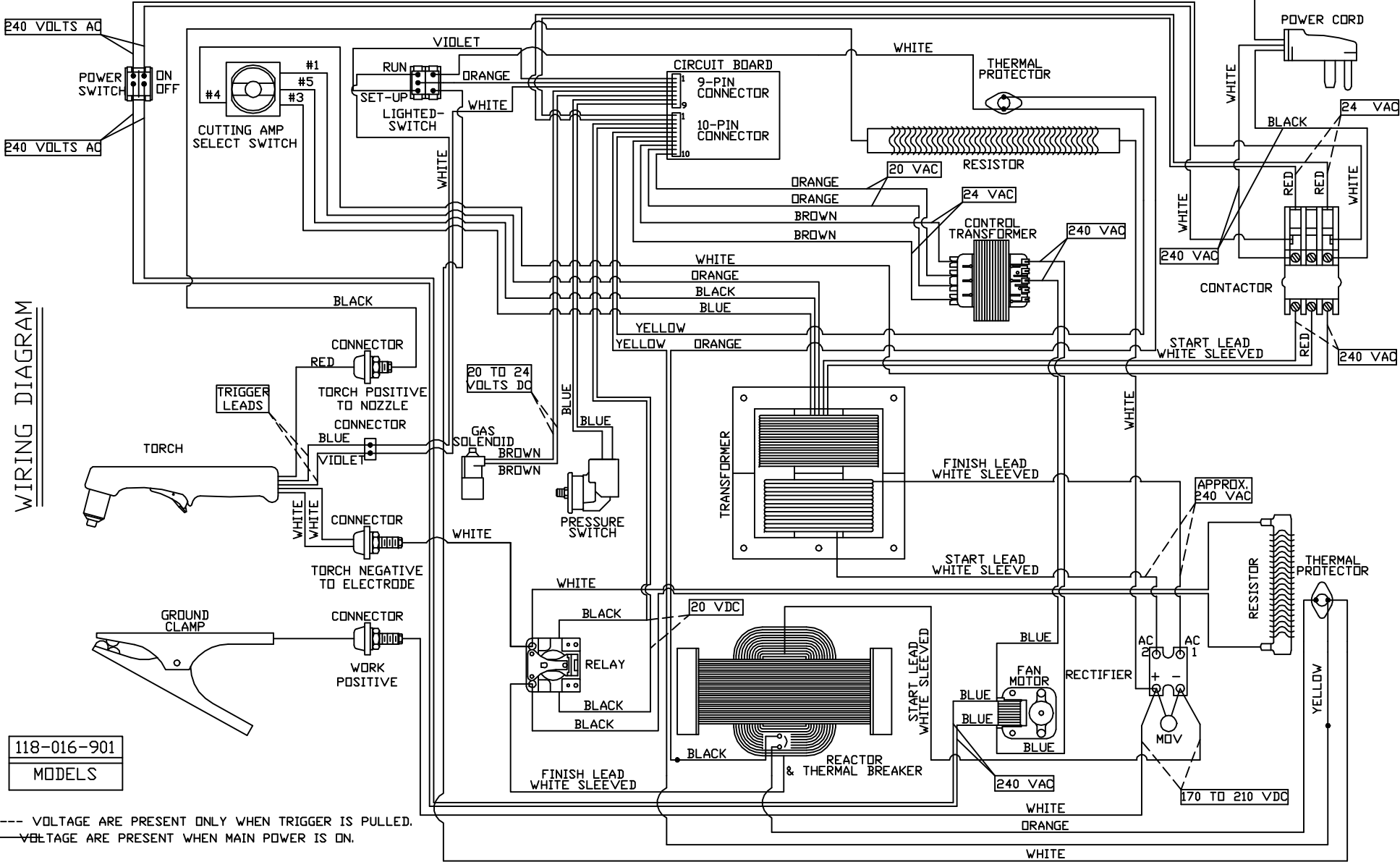
12/9/2008

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
118-016	230V, 66 amp	50A	42%

Rated Output	Voltage Settings	Agency Listing	Max Output
50 amps	3	CSA	50 amps

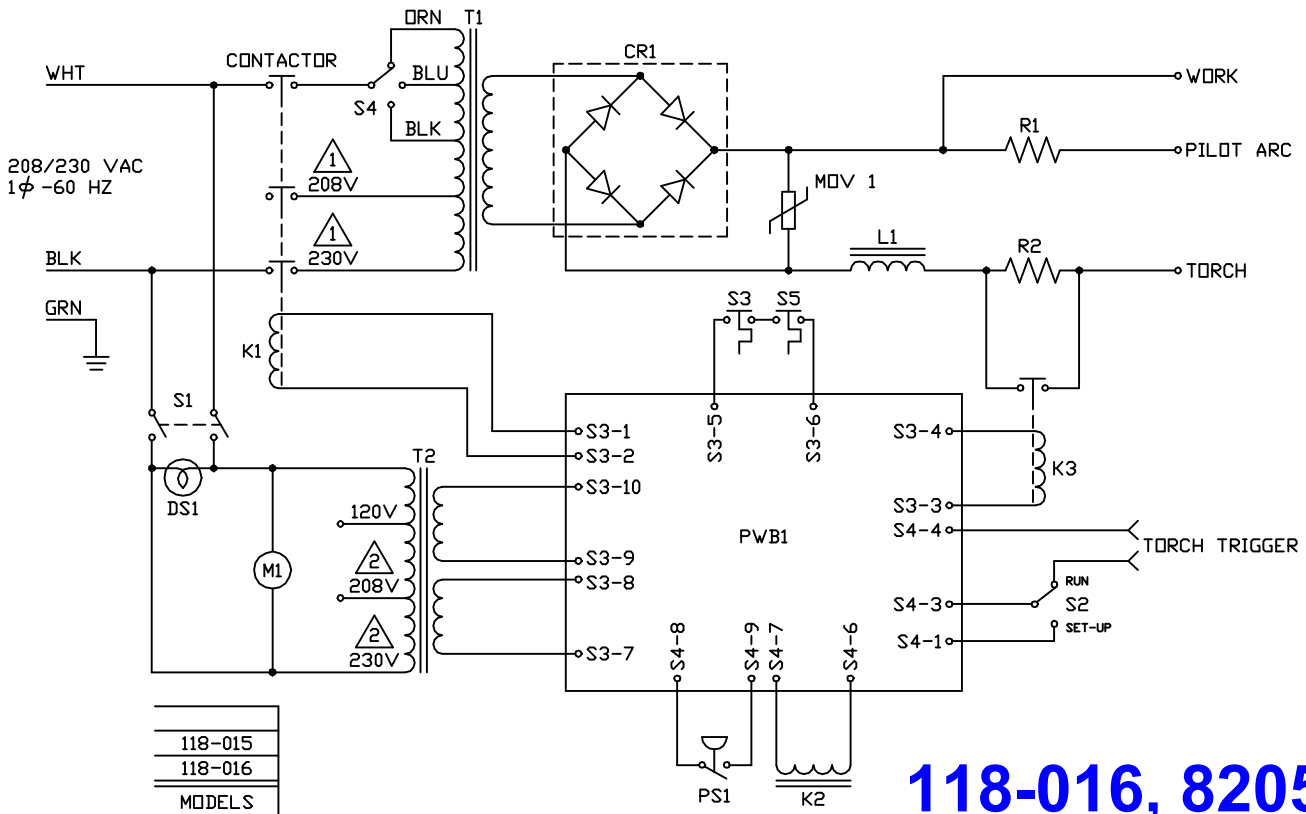
118-016, 82050

WIRING DIAGRAM



118-016-901
MODELS

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



118-015
118-016
MODELS

SYM	DESCRIPTION
CR1	100 A, 1200 V, FULL WAVE BRIDGE
K1	40 A, 3 POLE, 24 VAC COIL
K2	GAS SOLENOID N.C. 24 VDC COIL
K3	RELAY, 30A, SPST N.O. 24 VDC COIL
L1	40 mH, 50A REACTOR
M1	FAN MOTOR
MOV1	TRANSIENT PROTECTOR
PS1	PRESSURE SWITCH
PWB1	CONTROL CIRCUIT BOARD
R1	2 Ω , 420 W RESISTOR
R2	1.5 Ω , 100 W RESISTOR
S1	POWER SWITCH, DPST, LIGHTED (DS1)
S2	RUN/SET-UP SWITCH, SPDT
S3	THERMAL BREAKER
S4	3-POSITION SWITCH
S5	THERMAL BREAKER
T1	MAIN CUTTING TRANSFORMER
T2	CONTROL TRANSFORMER

NOTES:

① SHOWN WIRED FOR 230V OPERATION. FOR 208V OPERATION, EXCHANGE WIRES INDICATED AT CONTACTOR.

② SHOWN WIRED FOR 230V OPERATION. FOR 208V OPERATION, EXCHANGE WIRES INDICATED AT TRANSFORMER (T2).

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230 TO 208 VOLT CONVERSION INSTRUCTIONS

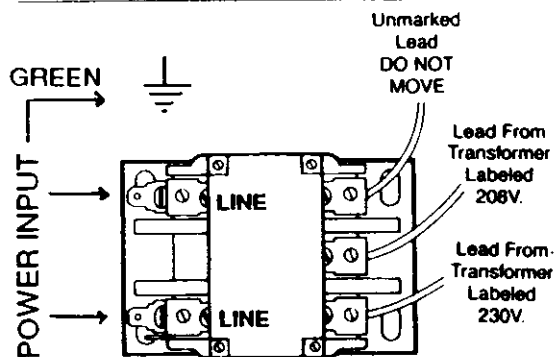
ELECTRIC SHOCK CAN KILL! To reduce risk of electric shock, **MAKE SURE** this cutter is **UNPLUGGED** from the AC power source before removing cover.

MAKE CONVERSIONS AT BOTH THE CONTACTOR AND THE CONTROL TRANSFORMER

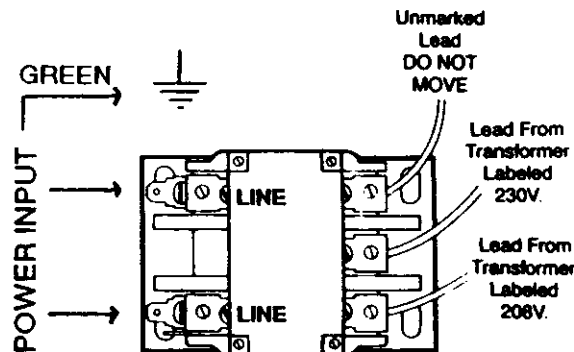
CONVERSION AT CONTACTOR

Remove cover from cutter. Locate contactor on rear panel of cutter and position the marked wires **FROM THE TRANSFORMER** on the contactor terminals as shown in the diagram below (make sure any sleeving is pushed up as close to the contactor terminals as possible to expose the wire markings). Tighten all contactor connections securely and slide all wire sleeving as far up to the contactor terminals as possible.

For 230 Volt Operation (Set at Factory)



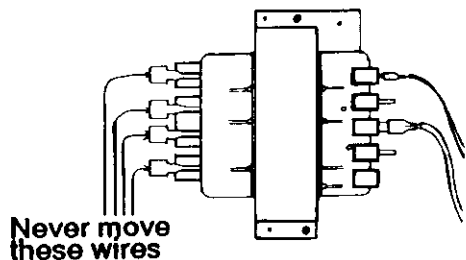
For 208 Volt Operation (Set by Owner)



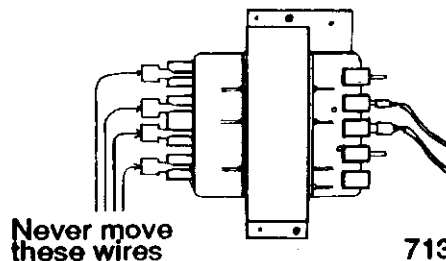
CONVERSION AT CONTROL TRANSFORMER

Locate the control transformer (on the rear panel on some models and on the floor of the cutter on others) and move **ONLY ONE WIRE** to obtain the desired operation setting as shown in the diagram below. Then replace the cutter's cover **BEFORE PLUGGING THE CUTTER INTO AC POWER SOURCE**.

For 230 Volt Operation (Set at Factory)



For 208 Volt Operation (Set by Owner)



713-893-000

118-016, 82050

