

PRECISION TIG 185 WIRING DIAGRAM G4549 REV: B

VOLTAGE RECONNECTION
SEE RATING PLATE FOR SPECIFIC VOLTAGES

230 or 400-415 or 575 VOLT CONNECTION
(AS SHOWN & AS SHIPPED FROM FACTORY)

- H1 and H3 (HIGH) TO POWER SWITCH.
- H2 NOT CONNECTED; INSULATE.

208 or 380 or 460 VOLT CONNECTION

- H1 and H2 (LOW) TO POWER SWITCH.
- H3 NOT CONNECTED; INSULATE.

C1 AND C2 MUST ALWAYS BE CONNECTED ACROSS TRANSFORMER PRIMARIES

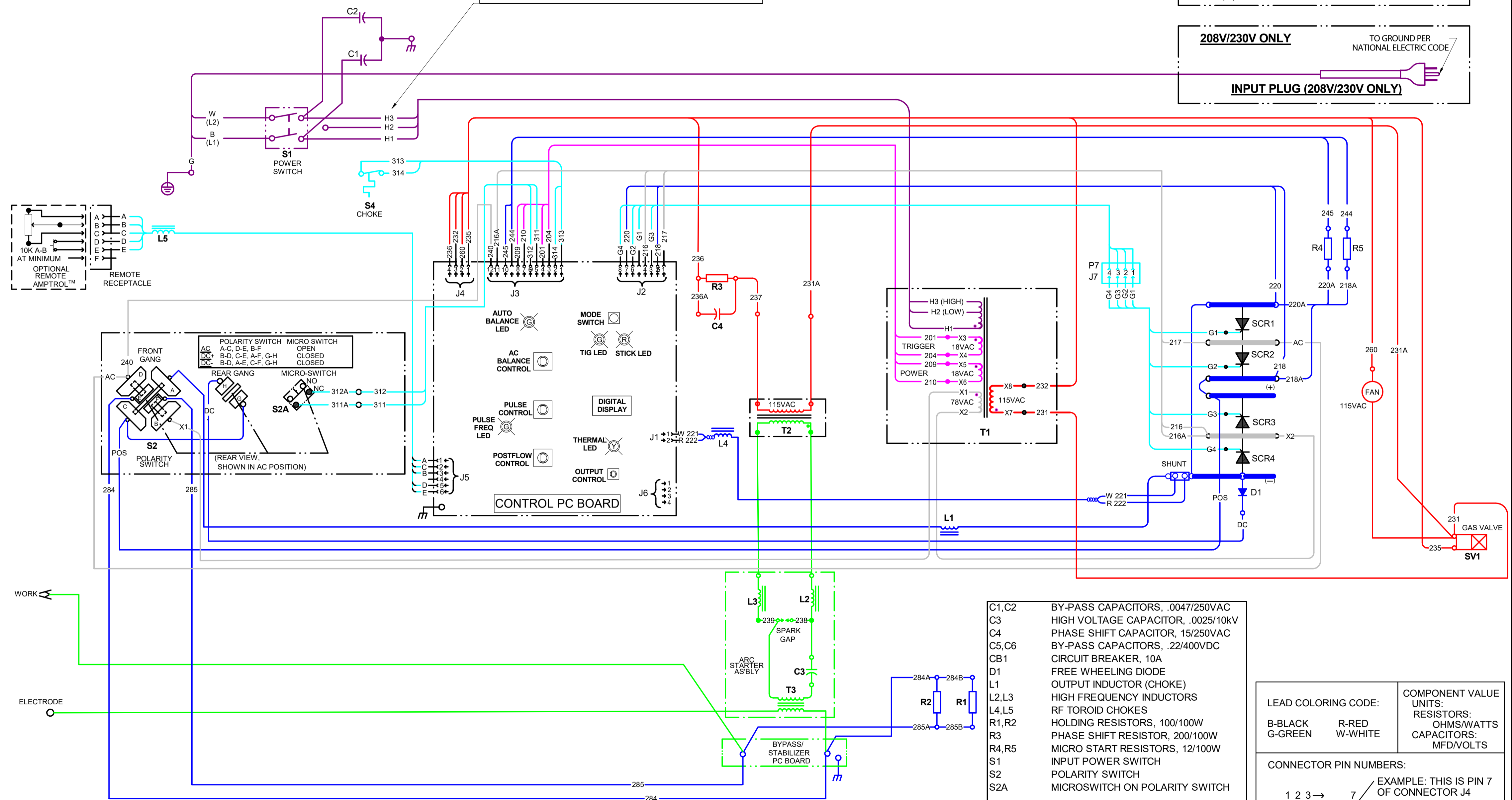
380V AND ABOVE

CONNECT GREEN LEAD TO GROUND PER NATIONAL AND LOCAL ELECTRICAL CODE
CONNECT BLACK AND WHITE LEADS TO SUPPLY CIRCUIT

208V/230V ONLY

TO GROUND PER NATIONAL ELECTRIC CODE

INPUT PLUG (208V/230V ONLY)



- C1,C2 BY-PASS CAPACITORS, .0047/250VAC
- C3 HIGH VOLTAGE CAPACITOR, .0025/10kV
- C4 PHASE SHIFT CAPACITOR, 15/250VAC
- C5,C6 BY-PASS CAPACITORS, .22/400VDC
- CB1 CIRCUIT BREAKER, 10A
- D1 FREE WHEELING DIODE
- L1 OUTPUT INDUCTOR (CHOKE)
- L2,L3 HIGH FREQUENCY INDUCTORS
- L4,L5 RF TOROID CHOKES
- R1,R2 HOLDING RESISTORS, 100/100W
- R3 PHASE SHIFT RESISTOR, 200/100W
- R4,R5 MICRO START RESISTORS, 12/100W
- S1 INPUT POWER SWITCH
- S2 POLARITY SWITCH
- S2A MICROSWITCH ON POLARITY SWITCH
- S4 MAIN CHOKE THERMOSTAT
- SCR1,2,3,4 MAIN POWER SCR'S
- SV1 GAS SOLENOID VALVE, 115VAC
- T1 MAIN TRANSFORMER
- T2 HIGH VOLTAGE TRANSFORMER
- T3 HIGH FREQUENCY TRANSFORMER

LEAD COLORING CODE:

B-BLACK	R-RED
G-GREEN	W-WHITE

COMPONENT VALUE UNITS:
RESISTORS: OHMS/WATTS
CAPACITORS: MFD/VOLTS

CONNECTOR PIN NUMBERS:

EXAMPLE: THIS IS PIN 7 OF CONNECTOR J4

VIEW OF CONNECTOR ON PC BOARD
ELECTRICAL SYMBOLS PER E1537.



CLEVELAND, OHIO