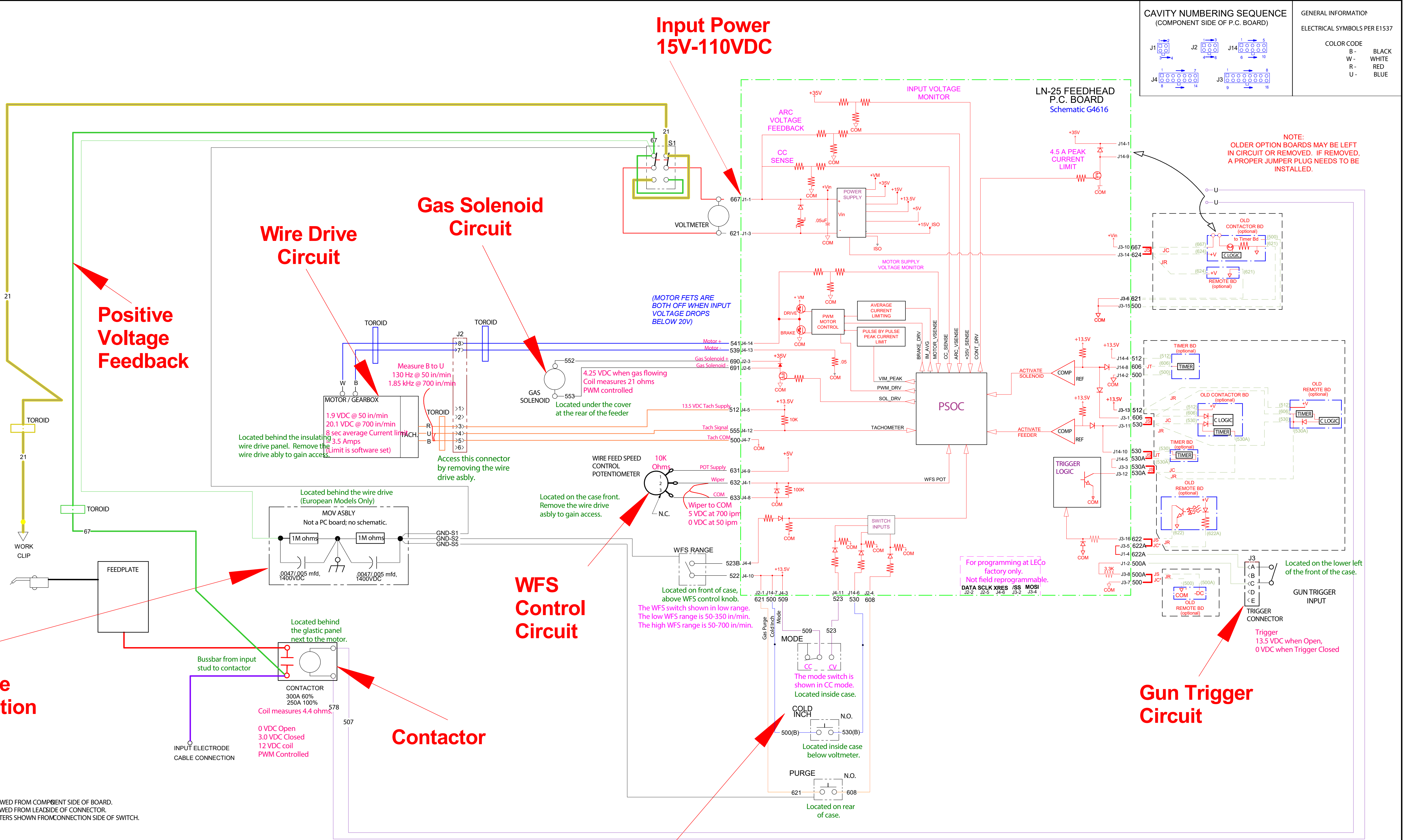


LN-25 (ACROSS THE ARC) MACHINE SCHEMATIC G5366 REV: A



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

GENERAL INFORMATION
ELECTRICAL SYMBOLS PER E1537

COLOR CODE
B - BLACK
W - WHITE
R - RED
U - BLUE

N.A. CAVITY NUMBERING SEQUENCE AS VIEWED FROM COMPONENT SIDE OF BOARD.
N.B. CAVITY NUMBERING SEQUENCE AS VIEWED FROM LEADSIDE OF CONNECTOR.
N.C. TOGGLE SWITCHES AND POTENTIOMETERS SHOWN FROM CONNECTION SIDE OF SWITCH.

Model	Ranger 8.9	Classic	Ranger 250, 305 Commander 300,400,500 (Common Analog Controls)	V350 (Common Digital Controls)	DC-400, 600	Square Wave TIG 300/355	Miller Inverters	STT II	Note: Most semiautomatic wire welding processes perform better using constant voltage power sources. Be sure the proper power source is used for your application. Contactor life may be shortened in applications using CC machines with high OCV.
K449 Across the Arc	Recommended all CV operation.	Recommended for CV operation. (Wire Feed Module Required)	Recommended for CV operation.	Recommended for CV operation. Not recommended for use when pulse welding.	Recommended for CV and CC operation.	Not recommended for CC operation because the customer may experience short contactor life from inductive nature of the power source. Not recommended with high frequency TIG starting.	Recommended for CV voltage sense operation. Not recommended for use when pulse welding.	Not recommended for STT operation.	

OPTION BOARD EXPLANATION
There are three optional boards available for the LN-25. The wiring associated with these boards is indicated by dashed lines and abbreviations are as follows:
JS - Standard Wiring, No Option Boards Installed
JC - Optional Contactor Board.
JR - Optional Remote Board.
JT - Optional Timer Board. If timer kit is installed, and remote board is not present, then jumper is installed in J11.
If remote board is present, then jumper is installed in J6 of remote board.
The Optional Boards are divided on this priority.

Inch/Purge/Mode
Input Switches