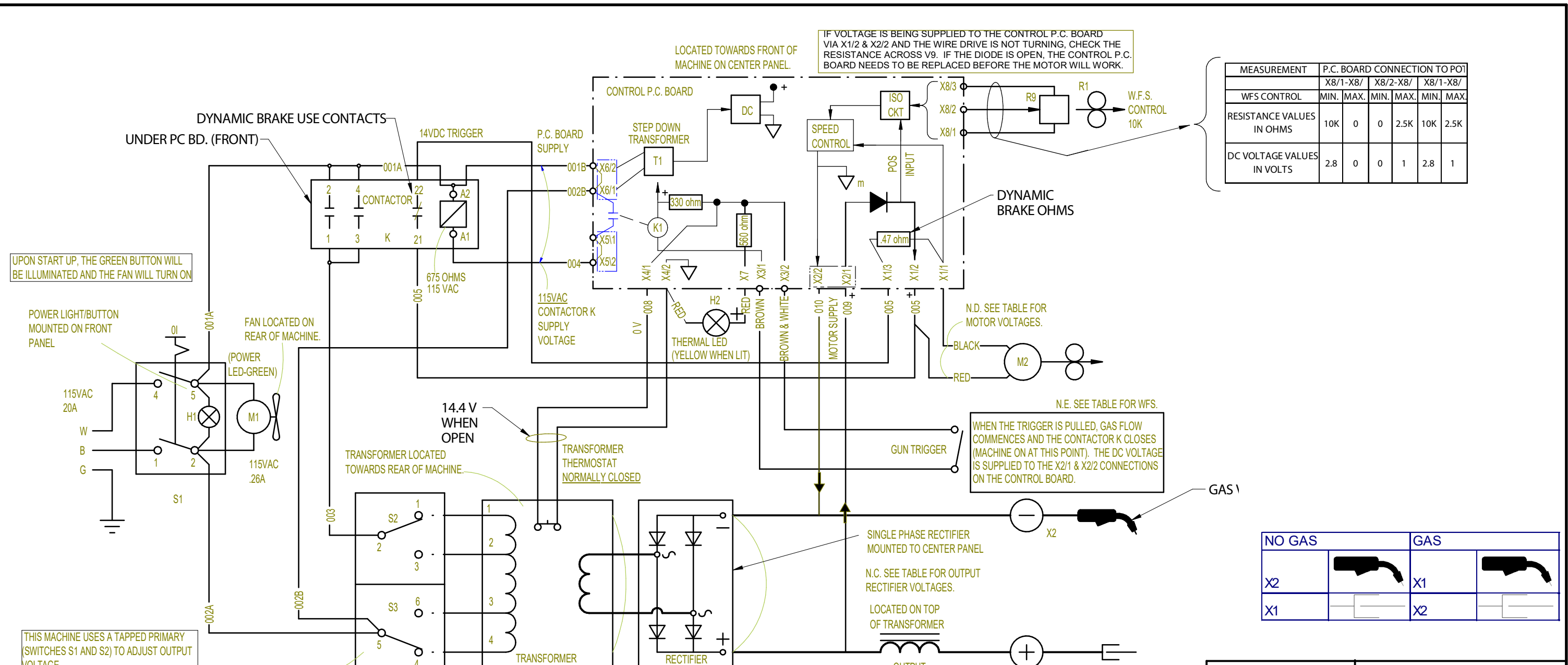


HANDY MIG MACHINE SCHEMATIC M20126 REV: B



MEASUREMENT	P.C. BOARD CONNECTION TO POT					
	X8/1-X8/2		X8/2-X8/3		X8/1-X8/3	
WFS CONTROL	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.
RESISTANCE VALUES IN OHMS	10K	0	0	2.5K	10K	2.5K
DC VOLTAGE VALUES IN VOLTS	2.8	0	0	1	2.8	1

	NO GAS		GAS	
X2		X1		
X1		X2		

N.A.		N.B.		N.C.		N.D.		N.E.**	
VOLTAGES WERE TAKEN AT MAXIMUM POTENTIOMETER SETTING									
HEAT SETTINGS	SWITCH S2 AND S3 CONNECTIONS	CONNECTION - OUT OF TRANSFORMER (RMS VALUES)	CONNECTION - OUT OF RECTIFIER (RMS VALUES)	DISCONNECTED FROM RECTIFIER (RMS VALUES)	VOLTAGE INTO WIRE DRIVE MOTOR	TENSION ARM AT MINIMUM SETTING *	TENSION ARM AT RECOMMENDED SETTING	WIRE FEED SPEED RANGE IN INCHES PER MINUTE	
HIGH	2	2-1 5-4	32VAC	31.56VDC	39VDC	450-500	375-425		
HIGH	1	2-1 5-6	28.45VAC	27.85VDC	34.5VDC	350-400	250-300		
LOW	2	2-3 5-4	25.52VAC	24.8VDC	30.75VDC	300-340	250-300		
LOW	1	2-1 5-6	23.14VAC	22.35VDC	27.85VDC	250-300	220-240		

LISTED VOLTAGES REFLECT AN INPUT VOLTAGE OF 120.9 VAC

* MINIMUM SETTING IS DEFINED AS THE LIGHTEST SPRING FORCE THAT WILL FEED WIRE WITHOUT RESULTING IN SLIPPAGE AT THE DRIVE ROLLS

** VALUES MAY VARY FROM VALUES IN THE CHART DEPENDING ON THE METHOD OR WFS MEASUREMENT AND WIRE FEEDER SETUP. FRICTIONAL DRAG RESULTING FROM WIRE FEED TENSION SETTING, CONDITION OF LINER, KINKS OR LOOPS IN GUN CABLE OR WIRE FEED SPEED METER WILL AFFECT THE WFS VALUE.

LEAD COLOR CODE:
 B-BLACK
 G-GREEN
 O-ORANGE
 R-RED
 U-BLUE
 W-WHITE
 Y-YELLOW

LABELS:
 COMMON
 FRAME GROUND
 EARTH GROUND

COMPONENT VALUE UNITS:
 CAPACITOR: MFD/VOLTS
 RESISTOR: OHMS/WATTS

CONNECTOR PIN NUMBERS:
 EX. 12 PIN CONNECTOR

1 2 → 6
 ○ ○ ○ ○ ○ ○
 ○ ○ ○ ○ ○ ○
 7 → 12
 LATCH

VIEW OF CONNECTOR ON PC BOARD