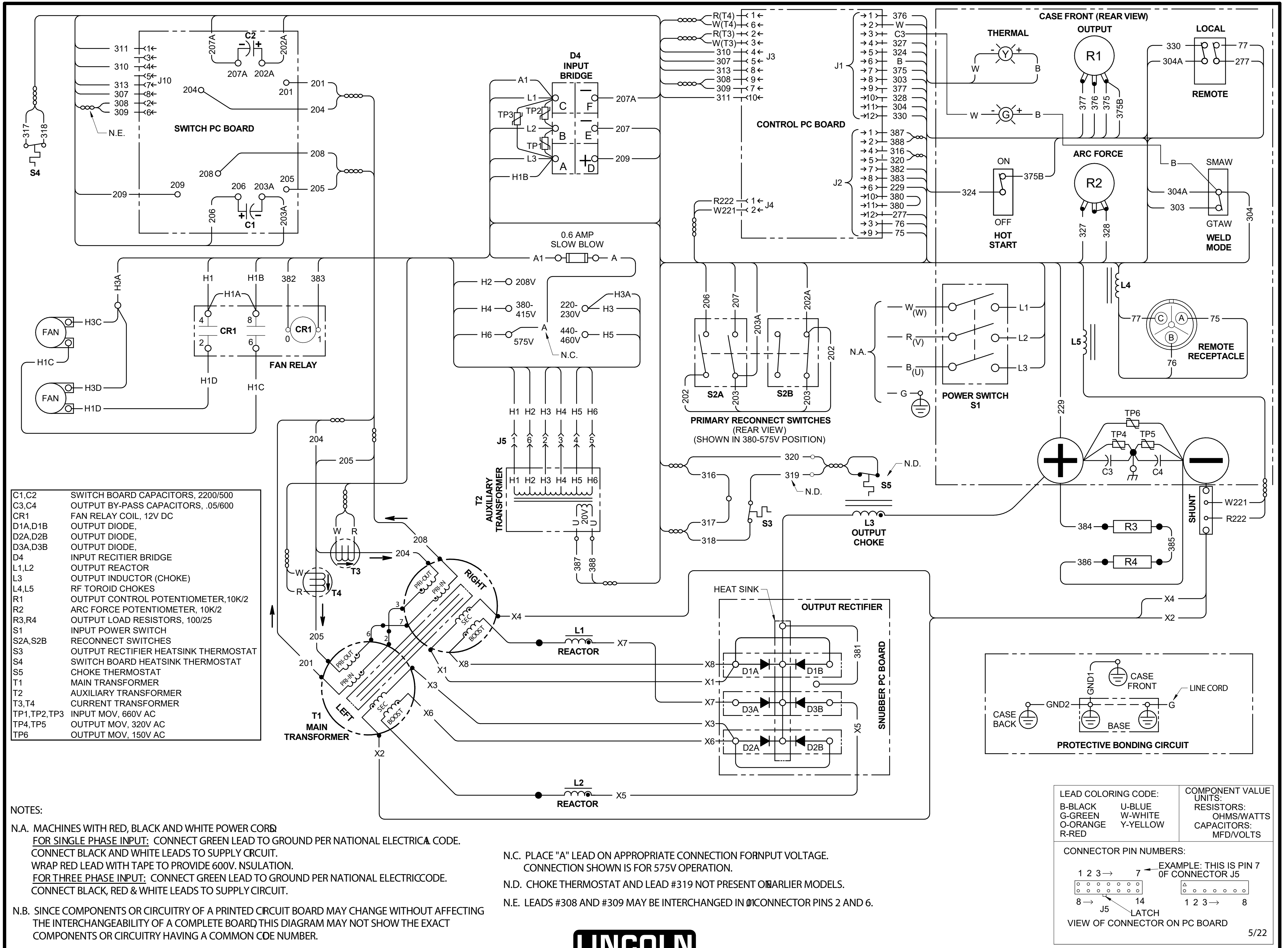


ES275i RED-D-ARC WIRING DIAGRAM G4365-4 REV: D



- C1,C2 SWITCH BOARD CAPACITORS, 2200/500
- C3,C4 OUTPUT BY-PASS CAPACITORS, .05/600
- CR1 FAN RELAY COIL, 12V DC
- D1A,D1B OUTPUT DIODE,
- D2A,D2B OUTPUT DIODE,
- D3A,D3B OUTPUT DIODE,
- D4 INPUT RECTIFIER BRIDGE
- L1,L2 OUTPUT REACTOR
- L3 OUTPUT INDUCTOR (CHOKE)
- L4,L5 RF TOROID CHOKES
- R1 OUTPUT CONTROL POTENTIOMETER, 10K/2
- R2 ARC FORCE POTENTIOMETER, 10K/2
- R3,R4 OUTPUT LOAD RESISTORS, 100/25
- S1 INPUT POWER SWITCH
- S2A,S2B RECONNECT SWITCHES
- S3 OUTPUT RECTIFIER HEATSINK THERMOSTAT
- S4 SWITCH BOARD HEATSINK THERMOSTAT
- S5 CHOKE THERMOSTAT
- T1 MAIN TRANSFORMER
- T2 AUXILIARY TRANSFORMER
- T3,T4 CURRENT TRANSFORMER
- TP1,TP2,TP3 INPUT MOV, 660V AC
- TP4,TP5 OUTPUT MOV, 320V AC
- TP6 OUTPUT MOV, 150V AC

NOTES:

N.A. MACHINES WITH RED, BLACK AND WHITE POWER CORD
 FOR SINGLE PHASE INPUT: CONNECT GREEN LEAD TO GROUND PER NATIONAL ELECTRICAL CODE.
 CONNECT BLACK AND WHITE LEADS TO SUPPLY CIRCUIT.
 WRAP RED LEAD WITH TAPE TO PROVIDE 600V. INSULATION.
 FOR THREE PHASE INPUT: CONNECT GREEN LEAD TO GROUND PER NATIONAL ELECTRICAL CODE.
 CONNECT BLACK, RED & WHITE LEADS TO SUPPLY CIRCUIT.

N.B. SINCE COMPONENTS OR CIRCUITRY OF A PRINTED CIRCUIT BOARD MAY CHANGE WITHOUT AFFECTING THE INTERCHANGEABILITY OF A COMPLETE BOARD THIS DIAGRAM MAY NOT SHOW THE EXACT COMPONENTS OR CIRCUITRY HAVING A COMMON CODE NUMBER.

N.C. PLACE "A" LEAD ON APPROPRIATE CONNECTION FOR INPUT VOLTAGE.
 CONNECTION SHOWN IS FOR 575V OPERATION.

N.D. CHOKE THERMOSTAT AND LEAD #319 NOT PRESENT ON EARLIER MODELS.

N.E. LEADS #308 AND #309 MAY BE INTERCHANGED IN CONNECTOR PINS 2 AND 6.



CLEVELAND, OHIO U.S.A.

LEAD COLORING CODE:		COMPONENT VALUE UNITS:	
B-BLACK	U-BLUE	RESISTORS:	OHMS/WATTS
G-GREEN	W-WHITE	CAPACITORS:	MFD/VOLTS
O-ORANGE	Y-YELLOW		
R-RED			
CONNECTOR PIN NUMBERS:			
EXAMPLE: THIS IS PIN 7 OF CONNECTOR J5			
VIEW OF CONNECTOR ON PC BOARD			