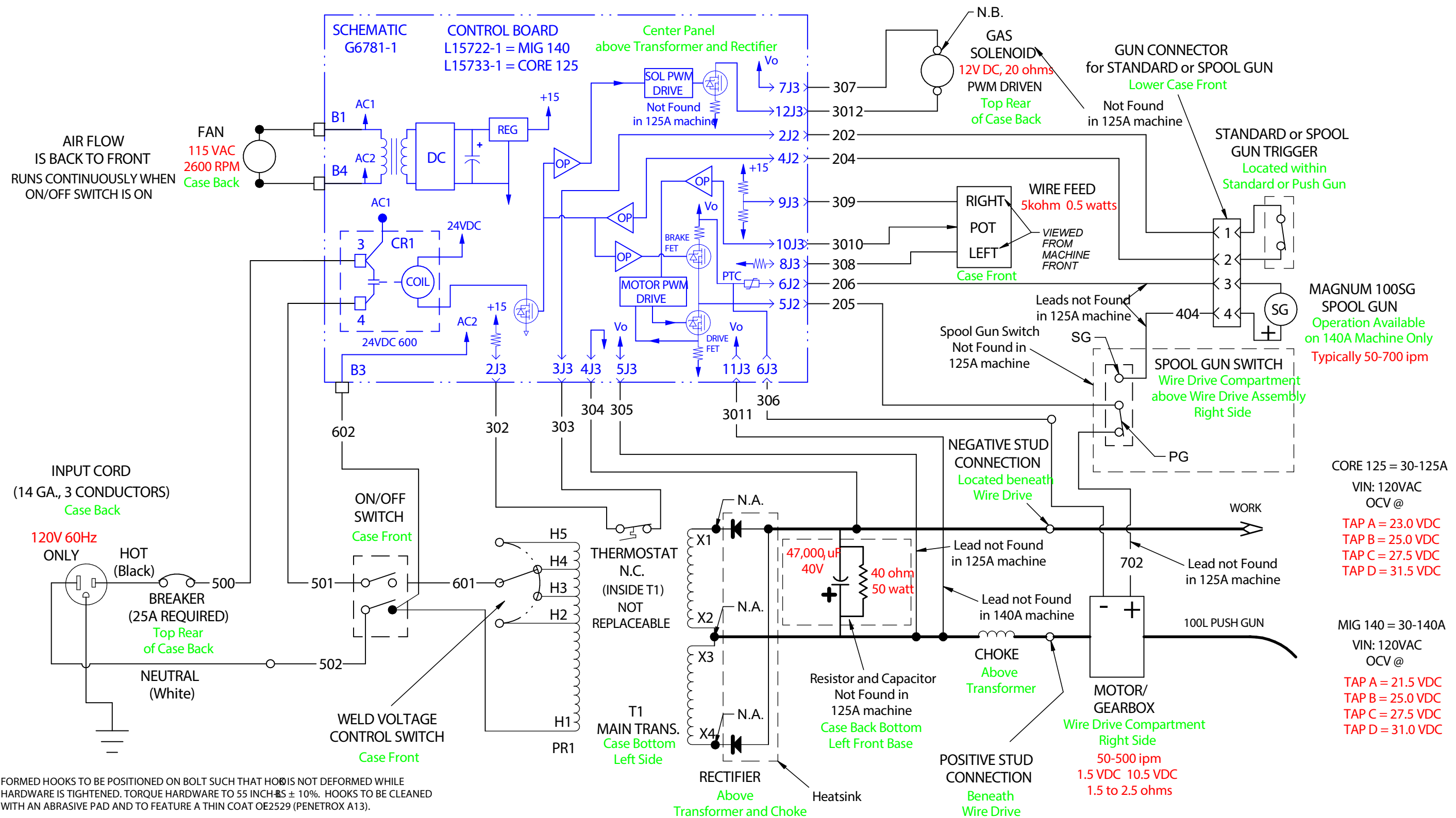


SMALL WIRE FEEDERS MACHINE SCHEMATIC M22435 REV: A



N.A. FORMED HOOKS TO BE POSITIONED ON BOLT SUCH THAT HOOK IS NOT DEFORMED WHILE HARDWARE IS TIGHTENED. TORQUE HARDWARE TO 55 INCH-~~LB~~ $\pm 10\%$. HOOKS TO BE CLEANED WITH AN ABRASIVE PAD AND TO FEATURE A THIN COAT OE2529 (PENETROX A13).

N.B. PARALLEL TERMINALS ON SOLENOID TO BE CONNECTED TO 307 AND 3012 LEADS. GROUND TERMINAL TO BE UNUSED. VOLTAGE BETWEEN DISCONNECTED 307 AND 3012 LEADS WILL MATCH THE O.C.V. PRESENT AT THE OUTPUT STUDS.

CORE 125 = 30-125A
VIN: 120VAC
OCV @

TAP A = 23.0 VDC
TAP B = 25.0 VDC
TAP C = 27.5 VDC
TAP D = 31.5 VDC

MIG 140 = 30-140A
VIN: 120VAC
OCV @

TAP A = 21.5 VDC
TAP B = 25.0 VDC
TAP C = 27.5 VDC
TAP D = 31.0 VDC