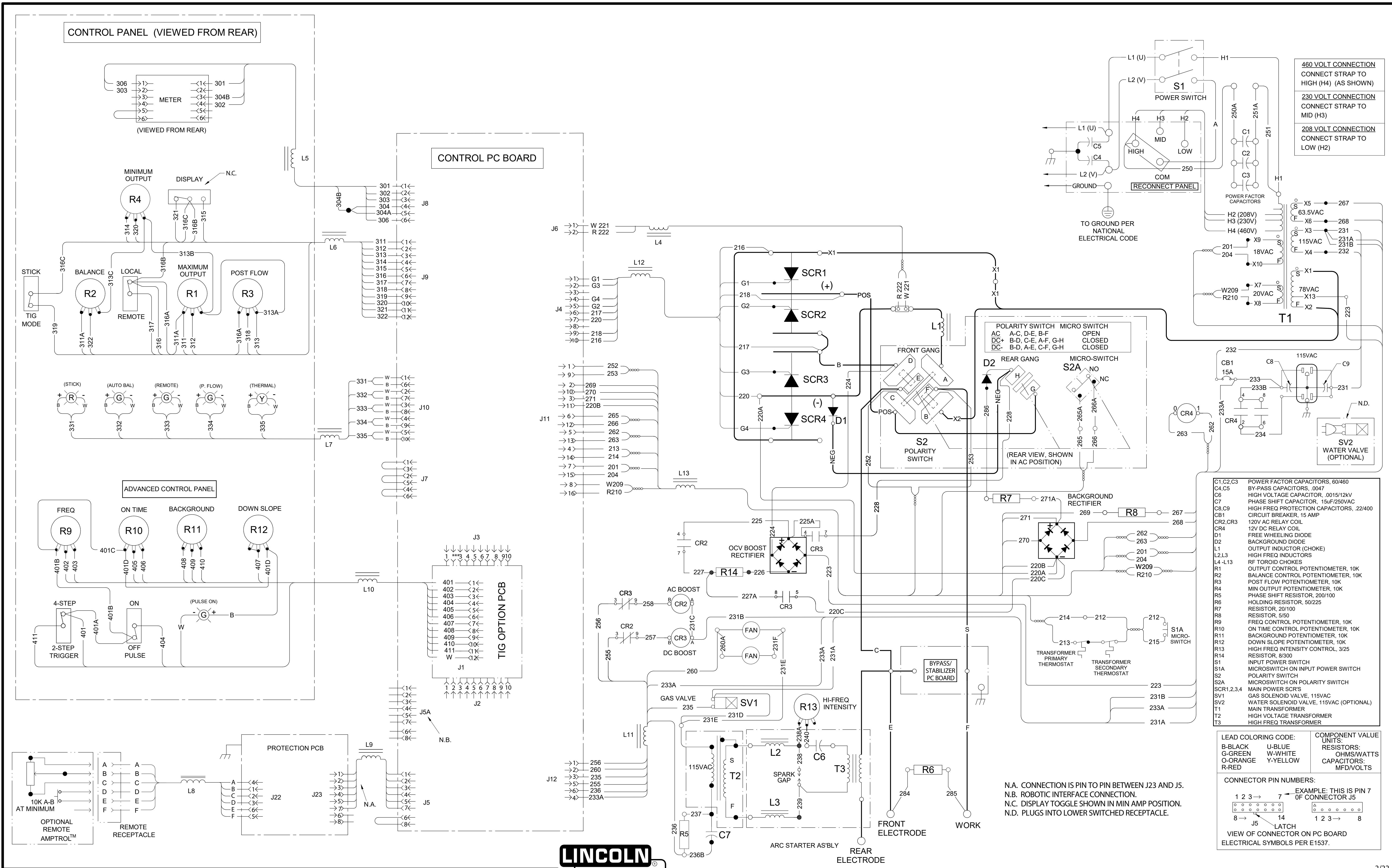


PRECISION TIG 375 WIRING DIAGRAM G4047 REV:A



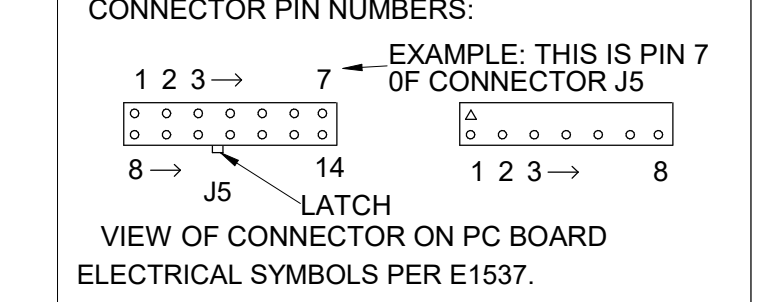
460 VOLT CONNECTION
CONNECT STRAP TO HIGH (H4) (AS SHOWN)

230 VOLT CONNECTION
CONNECT STRAP TO MID (H3)

208 VOLT CONNECTION
CONNECT STRAP TO LOW (H2)

- C1, C2, C3 POWER FACTOR CAPACITORS, 60/460
- C4, C5 BY-PASS CAPACITORS, .0047
- C6 HIGH VOLTAGE CAPACITOR, .0015/12kV
- C7 PHASE SHIFT CAPACITOR, 15uF/250VAC
- C8, C9 HIGH FREQ PROTECTION CAPACITORS, .22/400
- CB1 CIRCUIT BREAKER, 15 AMP
- CR2, CR3 120V AC RELAY COIL
- CR4 12V DC RELAY COIL
- D1 FREE WHEELING DIODE
- D2 BACKGROUND DIODE
- L1 OUTPUT INDUCTOR (CHOKE)
- L2, L3 HIGH FREQ INDUCTORS
- L4-L13 RF TOROID CHOKES
- R1 OUTPUT CONTROL POTENTIOMETER, 10K
- R2 BALANCE CONTROL POTENTIOMETER, 10K
- R3 POST FLOW POTENTIOMETER, 10K
- R4 MIN OUTPUT POTENTIOMETER, 10K
- R5 PHASE SHIFT RESISTOR, 200/100
- R6 HOLDING RESISTOR, 50/225 RESISTOR, 20/100
- R7 RESISTOR, 5/50
- R8 FREQ CONTROL POTENTIOMETER, 10K
- R9 ON TIME CONTROL POTENTIOMETER, 10K
- R10 BACKGROUND POTENTIOMETER, 10K
- R11 DOWN SLOPE POTENTIOMETER, 10K
- R12 HIGH FREQ INTENSITY CONTROL, 3/25
- R13 RESISTOR, 8/300
- S1 INPUT POWER SWITCH
- S2 POLARITY SWITCH
- S2A MICROSWITCH ON POLARITY SWITCH
- SCR1, 2, 3, 4 MAIN POWER SCRS
- SV1 GAS SOLENOID VALVE, 115VAC
- SV2 WATER SOLENOID VALVE, 115VAC (OPTIONAL)
- T1 MAIN TRANSFORMER
- T2 HIGH VOLTAGE TRANSFORMER
- T3 HIGH FREQ TRANSFORMER

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			



N.A. CONNECTION IS PIN TO PIN BETWEEN J23 AND J5.
N.B. ROBOTIC INTERFACE CONNECTION.
N.C. DISPLAY TOGGLE SHOWN IN MIN AMP POSITION.
N.D. PLUGS INTO LOWER SWITCHED RECEPTACLE.

