



N.A. A DASH N° IS STAMPED ON THE LAMINATION OF L2 NEAR THE COIL. THE SIDE OF L2 WITH THE DASH N° MUST FACE THE HEAVY LEAD THAT CONNECTS TO THE POSITIVE STUD (OR POLARITY SWITCH, IF SO EQUIPPED).

THIS LEAD IS NOT USED WHEN POLARITY SWITCH IS INSTALLED

LEGEND

SPECIFIED VALUES OF NUMBERED COMPONENTS

CONTROL CIRCUIT P.C. BOARD

C20	.022 MFD.	R20	500 Ω 1/4 W.
C21	.22 MFD.	R21	100 Ω
C22	150 MFD.	R22	2.2 K Ω
C23	.047 MFD.	R23	270 Ω 1W.
C24	100 MFD.	R24	15 K Ω
C25	30 MFD.	R25	10 Ω
C26	50 MFD.	R26	100 Ω
		R27	39 K Ω
		R28	1.8 K Ω
		R29	2.8 K Ω
		R30	1 K Ω
		R31	500 Ω 1/4 W.
DZ20	20 V.	R32	3.9 K Ω
DZ21	6.2 V.	R33	200 Ω 10W.
TP1	50V	R34	1.5 K Ω 2W
TP2	150V		
TP3	150V	R36	1 K Ω 1/4 W.
Q20	1A, 200V, P.N.P.	R37	330 Ω
Q21	1A, 200V, P.N.P.		
SCR1	4 A, 400 V.		
QUS	2N 4989		
F1	1/4 AMP SLOW BLOW FUSE		

FOR CONTROL P.C. BOARD C208-1 OR HIGHER USE M17163-1 SCHEMATIC FOR COMPONENT VALUES AND CIRCUIT CONNECTIONS.

FIRING CIRCUIT P.C. BOARD

C40, C41, C42	.02 MFD	R40, R41, R42	430 Ω 5W
C43, C44, C45	4.7 MFD	R43, R44, R45	27 Ω
C46, C47, C48	.047 MFD	R46, R47, R48	150 Ω
C49, C50, C51	.047 MFD	R49, R50, R51	3.3 K Ω
C52, C53, C54	.1 MFD	R52, R53, R54	6.8 K Ω
C55, C56, C57	.022 MFD	R55, R56, R57	47 K Ω
C58, C59, C60	.22 MFD	R58, R59, R60	47 Ω
C61	.022 MFD	R61, R62, R63	1 K Ω
C62, C63, C64	2 MFD	R64, R65, R66	10 Ω
C65, C66, C67	100 MFD	R67, R68, R69	47 Ω
		R70, R71, R72	500 Ω 1/4 W.
		R73, R74, R75	100 K Ω 1/4 W.
		R76, R77, R78	270 Ω 5W.
		R79, R80, R81	5.1 Ω
		R82, R83, R84	100 Ω
		R85, R86, R87	6.8 Ω 5W.

D46 THRU D54 1 AMP

DZ40, DZ41, DZ42 20 V. 1W.

Q40, Q41, Q42 2N 3393 NPN

Q43, Q44, Q45 UJT

SCR1, SCR2, SCR3 4 A, 400V.

NOT ON P.C. BOARDS

C1	.05 + .05 MFD	R1	50 Ω 50W
C2	.68 MFD.	R2	40 Ω 100W
C3	.68 MFD.	R3	10 K Ω 2W
C4	.68 MFD.	R4	50 Ω
C5	1 MFD	R5	270 Ω
		R6	47 Ω
D1	1 AMP	R7	47 Ω
D2	1 A 2P	R8	47 Ω
D3	1 AMP	R9	27 Ω

- CT1, CT2, CT3 CURRENT TRANS.
- L1 D.C. OUTPUT FILTER
- L2 FEEDBACK FILTER
- ICR INPUT STARTER
- SCR1 - D4
- SCR2 - D5
- SCR3 - D6
- D7
- SW1 POWER SWITCH
- SW2 MACH. REMOTE SWITCH
- SW3 DIAL SELECTOR SWITCH
- T1 MAIN TRANSFORMER
- T2 CONT. TRANSFORMER

A.N.S.I. ELECTRICAL SYMBOLS PER E-1537

NOTE: SINCE COMPONENTS OR CIRCUITRY ON A PRINTED CIRCUIT BOARD MAY CHANGE WITHOUT AFFECTING THE INTERCHANGEABILITY OF A COMPLETE BOARD, THIS DIAGRAM MAY NOT SHOW THE EXACT COMPONENTS OR CIRCUITRY OF CONTROLS HAVING A COMMON CODE NUMBER.

THE LINCOLN ELECTRIC CO. CLEVELAND, OHIO U.S.A.	CHG SHEET No 2-80-80 200000 11-20-81E 5-1-44K	TYPE IDEALARC R3R-500 (TRIPLE VOLTAGE)	SUBJECT SCHEMATIC
DATE 1-22-80	SCALE	SUP'D BY G-1485	OR J.N. CUE
			G-1526