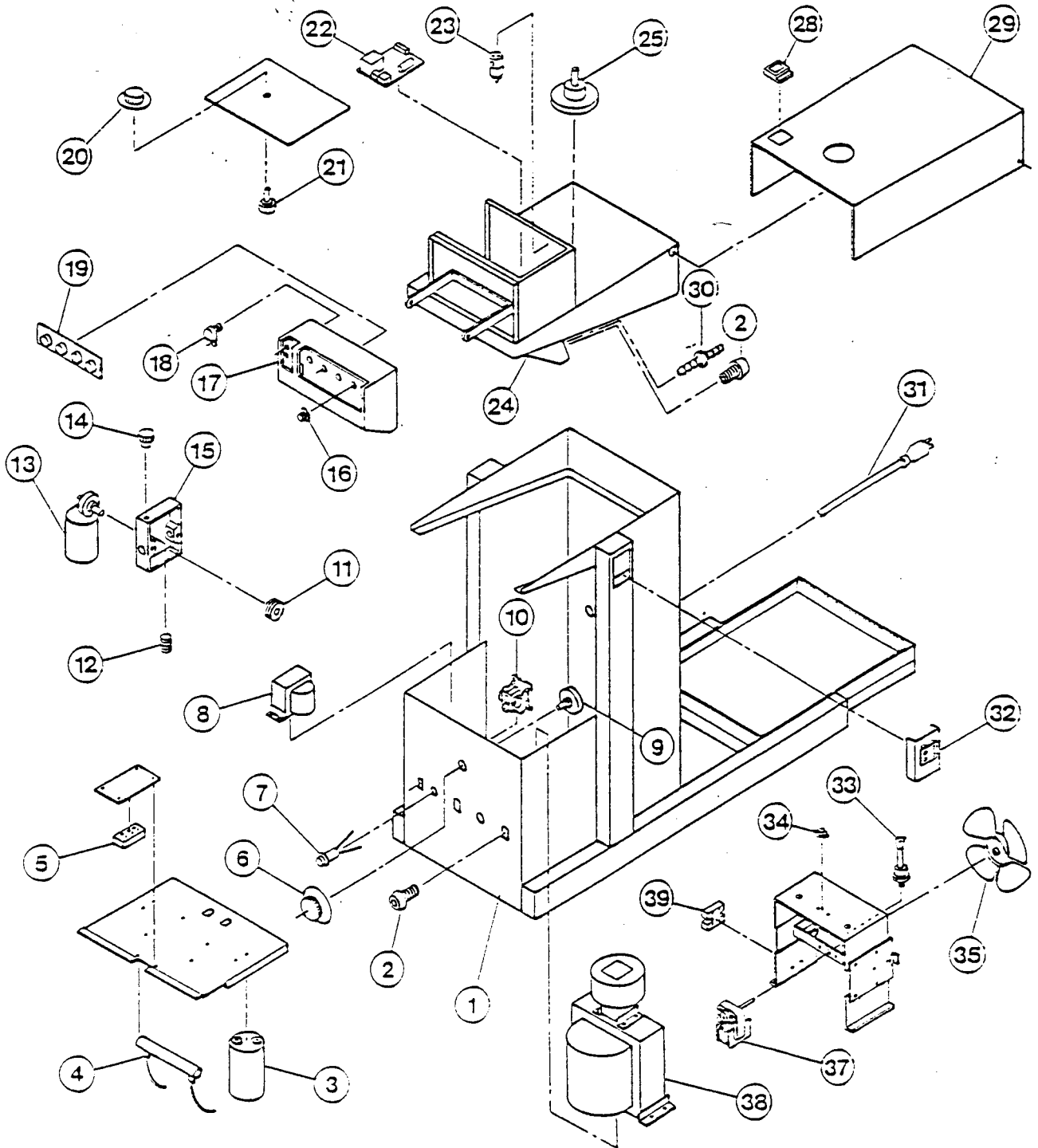


# 117-024, YA240



# 117-024, YA240

Item	Lincoln Stock #	Customer #	Description
1		410-451-020	Front Panel
2	312-045-666	312-045-000	Receptace, panel mount
3	213-018-666	213-018-666	Capacitor, 45,000mf, 45Vdc
4		860-784-000	Resistor assy.
5		239-057-000	Terminal block
6		246-154-000	Knob, 3"
7		245-095-666	Power Light
8		860-623-000, <b>880-041-888</b>	Control Transformer, 230Vac to 24Vdc, 6 amp
9		<b>246-149-000</b>	Heat switch, 9 position
10	216-010-666	216-010-666	Power switch
11	310-122-500	4323	Drive roller, 0.024 / 0.030 / 0.035
	860-616-002	4324	Drive roller for aluminum
12		330-025-000	Tension spring, .95", 6 turns
13	216-079-666	860-581-100	Drive motor
14		246-160-000	Tension knob, M10 X 1" threads
15		860-803-666	Complete drive assembly
16		246-127-666	Knob, 1"
17		860-673-000	Plastic nose with leads
18		216-058-000	Push-On momentary switch
19	860-489-666	860-489-666	Spot stitch pcb
20		246-158-666	Knob, 2.75"
21		<b>246-120-000</b>	Potentiometer, 5K, 1/2 watt
22	860-614-666	860-614-666	Main circuit board w/ transistor

Made from 2-14-86 (C126067) to 9-25-87 (C474807), 705

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
117-024	230V, 44A	50A	60%

Item	Lincoln Stock #	Customer #	Description
23	246-086-666	246-212-666	Gas solenoid, 24Vdc
24		312-063-666	Plastic undercarriage
25	312-066-666	860-575-100	Spindle
28		312-042-666	Slide latch
29		860-883-000	Hood with latch & labels
30		253-047-000	Hose barb fitting, double sided for 3/16" hose
31		248-178-666	Power cord
32		860-832-666	Drive head lock assembly
33	244-070-666	244-070-666	Diode
34	216-053-000	216-053-000	Thermostat
35	316-010-000	316-010-000	Fan blade
37	216-099-666	216-067-000	Fan motor
38		860-818-888	Main transformer
39	216-062-666	216-062-000	Triac Relay, 75 amp

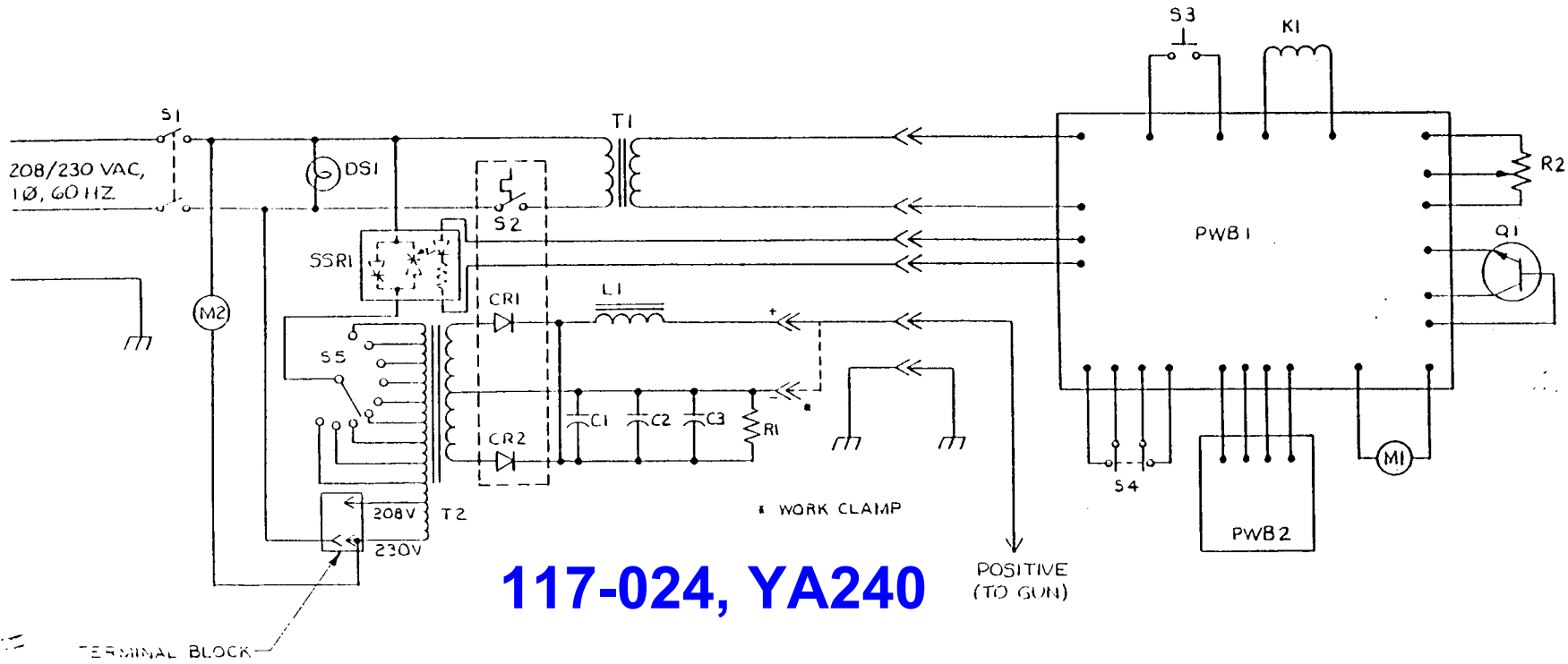
## Not Shown

40		<b>238-009-500</b>	Ground cable w/plug & clamp, 12'
41	<b>238-393-000</b>	238-191-100	<b>Replacement mig gun assembly, 12'</b>
42	<b>238-296-666</b>		<b>Replacement mig gun assembly, 15'</b>
43		<b>860-860-100, YA240-1</b>	Umbilical cord, 20'
44	KP45-40-15	4331, KP1937-1	Steel liner for original gun w/ o-ring
45	KP44-3545-15	4370, KP1933-1	Steel liner w/o o-ring for 238-393/238-296
46	KP1959-1	4325, 334-374-000	Teflon liner for original gun w/o-ring
47	KP42N-3545-15	4368, KP1955-1	Teflon liner w/o o-ring for 238-393/238-296

8/21/2007

Rated Output	Voltage Settings	Agency Listing	Max Output
225 amps	9	CSA	250 amps





**117-024, YA240**

# 117-024, YA240 Schematic Legend

## Symbol Description

<b>C1</b>	45,000 $\mu$ f, 45v, Electrolytic Capacitor
<b>C2</b>	45,000 $\mu$ f, 45v, Electrolytic Capacitor
<b>C3</b>	45,000 $\mu$ f, 45v, Electrolytic Capacitor
<b>CR1</b>	Diode, 1N3737, 250 Amp, 300 PIV
<b>CR2</b>	Diode, 1N3737, 250 Amp, 300 PIV
<b>DS1</b>	220v neon light
<b>K1</b>	Gas Solenoid, 24vdc coil
<b>L1</b>	Reactor coil
<b>M1</b>	Wirefeed motor, 24vdc
<b>M2</b>	Fan Motor, 230vac
<b>PWB1</b>	Control circuit board
<b>PWB2</b>	Spot-stitch circuit board

## Symbol Description

<b>Q1</b>	2N3055 Drive Transistor
<b>R1</b>	Resistor, 12.5 $\Omega$ , 100 watt
<b>R2</b>	5K $\Omega$ , 1W potentiometer
<b>S1</b>	Power switch, DPST
<b>S2</b>	Thermal breaker, 175 degrees Celsius open
<b>S3</b>	Gun trigger, SPST
<b>S4</b>	DPDT, Momentary, Center Off
<b>S5</b>	9 position rotary heat switch
<b>SSR1</b>	Triac Relay, D2475, 75 amp
<b>T1</b>	Control transformer, 230Vac to 24vac, 6 amp
<b>T2</b>	Weld transformer

**CONTINUOUS**  
**SPOT**                      **STITCH**

**MODE**

**WELD TIME**

**4**   **5**   **6**

**3**

**7**

**2**

**8**

**1**

**9**

**SPOT**

**WELD TIME**

**4**   **5**   **6**

**3**

**7**

**2**

**8**

**1**

**9**

**STITCH**

**WELD INTERVAL**

**4**   **5**   **6**

**3**

**7**

**2**

**8**

**1**

**9**

**STITCH**