

117-015, All Star, WFW1, WS117K

117-015, All Star

Item	Lincoln Stock #	Customer #	Description
1	312-045-666	312-045-000	Receptace, panel mount
2		245-078-666	Indicator light, 230Vac, amber
3	246-041-666 will work	246-095-000	Knob, Heat & Wire Control, 1.5"
4		246-094-000	Knob, 1"
5	NLA	541-067-000	Insulation for pcb
6	860-489-666	860-489-000	Spot stitch board
7	NLA	711-150-040	Faceplate
8	NLA	512-035-000	Rubber cushion
9	NLA	541-073-000	Domed hole plug
10	216-055-666	216-055-666	Triac Relay, 40 amp
11		860-652-888	Main weld transformer
12	216-079-666	860-581-100	Drive motor, 24Vdc
13	Included with 860-614-666 PCB	221-006-000	Drive Transistor
14		880-041-888	Drive transformer 230Vac - 24Vac
15	310-122-500	4323	Drive roller, 0.024 / 0.030 / 0.035
	860-616-002	4324	Drive roller, neoprene
16	NLA	310-123-000	Drive tension bar
17	NLA	081-044-000	Tension adjustment bolt
18	NLA	330-021-000	Tension spring
19	NLA	246-113-000	Tension knob
20	NLA	410-325-000	Inlet guide tube
21	312-066-666	312-066-666	Spindle
23	246-086-666	246-212-666	Gas solenoid
24	NLA	860-506-000	Heat sink assy.

Made from 9-23-83 (B378665) to 12-8-87 (C542732) - 2673

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
117-015	230V, 20A	25A	20%

Item	Lincoln Stock #	Customer #	Description
25	216-053-666	216-053-000	Thermostat
26	214-004-666	214-004-666	Diode
27		246-103-000	Handle
28		246-116-000	Fuse holder
		245-060-000	Fuse, BAN30 or BLN30
29		248-164-666	Power cord
30		541-020-000	Strain relief
31	NLA	410-230-100	Hood
32		860-523-000	Resistor assy., 25Ω, 50 watt
33	NLA	410-190-000	Buss bar
34	213-018-666	213-018-200	Capacitor, 45,000mf, 45Vdc
35	216-042-666	216-042-000	Power Switch, 230Vac, 40a
36	NLA	239-094-000	Terminal block
37	NLA	216-058-000	Push-on momentary switch
38	NLA	410-347-020	Right side panel
39	NLA	410-348-020	Left side panel
40	860-614-666	860-614-666	Main circuit board w/ transistor

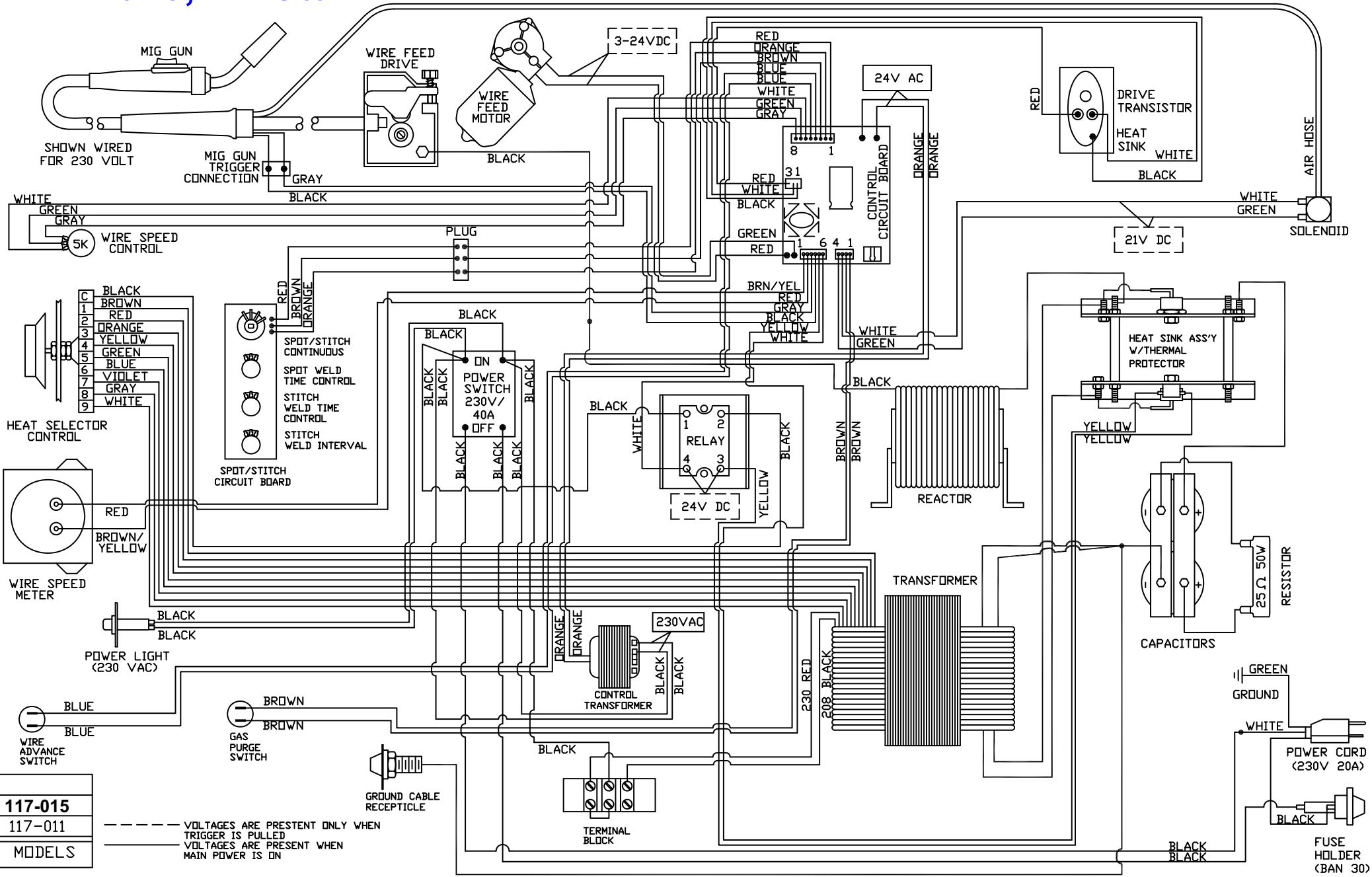
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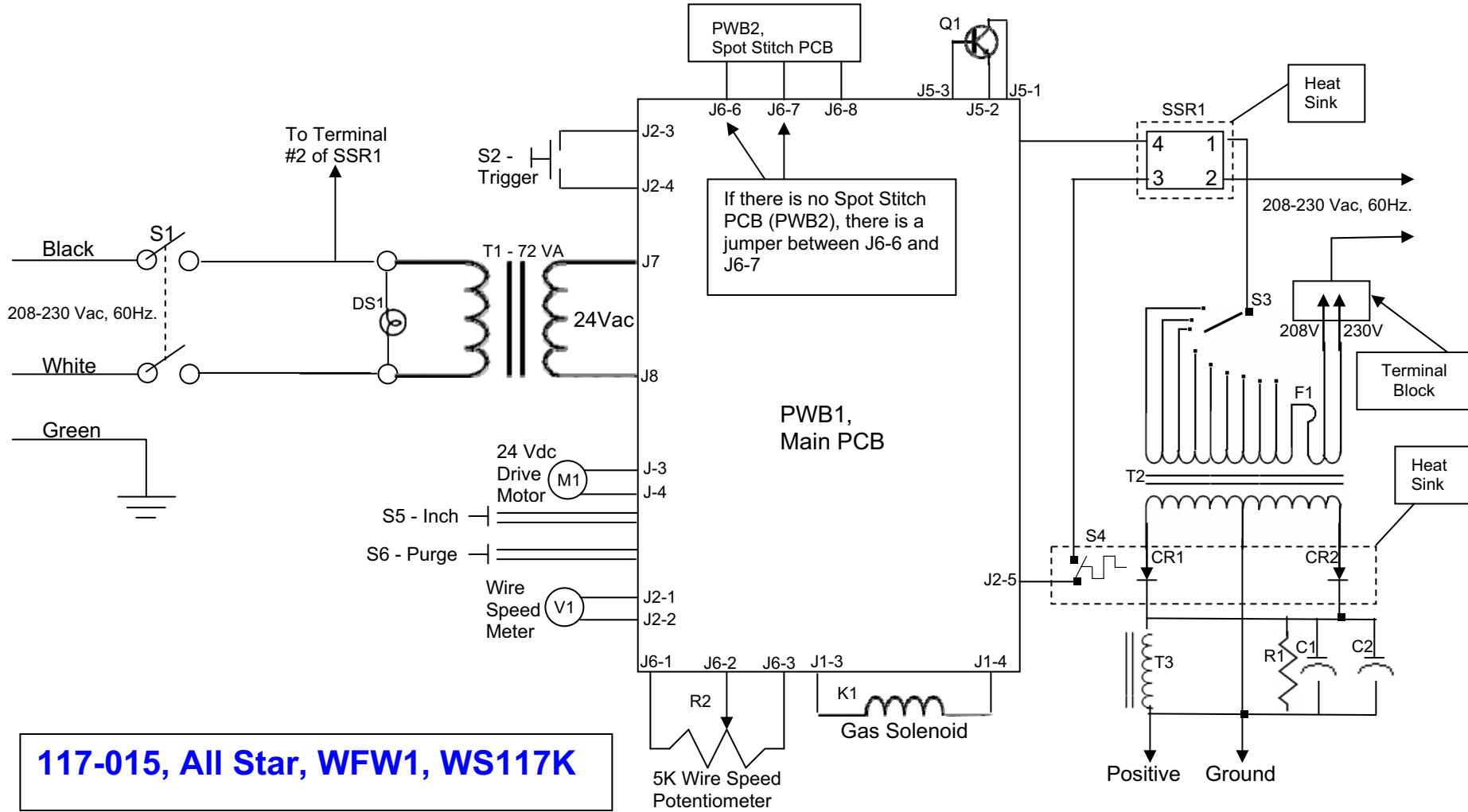
41	238-155-000	4320	Mig gun assembly less tip & nozzle, 10'
	334-203-000	4348	Nozzle for steel welding
	KP11-25	43090	0.025 Contact Tips
42		238-009-500	Ground cable w/plug & clamp, 12'
43	334-303-001	334-286-666	Gas regulator
44	059-245-666		Gas hose

8/9/2008

Rated Output	Voltage Settings	Agency Listing	Max Output
130 amps	9	CSA	130 amps

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C1 & C2 - 45,000µf, 45V, Electrolytic Capacitor	Q1 - MJ15015 Drive Transistor	S5 - Momentary Gas Purge Button
CR1 & CR2 - Diode, 250 Amp, 300 PIV	R1 - Resistor, 12.5Ω, 100 Watt	SSR1 - Triac Relay, 75 Amp
DS1 - 220V Neon Lamp	R2 - 5kΩ, ½ W Potentiometer	T1 - Control Transformer, 230 Vac to 24 Vac
F1 - Thermal One Shot, 240° Celsius Open	S1 - Power Switch, DPST, 60 Amp	T2 - Transformer, Main Weld
K1 - Gas Solenoid, 24 Vdc Coil	S2 - Gun Trigger, SPST	T3 - Reactor Coil
M1 - Drive Motor, 24 Vdc	S3 - Switch, Rotary 9 Position	V1 - Wire Speed Meter (not on all models)
PWB1 - Main Circuit Board	S4 - Thermal Breaker, 175° Celsius Open	
PWB2 - Spot Stitch Circuit Board	S5 - Momentary Inch Button	

117-015, All Star Schematic Legend

Symbol Description

C1	90,000 μ f, 45v, Electrolytic Capacitor
CR1	Diode, 150 amp, 300PIV
CR2	Diode, 150 amp, 300PIV
DS1	220v neon light
F1	One shot, 240 degrees celsius open
K1	Gas Solenoid, 24vdc coil
M1	24Vdc Wirefeed Motor
PWB1	Main Circuit Board
PWB2	Spot-Stitch Circuit Board
Q1	2N3055
R1	Resistor, 25 Ω , 50 watt
R2	5K Ω , 1W potentiometer

Symbol Description

R3	Resistor, 470 Ω , 1/2 watt
S1	DPST, Main Power Switch
S2	SPST, Gun Trigger
S3	9 Pole Rotary Switch
S4	Thermal Breaker, 175 degrees Celsius open
S5	SPST, Momentary Gas Purge
S6	SPST, Momentary Inch
SSR1	Triac Relay, D2440, 40 amp
T1	Control transformer, 230Vac to 24vac, 6 amp
T2	Weld transformer
T3	Reactor coil
V1	Wire Speed Meter