



LEGEND

- 2CR PILOT RELAY
- 7CR FLASHING CIRCUIT RELAY
- 8CR HOT START RELAY
- 9CR S-67 CONTACTOR
- 10CR REED SWITCH
- C1 0.1 MFD.
- C2 .047 MFD.
- C3 200 MFD.
- C4 0.1 MFD.
- C5 .047 MFD.
- C6 .047 MFD.
- C8 1.0 MFD.
- C9 6. MFD.
- C10 .022 MFD.
- C11 .022 MFD.
- C12 0.1 MFD.
- D1 22 A
- D2 22 A
- D3 16 A
- D5 16 A
- D6 16 A
- D7 100A
- D8 100A
- D9 100A
- D10 100A
- D11 100A
- D12 100A
- D13 1A
- D14 1A
- D16 1A
- L1 33 MH.
- Q1 2N3390
- Q2 2N5087
- Q3 UJT
- Q4 2N5087
- Q5 2N5087
- R1 2.5K Ω
- R3 4.7K Ω
- R4 3.9K Ω
- R5 3.0K Ω
- R6 2.2K Ω
- R7 1.5K Ω
- R8 1.0K Ω
- R9 1.0K Ω
- R10 4.7K Ω
- R11 2400 Ω
- R12 330 Ω
- R13 330 Ω
- R14 680 Ω
- R15 10K Ω
- R16 267 Ω
- R17 50K Ω TRIM
- R18 50K Ω TRIM
- R19 10K Ω V.V. CONTROL
- R20 10K Ω C.V. CONTROL
- R21 0.5 Ω 50 W.
- R25 50K Ω TRIM
- R26 10K TRIMMER (FORMERLY 50K)
- R27 5K Ω PORTABLE FIELD CONTROL
- R28 1.2K Ω
- T1 PULSE TRANSFORMER
- Z1 20V, 1W.
- S1 TOGGLE SWITCH
- S2 POLARITY SWITCH
- SCR1 2N4172
- SCR2 2N4172
- F2 AC, 20 AMP
- R22 100 Ω
- R24 500 Ω
- R29 100 Ω (NOT USED ON EARLY MODEL)

S1 SWITCH SHOWN IN VARIABLE VOLTAGE POSITIONS

* PARTS ON SMALL P.C. BOARD
 Δ PARTS ON LARGE P.C. BOARD

A.N.S.I. ELECTRICAL SYMBOLS PER E-18.57.

NOTE: SINGLE COMPONENTS OR CIRCUITS ON A P.C. BOARD MAY CHANGE WITHOUT AFFECTING THE INTERCHANGABILITY OF A COMPLETE BOARD. THIS PRINT MAY NOT SHOW THE EXACT COMPONENTS OR CIRCUITRY OF CONTROLS HAVING A COMMON CODE NUMBER.

TYPE 541-400 WELDERS
 S-14-75D
 THE LINCOLN ELECTRIC CO.
 CLEVELAND, OHIO U.S.A.
 DATE 2-24

L-5532
 LEAD-COLORED CODES
 BLUE
 BROWN