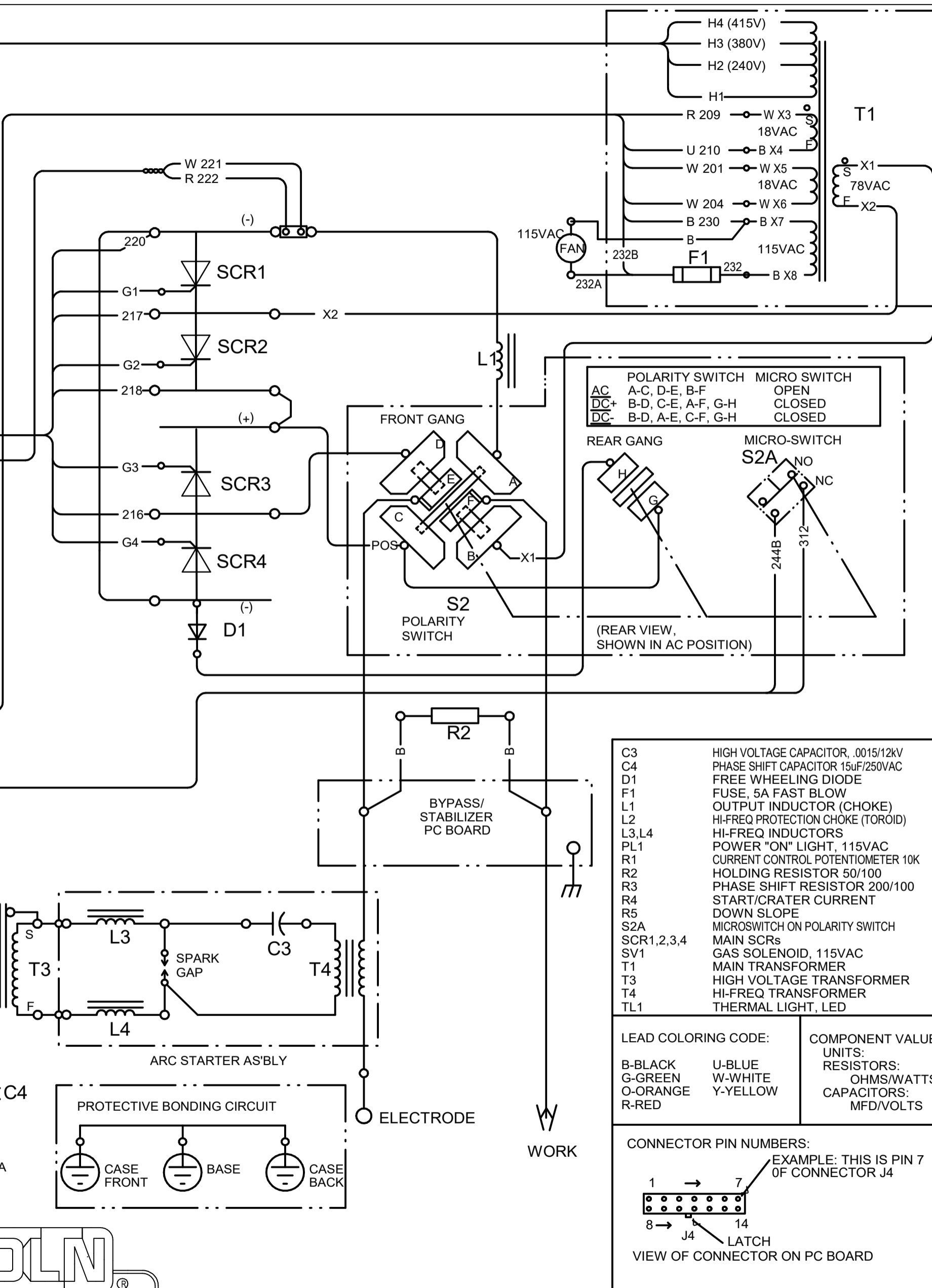
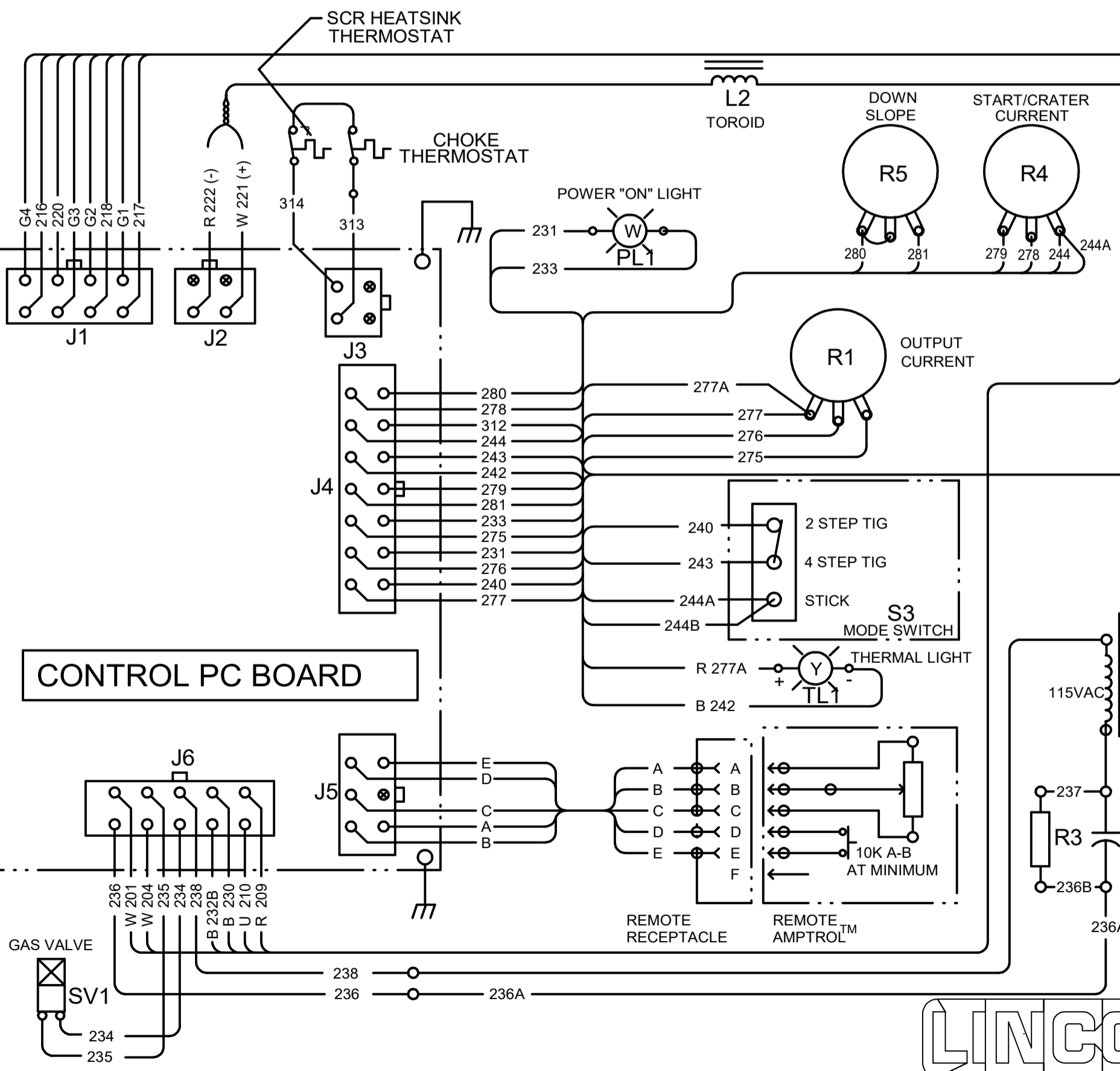
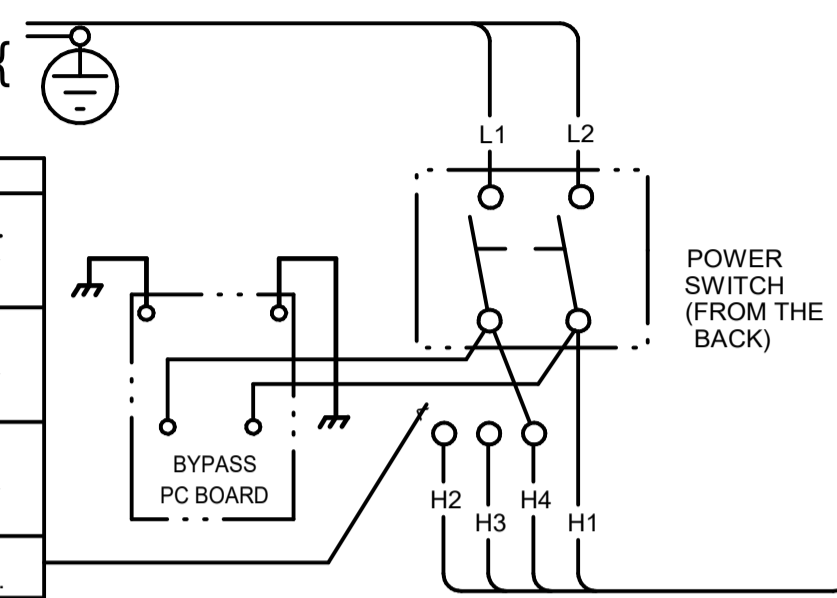


SQUARE WAVE TIG 175 (240/380/415/1/50/60) WIRING DIAGRAM L10808 REV: D

GROUND MACHINE PER NATIONAL AND LOCAL ELECTRICAL CODES. CONNECT THE TWO SUPPLY WIRES TO THE TOP OF THE POWER SWITCH AS SHOWN.

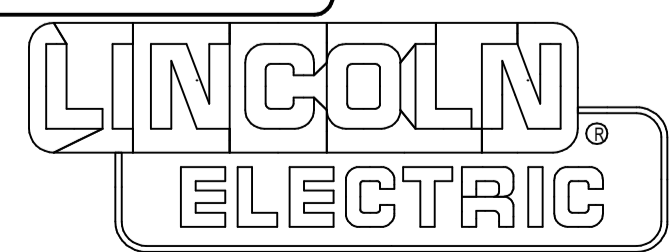
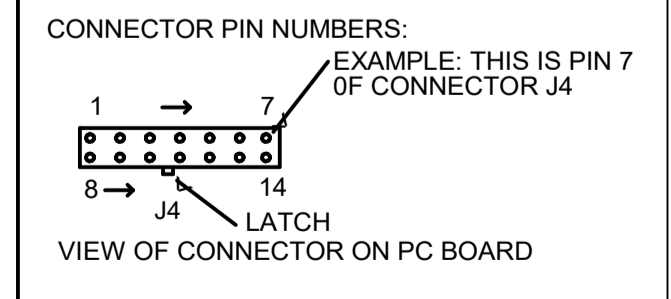
VOLTAGE RECONNECTION	
415 VOLT CONNECTION (AS SHOWN)	CONNECT COPPER LINK FROM POWER SWITCH STUD TO H4. TIGHTEN NUTS.
380 VOLT CONNECTION	CONNECT COPPER LINK FROM POWER SWITCH STUD TO H3. TIGHTEN NUTS.
240 VOLT CONNECTION	CONNECT COPPER LINK FROM POWER SWITCH STUD TO H2. TIGHTEN NUTS.
BYPASS PC BOARD MUST ALWAYS BE CONNECTED ACROSS POWER SWITCH.	



POLARITY SWITCH MICRO SWITCH	
AC	A-C, D-E, B-F OPEN
DC+	B-D, C-E, A-F, G-H CLOSED
DC-	B-D, A-E, C-F, G-H CLOSED

C3	HIGH VOLTAGE CAPACITOR, .0015/12kV
C4	PHASE SHIFT CAPACITOR 15uF/250VAC
D1	FREE WHEELING DIODE
F1	FUSE, 5A FAST BLOW
L1	OUTPUT INDUCTOR (CHOKE)
L2	HI-FREQ PROTECTION CHOKE (TOROID)
L3, L4	HI-FREQ INDUCTORS
PL1	POWER "ON" LIGHT, 115VAC
R1	CURRENT CONTROL POTENTIOMETER 10K
R2	HOLDING RESISTOR 50/100
R3	PHASE SHIFT RESISTOR 200/100
R4	START/CRATER CURRENT
R5	DOWN SLOPE
S2A	MICROSWITCH ON POLARITY SWITCH
SCR1,2,3,4	MAIN SCRS
SV1	GAS SOLENOID, 115VAC
T1	MAIN TRANSFORMER
T3	HIGH VOLTAGE TRANSFORMER
T4	HI-FREQ TRANSFORMER
TL1	THERMAL LIGHT, LED

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			



CLEVELAND, OHIO U.S.A.