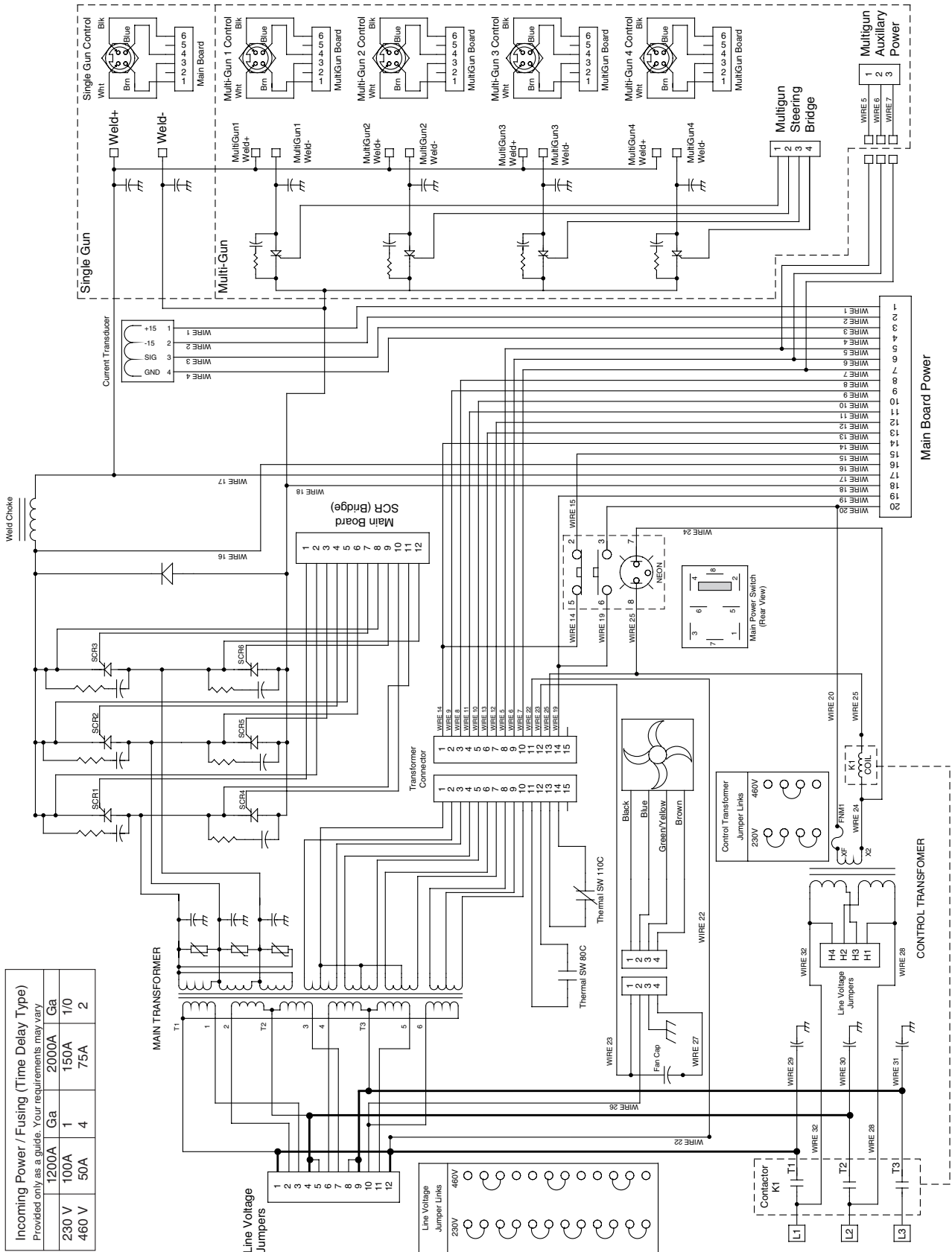


Section 8

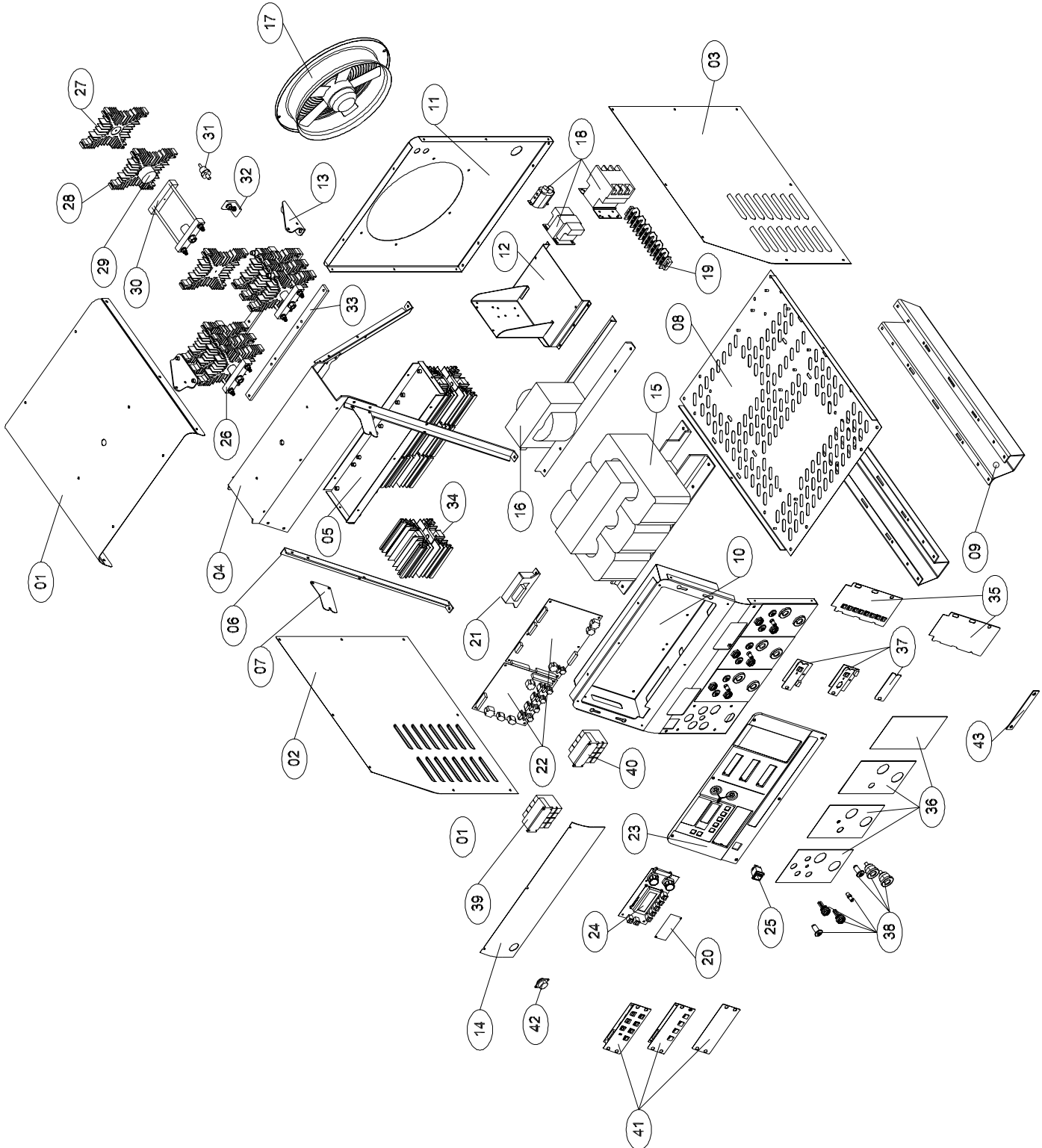
Schematic Diagram



Incoming Power / Fusing (Time Delay Type)			
Provided only as a guide. Your requirements may vary			
1200A	Ga	2000A	Ga
230 V	100A	150A	1/0
460 V	50A	75A	2

Section 9

Parts List



Section 9

Parts List

Item	Description	Part Number
01	Sheet Metal Top	PAS240
02	Sheet Metal Left Side	PAS242
03	Sheet Metal Right Side	PAS241
	Schematic Decal	PAD241
04	Cross Brace	PAC280
05	Multigun SCR Support Pan	PAC281
06	A-Arm Left Front / Right Rear	PAC260
	A-Arm Right Front / Left Rear	PAC261
07	Front Sheet Metal Reinforcement Bracket	PAK111A
08	Base Pan	PAC221
09	Chassis Leg	PAC201
10	Front Sheet Metal Assembly	PAS225
11	Rear Sheet Metal	PAS230
12	Auxillary Module Tray	PAK125
	Voltage Jumper Decal	PAD125
	Jumper Wire T1	PAH013
	Jumper Wire T2	PAH012
	Jumper Wire T3	PAH011
	Delta Jumper Wire T1-T3	PAH010
13	Rectifier Bracket Right Side	PAK102A
	Rectifier Bracket Left Side	PAK101A
	Isolation Flat Washer	WFN43-62-25
	Isolation Shoulder Washer	WSN25-62-50x42-39
14	Finish Panel (standard)	PAM250
	Finish Panel (Robot/HLC connector)	PAM251
15	Transformer 1200A 60hz	PAE501
	Transformer 2000A 60hz	PBE501
	Transformer 1200A 50hz	PAE500
	Transformer 2000A 50hz	PBE500
16	Weld Choke 1200A	PAE600
	Weld Choke 2000A	PBE600
17	Cooling Fan Assembly	PAE902
18	Contact 1200A	PAE101
	Contact 2000A	PBE101
	Control Transformer	ETC440/220-110-50
	Control Transformer Fuse	EFFNM-1
	Fan Capacitor	EC370-6
19	Terminal Strip	ETB70-12
	Terminal Strip Jumper Link	ETBJ70
20	Protective LCD Screen Shield	PAM1301
21	Current Transducer 1200A	ECT1000
	Current Transducer 2000A	ECT1500
22	Main PCB (right side)	PAP101C
	Multigun/Autofeed Board (Left Side)	PAP1201B
23	Control Panel	PAM1300
24	User Interface Assembly	PAE2000
	Rotary Knobs	PAM110
	Ribbon Cable to Main Board	PAH004

Item	Description	Part Number
25	Power Switch	PAE3
26	Rectifier Assembly	PAE1050
	Single Phase Filter Network	PAE800
	AC Surge Network	PAE802
	SCR Harness	PAH001
27	Single Sided Heatsink	PAM2
	Spring Pin Locator	SPC12-37ZP
	Thermal Paste	ETP
28	Double Sided Heatsink	PAM3
29	Weld SCR 1200A	ESR55006PK
	Weld SCR 2000A	ESR75006PK
30	SCR Clamp 1200A	PAM200
	SCR Clamp 2000A	PBM200
31	Snubber Diode	EDS004
32	Snubber Diode Bracket	PAM50
33	Rectifier Buss Bar	PAE1001
34	Steering SCR Assembly	PAE1060
	Steering SCR Heatsink	PAM4
	Steering SCR	ESR120002PK
	Steering SCR Clamp	PAM202
	Isolation Flat Washer	WFN43-62-31
	Isolation Shoulder Washer	WSN25-62-50x42-39
	Common Side Jumper	PAE81
35	Multi-gun Steering SCR Harness	PAH016
	Memory Module Blanking Plate	PAS140A
36	Memory Module Assembly	PAE2102
	Weld Output Blanking Plate	PAM1100
	Standard Weld Output (3 Hole)	PAM1110
	Weld Output with Gas (4 Hole)	PAM1120
	Weld Output with Autofeed (7 Hole)	PAM1130
37	Small Module Blanking Plate	PAS120A
	Data Recorder Module	PAE2103
	Gas Control Module	PAE2101
38	Panel Mount Weld Cable Connector (Red)	CCL1/ORFR
	Panel Mount Weld Cable Connector (Black)	CCL1/ORFB
	Gas Connector Panel Mount	PNBQ-156B
	Gun Control Cable Panel Mount Connector	PAH014
	Feeder Bowl Cable Panel Mount Connector	PAH015
	Autofeed Air Line Bulkhead Connector	PNB25T25TS
39	Gas Manifold	PNMA-4
	Gas Valve	PNVA24-2
	Gas Valve Station Plug	PNMA-PLUG
40	Autofeed Air Manifold	PNMB-4
	Autofeed Valve	PNVA24-4
	Autofeed Valve Station Plug	PNMB-PLUG
41	Multi-gun / Autofeed Blanking Plate	PAS130A
	Multi-gun User Interface	PAE1202
	Multi-gun / Auto Feed User Interface	PAE1203
42	Robot / High Level Control Harness	PAH017
43	Multi-gun Ground Jumper Link	PAE80

Items Not Shown

44	Weld Output Filter	PAE801	52	Retention Strap Spring	PAM72
45	Cable 1200A Rectifier to Choke	CW3KK-1.3	53	Main Wiring Harness	PAH002
46	Cable 1200A Choke to Ground	CW34K-2.3	54	Multi-gun/Autofeed Aux Power Harness	PAH003
47	Cable 1200A Rectifier to Gun	CW34K-3	55	Incoming Power Cord Grip	ECG1P
48	Cable 2000A Rectifier to Choke	CW5LL-1.3	56	Rear Sheet Metal Hole Plug	PNP75
49	Cable 2000A Choke to Ground	CW5ML-2.3	57	Ribbon Cable Main PCB to MG PCB	PAH006
50	Cable 2000A Rectifier to Gun	CW5ML-3	58	Power Cable Main PCB to MG PCB	PAH005
51	Control Panel Retention Straps	PAM71	59	Autofeed Solenoid Harness	PAH008