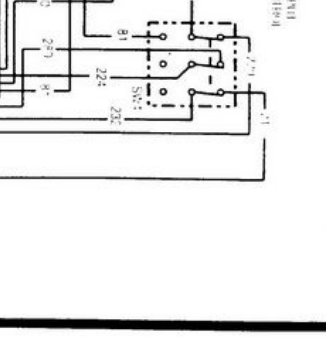
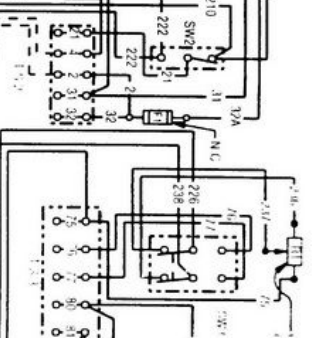
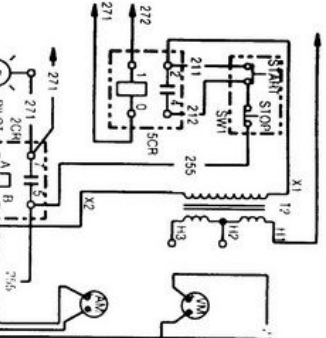
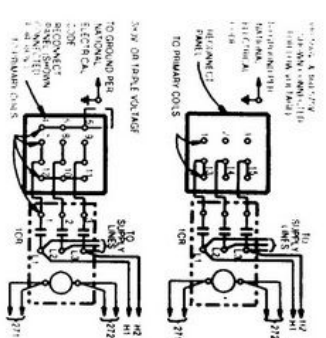
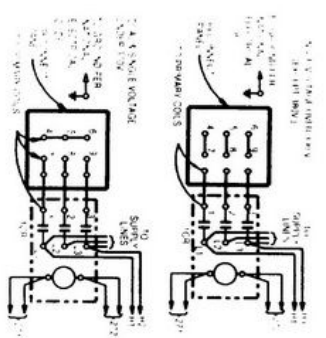
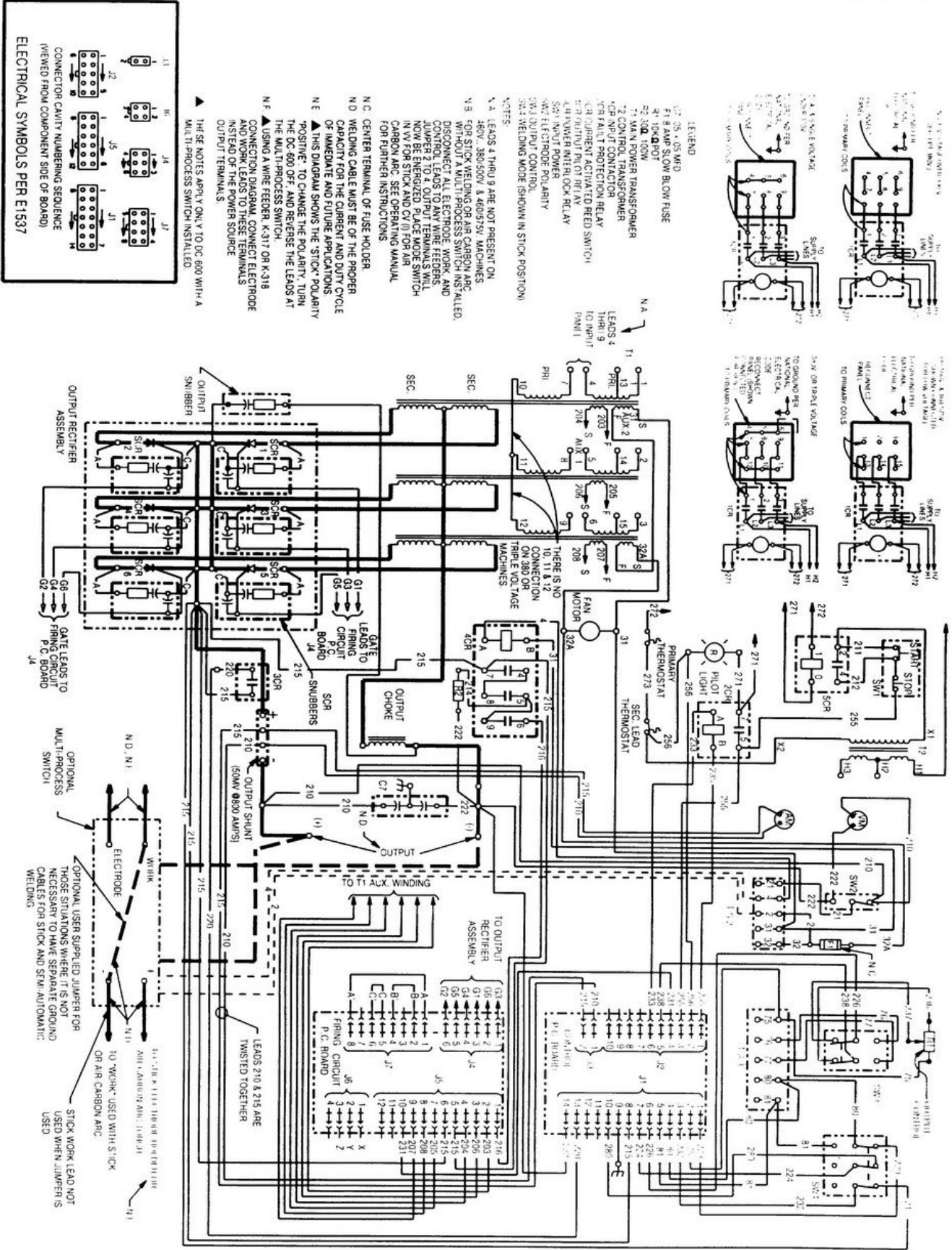
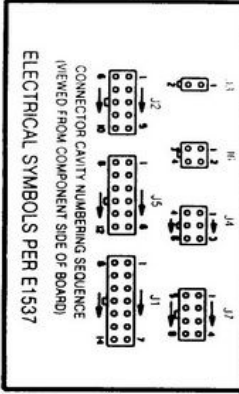


WIRING DIAGRAM (Various Single, Dual and Triple Voltage Machines)



- LEAD NO.
- *1 8 AMP SLOW BLOW FUSE
 - *2 CONTROL TRANSFORMER
 - *3 MAIN POWER TRANSFORMER
 - *4 SCR INPUT CONTACTOR
 - *5 SCR FAULT PROTECTION RELAY
 - *6 SCR CURRENT ACTIVATED REED SWITCH
 - *7 SCR OUTPUT PILOT RELAY
 - *8 SCR OVER INTERLOCK RELAY
 - *9 SCR INPUT POWER
 - *10 SCR FET CONTROL
 - *11 SCR OUTPUT CONTROL
 - *12 WELDING MODE (SHOWN IN STICK POSITION)

- NOTES
- N.A. LEADS 1 THRU 9 ARE NOT PRESENT ON -460V, 380/500V & 480/575V MACHINES.
 - N.B. FOR STICK WELDING OR AIR CARBON ARC WELDING, A MULTI-PROCESS SWITCH IS INSTALLED.
 - N.C. CENTER TERMINAL OF FUSE HOLDER.
 - N.D. WELDING CABLE MUST BE OF THE PROPER CAPACITY FOR THE CURRENT AND DUTY CYCLE OF IMMEDIATE AND FUTURE APPLICATIONS.
 - N.E. THIS DIAGRAM SHOWS THE 'STICK' POLARITY 'POSITIVE'. TO CHANGE THE POLARITY, TURN THE DC-600 OFF AND REVERSE THE LEADS AT THE MULTI-PROCESS SWITCH.
 - N.F. ▲ USING A WIRE FEEDER, K-317 OR K-318 CONNECTION DIAGRAM, CONNECT ELECTRODE AND WORK LEADS TO THESE TERMINALS INSTEAD OF THE POWER SOURCE OUTPUT TERMINALS.
- ▲ THE SE NOTES APPLY ONLY TO DC-600 WITH A MULTI-PROCESS SWITCH INSTALLED.



CONNECTOR CAVITY NUMBERING SEQUENCE (VIEWED FROM COMPONENT SIDE OF BOARD)

ELECTRICAL SYMBOLS PER E1537

TO CHECK THE MOTOR OPERATION, THE CARBON ARC CIRCUIT MUST BE USED.

OPTIONAL USER SUPPLIED JUMPER FOR THOSE SITUATIONS WHERE IT IS NOT NECESSARY TO HAVE SEPARATE GROUND CABLES FOR STICK AND SPW. AUTOMATIC WELDING.

TO WORK USED WITH STICK OR AIR CARBON ARC

STICK WORK LEAD NOT USED WHEN JUMPER IS USED

LEADS 210 & 215 ARE TWISTED TOGETHER

TO OUTPUT RECTIFIER ASSEMBLY

TO T1 AUX. WINDING

TO CHECK MOTOR OPERATION, THE CARBON ARC CIRCUIT MUST BE USED.

OPTIONAL USER SUPPLIED JUMPER FOR THOSE SITUATIONS WHERE IT IS NOT NECESSARY TO HAVE SEPARATE GROUND CABLES FOR STICK AND SPW. AUTOMATIC WELDING.

NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual. The specific diagram for a particular code is pasted inside the machine on one of the enclosure panels. If the diagram is illegible, write to the Service Department for a replacement. Give the equipment code number.