



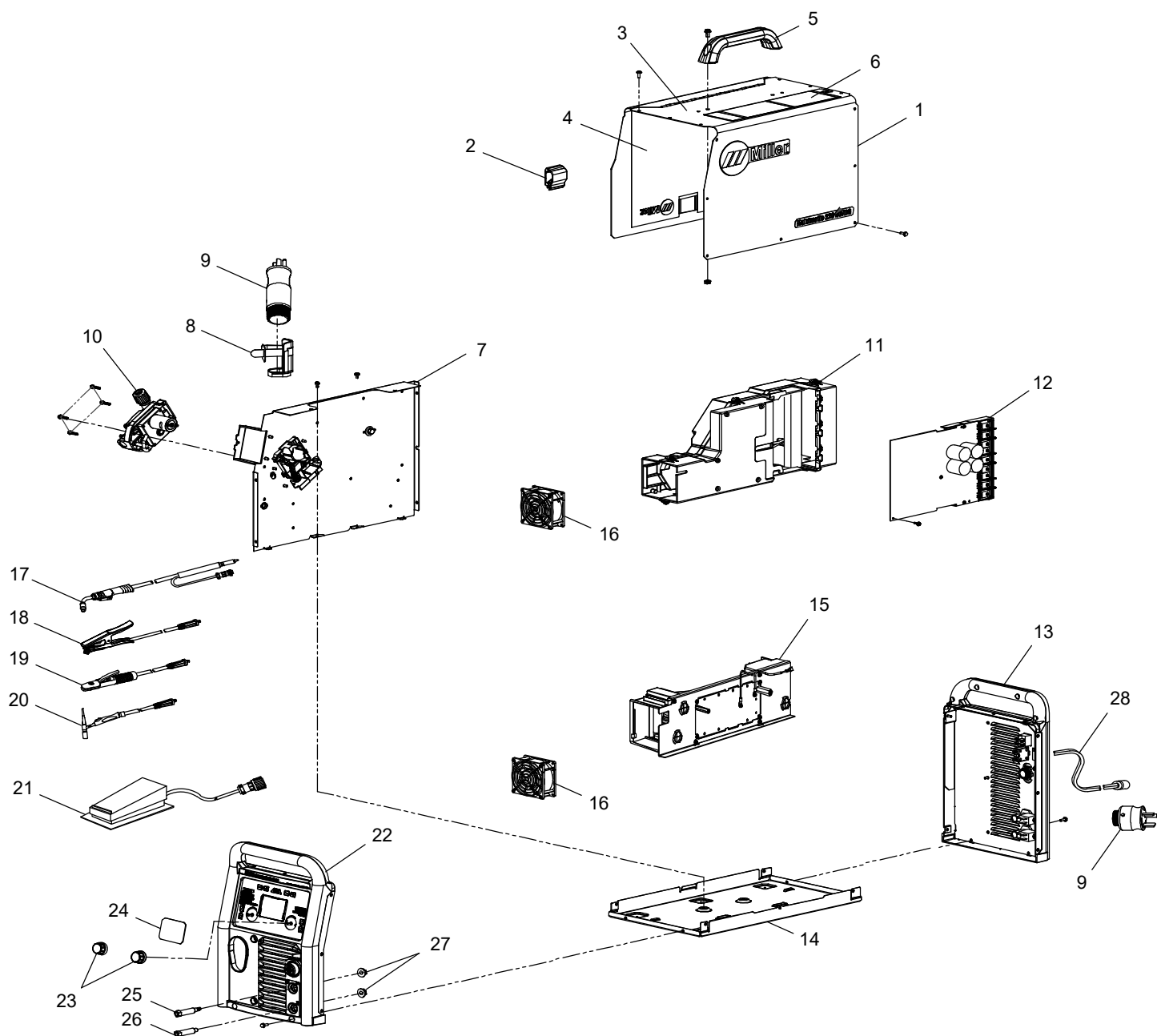
PM- 281431 D

Multimatic 220

Effective with Serial Number
MJ418713N - ZZ222222



PARTS MANUAL



Main Assembly

Main Assembly

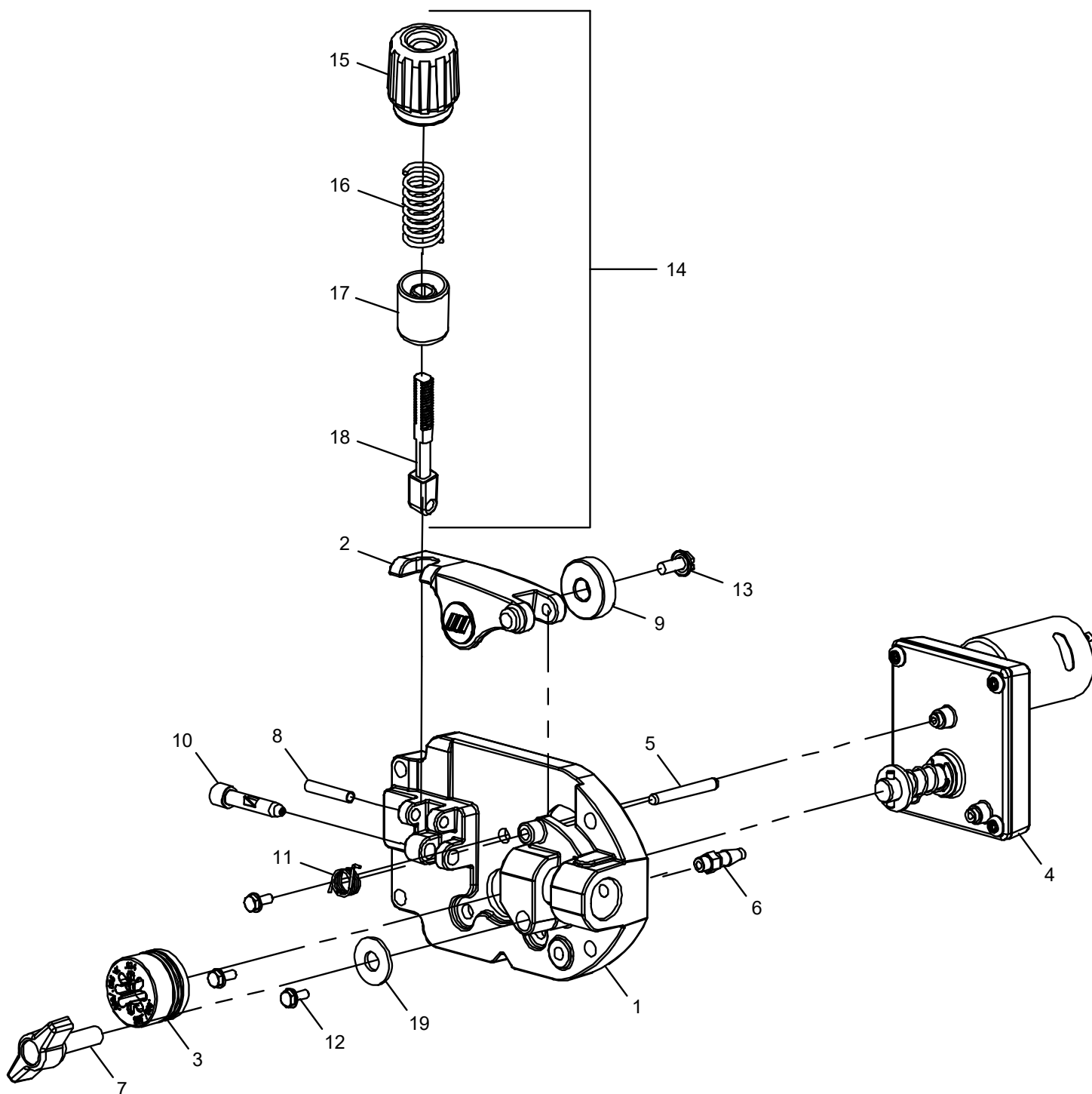
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		281401	Wrapper Assy	1
2		230363	Latch, Slide Flush Mtg Hole 1.750 Wide x 1.500 Lg	1
3		282821	Insulator, Wrapper 6.000 x 15.000	1
4		282820	Insulator, Wrapper 4.000 x 8.000	1
5		265650	Handle Assy, Center	1
6		282298	Label, Warning Gnrl Precaut W O/I and AC Out	1
7			Baffle Assembly	1
8		271430	Holder, Power Cord Adapter w/Strap	1
9		219261	Adapter, Power Cable 5-15P (115V/15A)	1
/		219258	Adapter, Power Cable 6-50P (230V/50A)	1
/		~ 219259	Adapter, Power Cable 5-20P (115V/20A)	1
10			Drive Assembly, Wire	1
11			Primary Windtunnel with Components	1
12	PC1	281032	Circuit Card Assy, Primary Control	1
13			Rear Panel Assembly	1
14		281390	Base, Multimatic 220 AC/DC	1
15			Secondary Windtunnel with Components	1
15			Secondary Heatsink with Components	1
16	FM1,FM2	284484	Kit, Fan Replacement Multimatic 220 AC/DC	2
17		248282	Gun, M-100 10Ft .030-.035	MJ418713N - MK099824N 1
17		1770027	MDX-100 Gun 10 ft .030-.035 w/Acculock	MK099825N - ZZ222222N 1
18		208561	Work Clamp, w/Cable & Connector - 10 Ft	1
19		208596	Holder, Electrode w/Cable & Connector	1
20		WP1712RDI25	Tig Torch, A-150 12.5 Ft	1
21		194744	RFCS-14HD (Foot Control)	1
22			Front Panel Assembly	1
23		266591	Knob, Encoder 1.250 Dia x 6mm Id Push On w/Spring	2
24		271493	Lens Covet, Replaceable	1
25		282082	Rcpt, Tw Lk Brass Power/Gas Female w/Ring	1
26		282119	Rcpt, Tw Lk Brass Power Female	1
27		281403	Insulator, Bulkhead 25Mm Tig	2
28		265471	Cable, Power 7 Ft 5 In 14 Ga 3C SOOW w/Spl Plg	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

Hardware is common and not available unless listed.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.



Wire Drive Assembly

Wire Drive Assembly

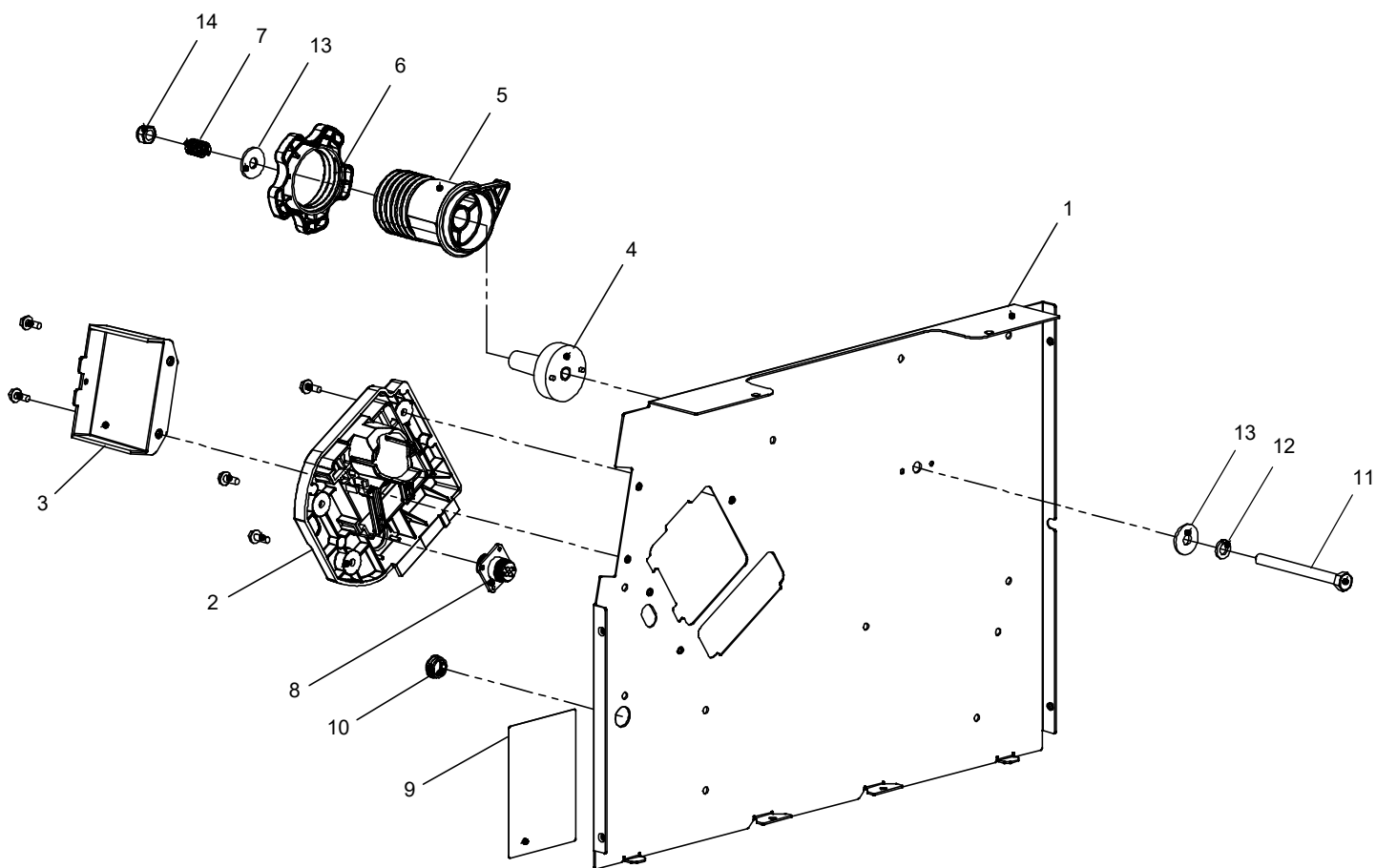
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		274147	Housing, Drive (Machined)	1
2		274149	Lever, Pressure Roll	1
3		261157	Roll, Drive 024, 030-035V Wire, 035VK Wire	1
4	DM	261150	Motor, Gear 16 Vdc w/Leads Dbl Needle Bearing	1
5		608058	Pin, Dowel Hrd .187 x 1.500 Lg	1
6		263411	Fitting, Barbed Gas	1
7		222035	Knob, T 1562 Bar w/312-18 Stud 1000 Lg Plstc	1
8		010224	Pin, Spring CS .187 x 1.000	1
9		189915	Bearing, Ball Rdl Sgl Row 9mm x 26mm x 8mm Wide Sh	1
10		261151	Guide, Wire Inlet 060	1
11		264715	Spring, Torsion	1
12		197172	Screw, 006-32 x .37 Hexwhd-Pln Silver Tri-Lobe	3
13		188846	Screw, 0.10-32 x .50 Hex Hd-Slt Stl Zinc Sqcone Sems	1
14		221980	Knob, Tension	1
15		196895	Knob, Tension	1
16		234200	Spring, Cprsn .696 Od x .086 Wire x 1.500	1
17		198080	Cup, Spring 185	1
18		225718	Fastener, Pinned	1
19		604538	Washer, Flat .344 Id x 0.688 Od x .065T Stl Pld Ansi .312	1
/		282797	Tubing, PVC .187 Id x .312 Od x 24.000 Clear	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

Hardware is common and not available unless listed.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.



Baffle Assembly

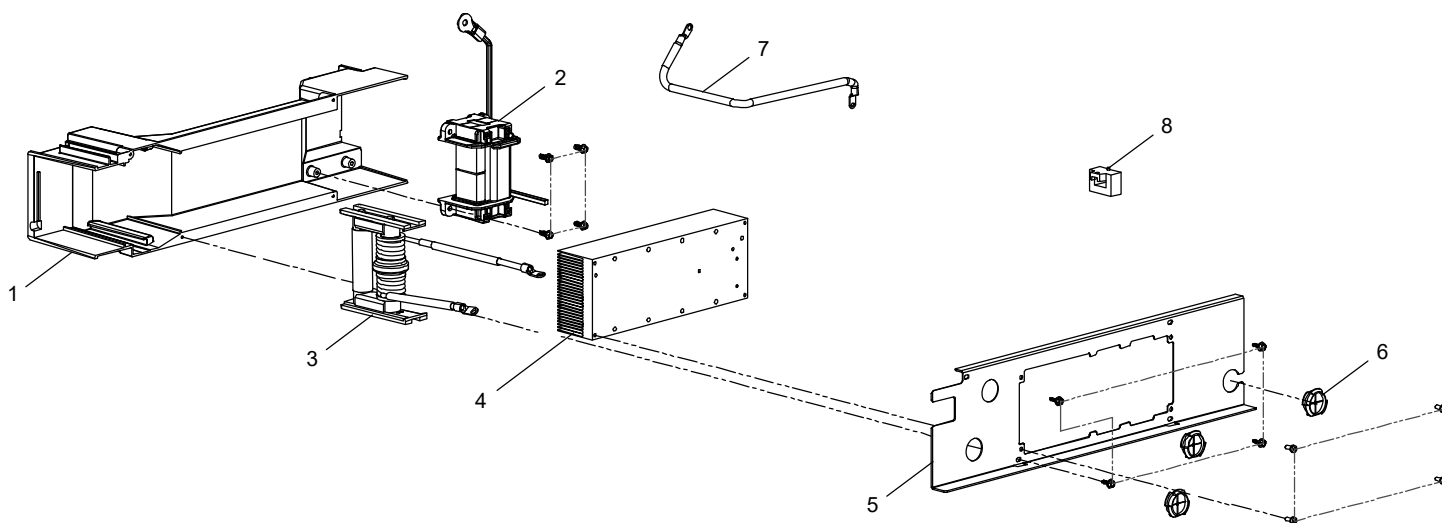
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		281391	Baffle, Center	1
2		281732	Insulator, Drive Housing Multimatic 220 AC/DC	1
3		263788	Enclosure, Electronics	1
4		202726	Adapter, Spool Hub	1
5		265004	Hub, Spool	1
6		235607	Nut, Hub	1
7		225257	Spring, Cprsn .467 Od x .060 Wire x .700 Pld	1
8		281413	Harness, Wrg Unit Main Multimatic 220 AC/DC	1
9		231985	Label, Warning Electric Shock	1
10		209412	Bushing, Snap-In Nyl .500 Id x .625 Mtg Hole	1
11		203071	Screw, .312-18 x .350 Hex Hd-Pln Gr5 Pld Full Thread	1
12		602211	Washer, Lock .318 Id x 0.586 Od x .078T Stl Pld Split .312	1
13		203072	Washer, Flat .331 Id x 0.945 Od x .079T Stl Pld	2
14		204608	Nut, 312-18 .50Hex .34H Stl Pld Elastic Stop Nut	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

Hardware is common and not available unless listed.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.



Secondary Windtunnel with Components

Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		281428	Windtunnel, Secondary	1
2	L3	281415	Xfmr, HF Coupling	1
3	L2	281423	Inductor, Output	1
4		281969	Heat Sink Assy, Secondary Multimatic 220	1
5		281466	Bracket, Mtg Heat Sink	1
6		278885	Grommet, Rubber	3
7		282276	Lead List, Large	1
8	HD1	191941	Transducer, Current 200A Module Supply V +/- 15V	1

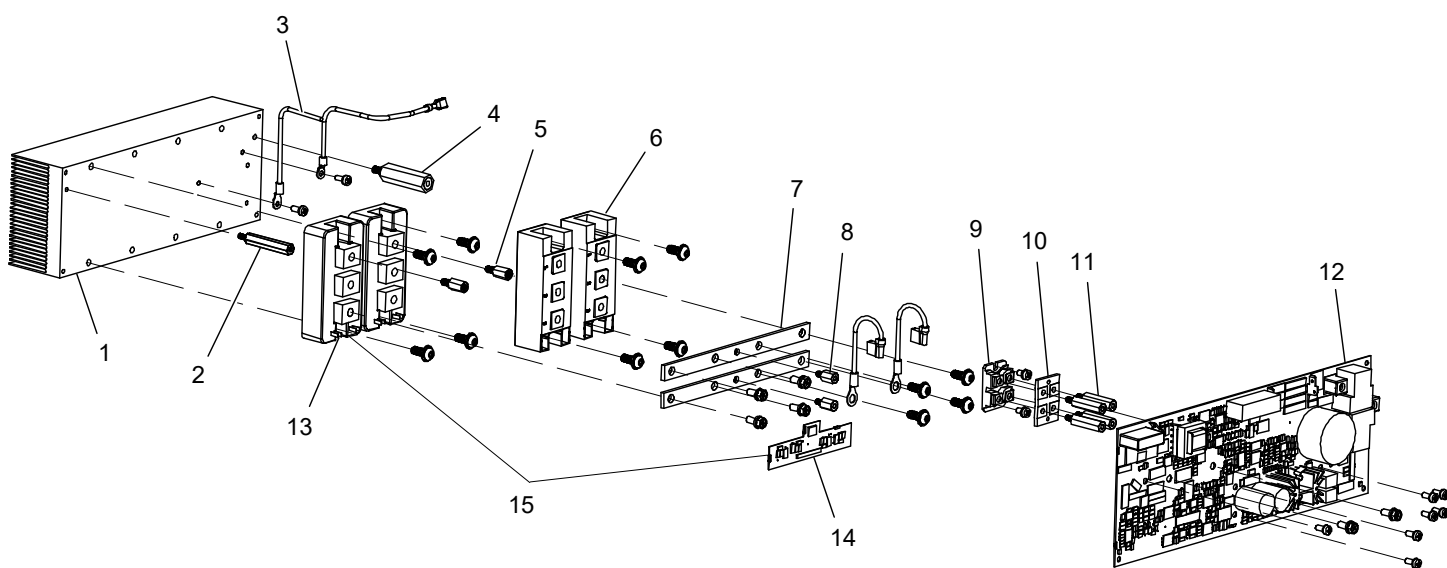
*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

Hardware is common and not available unless listed.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Multimatic 220



Secondary Heatsink with Components

Secondary Heatsink with Components

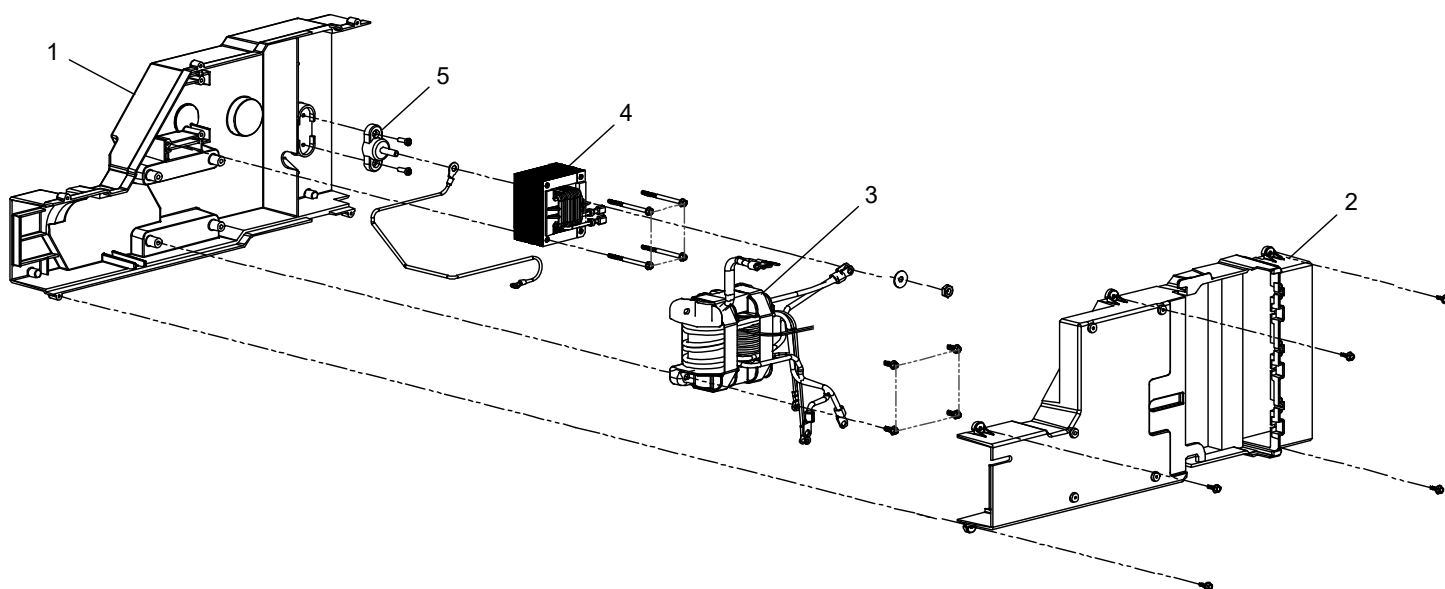
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		281417	Heat Sink, Secondary	1
2		281962	Stand-Off, M4 x 0.7 x 45mm Lg 8mm Hex Stl M and F	1
3	RT1	282398	Thermistor, NTC 30K Ohm at 25 Deg C 7.00 Lead	1
4		283154	Stand-Off, M5 x 0.8 x 45mm Lg 13mm Hex M and F Insulator	1
5		281961	Stand-Off, M5 x 0.8 x 14mm Lg 8mm Hex Al M and F	2
6	SR1,SR2	283391	Kit, Diode Ultra Fast Recovery 205A 600V Dual	2
7		281405	Bus Bar, Output	2
8		276732	Stand-Off, M4 x 0.7 x 12mm Lg 8mm Hex Al M and F	2
9		259419	Kit, Ultra-fast Diode	2
10		250831	Spacer, PWB	1
11		274924	Stand-Off, M4 x 0.7 x 30mm Lg 8mm Hex AL M&F	4
12	PC3	281065	Circuit Card Assy, Commutator Cntrl	1
13	PM1,PM2	281388	Transistor, Igbt 300A 650V	2
			For serial numbers that end in N	
13	PM1,PM2	283711	Transistor, IGBT 100A 650V	2
			For serial numbers that end in Y	
14		282562	Circuit Card Assy, Breakaway Board (281065)	1
			For serial numbers that end in N	
14		285941	Circuit Card Assy, Gate Drive	1
			For serial numbers that end in Y	
/		285687	Circuit Card Assy, Secondary Igbt Gate Drive	1
/		285516	Cable, Ribbon 10 Posn 2.750 In w/Plug (Not Shown)	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

Hardware is common and not available unless listed.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.



Primary Windtunnel with Components

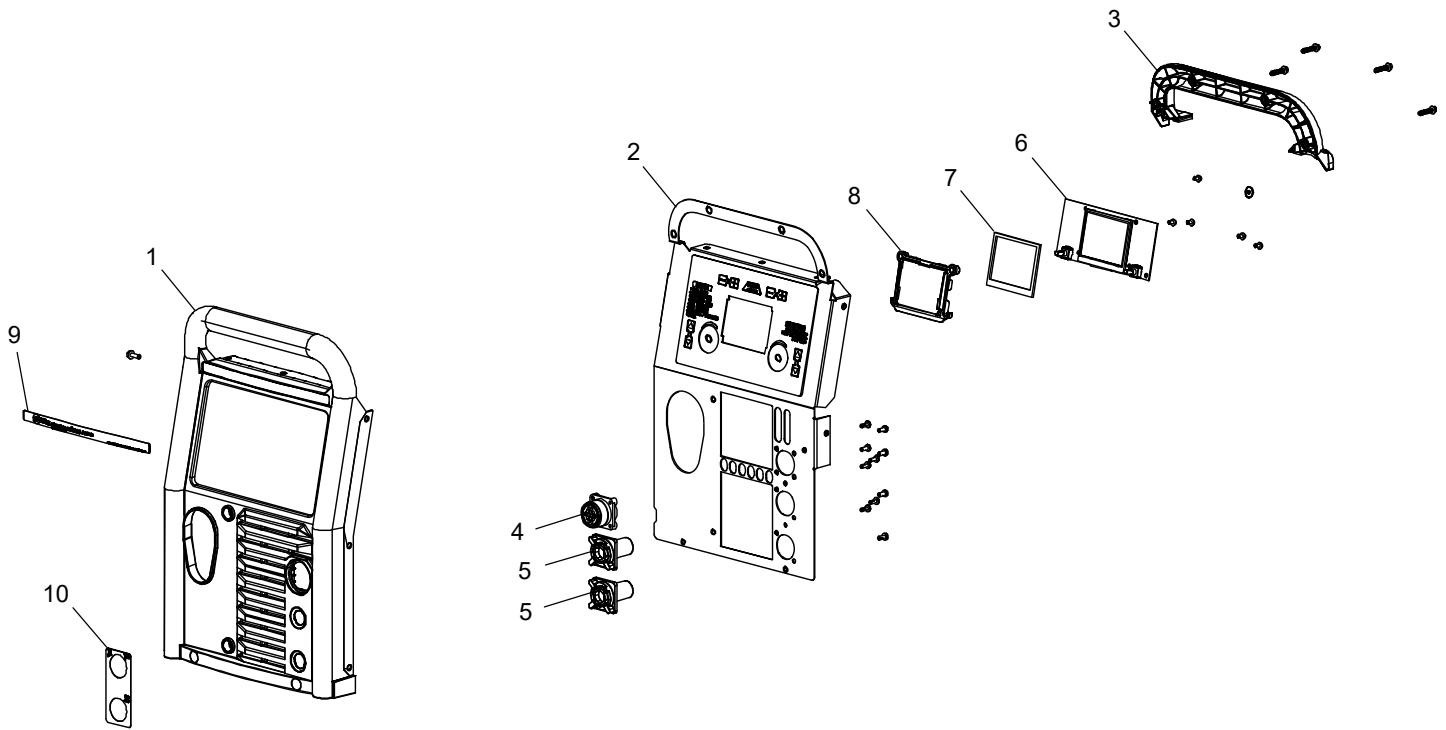
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		281411	Windtunnel, Lh	1
2		281412	Windtunnel, Rh	1
3	T1	281433	Xfmr, Main	1
4	L1	265756	Input, Inductor	1
5		263441	Stud, Connection Single	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

Hardware is common and not available unless listed.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.



Front Panel Assembly

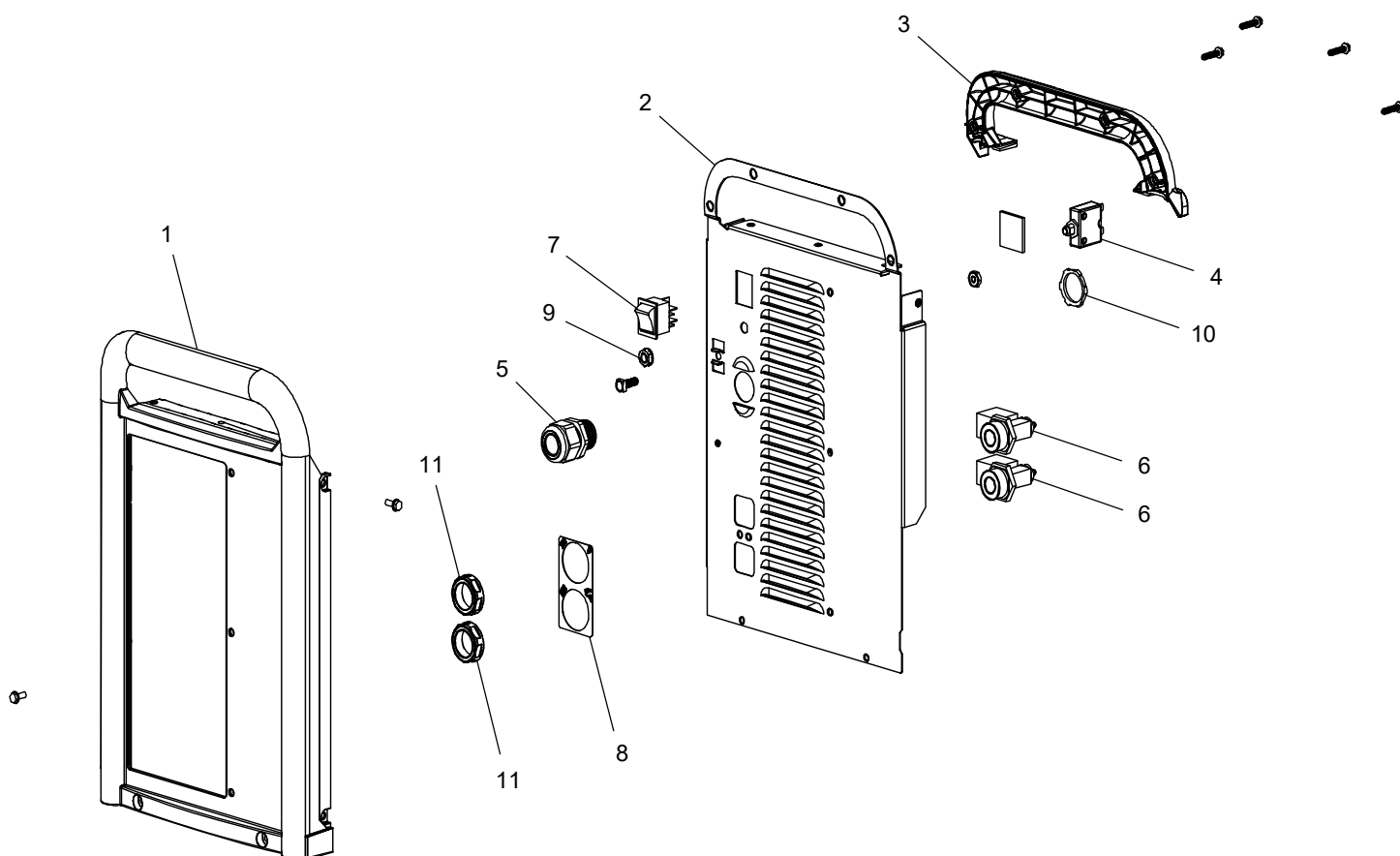
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		281392	Bezel, Front	1
2		284580	Kit, Front Panel Replacement Multimatic 220	1
3		263752	Bezel, Handle	1
4		281402	Lead Assy, Process Control 14 Pin	1
5		281403	Insulator, Bulkhead 25Mm Tig	2
6		280928	Circuit Card Assy, Interface w/Prgm Multimatic 220	1
7		271494	Lens, Front Panel	1
8		272954	Gasket, Lcd Display Multimatic 215	1
9		281425	Label, Nameplate Multimatic 220 AC/DC	1
10		282839	Label, Secondary Connection Tig/Stick/Work	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

Hardware is common and not available unless listed.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.



Rear Panel Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		281394	Bezel, Rear	1
2		281389	Panel, Rear	1
3		263752	Bezel, Handle	1
4	CB1	282427	Supplementary Protector, Man Reset 1P 35A 250 Vac Fr	1
5		201155	Bushing, Strain Relief .450/.709 Id x 1.068 Mtg Hole	1
6	GS1,GS2	262572	Valve, 24 Vdc 1Way 750-14 Thd 2mm Orf 100Psi	2
7	S1	264751	Switch, Rocker DPST 20A 250 Vac On-Off Blk Panel Mtg	1
8		272940	Label, Gas Valve Mig/Tig Multimatic 215	1
9		147195	Nut, .375-27 .54Hex 25H Nyl Flange 62D	1
10		198245	Nut, Conduit .750 Npt Pld 1.388 Od x .150 Thk	1
11		272186	Nut, .750-14 Nps 1.312Hex .413H Nyl	2

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

Hardware is common and not available unless listed.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.