



PM283935A

2020-10

Processes



Multiprocess Welding

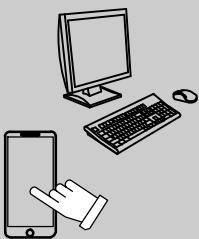
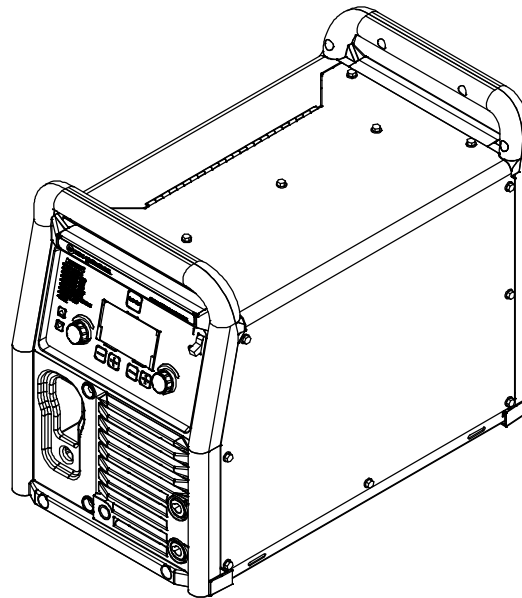
Description



Arc Welding Power Source And
Wire Feeder

Multimatic[®] 235

Eff w/Serial No. NA288617N And Following

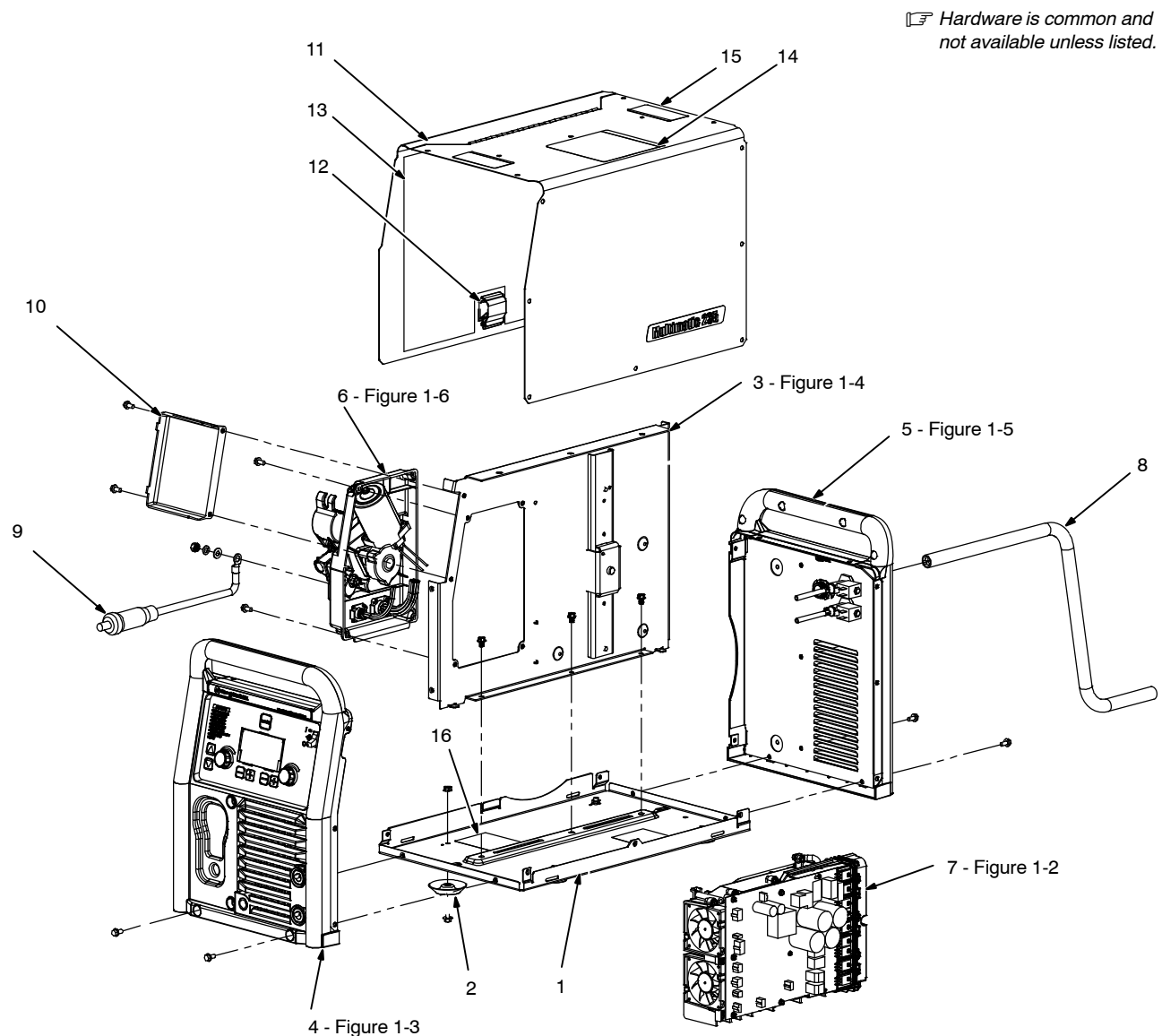


For product information,
Owner's Manual translations,
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PARTS MANUAL

SECTION 1 – PARTS LIST EFF W/SERIAL NO. NA288617N AND FOLLOWING



907780

Figure 1-1. Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-1. Main Assembly				
...	1	...	+277329 .. Base	1
...	2	...	229325 .. Foot, Mtg Unit	4
...	3	...	Figure 1-4 .. Baffle Assy, Center	1
...	4	...	Figure 1-3 .. Panel Assy, Front	1
...	5	...	Figure 1-5 .. Panel Assy, Rear	1
...	6	...	Figure 1-6 .. Drive Assy, Wire	1
...	7	...	Figure 1-2 .. Windtunnel, w/Components	1
...	8	...	287595 .. Cord Set, 250V 6-50P12Ga 3/C 9 Ft SOOW JKT	1

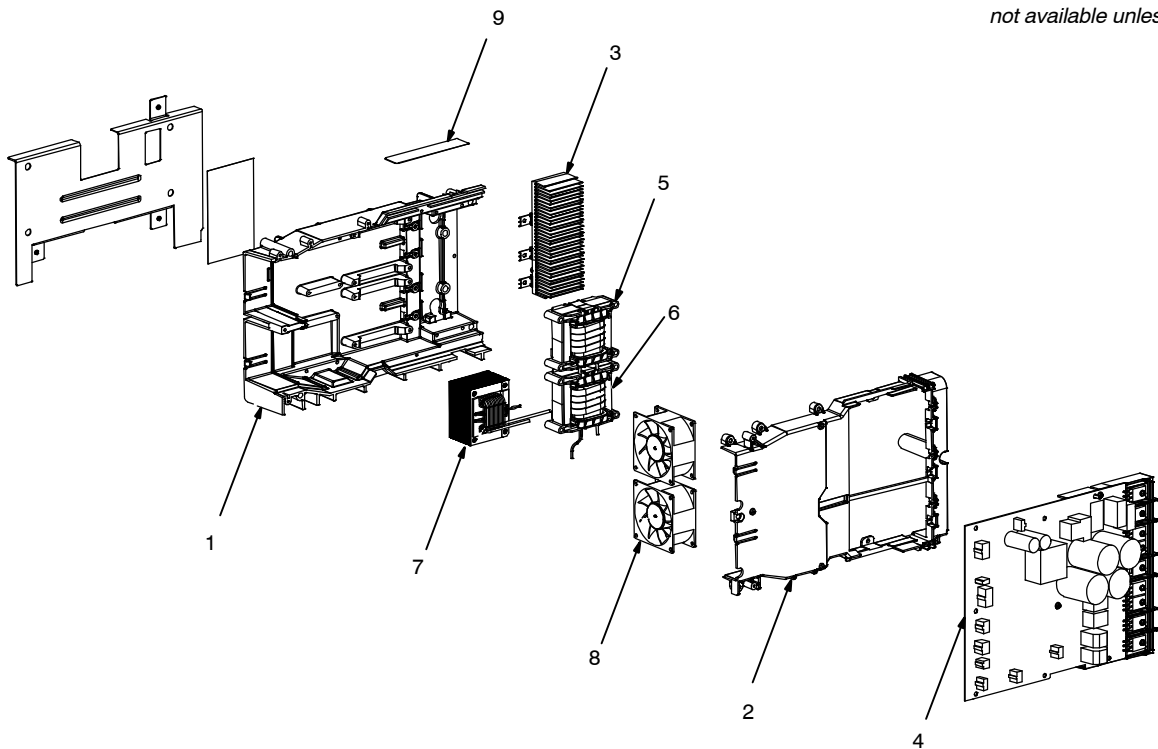
Eff w/Serial No. NA288617N And Following

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-1. Main Assembly (Continued)				
... 9		278556	.. Lead Assy, Drive Polarity	1
... 10		277905	.. Enclosure, Electronics	1
		288431	.. Core, Ferrite 28.50MM OD X 13.80MM Id X 28.60MM Lg	1
... 11		289249	.. Kit, Wrapper w/Labels (Includes)	1
		277356	 Wrapper Assy	1
... 12		230363	 Latch, Slide Flush Mtg Hole 1.750 Widex 1.500 Lg	1
... 13		283930	 Label, Parameter/Polarity	1
... 14		231983	 Label, Warning General Precautionary (En/Fr/Sp)	1
... 15		283727	 Label, Warning Falling Equipment (En/Fr/Sp)	2
... 16		231985	.. Label, Electric Shock And Pinch Points (En/Fr/Sp)	1
		278103	.. Cable, Electrode 15 Ft No 3 W/Holder & Male Tw Lk	1
		234263	.. Regulator/Flowgauge, 0-50 CFH Ar/Co2/Mix W/Filter	1
		278108	.. Cable, Work 10 Ft No 3 W/Clamp & Tw Lk	1
		252046	.. Hose, Gas 5 Ft W/Fittings	1
		283942	.. Harness, Wrg Unit Main (Includes)	1
..... PLG6	..	131198	 Conn, Rect Mini 045 3Skt 1Row Plug Cable Lkg	1
..... PLG13	..	201565	 Conn, Rect Mini 045 4Skt 1Row Plug Cable Lkg	1
..... PLG8	..	113751	 Conn, Rect Mini 045 8Skt 2Row Plug Cable Lkg	1
..... PLG5	..	113752	 Conn, Rect Mini 045 10Skt 2Row Plug Cable Lkg	1
..... PLG7	..	233692	 Conn, Rect Micro 3Mm 4Skt 2Row Plug Cable Lkg	1
..... RC53	..	189238	 Conn, Circ Ms/Cpc 10Skt Size 18 Rcpt Panel Pushin	1
..... RC54	..	081560	 Conn, Circ Cpc 4Skt Size 11 Rcpt Panel Pushin	1

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

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.

Hardware is common and not available unless listed.



283925

Figure 1-2. Windtunnel Assembly (Figure 1-1, Item 7)

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-2. Windtunnel Assembly				
1		282092	Windtunnel, LH	1
2		282091	Windtunnel, RH	1
3	SR1	284558	Rectifier Assy	1
4	PC1	289263	Kit, Control Board wProgram Replacement	1
5	T1	264318	Xfmr, 7.5:1 Yel Grn	1
6	T2	264319	Xfmr, 7.5:1 Red Blk	1
7	L1	284491	Inductor, Input	1
8	FM1-FM2	263000	Fan, Muffin 24vdc 9000 RPM 134 Cfm 80mm	2
9		257273	Label, Blank Black Insulator 1.000 X 4.750	1
		289250	Kit, Windtunnel And PCB Replacement	1

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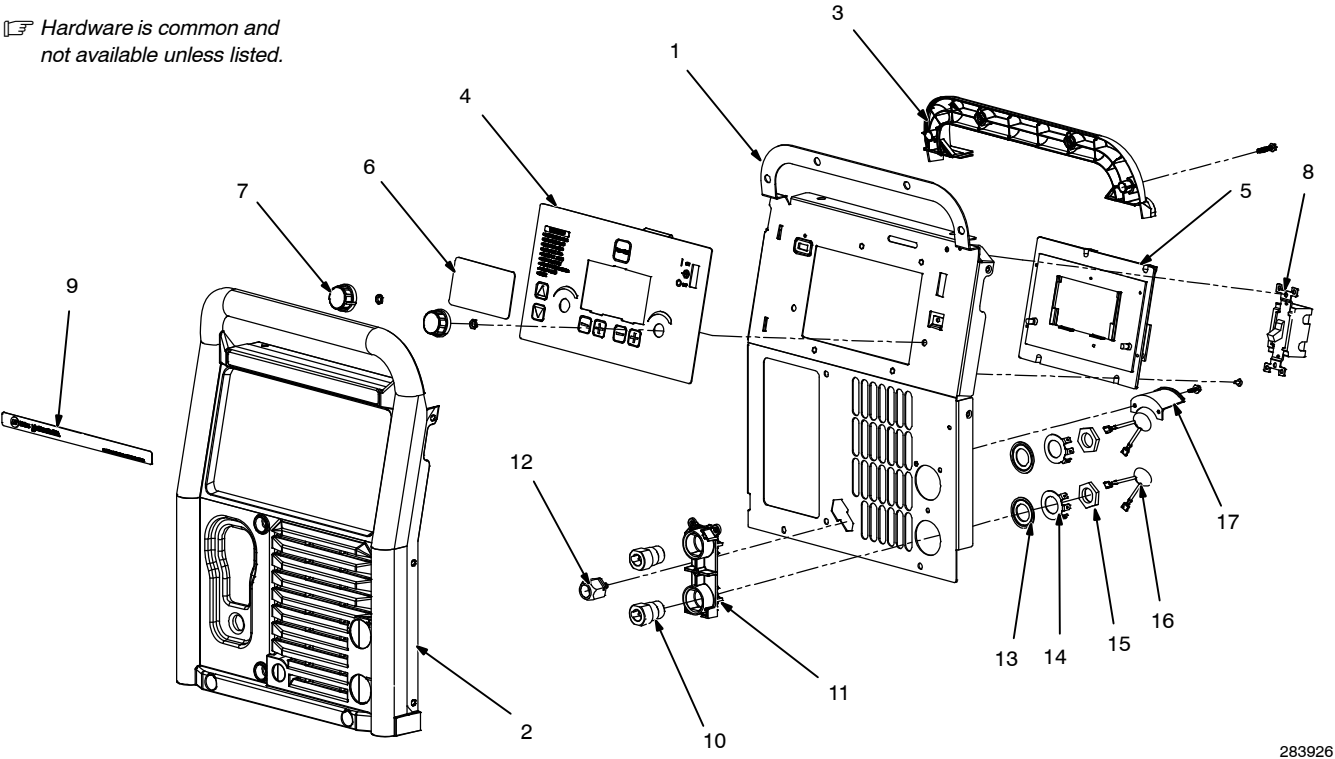


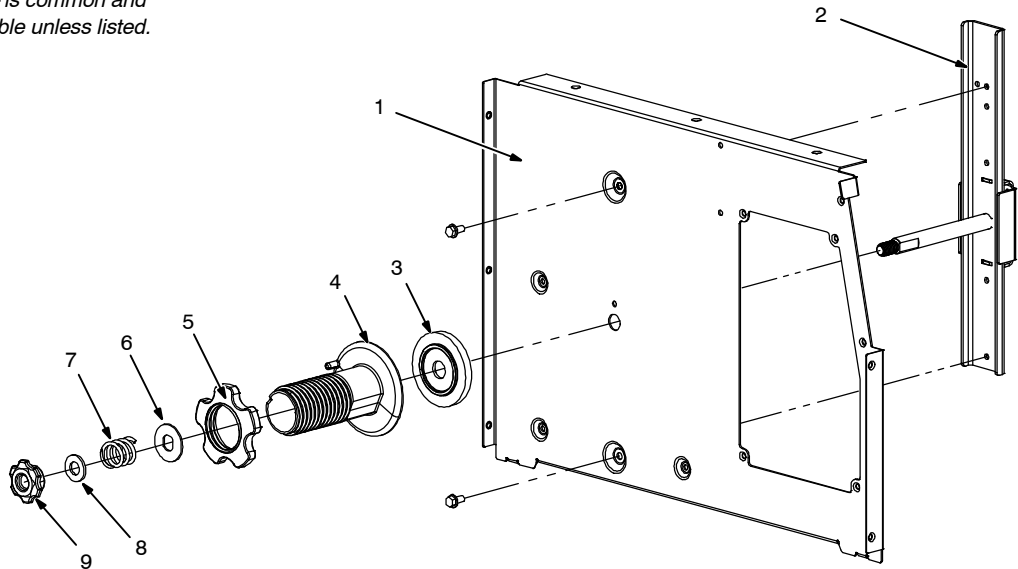
Figure 1-3. Front Panel Assembly (Figure 1-1, Item 4)

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-3. Front Panel Assembly				
1		282075	Panel Assy, Front W/Pems	1
2		277362	Bezel, Front	1
3		277653	Handle, Half	1
4		289337	Kit, Membrane Replacement	1
5	PC2	281109	Circuit Card Assy, Interface LCD Display	1
6		284596	Lens Cover, Replaceable	1
7		266591	Knob, Encoder 1.250 Dia X 6MM Id Push On W/Spring	2
8	S1	124511	Switch, Tgl DPST 40A 600Vac Scr Term	1
9			Label, Nameplate (Order By Model And Serial Number)	1
10		279111	Receptacle, Twist Lock Brass Fem Panel Mtg (Dinse)	1
11		277690	Insulator, Bulkhead 50MM	1
12		277691	Fitting, Gas	1
13		229338	Washer, Domed Load .812 Id X 1.450 OD X .070 Thk	2
14		278163	Terminal, Connector Friction Three Position	1
15		185717	Nut, M20-1.5 1.00Hex .19H Brs Locking	2
16		284861	Capacitor, Cer Disc .01 uF 1000 VDC	2
17		298918	Cover, Dinse Plastic	1

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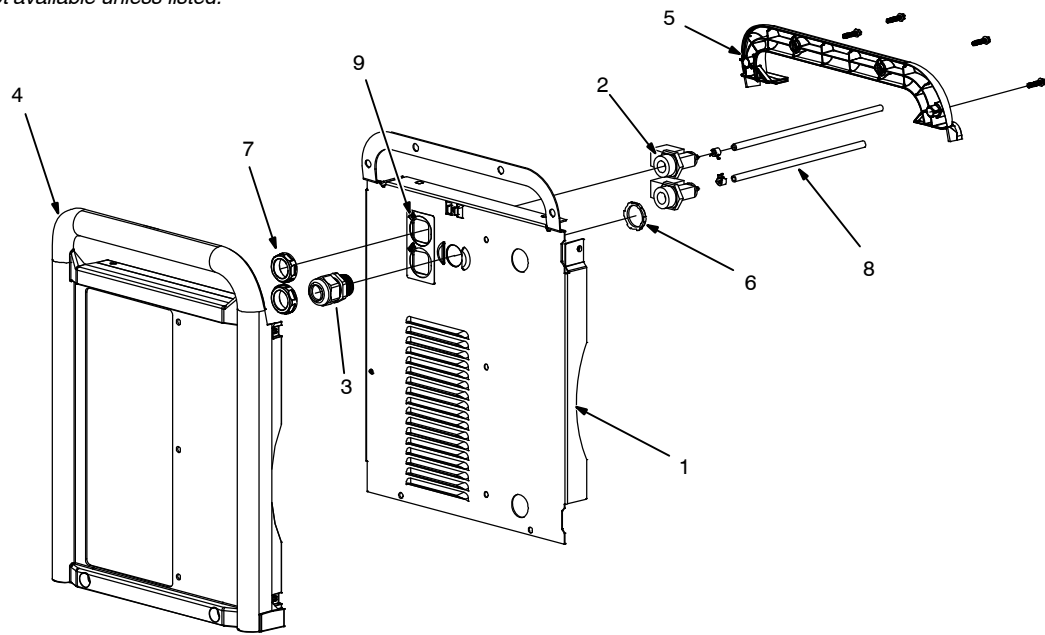
Figure 1-4. Center Baffle Assembly (Figure 1-1, Item 3)

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-4. Center Baffle Assembly				
1		277359	Baffle, Center	1
2		283924	Spool, Support Assy	1
3		287119	Washer, Brake Plastic	1
4		279587	Hub, Spool 12 Inch	1
5		280091	Nut, Hub	1
6		231211	Washer, Anti-Turn	1
7		172918	Spring	1
8		602247	Washer, Flat .531 IDx1.062OD x.095T Stl Pld Ansi .500	1
9		279504	Knob, Tensioner 1/2-13 Thread	1

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Eff w/Serial No. NA288617N And Following

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Figure 1-5. Rear Panel Assembly (Figure 1-1, Item 5)

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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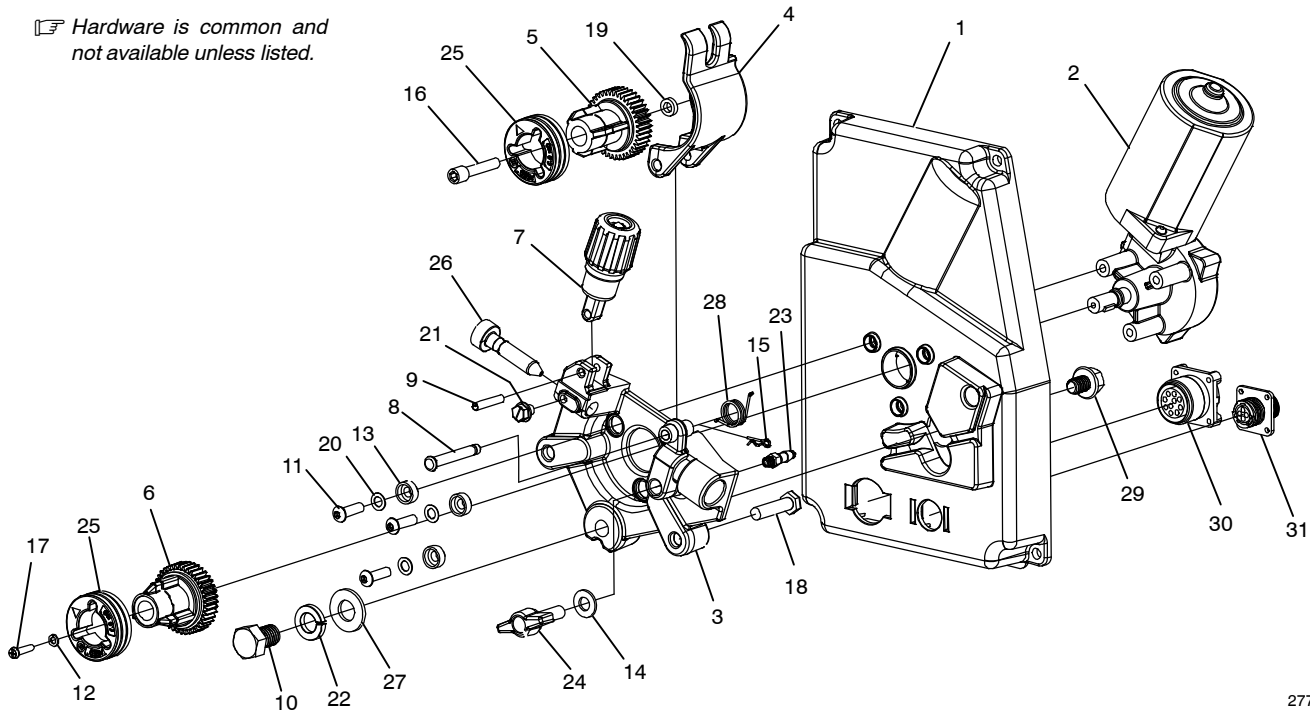
Figure 1-5. Rear Panel Assembly

...	1	...	277949	..	Panel, Rear	...	1
...	2	.. GS1/GS2	262572	..	Valve, 24 VDC 1way .750-14 Thd 2 MM Orf 100psi	...	2
...	3	...	282261	..	Bushing, Strain Relief .709/.984 Id X1.375 Mtg Hole	...	1
...	4	...	277950	..	Bezel, Rear	...	1
...	5	...	277653	..	Handle, Half	...	1
...	6	...	182445	..	Nut, Conduit 1.000 Npt Pld 1.688 OD X .200 Thk	...	1
...	7	...	272186	..	Nut, 750-14 Nps 1.312 Hex .413h Nyl	...	2
...	8	...	250864	..	Hose, Gas 27 In	...	2
...	9	...	278406	..	Label, Gas Valve MIG/TIG	...	1

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Eff w/Serial No. NA288617N And Following

Hardware is common and not available unless listed.



277769

Figure 1-6. Wire Feed Drive Assembly (Figure 1-1, Item 6)

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 1-6. Wire Feed Drive Assembly

...	1	277437	Insulator	1
...	2	DM 283174	Motor, Wire Drive W/Lead Assemblies	1
...	3	277657	Housing, Drive (Machined)	1
...	4	277795	Lever, Pressure Roll (Machined)	1
...	5	172075	Carrier, Drive Roll W/Cmpnts 24 Pitch	1
...	6	173619	Carrier, Drive Roll W/Cmpnts 24 Pitch 10 MM Shaft	1
...	7	221976	Knob, Tension Adjust Assy	1
...	8	273112	Pin, Clevis .250 OD X 1.751 Lg W/Groove And Cham	1
...	9	010224	Pin, Spring Cs .187 X 1.000	1
...	10	282942	Screw, 500-13x .75 Hex Hd-Phl Stl Pld Slf Tpg Ab	1
...	11	174610	Screw, M 6-1.0x 20 Soc Hd-Hex Button Cap Blk	3
...	12	602200	Washer, Lock .168IDx0.293ODx.040t Stl Pld Split #8	1
...	13	173620	Bushing, Mtg Motor	3
...	14	604538	Washer, Flat .344IDx0.688ODx.065t Stl Pld Ansi.312	1
...	15	151828	Pin, Cotter Hair .042 X .750	1
...	16	602009	Screw, 250-20x1.25 Soc Hd-Hex Gr8 Pln	1
...	17	209079	Screw, M 4- .7x 16 Pan Hd-Phl Pld Din 7985	1
...	18	604534	Screw, 312-18x1.25 Hex Hd-Pln Gr5 Pld	1
...	19	166072	Spacer, Gear	1
...	20	192029	Washer, Flat .250ID x0.437OD x.020t Stl Pln	3
...	21	233030	Screw, 250-20x .25 Hexwhd Machine Stl Pld	1
...	22	602216	Washer, Lock .502IDx0.879ODx.151t Stl Pld Split.500	1
...	23	263411	Fitting, Barbed Gas	1
...	24	222035	Knob, T 1.562 Bar W/.312-18 Stud 1.000 Lg Plstc	1
...	25	189285	Roll, Drive V Groove .035-.045 Wire	2
...	26	221912	Guide, Wire Inlet Nylon .023 - .052	1
...	27	602247	Washer, Flat .531IDx1.062ODx.095t Stl Pld Ansi.500	1
...	28	230801	Spring, Torsion	1
...	29	280210	Bolt, Hex Head Flange Stl .375-16 X .500 Gr8 Pld Zc	1
...	30	RC53 221777	Conn, Circ Ms/Cpc 10skt Size 18 Rcpt Panel W/terms	1
...	31	RC54 048282	Rcpt W/Skts (Service Kit)	1

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Eff w/Serial No. NA288617N And Following

1-1. MDX Gun Consumables

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
MDX-250 Gun				
... 1		N-M1200C	Nozzle, AccuLock MDX Copper, 1/2 in. Bore, Flush	1
		◆N-M1218C	Nozzle, AccuLock MDX Copper, 1/2 in. Bore, .125 in. Recess	1
		◆N-M5800C	Nozzle, AccuLock MDX Copper, 5/8 in. Bore, Flush	1
		◆N-M5818C	Nozzle, AccuLock MDX Copper, 5/8 in. Bore, .125 in. Recess	1
		◆N-M58XTC	Nozzle, AccuLock MDX Copper, 5/8 in. Bore, .125 in. Stickout	1
		◆T-M023	Contact Tip, AccuLock MDX .023 in. Wire x 1.125 in.	
		◆T-M030	Contact Tip, AccuLock MDX .030 in. Wire x 1.125 in.	
... 2		◆T-M035	Contact Tip, AccuLock MDX .035 in. Wire x 1.125 in.	
		◆T-M045	Contact Tip, AccuLock MDX .045 in. Wire x 1.125 in.	
		◆T-M047	Contact Tip, AccuLock MDX 3/64 in. Wire x 1.125 in.	
... 3		D-M250	Diffuser, AccuLock MDX	1
... 4		◆LM1A-15	Liner, AccuLock MDX .023/.025 in. Wire x 15 ft	1
		LM2A-15	Liner, AccuLock MDX .030/.035 in. Wire x 15 ft	1
		LM3A-15	Liner, AccuLock MDX .035/.045 in. Wire x 15 ft	1
... 5		2200169	Assy, Power Pin	1

◆OPTIONAL

1-2. Drive Roll And Wire Guide Kits

☞ Base selection of drive rolls upon the following recommended usages:

- 1 V-Grooved rolls for hard wire.
- 2 U-Grooved rolls for soft and soft shelled cored wires.
- 3 U-Cogged rolls for extremely soft shelled wires (usually hard surfacing types).
- 4 V-Knurlled rolls for hard shelled cored wires.
- 5 Drive roll types may be mixed to suit particular requirements (example: V-Knurlled roll in combination with U-Grooved).

Wire Diameter			Kit No.	Drive Roll		Inlet Wire Guide
Fraction	Decimal	Metric		Part No.	Type	
.023/.025 in.	.023/.025 in.	0.6 mm	087 131	087 130	V-Grooved	056 192
.030/.035 in.	.030/.035 in.	0.8/0.9 mm	204 579	203 526	V-Grooved	056 192
.030 in.	.030 in.	0.8 mm	079 594	053 695	V-Grooved	056 192
.035 in.	.035 in.	0.9 mm	079 595	053 700	V-Grooved	056 192
.045 in.	.045 in.	1.2 mm	079 596	053 697	V-Grooved	056 193

Ref. S-0026-B/7-91

Notes

Notes

Notes

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