

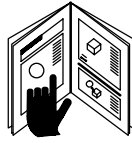
# FIELD INSTRUCTIONS

February 2000

FORM: F119 176A

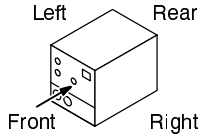
Use above FORM number when ordering extra manuals.

## For Preflow Timer Kit 042 144 In Syncrowave® 250 Models



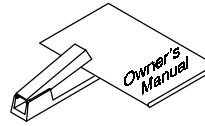
Read and follow these instructions and all safety blocks carefully.

Call your distributor if you do not understand the directions.



All directions are given as facing front panel.

Keep hardware for reuse.



Staple these instructions inside Owner's Manual.

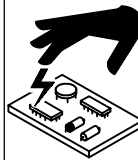


### WARNING



#### ELECTRIC SHOCK can kill

- Do not touch live electrical parts.
- Turn Off wire feeder and welding power source, and disconnect input power before beginning this installation.



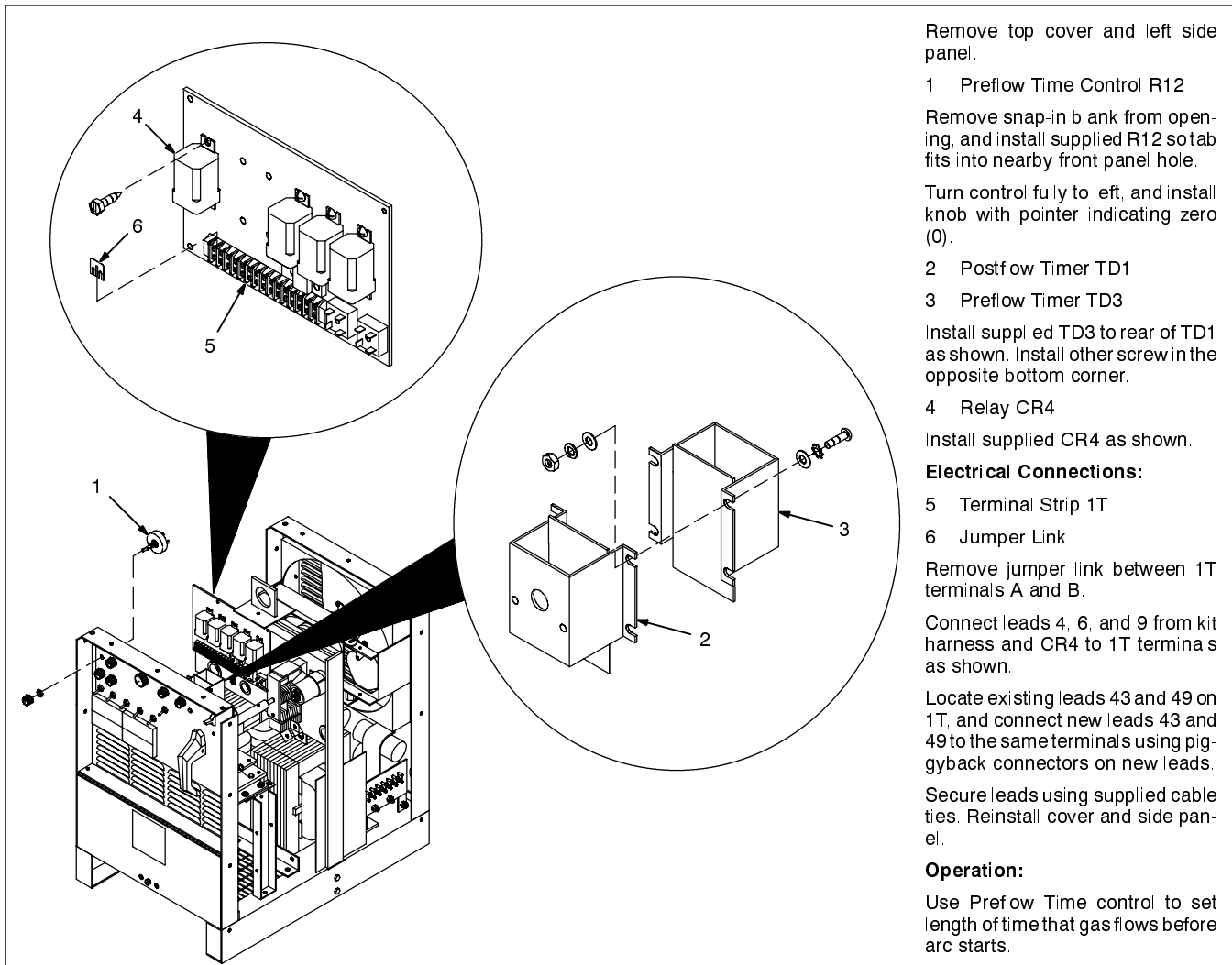
#### STATIC ELECTRICITY can damage parts on circuit boards.

- Put on grounded wrist strap BEFORE handling boards or parts.

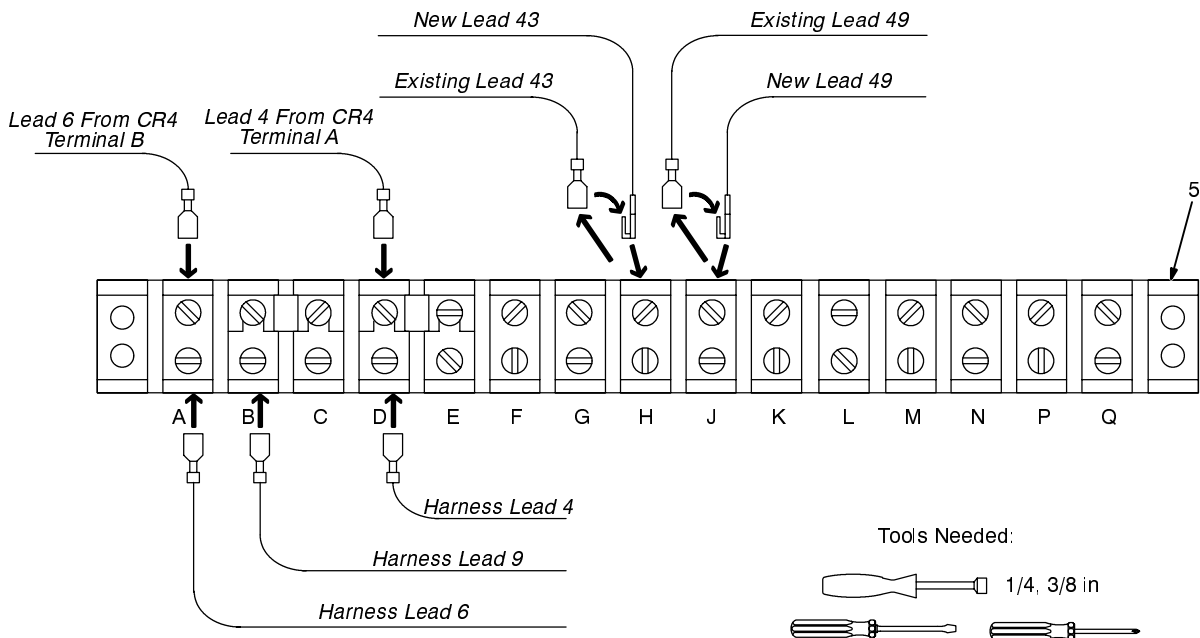
Have only qualified persons familiar with and following standard safety practices install this kit.

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| Dia.<br>Mkgs. | Part<br>No.    | Description  | Quantity |
|---------------|----------------|--|----------|
|               | <b>042 144</b> | <b>Kit, Pre-Flow Timer (Field)</b>                               |          |
| ...           | TD3            | ... 116 476 .. TIMER, delay .....                                | 1        |
| ...           | R12            | ... 115 862 .. POTENTIOMETER, C sltd sft 1/T .50W 500K ohm ..... | 1        |
| ...           |                | ... 097 922 .. KNOB, pointer .....                               | 1        |
| ...           | CR4            | ... 006 393 .. RELAY, encl 24VAC DPDT .....                      | 1        |
| ...           |                | ... 604 804 .. SCREW, 8-15 x .375 .....                          | 2        |
| ...           |                | ... 072 785 .. SCREW, 6-32 x .375 .....                          | 2        |
| ...           |                | ... 603 586 .. WASHER, flat .156 ID stl .....                    | 4        |
| ...           |                | ... 602 199 .. WASHER, tooth .141 ID stl .....                   | 2        |
| ...           |                | ... 602 198 .. WASHER, lock .141 ID stl split .....              | 2        |
| ...           |                | ... 604 645 .. NUT, .375-32 stl .....                            | 1        |
| ...           |                | ... 605 510 .. CABLE TIE, 0-.750 bundle .....                    | 6        |
| ...           |                | ... 106 702 .. NUT, 006-32 .31 hex .20H stl pld ser flange ..... | 2        |



**Electrical Connections**



ST-801 283-A / Ref. S-126 662-B

**Figure 1. Installation And Operation**