

Optional extras - Fitting Instructions Digital Meter Kit (AC/DC 252 only)

1. Disconnect the machine from the mains supply

WARNING

Placing the welding unit rear panel power switch in the 'off' position does not shut off all power within the equipment.

2. Remove the 2 retaining screws at the upper left and right hand corners of the operator control panel and 'hinge' down the panel.

3. Remove the blanking grommet from the VOLTS/AMPS selector switch hole.

4. Carefully disconnect the ribbon cable-plug from receptacle P1 of the slope module pcb, see photographs in spares section at the end of this manual.

5. Install the meter locating the switch through the front panel and fitting the screws provided through the pcb into the stand-off pillars. Fit & tighten the bezel nut switch seal onto the switch.

6. Connect the ribbon cable supplied with the meter kit between receptacle P1 of the slope module pcb and receptacle P2 of the digital meter pcb.

7. Connect the free end of the ribbon cable from receptacle P2 of the main control pcb to receptacle P1 of the digital meter pcb. Refer to drawing on page 21 for guidance on ribbon cable connections.

8. Close the control panel and refit the 2 retaining screws.

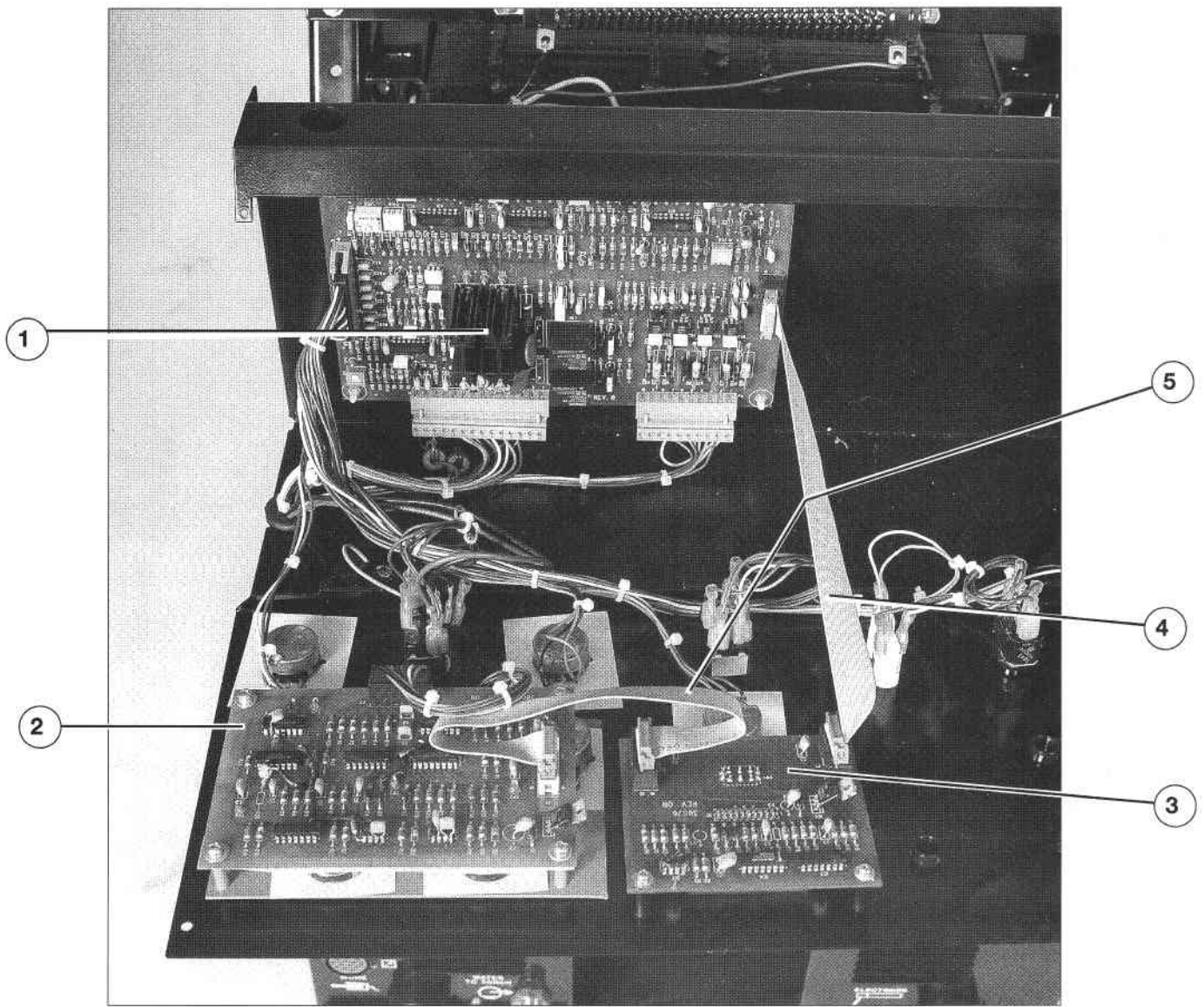
9. See controls section for operation details.

Transtig AC/DC 252 & 352 Optional Parts List

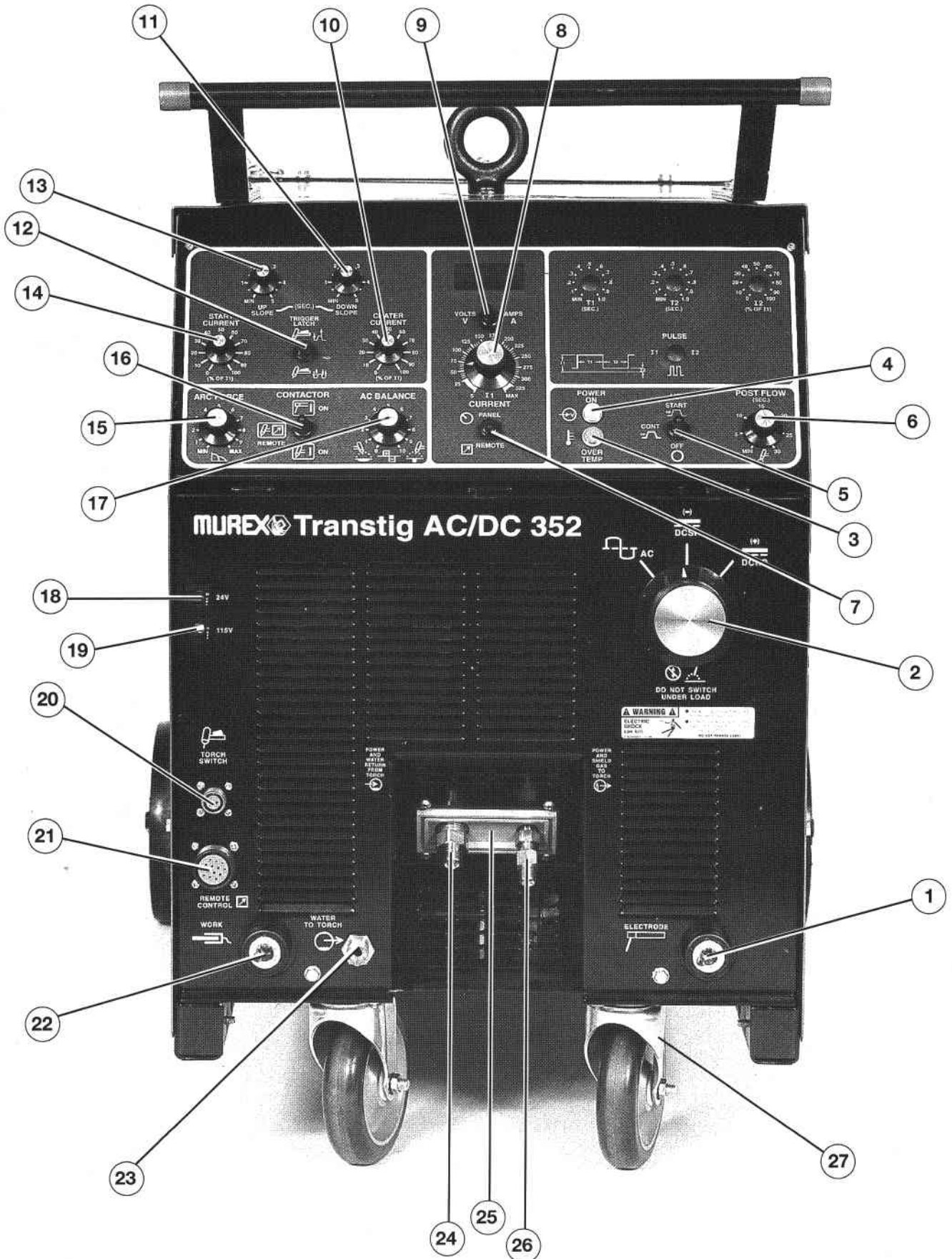
Optional Items

Pulse Tig Kit	1415323	(Requires Installation)
Digital Meter Kit (252 Only)	1415322	(Requires Installation)
FC-5B Foot Control Unit	1415231	
OCE 2H Water Cooler	1414013	
Water Hose for OCE 2H (2 Reqd)	1415328	
35/50mm ² Dins Plug	1380441	
2 Pin Torch Switch Plug	1407817	
TIG Welders Accessory Kit (Gloves, Key, Headshield etc)	1407716	
TG 203 TIG Torch Incl Switch 3.8m	1415320	
TW 253 TIG Torch Incl Switch 3.8m	1415024	
TW 451 TIG Torch Incl Switch 3.8m	1415026	
400A Electrode Holder & 5m Lead	1403220	
10mm ² Primary Cable (per metre)	1003523	
7/8" LH to 3/8" RH BSP Power/Water Adaptor	36299	(Supplied with unit)
5/8" RH to 1/4" RH BSP Power/Gas Adaptor	21495	(Supplied with unit)
5/8" LH Nut for Water Inlet/Return	10N40	(Supplied with unit)
Nipple for Water Hose	11N22	(Supplied with unit)

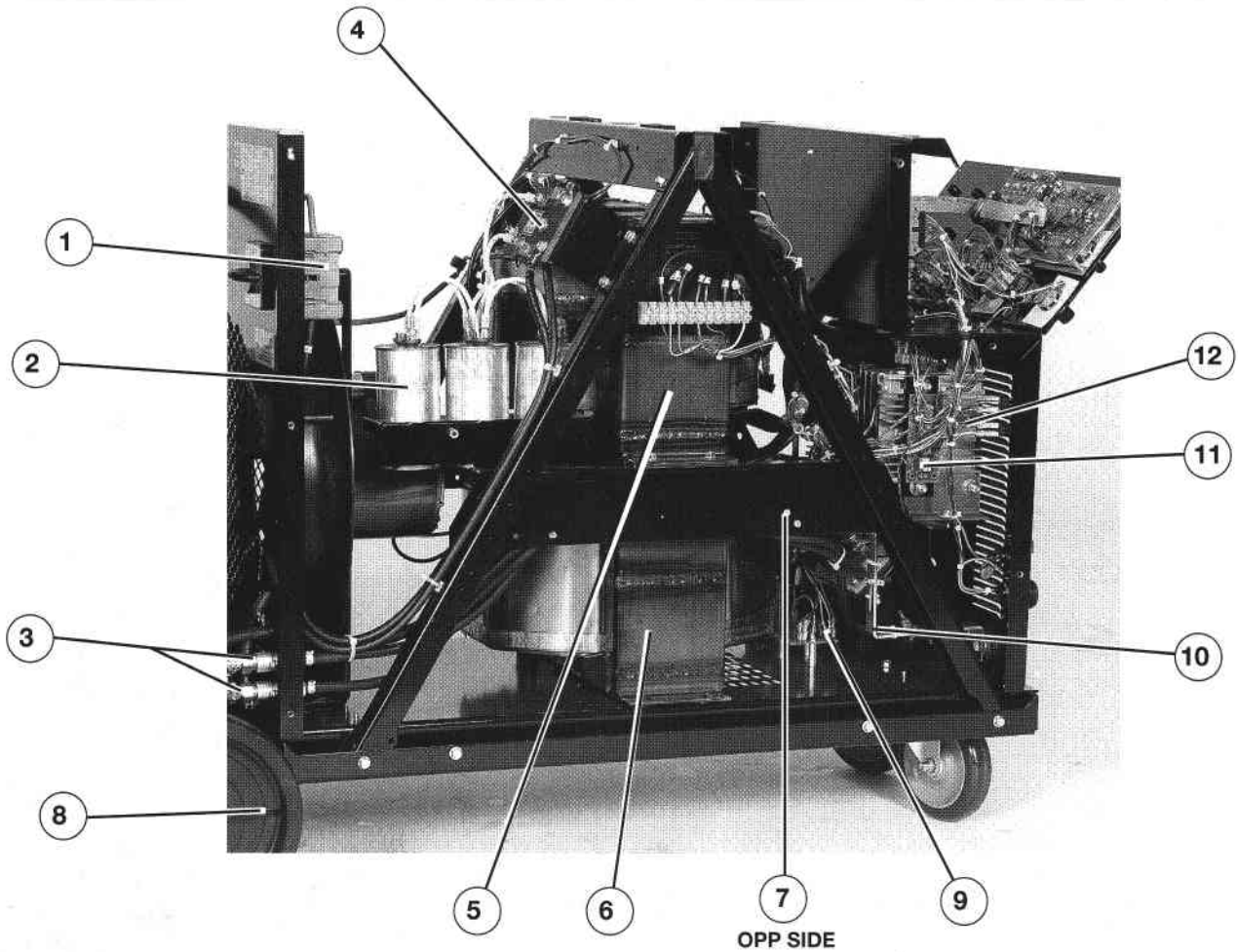




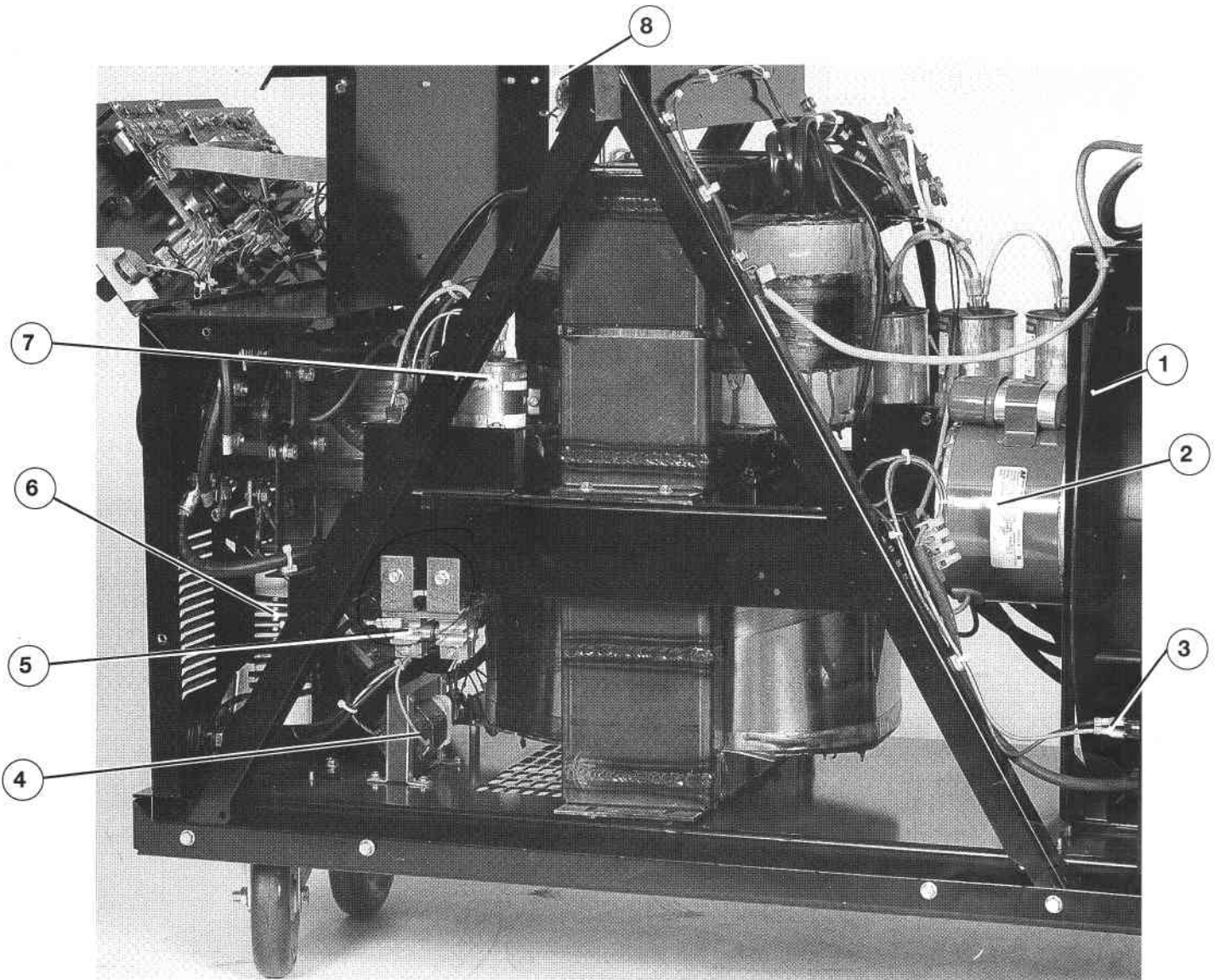
Position	Part No.	Description	Cat Ref.
1	38089	Main control pcb	PCB 1
2	38080	Slope control pcb	PCB6
3	38076	Digital Meter pcb (352 only)	PCB 5
4	677938	Ribbon cable ass'y	-
5	677938	Ribbon cable ass'y (352 only)	-



Position	Part No.	Description	Cat Ref.
1	1414606	Dins socket	-
2	36176	Polarity switch	52
-	1414846	Knob for item 2	-
3	13792157	Yellow lamp	PL2
4	951815	White lamp	PL1
5	1414975	Switch 3 posn, HF	S5
6	951511	Potentiometer, post flow	R5
-	1414954	Knob for item 6	-
7	1414601	Switch 2 posn, local/remote	S4
8	1407182	Potentiometer, weld current	R2
-	1414603	Knob for item 8	-
9	38076	Digital meter pcb (352 only)	PCB5
10	599670	Potentiometer, crater current	-
-	1414982	Knob for item 10	-
11	599670	Potentiometer, slope down	-
-	1414982	Knob for item 11	-
12	950629	Switch 2 posn, 2/4 stroke	-
13	599670	Potentiometer, slope up	-
-	1414982	Knob for item 13	-
14	599670	Potentiometer, start current	-
-	1414982	Knob for item 14	-
15	992804	Potentiometer, arc force	-
-	1414954	Knob for item 15	-
16	1414986	Switch 3 posn, contactor	S3
17	1407182	Potentiometer, balance	R4
-	1414954	Knob for item 17	-
18	1414992	Circuit Breaker 10A	CB1
19	1414992	Circuit Breaker 10A	CB2
20	538500902	Socket 2 Way	- plug 1407817
21	951916	Socket 14 Way	J2 ← plug 1414942
22	1414606	Dins Socket	-
23	99512789	3/8" BSP bulkhead fitting	-
24	36299	Adaptor 7/8 LH to 3/8 RH	-
25	30612	Output block	-
26	21495	Adaptor 5/8 to 3/8 RH	-
27	952013	Front castor	-
28	672786	Lift eye	-
-	1414972	Toggle Switch cover	-



Position	Part No.	Description	Cat Ref.
1	36107	Power Switch AC/DC 252	S1
1	950945	Power Switch AC/DC 352	S1
2	1415110	Capacitor PF (3 reqd)	C8, 9, 10
3	10N40	Nut LH	-
3	11N22	Nipple	-
4	32218	Terminal board	TB1
5	36149	Mains transformer AC/DC 252	T1
5	36144	Mains transformer AC/DC 352	T1
6	36147	Inductor AC/DC 252	T1
6	36142	Inductor AC/DC 352	L1
7	951634	Solenoid Valve	SOL1
8	13730912	Rear Wheel	-
9	674971	Filter pcb	PCB4
10	36184	Shunt	SH1
11	38074	Snubber pcb	PCB2
12	36191	Dual SCR ass'y	SCR1, 2, 3, 4



Position	Part No.	Description	Cat Ref.
1	36173	Fan blade	-
2	1414614	Fan motor	M1
3	1414991	Circuit breaker 5A	CB3
4	951179	HV Transformer	H1
5	1415104	Spark gap point	-
5	1415102	Spark gap pcb	PCB3
5	673579	Spark gap heatsink	-
6	36415	HF transformer	T3
7	1414650	Capacitor 60 μ F 370V	C1
7	17240075	Resistor 25W	R6
7	13730469	Bridge rectifier	BR1
8	1414863	Resistor 16 Ω 300W	R1

1414670 *HF Capacitor*



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