1. Typical Connection

Turn Off welding power source.
1. Foot Control
2. Remote 14 Or Remote 5 Receptacle

Insert plug into matching 14-socket, or 5-socket receptacle, as applicable, on welding power source. Tighten collar.

Ref. ST-801 736

2. Remote Amperage Control For Welding Power Source Without Remote Control Switch

Select Weld Process ➔ Select Range And Polarity ➔ Select Maximum Amperage Percentage. 50% = Approx. 33 A DC ➔ Press pedal lightly to turn weld output and gas flow on. Press pedal further to increase weld output. Release pedal to turn off weld output and gas flow.

Ref. ST-155 790-E
3. Remote Amperage Control For Welding Power Source With Remote Control Switch But Without Output (Contactor) Control

Example Of Combination Front Panel And Remote Amperage Control

See welding power source Owner's Manual to determine if Remote Foot Control works as a combination or as full Amperage control.

In Example:
Min = 30 A In Range A or 40 A In Range B (Unit Minimum)
Max = 95 A In Range A or 200 A In Range B (Control Setting)

Set Switch ➔ Set Desired Maximum Amperage For Application ➔ Press pedal to increase weld output. Release pedal to decrease weld output.

OR

EXAMPLE Of Full Remote Amperage Control

In Example:
Min = 30 A In Range A or 40 A In Range B (Unit Minimum)
Max = 225 A In Range A or 375 A In Range B (Unit Maximum)

Set Switch ➔ Control Setting Does Not Matter ➔ Press pedal to increase weld output. Release pedal to decrease weld output.

Ref. ST-122 023-A / Ref. ST-141 127-A / ST-039 411-D
4. Remote Amperage Control For Welding Power Source With Remote Control Switch And Output (Contactor) Control

Example Of Combination Front Panel And Remote Amperage Control

See welding power source Owner’s Manual to determine if Remote Foot Control works as a combination or as full Amperage control.

Example Of Full Remote Amperage Control

Press pedal lightly to turn weld output and gas flow on. Press pedal further to increase weld output. Release pedal to turn off weld output and gas flow.
5. Adjusting Potentiometer Timing

- Disconnect foot control from welding power source/generator.
- Turn unit upside down, and remove bottom plate.
- Label
- Gear
- Turn gear on potentiometer shaft counterclockwise as far as possible.
- Pull drive belt tight and mesh belt teeth with gear teeth.
- Connect free end of small spring into end of drive belt.
- Reinstall bottom plate

6. Changing Cord Location On RFCS-14HD Models

- Disconnect foot control from welding power source/generator.
- Bottom Plate
- Turn unit upside down, and remove bottom plate.
- Cord Slots
- Remove screw that holds cord in its factory installed location.
- Position cord in desired slot.
- Slide strain relief down cord and into slot to protect cord. Secure cord with screw in the same manner in which it came from the factory.
- Reinstall bottom plate

7. Circuit Diagram

- Do not touch live electrical parts.
- Disconnect input power or stop engine before servicing.
- Do not operate with covers removed.
- Do not install, use, or service this unit.

- SA-183 957-B
### 8. Parts List

<table>
<thead>
<tr>
<th>Item No.</th>
<th>Dia. Mkgs.</th>
<th>Part No.</th>
<th>Description</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>182 030</td>
<td></td>
<td>Belt, drive</td>
<td>1 1 1</td>
</tr>
<tr>
<td>2</td>
<td>185 929</td>
<td></td>
<td>Pedal / housing / bottom plate</td>
<td>1 1 1</td>
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<tr>
<td>3</td>
<td>198 036</td>
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<td>Bottom Plate, heavy duty</td>
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</tr>
<tr>
<td>4</td>
<td>182 627</td>
<td></td>
<td>Spring, ext .375 OD</td>
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<tr>
<td>5</td>
<td>S1</td>
<td>183 629</td>
<td>Switch, limit 10A 125/250V</td>
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<td>182 628</td>
<td></td>
<td>Cable Control</td>
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<td>1</td>
</tr>
<tr>
<td>6</td>
<td>199 405</td>
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<td>Cable Control</td>
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<td>PGL1</td>
<td>131 204</td>
<td>Connector &amp; Sockets</td>
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<tr>
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<td>175 284</td>
<td></td>
<td>Cable, port 20ga 5/c</td>
<td>21ft 21ft</td>
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<td>144 310</td>
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<td>Connector, clamp str</td>
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<tr>
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<tr>
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<td>C1, 2</td>
<td>028 291</td>
<td>Capacitor, cer disc</td>
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