



PM-261726A

2020-08

**Processes**



TIG (GTAW) Welding



Stick (SMAW) Welding

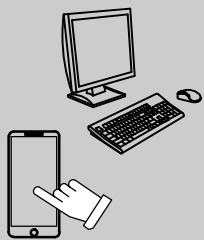
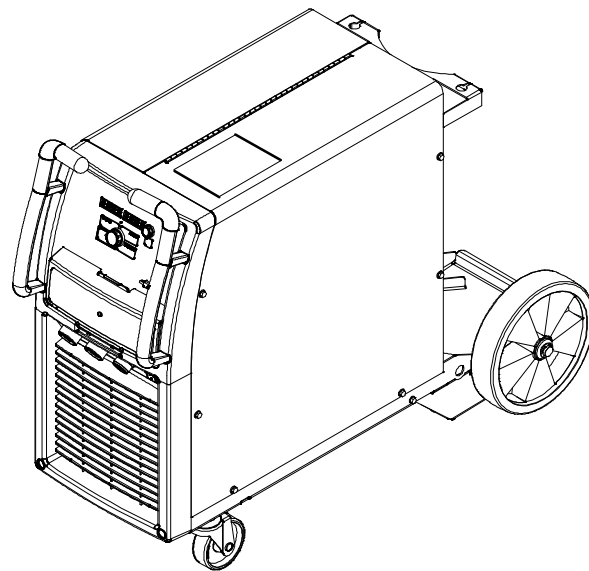
**Description**



# Syncrowave<sup>®</sup> 210

Eff w/Serial No. MD260121J And Following

For OM-261726 Revision A Thru J




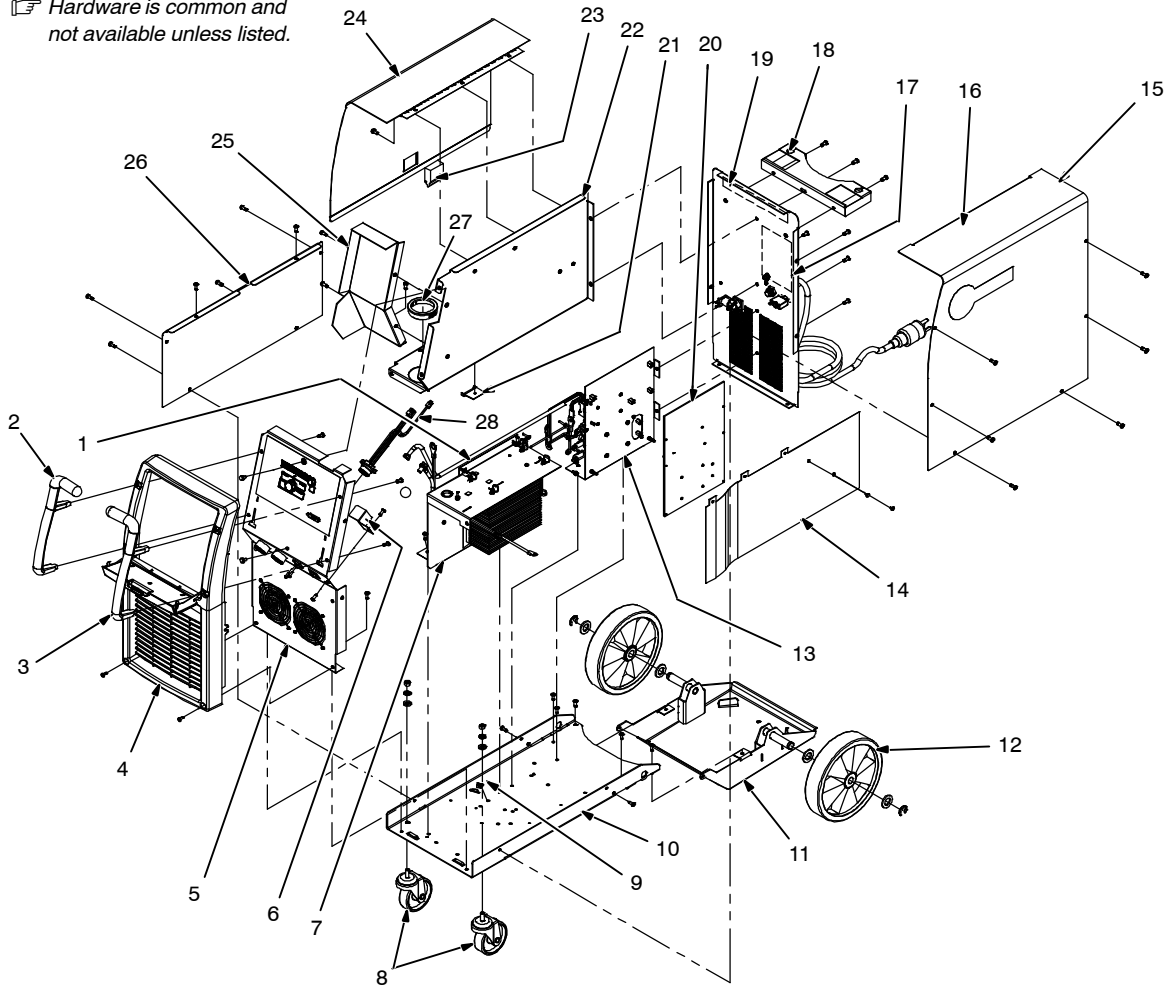
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## PARTS MANUAL

# SECTION 1 – PARTS LIST FOR MD260121J AND FOLLOWING

 Hardware is common and not available unless listed.



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**Figure 1-1. Main Assembly**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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**Figure 1-1. Main Assembly**

.. 1		218170	.. Hose, Nprn Brd No 1 x .250 Id x 25.00 (Prior to ME020102J)	1
.. 1		155527	.. Hose, Nprn Brd No 1 x .250 Id x 28.00 (Eff w/ME020102J)	1
.. 2		231554	.. Handle, Lh	1
.. 3		231553	.. Handle, Rh	1
.. 4		230304	.. Bezel, Front w/Consumable Tray	1
.. 5		Figure 1-2	.. Panel, Front w/Components	1
.. 6		260337	.. Bracket, Switch	1
.. 7		Figure 1-4	.. Windtunnel, Front w/Components	1
.. 8		008999	.. Caster, Swvl 4.00 in. Polyolefin	2
.. 9		231208	.. Connector, Faston 1/4 Ring w/75 Deg Bend	1
.. 10		229624	.. Base	1
.. 11		260788	.. Tray Assy, Bottle	1
.. 12		209869	.. Wheel, Polyolefin 10 in. Dia x 2.00 Wide .750 Hub Dia	2
.. 13		Figure 1-5	.. Windtunnel, Rear w/Components	1
.. 14		260787	.. Baffle, Air	1
.. 15		+229619	.. Wrapper	1
.. 16		230366	.. Label, Warning General precautionary	1
.. 17		+Figure 1-3	.. Panel, Rear w/Components	1
.. 18		260342	.. Bracket, Support Cylinder	1

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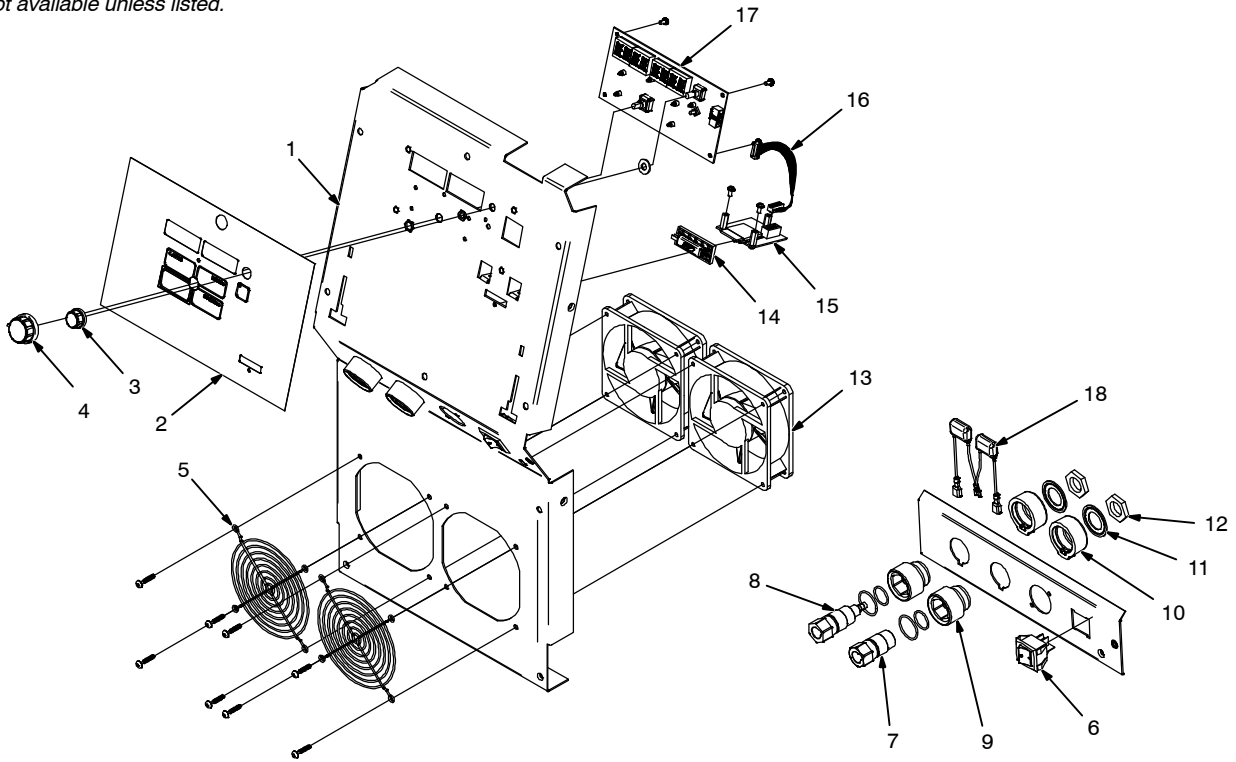
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 1-1. Main Assembly (continued)</b>				
.. 19 .....		228542 ..	Label, Warning Cylinder May Explode If Damaged .....	1
.. 20 .....	PC1 .....	281330 ..	Kit, Circuit Card Assy, Control w/Program & Interface (Eff w/MG340028L and Following) .....	1
.. 20 .....	PC1 .....	281498 ..	Kit, Circuit Card Assy, Control w/Program & Interface (Eff w/ME390001J to MG340028L) .....	1
.. 20 .....	PC1 .....	269044 ..	Kit, Circuit Card Assy, Control w/Program & Interface (Prior to ME390001J) .....	1
		131204 ..	Housing Plug+Skts, Plg7 (Service Kit) .....	1
		115094 ..	Housing Plug+Skts, Plg4 (Service Kit) .....	1
		201665 ..	Housing Plug+Skts, Plg2 (Service Kit) .....	1
		130203 ..	Housing Plug+Skts, Plg5 (Service Kit) .....	1
		115092 ..	Housing Plug+Skts, Plg1 (Service Kit) .....	1
		171117 ..	Housing Plug+Skts, Plg3, Plg19, Plg20 (Service Kit) .....	3
		279462 ..	Housing Plug+Skts, Plg8 (Service Kit) .....	1
		135635 ..	Housing Plug+Skts, Rc9,Rc10 (Service Kit) .....	2
.. 21 .....		262661 ..	Cover, Latch Hole .....	1
.. 22 .....		258290 ..	Baffle, Center .....	1
.. 23 .....		230363 ..	Latch, Slide Flush Mtg Hole 1.750 Wide x 1.500 Lg .....	1
.. 24 .....		229620 ..	Door, Hinged .....	1
.. 25 .....		260269 ..	Cover, Components .....	1
.. 26 .....		229621 ..	Panel, Side Lh Lower .....	1
.. 27 .....		232535 ..	Bushing, Snap-In Nyl 2.470 Id x 3.000 Mtg Hole (Eff w/ME020102J) .....	1
.. 28 .....	RC1 .....	261253 ..	Receptacle, 14-Pin .....	1

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

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
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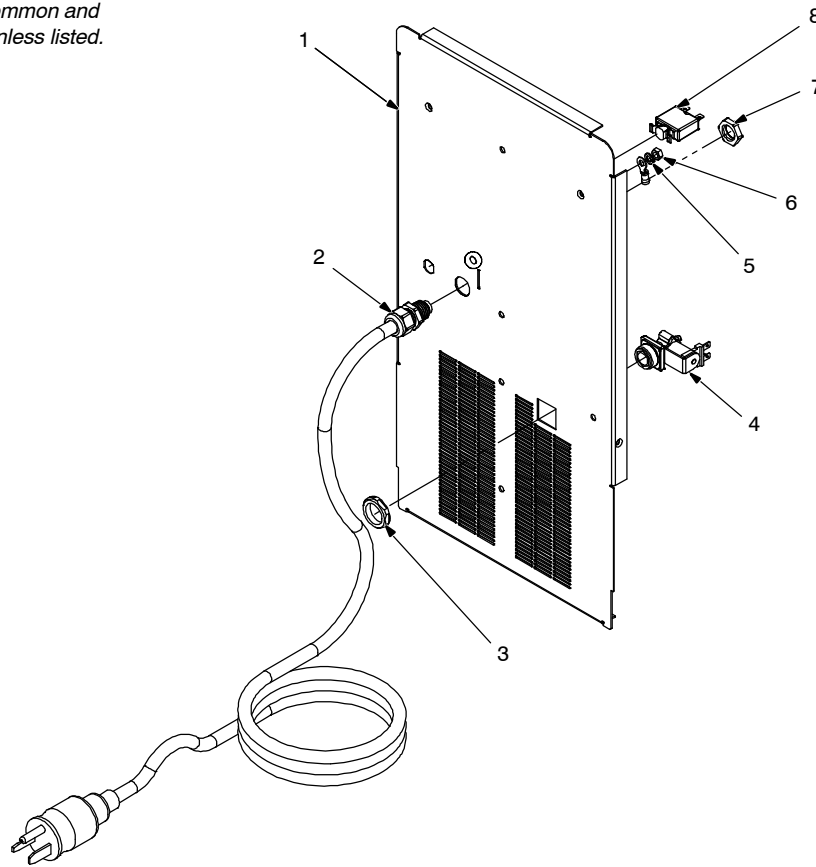
**Figure 1-2. Panel Front w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>261611 Figure 1-2. Panel Front w/Components</b>				
.. 1		258291	Panel, Front	1
.. 2			Nameplate (Order by Model and Serial Number)	1
.. 3		230052	Knob, .840 Dia x 4mm Id w/Spring Clip	1
.. 4		228546	Knob, Pointer 1.250 Dia x 6mm Id w/Spring Clip	1
.. 5		259127	Guard, Fan	2
.. 6	S1	177396	Switch, Rocker Dpst 15 A 250 VAC Off-None-On	1
.. 7	Work	202553	Receptacle, Twist Lock Brass Power (Female)	1
.. 8	Electrode	202811	Receptacle, Twist Lock Assy Gas Flow Through	1
.. 9		185712	Insulator, Bulkhead Front	2
.. 10		185713	Insulator, Bulkhead Rear	2
.. 11		229338	Washer, Domed Load .812 Id x 1.450 Od x .070 Thk	2
.. 12		185717	Nut, M20-1.5 1.00 Hex .19 Brs Locking	2
.. 13	FM1, FM2	239380	Fan, Muffin 24 VDC 3200 Rpm 141Cfm 4.125 Mtg	2
.. 14		254052	Cover SD Card	1
.. 15	PC5	274828	Kit, PC Board SD Card Interface	1
.. 16		254529	Cable, Ribbon 10 Posn 5.00 in. Skts To Skts	1
.. 17	PC3	269044	Kit, Circuit Card Assy Control & Interface (Prior To ME390001L)	1
.. 17	PC3	274829	Kit, PC Board Interface (Eff w/ME390001L)	1
.. 17		279463	Housing Plug+Skts, Plg31 (Service Kit)	1
.. 18	C1,C2	222752	Capacitor Assy (Eff w/MF240005L)	1

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261612-D

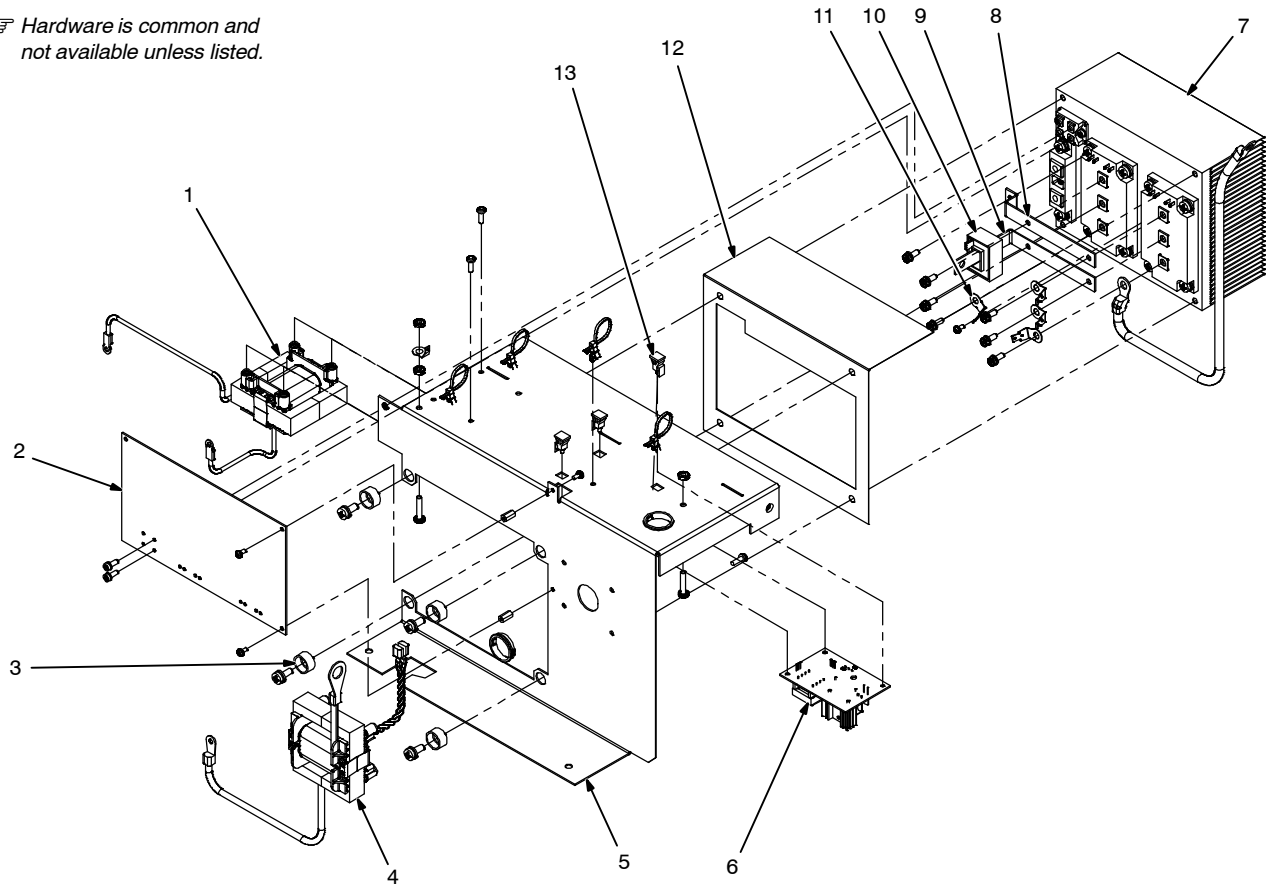
**Figure 1-3. Panel Rear w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>261612 Figure 1-3. Panel Rear w/Components</b>				
.. 1 .....		258292 ..	Panel, Rear .....	1
.. 2 .....		263699 ..	Cable, Power 10 Ft 2 in. w/Strain Relief .....	1
.....		219258 ..	Adapter, Power Cable 6-50P (230V/50A) (Eff w/MD260121J) .....	1
.....		219261 ..	Adapter, Power Cable 5-15P (115V/15A) (Eff w/MD260121J) .....	1
.. 3 .....		137761 ..	Nut, 750 Npt 1.31 Hex .27 H Nyl Blk .....	1
.. 4 ....	GS1	238805 ..	Valve, 24 VDC 2 Way 125 PSI Custom Port .054 Orf .....	1
.. 5 .....		602207 ..	Washer, Lock .255 Id x 0.489 Od x .062 T Stl Pld Split .250 .....	1
.. 6 .....		601865 ..	Nut, 250-20 .44 Hex .21 H Stl Pld Blk .....	1
.. 7 .....		217030 ..	Nut, Locking Strain Relief 1/2 in. Npt .270 Thick .....	1
.. 8 ....	CB1	233184 ..	Supplementary Protector, Man Reset 1P 35 A 250 VAC .....	1

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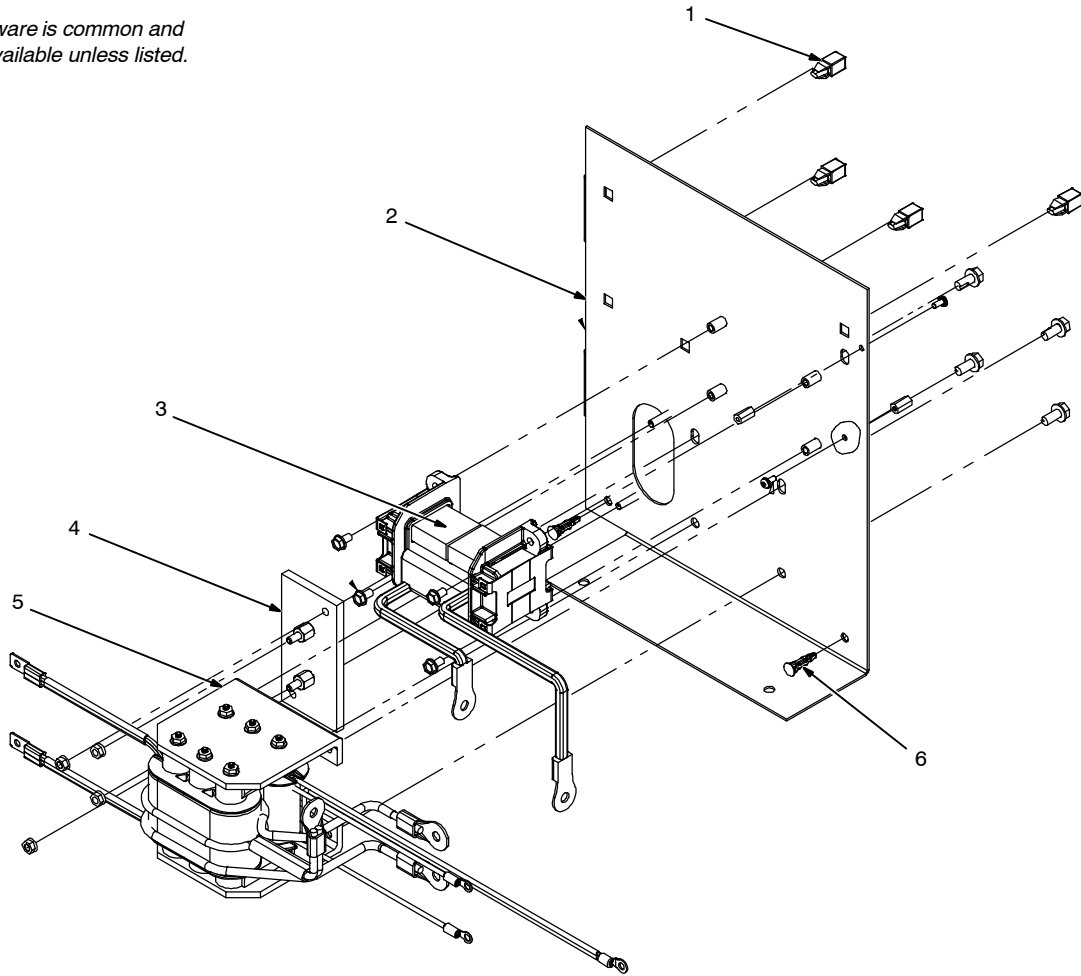
**Figure 1-4. Windtunnel, Front w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<hr/>				
		<b>260338</b>	<b>Figure 1-4. Windtunnel, Front w/Components</b>	
<hr/>				
.. 1	.. L1	.. 260376	.. Inductor, Input	1
.. 2	.. PC2	.. 257426	.. Circuit Card Assy, Commutator Control	1
		.. 115091	.. Housing Plug+Skts, Plg 21 (Service Kit)	1
.. 3		.. 181853	.. Insulator, Screw	4
.. 4	.. T2	.. 246530	.. Inductor, Arc Starter/Output 120 A	1
.. 5		.. 260339	.. Windtunnel, Front	1
.. 6	.. PC4	.. 247046	.. Circuit Card Assy, Arc Starter	1
		.. 131204	.. Housing Plug+Skts, Plg 41 (Service Kit)	1
.. 7		.. Figure 1-6	.. Heat Sink, IGBT Assembly	1
.. 8		.. 259126	.. Bus Bar, Positive	1
.. 9		.. 259529	.. Bus Bar, Negative	1
.. 10	.. HD1	.. 191941	.. Transducer, Current 200 A Module Supply V +/- 15 V	1
.. 11		.. 231208	.. Connector, Faston 1/4 Ring w/75 Deg Bend	4
.. 12		.. 260336	.. Insulator, Input	1
.. 13		.. 134201	.. Stand-Off Support, PC Card .312/.375 w/Post&Lock .43	3

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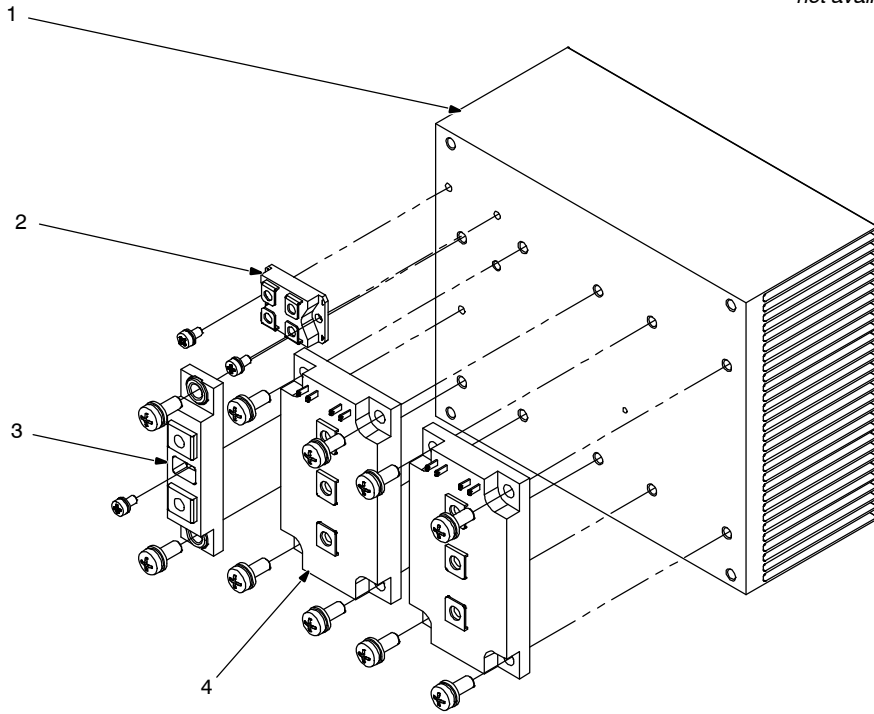
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**Figure 1-5. Windtunnel, Rear w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>260340 Figure 1-5. Windtunnel, Rear w/Components</b>				
.. 1 .....		083147 ..	Grommet, Scr No 8/10 Panel Hole .312 Sq .500 High (Prior To MF401008L) .....	6
.. .....		083147 ..	Grommet, Scr No 8/10 Panel Hole .312 Sq .500 High (Eff w/MF401008L) .....	4
.. 2 .....		260341 ..	Windtunnel, Rear .....	1
.. 3 .....	Z1	260371 ..	Inductor, Output .....	1
.. 4 .....		260025 ..	Connection Bd Assy, XFMR .....	1
.. 5 .....	T3	260367 ..	XFMR, Main .....	1
.. 6 .....		198122 ..	Stand-Off Support, PC Card .250 w/Post&Lock .500 (Eff w/MF401008L) .....	2

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**Figure 1-6. Heat Sink, IGBT Assembly**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>259123 Figure 1-6. Heat Sink, IGBT Assembly</b>				
.. 1 .....		259124 ..	Heat Sink, IGBT .....	1
.. 2 .....	D32	259419 ..	Kit, Ultra Fast Diode .....	1
.. 3 .....	D1	259418 ..	Kit, Ultra Fast Diode .....	1
.. 4 ..	PM1, PM2	267466 ..	Kit, IGBT .....	2

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