

CONVERSION KIT INSTRUCTIONS FOR 3000 AND 5000 SERIES

Kit Includes:

Front Panel with Timer Control Assembly (A-380M), "On-Off" Switch and Light (LP-745), Female Receptacle (A-316M), Contactor (A-304M) and Control Transformer (A-101) on L Mounting Plate, and Male Control Cord Plug (U-101).

CAUTION!

DO NOT ATTEMPT TO WORK INSIDE THE WELDER WITHOUT FIRST UNPLUGGING THE MAIN INPUT CABLE LEAD FROM THE 208/230 VOLT RECEPTACLE.

1. Removing the Bottom, Front and Back Panel:
 - a. Turn unit upside down and remove six (6) screws holding bottom panel. Looking at the front panel, it will depend on which version you have as to which wires and screws you will need to remove in order to remove the front panel.
 - b. Remove back panel and disconnect the two (2) hot wires of input power cable; leave ground wire from input power cable to cabinet connected. You will be reusing back panel and input cable.
2. Removing Electrical Parts:
 - a. Disconnect the welding transformer wires which are attached to components.
 - b. Remove all electrical parts from cabinet except the welding transformer and 50 ft. input power cable.
3. Installing Contactor, Transformer, L Mounting Bracket and Front Panel:
 - a. Install front panel using six (6) screws. You may need to enlarge mounting holes. (Reuse plastic welding terminal bushings from the old front panel.)
 - b. Remove the two (2) mounting bolts on the back side of transformer. Install contactor and transformer L mounting bracket on back side of transformer using bolts you removed. Make sure the components on the L mounting bracket are facing the side of the transformer from which the wires come out.
4. Connecting the Welding Transformer Wires (2):
(Refer to Figure A on back side of instruction sheet.)
 - a. Connect one (1) welding transformer wire to T1 on the contactor.
 - b. Connect second welding transformer wire as follows depending on input voltage:
 1. 230 VAC usage - Connect #3 welding transformer wire to T2 on the contactor. **DO NOT CONNECT #2 transformer wire to anything - insulate.**
 2. 208 VAC usage - Connect #2 welding transformer wire to T2 on the contactor. **DO NOT CONNECT #3 transformer wire to anything - insulate.**
 - c. If your welding transformer only has 2 wires, connect one (1) to T2 and the second wire to T1.
 - d. Connect the wires from the input power cable to L2 and L1 on the contactor. (See Fig. A.) You may have to lengthen or shorten wires. **NOTE: It does not matter which wire goes on which terminal. The ground wire must still be connected to the cabinet.**
 - e. Make sure all electrical connections are secure and that no wires are touching any part of the metal cabinet.
5. Installing Panels:
 - a. Install back panel using eight (8) screws.
 - b. Install bottom panel using six (6) screws.

NOTE: Step 6 is necessary if you have a 3-prong male plug on your control cord.

6. Replacing Male Plug on Control Line:

- a. Cut wire on control line as close as possible to 3-prong plug. Discard old 3-prong plug.
- b. Disassemble new plug by pulling out pin on side. Pull plug apart. Loosen screws for cable strain relief and push strain relief on to end of cable.
- c. Cut outer jacket of cable back 1/2". Cut off black wire; it will not be used. Trim ends of white and green wire back 3/16". Crimp and solder one wire on each terminal of plug.
NOTE: It does not matter which wire goes on which terminal.
- d. Push cable strain relief on to plug, making sure to align holes for pin and insert pin securely into hole on side. Tighten screws on cable relief. Conversion complete.

If you have any questions, contact:

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