

CITOMIG 185MP & 210MP

Spare Parts.....	1
Figure A: Machine Assembly	1
Figure B: Machine Assembly	2
Figure C: Wire Drive Assembly & Euro Socket Assembly.....	3
Electrical Schematic.....	4
CODE: 50400	4
CODE: 50399	4
WEEE.....	5
Quick Guide.....	7



Spare Parts

SP50399 / SP50400 REV03

11/22

ASSEMBLY PAGE NAME			Machine Assembly	Machine Assembly	Wire Drive Assembly	Euro Socket Assembly	Miscellaneous Items	
CODE NO.:	K NO.:	FIGURE NO.:	A	B	C	C	-	
50400	W000403579	CITOMIG 185MP	1	1	1	1	1	
50399	W000403578	CITOMIG 210MP	2	2	2	2	2	

*items highlighted in bold are recommended spare parts

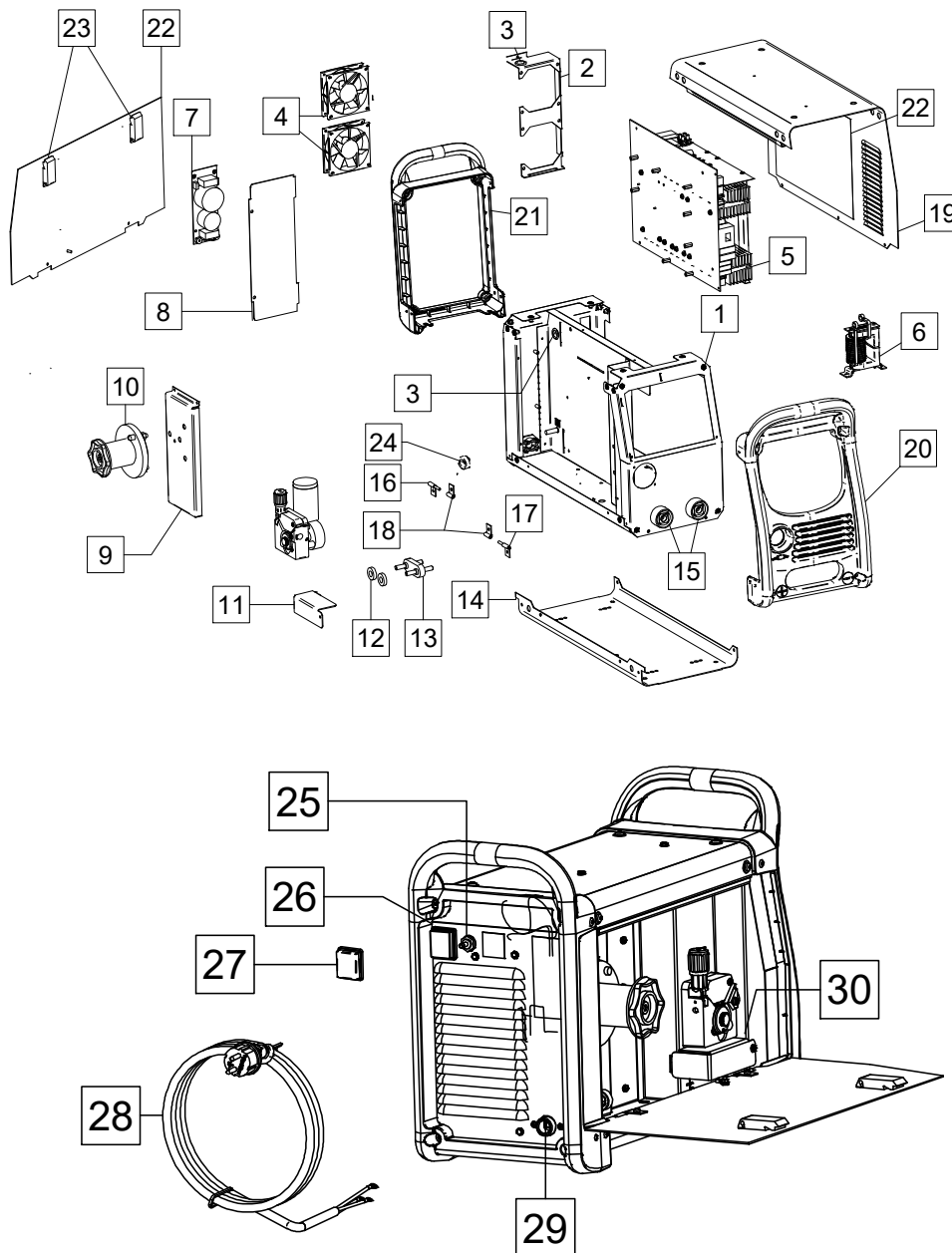
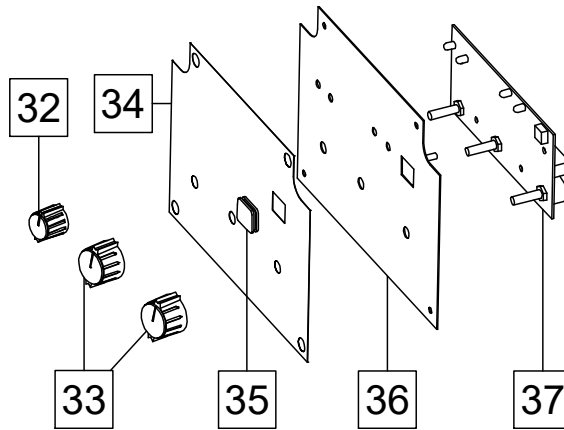


Figure A.

Figure A: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
1	RACK	R-3019-296-2/08R	1	X	-					
	RACK	R-3019-296-3/08R	1	-	X					
2	COVER	R-1019-292-2/08R	1	X	X					
3	RUBBER CABLE BUSH	1373-182-002R	2	X	X					
4	FAN	1111-311-082R	2	X	X					
5	P.C. BOARD	R-6042-064-1R	1	X	-					
	P.C. BOARD	R-6042-064-6R	1	-	X					
6	CHOCKE	R-4034-148-1R	1	X	X					
7	FILTER EMI	Y030-1R	1	X	X					
8	COVER	R-1019-336-1/08R	1	X	X					
9	SUPPORT	R-1019-297-1/08R	1	X	X					
10	REEL HUB COMPLETE	R-2013-126-1R	1	X	X					
11	COVER	R-1019-338-1/08R	1	X	X					
12	INSULATOR RING	D-1869-007-3R	2	X	X					
13	TERMINAL BLOCK X4	1361-599-328R	1	X	X					
14	COVER	R-1019-299-2/17R	1	X	X					
15	SOCKET X2, X3	W7690350R	2	X	X					
16	HINGLE AND AXLE	R-3019-471-1/17R	1	X	X					
17	HINGLE AND AXLE	R-3019-471-2/17R	1	X	X					
18	HINGLE	R-3019-470-1/17R	2	X	X					
19	COVER	R-1019-342-3R	1	X	X					
20	FRONT PANEL	R-0010-673-1R	1	X	X					
21	BACK PANEL	R-0010-674-1R	1	X	X					
22	LEFT SIDE PANEL	R-1019-341-3R	1	X	X					
23	LOCK	0654-610-004R	2	X	X					
24	FERRITE CORE	W5600005R	1	X	X					
25	GAS SOLENOID	0972-423-040R	1	X	X					
26	SWITCH	1115-270-019R	1	X	X					
27	BLACK FRAME SHIELD	1115-299-073R	1	X	X					
28	POWER LEAD	R-0010-435-1R	1	X	X					
29	CABLE RELIEF	1361-599-674R	1	X	X					
30	RUBBER CABLE BUSH	1361-599-198R	1	X	X					
68	THERMAL CIRCUIT	1115-299-033R	1	-	X					

CITOMIG 185MP



CITOMIG 210MP

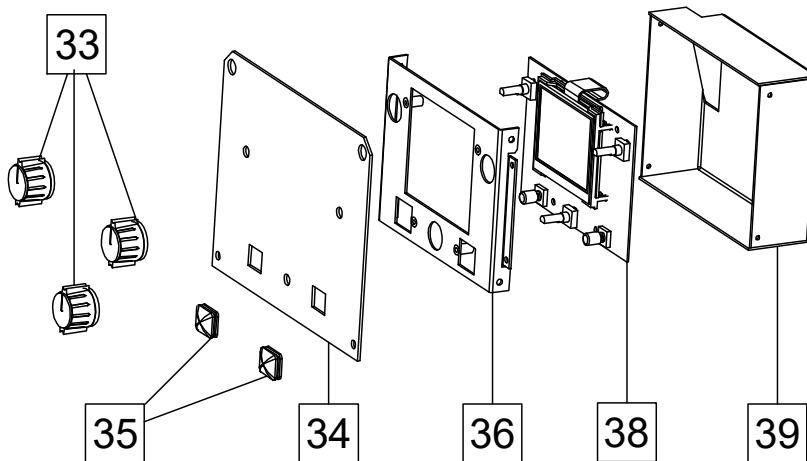


Figure B.

Figure B: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
32	KNOB CAP	090015026R 090015802R	1	X	-					
33	KNOBS CAP	90002771PR 090015827R	2	X	-					
	KNOBS CAP	90002771PR 090015827R	3	-	X					
34	STICKER	R-0010-687-1R	1	X	-					
	STICKER	R-0010-678-1R	1	-	X					
35	RUBBER BUTTOM	1373-182-005R	1	X	-					
	RUBBER BUTTOM	1373-182-005R	2	-	X					
36	FRONT PANEL 185 MP	R-3019-268-2/08R	1	X	-					
	FRONT PANEL 210 MP	R-3019-486-1/08R	1	-	X					
37	P.C. BOARD	Y031-1R	1	X	-					
38	P.C. BOARD COMPLETE	R-6042-063-4R	1	-	X					
	DISPLAY	0942-172-001R								
39	COVER	R-1012-929-1R	1	-	X					

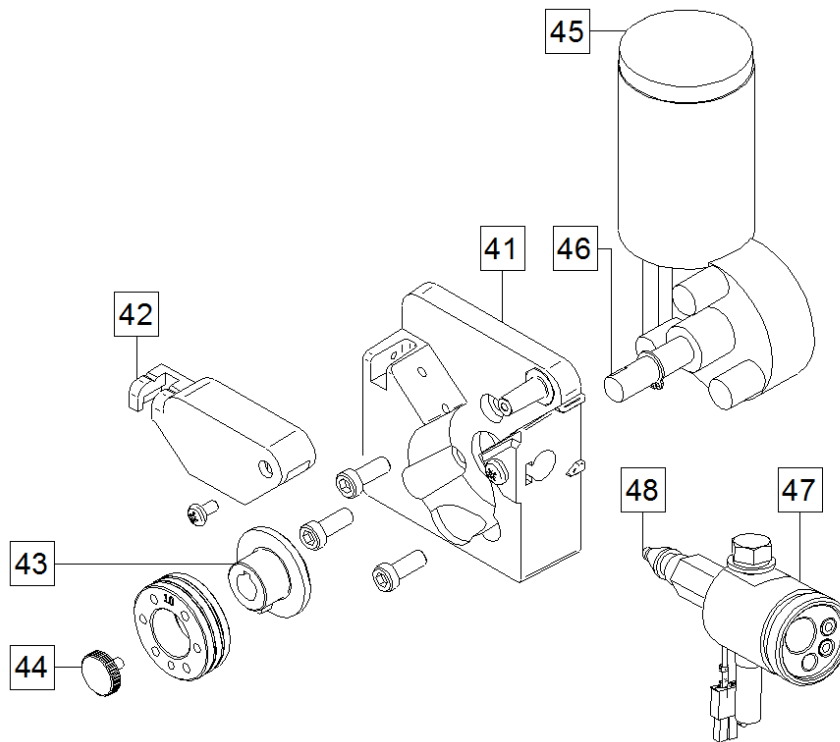


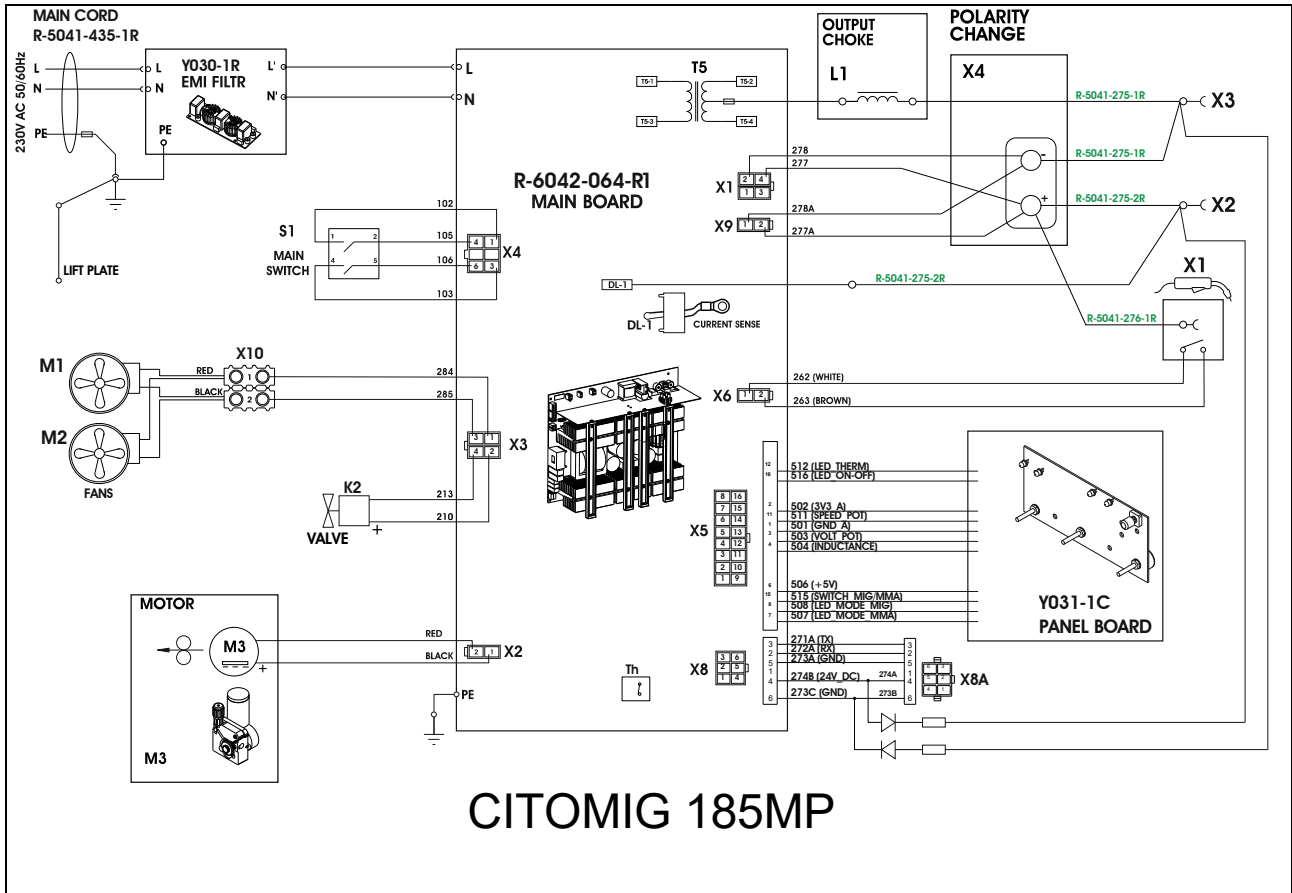
Figure C.

Figure C: Wire Drive Assembly & Euro Socket Assembly

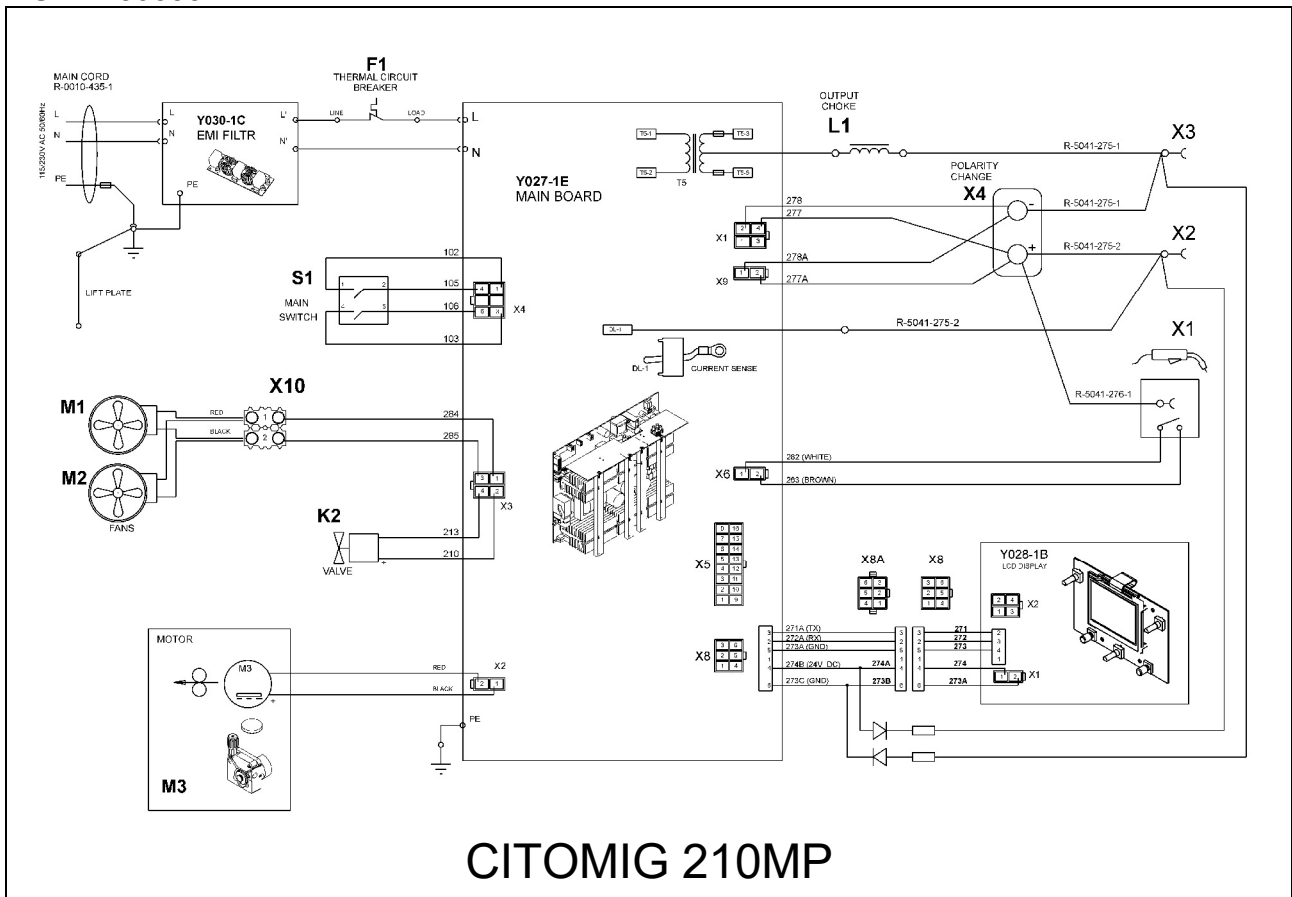
Item	Description	Part Number	QTY	1	2	3	4	5	6	7
	WIRE DRIVE ASSEMBLY	0744-000-246R	1	X	X					
41	FEED PLATE	0744-000-248R	1	X	X					
42	PRESSURE ARM COMPL	0744-000-249R	1	X	X					
43	DRIVE ROLL ADAPTER	0744-000-250R	1	X	X					
44	FIXING CAP	0744-000-251R	1	X	X					
45	MOTOR	0744-000-253R	1	X	X					
46	WOODROF KEY	0646-231-102R	1	X	X					
47	EURO SOCKET	R-8040-294-3R	1	X	X					
48	GUIDE PIPE	R-2010-017-2R	1	X	X					

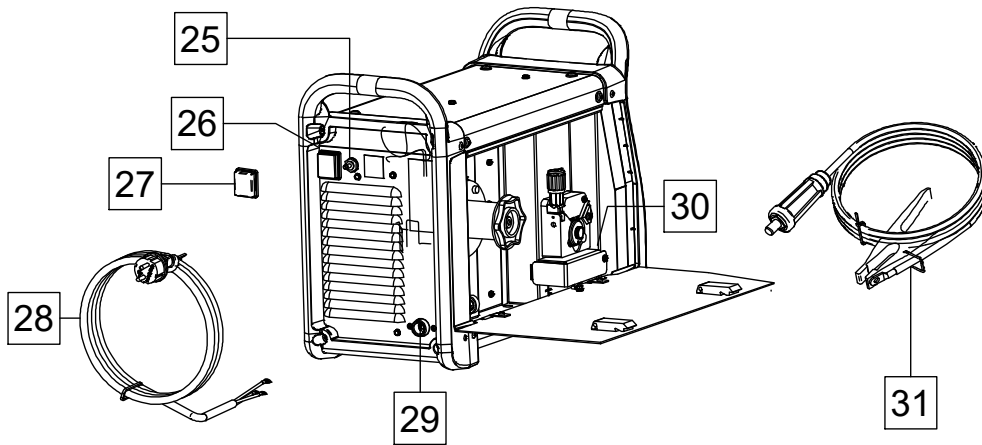
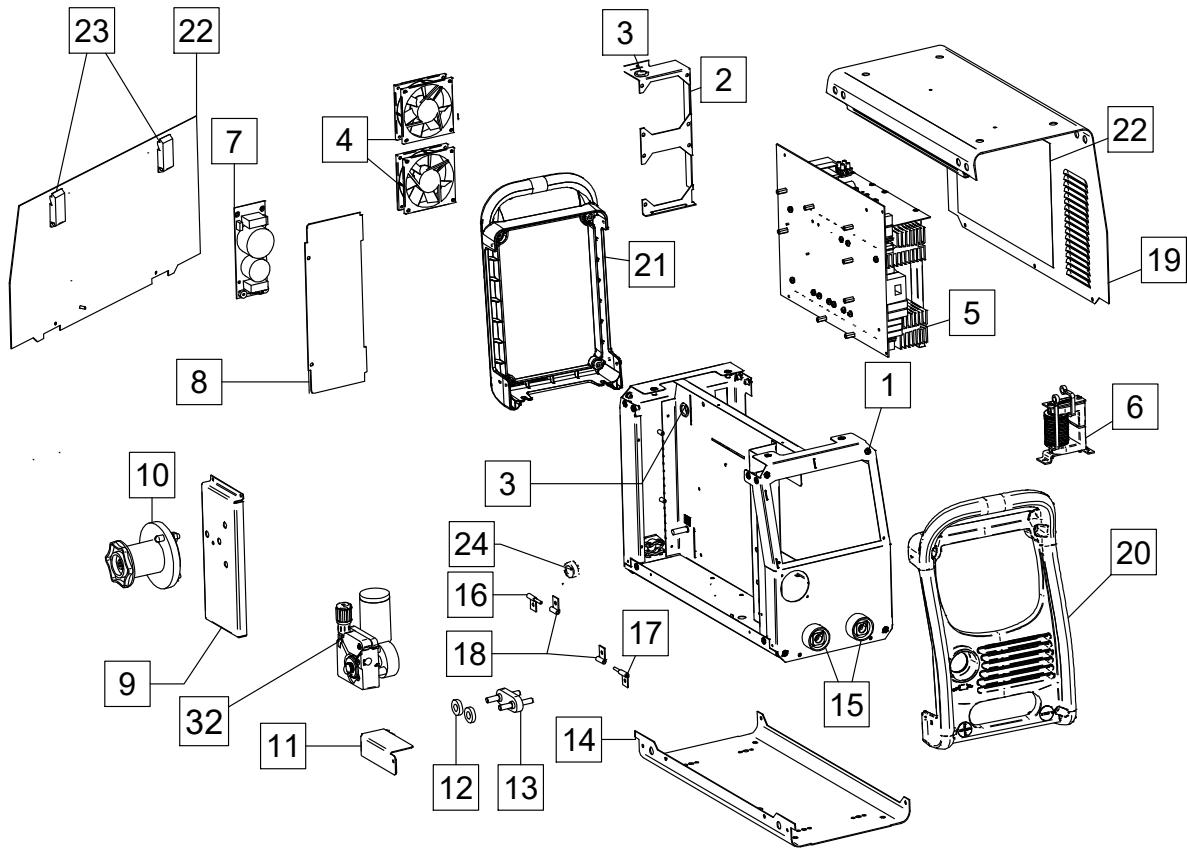
Electrical Schematic

CODE: 50400

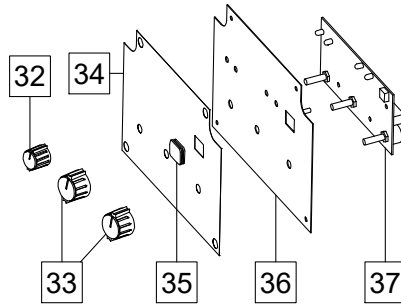


CODE: 50399

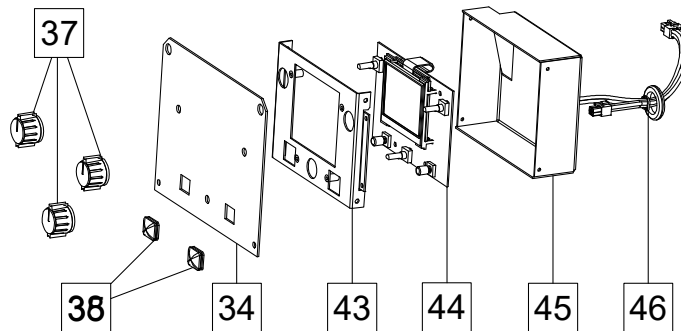




CITOMIG 185MP



CITOMIG 210MP



Description	Ref.	Recycle				ST				
		Fe	Al	Cu	Brass	Boards	Plastics	Liquid Cristal	External Electric Cables	Capacitors
RACK	1	X								
COVER	2,	X								
COVER	8,11,14,22,45		X							
LOCK	23						X			
LEFT SIDE PANEL	22		X							
FAN	4			X			X			
HINGLE	16, 17, 18	X								
P.C. BOARDS	5, 7, 40					X				
P.C. BOARD	44					X		X		
WIRE REEL SPINDLE	10	X					X			
SUPPORT	9	X								
SOCKET	15	X		X			X			
SWITCHES	26	X			X					
BLACK FRAME SHIELD	27						X			
KNOB	36, 37						X			
BUTTON	38						X			
GAS SOLENOID	25	X		X	X					
INSULATOR RING	12						X			
WIRE FEEDER	32	X		X			X			
TERMINAL BLOCK	13				X		X			
POWER LEAD	28			X	X		X			
WORK LEAD	31								X	
RUBBER CABLE BUSH	3, 30						X			
CABLE RELIEF	29						X			
CHOKE	6	X		X			X			
FRONT PANEL	39, 43	X		X						
WIRING HARNESS	46								X	
THERMAL CIRCUIT	68	X			X		X			

Quick Guide

QUICK GUIDE I

	Select Welding Process		SMAW (MMA) Welding		Basic menu
	Burnback		GMAW (MIG/MAG) Manual Welding		Brightness Level
	Run-in WFS		FCAW-S Self-shielded Manual Welding		View Software and Hardware Version Information
	Prewflow Time		GMAW (MIG/MAG) Synergic Welding		User Button
	Postflow Time		Select Process by Number		Cancel an Action
	Inductance		Select Gas		Switch On Output Voltage (TIG/MMA only)
	Spot Welding Setting		Select Wire Type (material)		Switch Off Output Voltage (TIG/MMA only)
	Spot Timer		Select Wire Size (diameter)		Unlock panel
	Switch off Spot Welding		Select Function of Gun Trigger (2-Step/4-Step)		Unlock Panel by Code
	2-Step		Configuration and Set-up		Hot Start
	4-Step		Lock/Unlock Panel		Arc Force
	Memory		Lock Panel		Adjust Voltage
	Save a Memory		Lock Panel by Code		Welding Material Thickness
	Recall a Memory (user memory)		Recall Factory Setting		Welding Current
	Clear a Memory		Select Menu (basic/advanced)		Wire Feeder Speed (WFS)
	GTAW (TIG) Welding		Advanced Menu		Voltage Reduction Device

User button

- Recalls selection menu [basic]
- Recalls selection menu [advanced] (default)
- Choose to redefine this button

Navigator knob

Changes the welding modes and their setting

Escape button

1. Cancels an action
2. Locks and Unlocks all knobs and buttons on the Panel (Press and Hold Button for 4s)

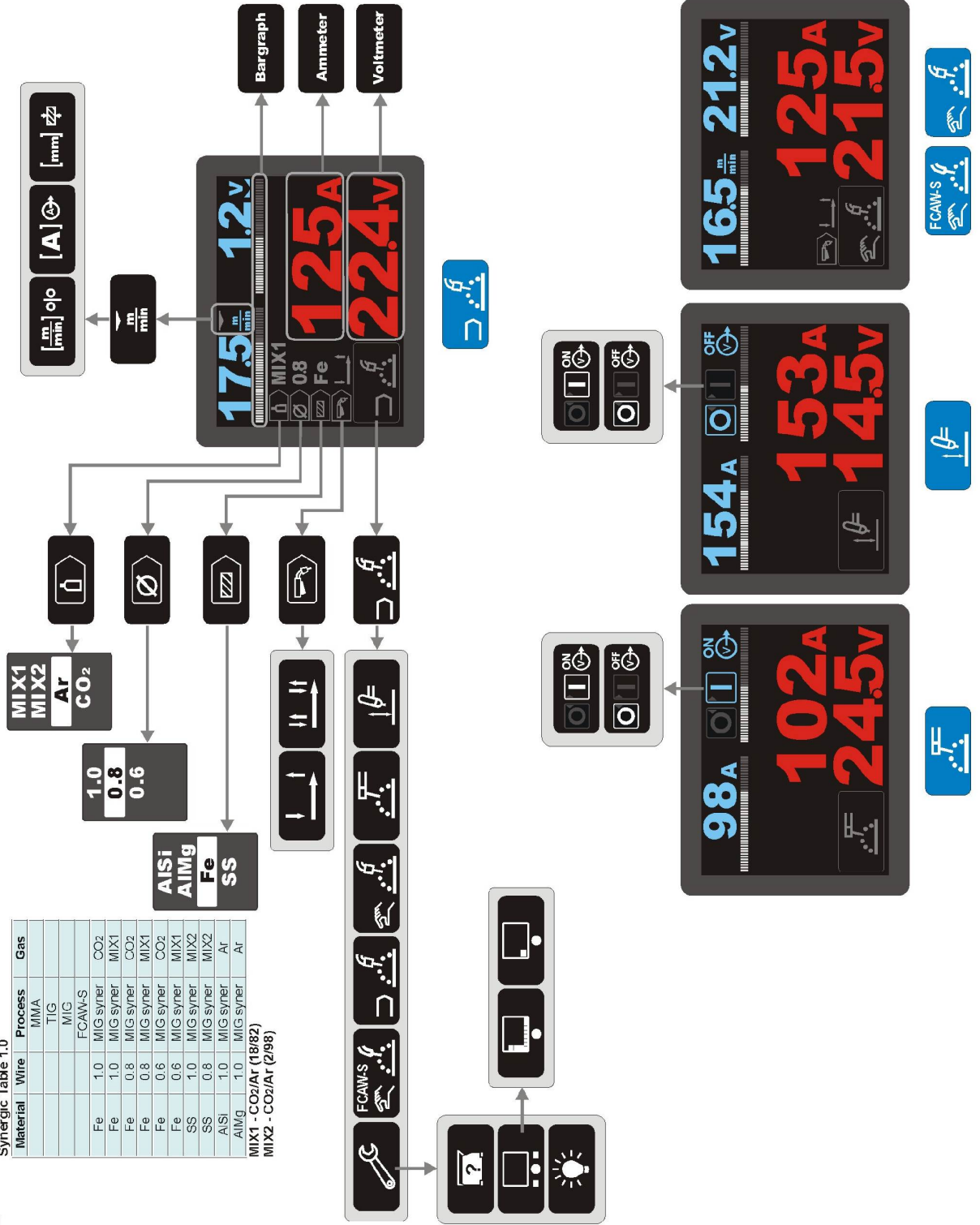
QUICK GUIDE II BASIC MENU



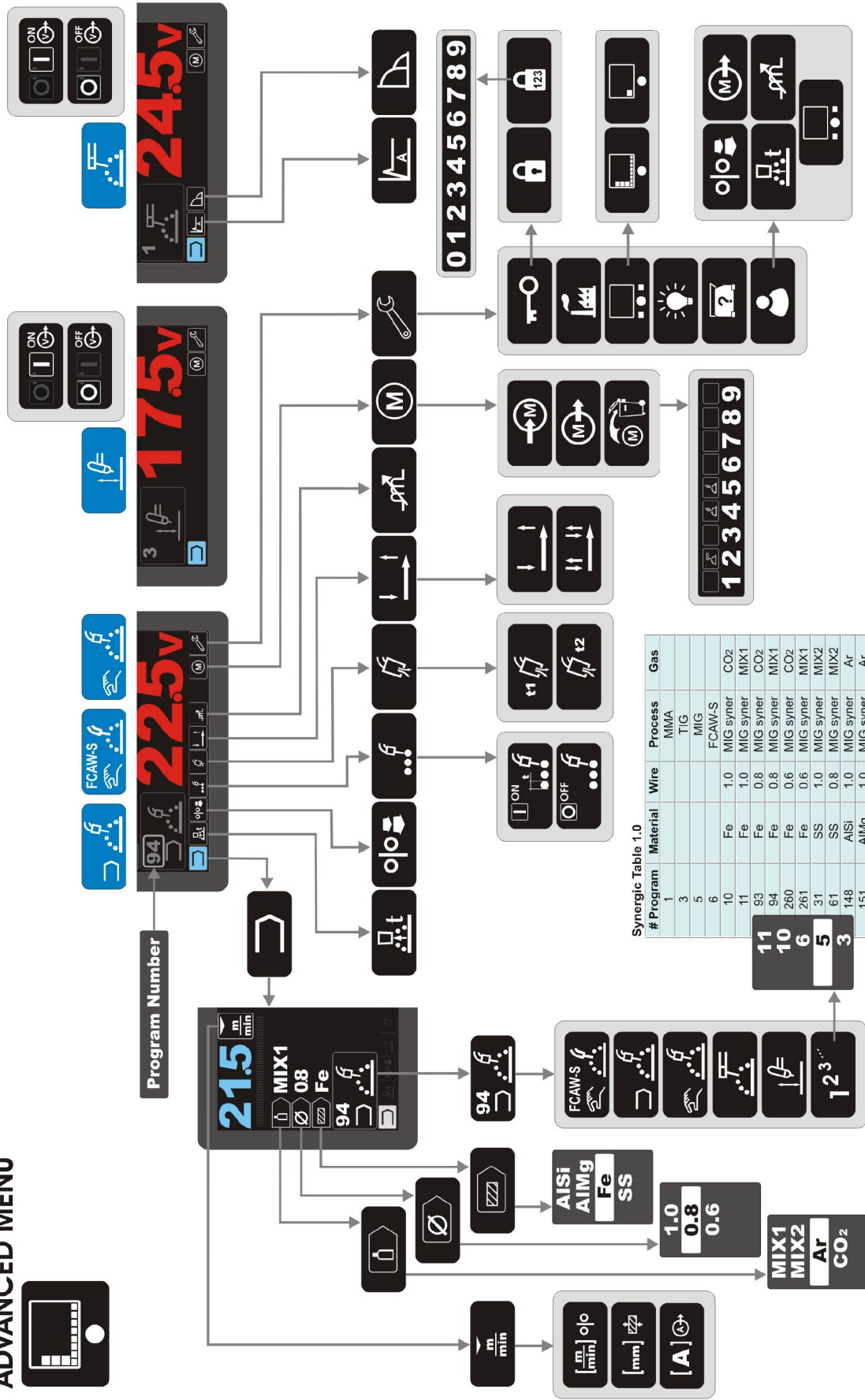
Synergic Table 1.0

Material	Wire	Process	Gas
		MMA	
		TIG	
		MIG	
		FCAW-S	
Fe	1.0	MIG syner	CO2
Fe	1.0	MIG syner	MIX1
Fe	0.8	MIG syner	CO2
Fe	0.8	MIG syner	MIX1
Fe	0.6	MIG syner	CO2
Fe	0.6	MIG syner	MIX1
Fe	0.6	MIG syner	MIX2
SS	1.0	MIG syner	MIX2
SS	0.8	MIG syner	MIX2
AlMg	1.0	MIG syner	Ar
AlMg	1.0	MIG syner	Ar

MIX1 - CO2/Ar (18/82)
MIX2 - CO2/Ar (2/98)



QUICK GUIDE III ADVANCED MENU



Synergic Table 1.0

# Program	Material	Wire	Process	Gas
1			MMA	
3			TIG	
5			MIG	
6			FCAW-S	
10	Fe	1.0	MIG syner	CO2
11	Fe	1.0	MIG syner	MIX1
93	Fe	0.8	MIG syner	CO2
94	Fe	0.8	MIG syner	MIX1
260	Fe	0.6	MIG syner	CO2
261	Fe	0.6	MIG syner	MIX1
31	SS	1.0	MIG syner	MIX2
61	SS	0.8	MIG syner	MIX2
148	AISI	1.0	MIG syner	Ar
151	AlMg	1.0	MIG syner	Ar

MIX1 - CO2/Ar (18/82)
MIX2 - CO2/Ar (2/98)