



PM-284833C

2024-04

Eff. w/Serial No. NA230285N

**Processes**



MIG (GMAW) Welding



Flux Cored (FCAW) Welding

**Description**

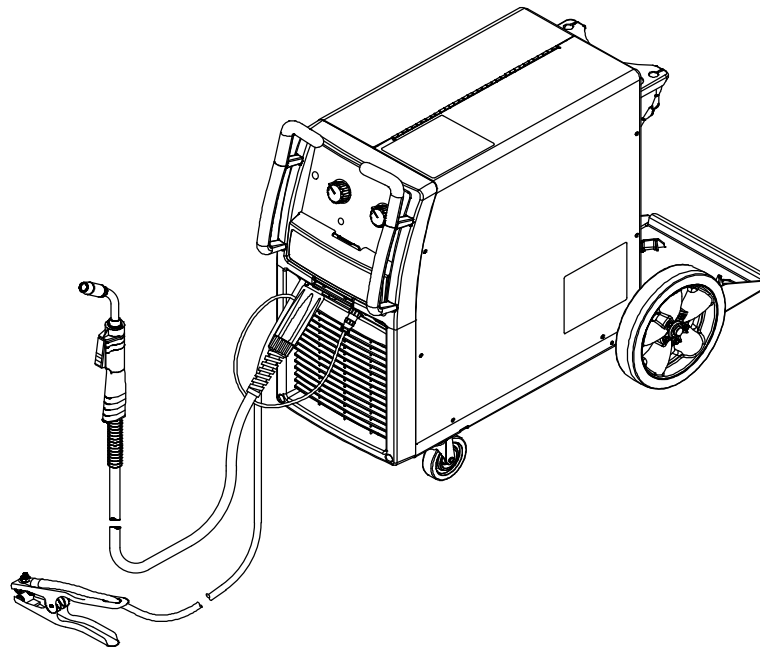


Arc Welding Power Source and Wire Feeder

# IronMan™ 240

## Eff w/NA230285N And Following

For OM-284833 Revision A And Following



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
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# PARTS LIST

File: MIG (GMAW)



# SECTION 1 – PARTS LIST

 Hardware is common and not available unless listed.

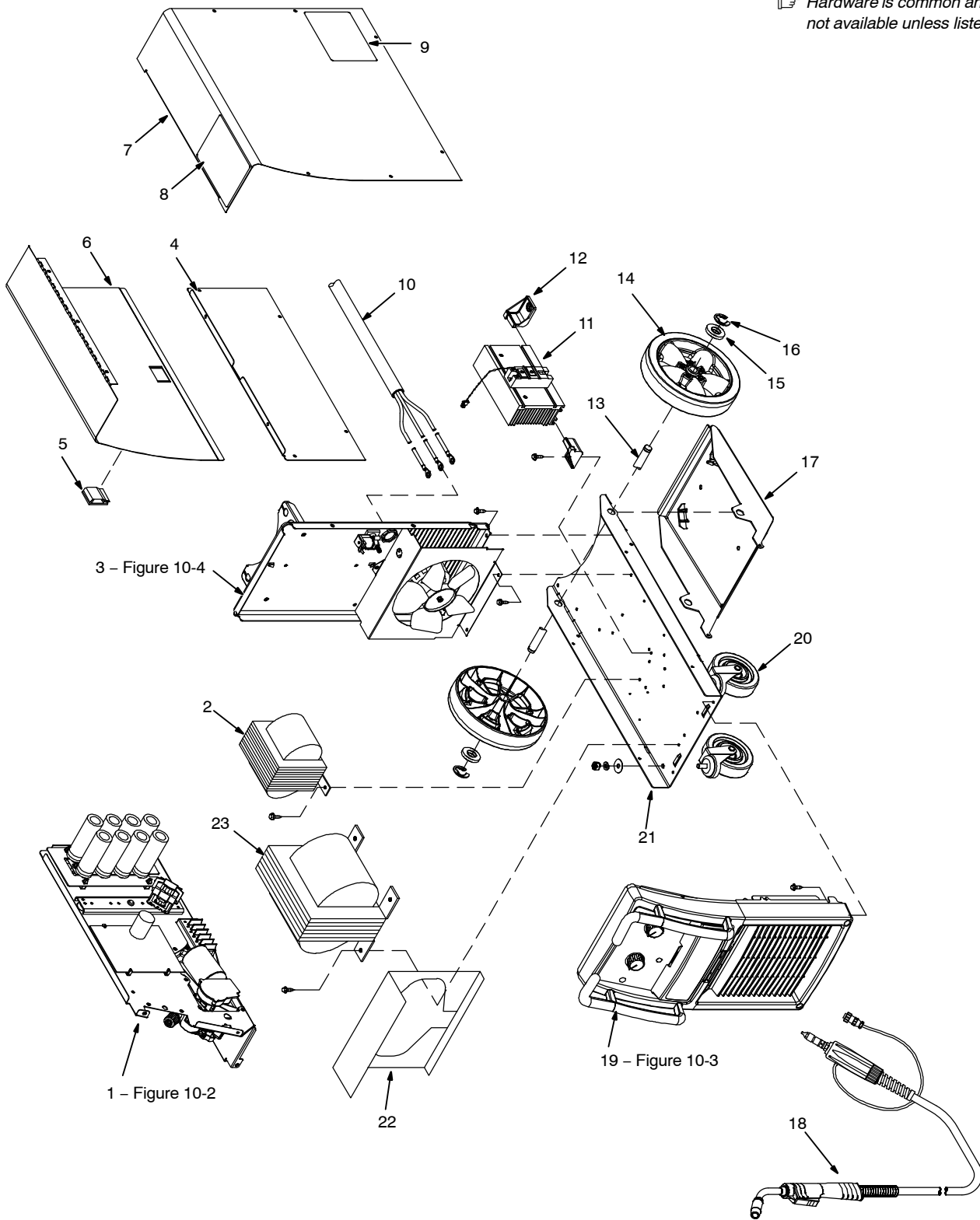


Figure 10-1. Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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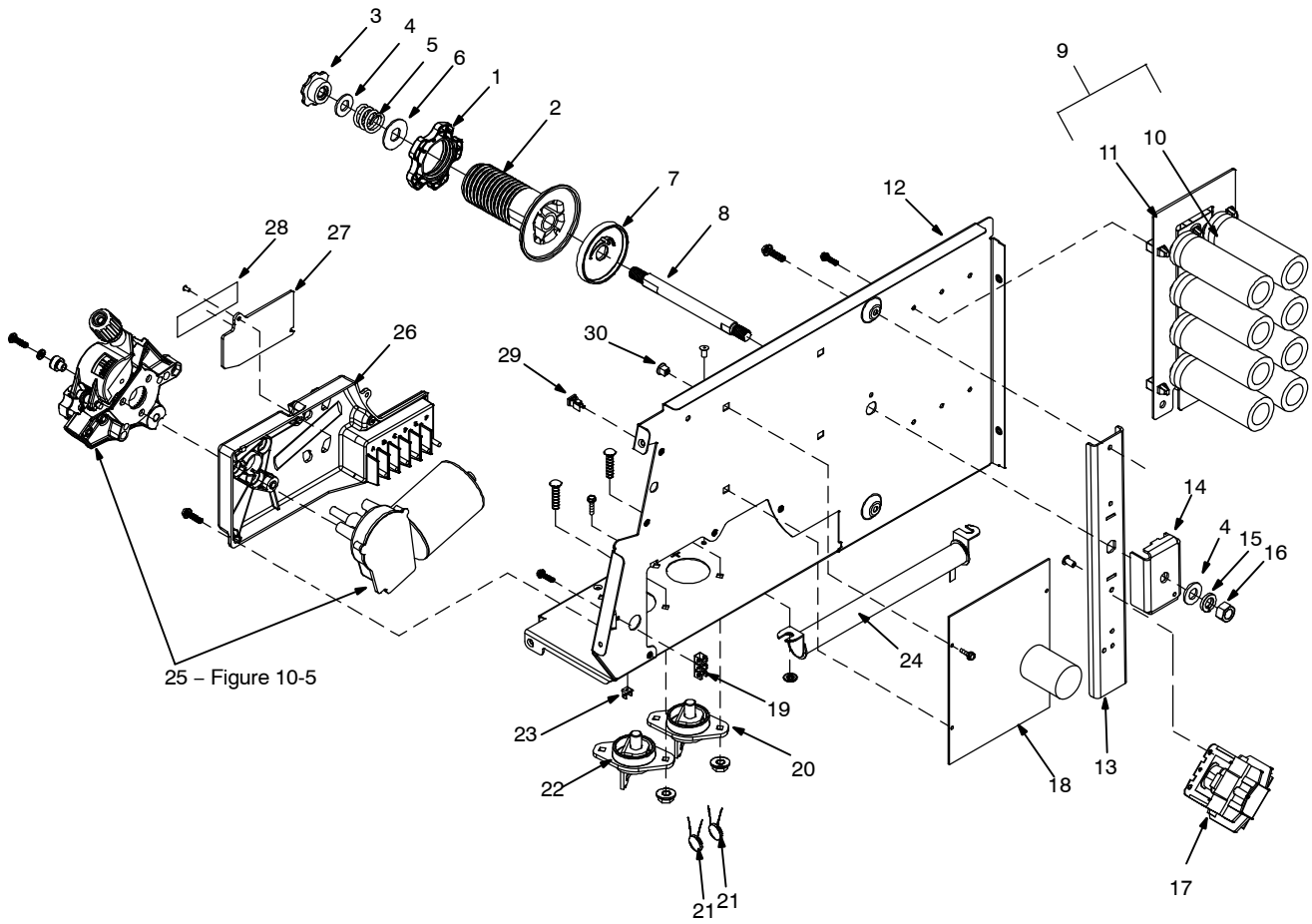
**Figure 10-1. Main Assembly**

1	Figure 10-2		Baffle, Center w/Components	1
2	Z1	231536	Stabilizer	1
3	Figure 10-4		Panel, Rear w/Components,	1
4		284823	Panel, Side LH Lower	1
5		230363	Latch, Slide Flush Mtg Hole 1.750 Widex 1.500 Lg	1
6		284824	Door, Hinged	1
7		+284822	Wrapper	1
8		231983	Label, Warning General Precautionary (En/Sp)	1
9		275317	Label, Warning Electric Shock/Incorr Input (En/Fr/Sp)	1
10		+280209	Cord Set, 250V 6-50P 8 Ga 3/C 12ft ST JKT	1
		231988	Label, Warning Electric Shock Power Cord (En/Sp)	1
11		232262	Rectifier Assy, SCR Main (Including)	1
12		205946	Foot, Mtg Rectifier	2
		232260	Rectifier, SCR Main (Including)	1
	PLG5	115094	Housing Plug & Skts	1
	SR1	197698	Thyristor, SCR Module 300a 400v Common Anode	1
		232261	Heat Sink, Rectifier	1
	C3,4	219460	Capacitor, Cer Disc .01 uf 1000 VDC w/Terms	2
	RT1	173632	Thermistor, NTC 30k ohm @ 25 Deg C 12in Lead	1
13		230798	Axle, Running Gear .750 Dia x 18.000	1
14		230799	Wheel, Polypropylene 10 in x 2.25 Wide	2
15		602250	Washer, Flat .812ID x1.469OD x.134t Stl Pld ANSI .750	2
16		121614	Ring, Rtnng Ext .750 Shaft x .085 Thk E Style Pld	2
17		229625	Tray, Cylinder Low	1
18		284973	HR200 Gun, .030-.035 Gun Replacement 15Ft (See Gun Owner's Manual)	1
19	Figure 10-3		Panel, Front w/Components,	1
20		235875	Caster, Swvl 4.00 in Polyolefin x 1.250 in Wide	2
21		229624	Base	1
22		248427	Baffle, Air Xfmr	1
23		283971	Xfmr, Power Main 208/240	1
		248426	Blank, Snap-in	2
	PLG8	096530	Conn, Rect Comm 093 4P/S 1row RCPT Cable Molex LKG	1
		237652	Regulator/Flowgauge, 0-50 CFH AR/CO2/Mix	1
		233473	Cable, Work 10 ft No 3 w/Clamp & Boot (Including)	1
		233452	Clamp, Work 300 Amp	1
		600318	Cable, Weld Cop Strd No 3 EPDM JKT (order by ft)	1
		196318	Cover, Cable BTRY Post BLK .75 ID	1
		269815	Hose, Gas Reinforced PVC w/Ftg 5 ft	1

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

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

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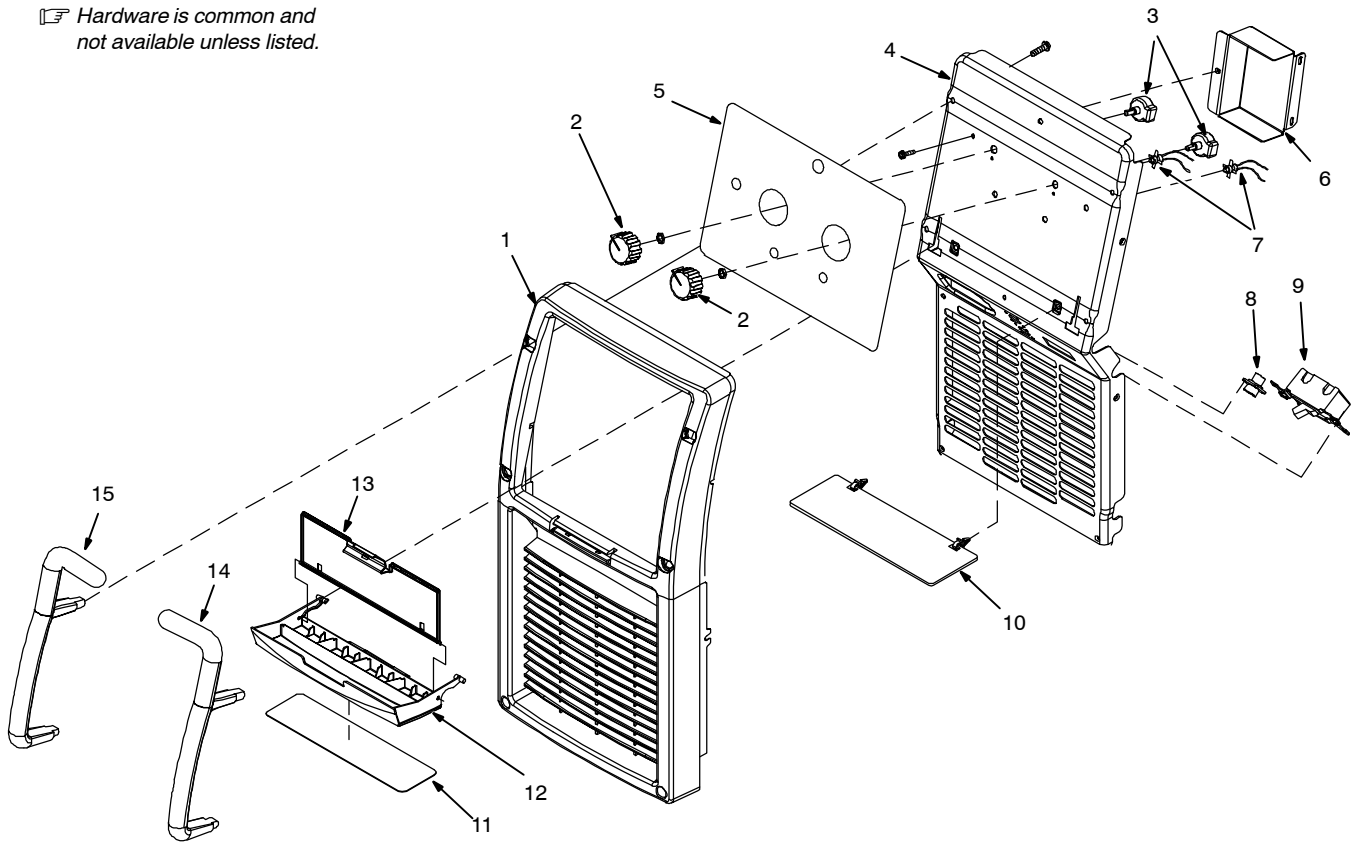
**Figure 10-2. Baffle, Center w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 10-2. Baffle, Center w/Components</b>				
.....		283969	.. Kit, Spool Hub (Including) .....	1
1		280091	.. Nut, Hub .....	1
2		279587	.. Hub, Spool 12 Inch .....	1
3		279504	.. Knob, Tensioner 1/2-13 Thread .....	1
4		602247	.. Washer, 531 Id x 1.062 Od x .095T Stl Pld Ansi .500 .....	2
5		172918	.. Spring, Cprsn .845 Od X .110 Wire x 1.500 Pld .....	1
6		231211	.. Washer, Anti-Turn .....	1
7		287119	.. Washer, Brake Plastic .....	1
8		271415	.. Shaft, Support Spool .....	1
9		185644	.. Capacitor Assy, .....	1
10	C5	184584	.. Capacitor, ELCTLT 15000 uf 45 VDC Can 1.395 .....	8
11		229801	.. Kit, Capacitor Buss Bar & Insulator .....	1
12		229623	.. Baffle, Center .....	1
		231985	.. Label, Warning Electric Shock And Pinch (En/Sp) .....	1
		226658	.. Label, Polarity/Drive Rolls .....	1
		284705	.. Label, Link Arr Pri V 208/240 .....	1
13		274304	.. Channel, Support Spool Hub .....	1
14		274305	.. Brace, Support Spool Shaft .....	1
15		602216	.. Washer, Lock .502 Id x .879 Od x .151T Stl Pld Split .500 .....	1
16		601879	.. Nut, .500-12 .75 Hex .44H Stl Pld .....	1
17		252908	.. Contactor, Def Prp 25A 1P 36Vdc Coil .....	1
18	PC1	281927	.. Circuit Card Assy, Control IM 240 .....	1
19		129524	.. Term, Frict 250x032 Uninsul Male .130 Stud Mtg 3pr .....	1
20	POS	097421	.. Terminal, Pwr Output Red .....	1
21	C1,C2	128750	.. Capacitor, Cer Disc .1 uf 500 VDC w/Terms .....	2
22	NEG	097416	.. Terminal, Pwr Output Black .....	1
23		600760	.. Term, Frict 250 x 032 Uninsul Male.130 Stud Mtg 1 Pair .....	1
24	R1	119998	.. Resistor, WW Fxd 300 W 5 ohm .....	1
		252662	.. Drive Assy, Wire w/Pri Link 2V (Including) .....	1
25	Figure 10-5		.. Motor And Wire Drive Assy .....	1
26		229630	.. Housing, Drive Assy/Pri Term Link 2 Voltage (Including) .....	1
27		229634	.. Door, Access Changeover .....	1
28		231987	.. Label, Warning High Voltage (En/Sp) .....	1
29		134201	.. Stand-off Support, PC Card .312/.375 w/Post&lock .43 .....	3
30		228165	.. Grommet, Scr No 8 Panel Hole .312 x .343 .515 High .....	1

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

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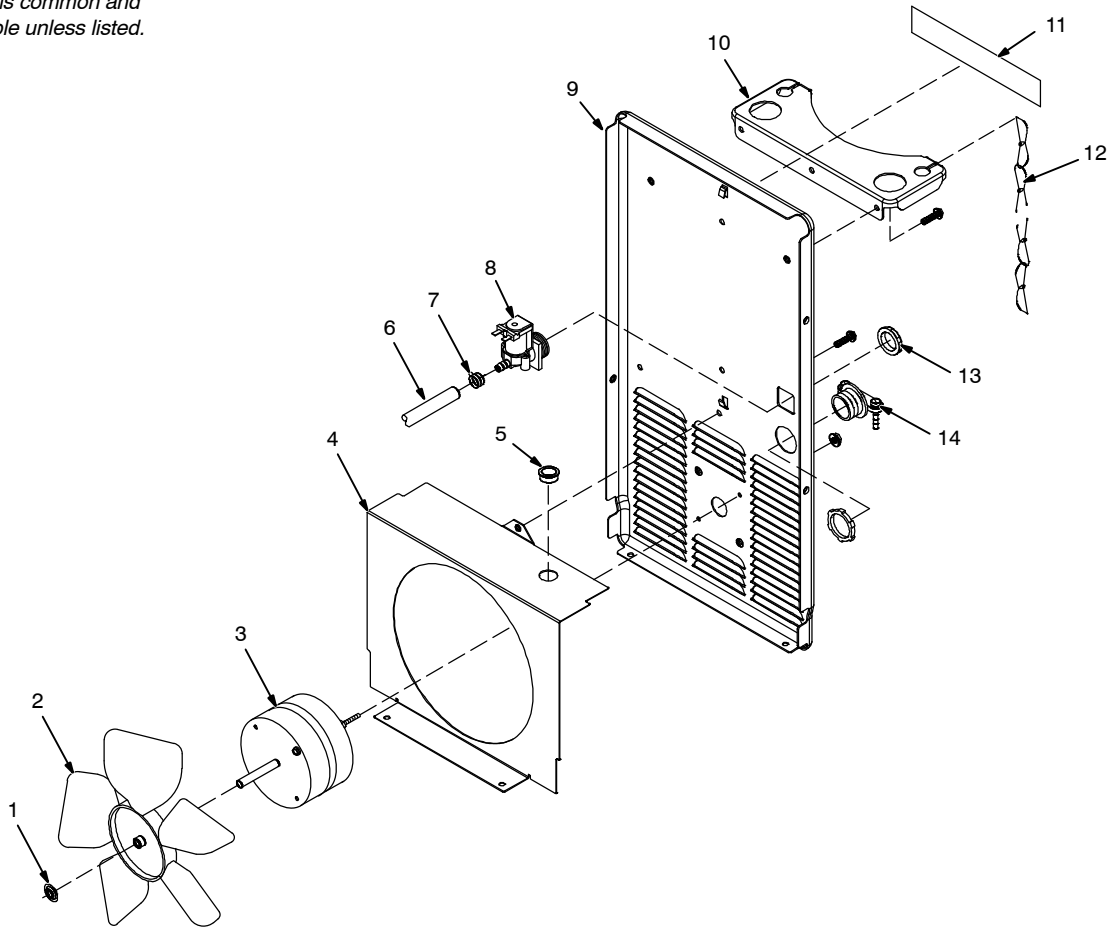
288982-A

**Figure 10-3. Panel, Front w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
...	...	230304	.. Bezel, Front w/Consumable Tray	1
...	...	286479	.. Label, Power/Mig Gun/Spoolgun	1
...	...	293816	.. Kit, Potentiometer w/Knobs Ironman 240 (Including)	1
...	...	238873	.. Knob, Pointer 1.625 Dia	2
...	R1,R2	246617	.. Pot Assy, w/Leads & Connector Cp Flat 1T 2 W	2
...	...	248495	.. Panel, Front	1
...	...	284825	.. Label, Controls	1
...	...	238079	.. Enclosure, PC Board/Pots	1
...	LED1,2	285899	.. Led Assy, w/Leads	1
...	RC1	048282	.. Rcpt w/Skts, (Service Kit) (MIG Gun)	1
...	S1	124511	.. Switch, Tgl Dpst 40A 600VAC Scr Term	1
...	...	284702	.. Flip Chart	1
...	...	230365	.. Clip, Snap In .250 Id x .250 Mntg Hole x .030-.125 Pnl	2
...	...	284826	.. Label, Nameplate	1
...	...	229617	.. Tray, Consumables	1
...	...	229618	.. Cover, Tray Consumables	1
...	...	287484	.. Label, Consumables HR200	1
...	...	231553	.. Handle, RH	1
...	...	231554	.. Handle, LH	1
...	...	287487	.. Cover, Hole Plastic Snap In	1

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

☞ Hardware is common and not available unless listed.



804918-A

**Figure 10-4. Panel, Rear w/Components**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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**Figure 10-4. Panel, Rear w/Components**

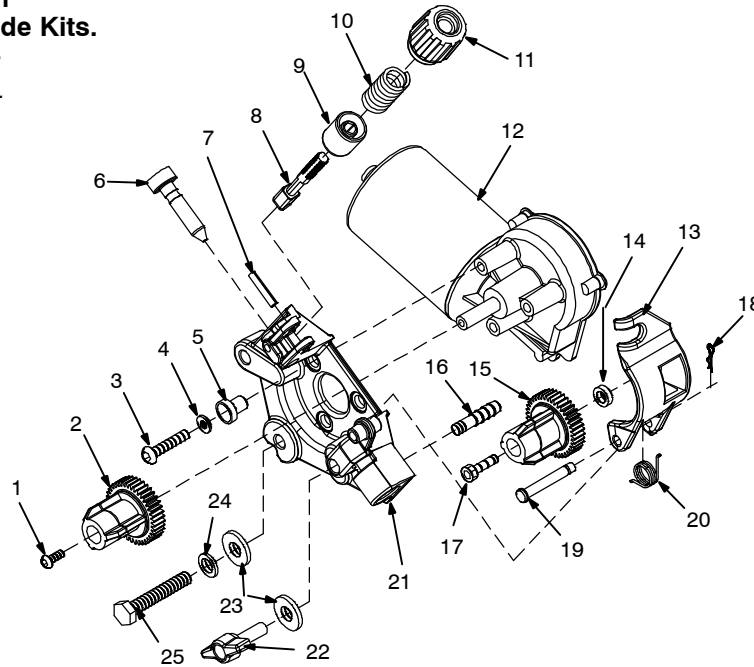
...	1	049399	.. Nut, 312-18 Push On .63d .07h Stl	1
...	2	148809	.. Blade, Fan 9.000 5wg 34deg .312 Bore CCW Plstc	1
...	3	FM 188706	.. Motor, Fan 230V 50/60Hz 1550 RPM .312 Dia Shaft	1
...	4	225669	.. Windtunnel	1
...	5	010493	.. Bushing, Snap-in Nyl .625 ID x .875 Mtg Hole	1
...	6	146524	.. Hose, SAE .187 ID x .410 OD X 27.000	1
...	7	149332	.. Clamp, Hose .405 - .485 Clp Dia Slftng Olive Dra	2
...	8	GS1 228035	.. Valve, 34VDC 2 Way Custom Port 1/8 ORF w/Frict	1
...	9	225282	.. Panel, Rear 252	1
...	10	+229628	.. Bracket, Support Cylinder	1
...	11	231986	.. Label, Warning Cyl May Explode If Damaged (En/Sp)	1
...	12	188441	.. Chain, Weldless 2/0 x 31. Bright Zinc Pld	1
...	13	272186	.. Nut, 750-14 NPS 1.312 Hex .413H Nyl	1
...	14	604102	.. Conn, Clamp Cable 1.000	1

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

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

**See Section 1-1  
Drive Roll & Wire Guide Kits.**

 Hardware is common and not available unless listed.



804919-C

**Figure 10-5. Wire Drive And Gears**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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**Figure 10-5. Wire Drive And Gears (Prior To Ser. NA360063N)**

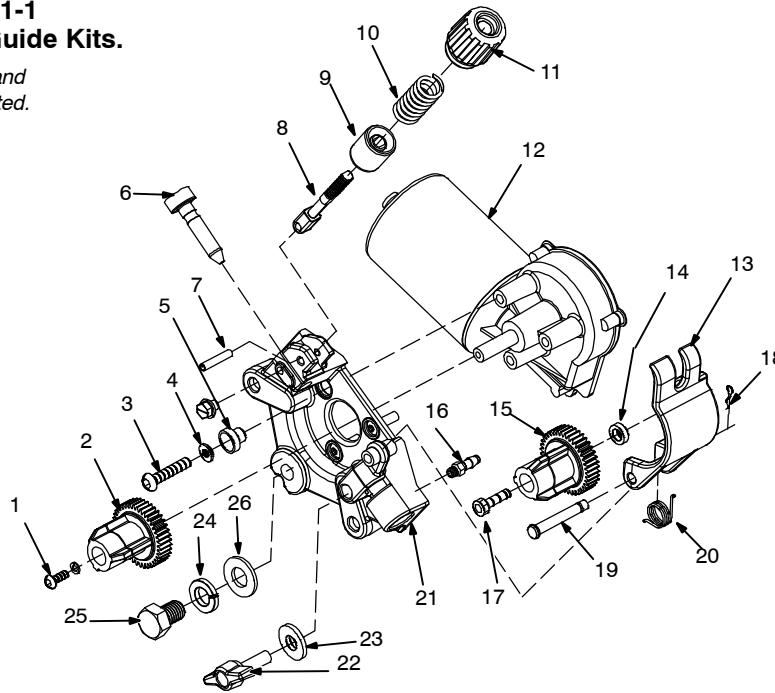
...	1	174609	.. Screw, M 4- .7 x 12 Cheese Hd Blk Din 84	1
...	2	173619	.. Carrier, Drive Roll w/Components 24 Pitch 10mm Shaf	1
...	3	174610	.. Screw, M 6-1.0 x 20 Soc Hd Button Cap Blk	3
...	4	192029	.. Washer, Flat .250 ID x0.437 OD x.015t Stl Pln	3
...	5	173620	.. Bushing, Mtg Motor	3
...	6	221912	.. Guide, Wire Inlet Nylon .023 - .052	1
...	7	010224	.. Pin, Spring CS .187 x 1.000	1
...		221976	.. Knob, Tension Adjust Assy (Including)	1
...	8	225718	.. Fastener, Pinned	1
...	9	196896	.. Cup, Spring	1
...	10	196897	.. Spring, CPRSN .695 OD x .095 Wire x 1.500	1
...	11	196895	.. Knob, Tension	1
...	12	249883	.. Motor, Gear 24 VDC 150 RPM 37.:5 Ratio	1
...	13	287529	.. Lever, Mtg Pressure Gear	1
...		230801	.. Spring, Torsion	1
...	14	166072	.. Spacer, Gear	1
...	15	172075	.. Carrier, Drive Roll w/Components 24 Pitch	1
...	16	263411	.. Fitting, Barbed Gas	1
...	17	602009	.. Screw, 250-20 x 1.25 Soc Hd-hex Gr8 Pln	1
...	18	151828	.. Pin, Cotter Hair .042 x .750	1
...	19	273112	.. Pin, Clevis .250 OD x 1.751 Lg w/Groove and Cham	1
...	20	230801	.. Spring, Torsion	1
...	21	287529	.. Housing, Adapter Drive Motor	1
...	22	222035	.. Knob, T 1.562 Bar w/.312-18 Stud 1.00 Lg	1
...	23	604538	.. Washer, Flat .344 ID x0.688 OD x.065t Stl Pld ANSI .312	3
...	24	602211	.. Washer, Lock .318 ID x 0.586 OD x .078t Stl Pld Split .312	2
...	25	604534	.. Screw, 312-18 x 1.25 Hex Hd-pln Gr5 Pld	1
...		203526	.. Roll, Drive V Groove .030-.035 Wire	2

\*Recommended Spare Parts.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

**See Section 1-1  
Drive Roll & Wire Guide Kits.**

 Hardware is common and not available unless listed.



804919-D

**Figure 10-6. Wire Drive And Gears**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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**Figure 10-6. Wire Drive And Gears (Eff with Ser. NA360063N)**

...	1	174609	.. Screw, M 4- .7 x 12 Cheese Hd Blk Din 84	1
...	2	173619	.. Carrier, Drive Roll w/Components 24 Pitch 10mm Shaf	1
...	3	174610	.. Screw, M 6-1.0 x 20 Soc Hd Button Cap Blk	3
...	4	192029	.. Washer, Flat .250 ID x0.437 OD x.015t Stl Pln	3
...	5	173620	.. Bushing, Mtg Motor	3
...	6	221912	.. Guide, Wire Inlet Nylon .023 - .052	1
...	7	010224	.. Pin, Spring CS .187 x 1.000	1
...		221976	.. Knob, Tension Adjust Assy (Including)	1
...	8	225718	.. Fastener, Pinned	1
...	9	196896	.. Cup, Spring	1
...	10	196897	.. Spring, CPRSN .695 OD x .095 Wire x 1.500	1
...	11	196895	.. Knob, Tension	1
...	12	249883	.. Motor, Gear 24 VDC 150 RPM 37.:5 Ratio	1
...	13	277795	.. Lever, Mtg Pressure Gear	1
...		230801	.. Spring, Torsion	1
...	14	166072	.. Spacer, Gear	1
...	15	172075	.. Carrier, Drive Roll w/Components 24 Pitch	1
...	16	263411	.. Fitting, Barbed Gas	1
...	17	602009	.. Screw, 250-20 x 1.25 Soc Hd-hex Gr8 Pln	1
...	18	151828	.. Pin, Cotter Hair .042 x .750	1
...	19	273112	.. Pin, Clevis .250 OD x 1.751 Lg w/Groove and Cham	1
...	20	230801	.. Spring, Torsion	1
...	21	277657	.. Housing, Adapter Drive Motor	1
...	22	222035	.. Knob, T 1.562 Bar w/.312-18 Stud 1.00 Lg	1
...	23	604538	.. Washer, Flat .344 ID x0.688 OD x.065t Stl Pld ANSI .312	1
...	24	602216	.. Washer, Lock .502 ID x 0.879 OD x .151t Stl Pld Split .500	1
...	25	282942	.. Screw, 500-13 x .750 Hex Hd-Phl Stl Pld	1
...	26	602248	.. Washer, Flat .531 ID x 1.062 OD .095T Stl Pld	1
...		203526	.. Roll, Drive V Groove .030-.035 Wire	2

\*Recommended Spare Parts.

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## 1-1. Drive Roll And Wire Guide Kits

☞ Base selection of drive rolls upon the following recommended usages:

- 1 V-Grooved rolls for hard wire.
- 2 U-Grooved rolls for soft and soft shelled cored wires.
- 3 U-Cogged rolls for extremely soft shelled wires (usually hard surfacing types).
- 4 V-Knurled rolls for hard shelled cored wires.
- 5 Drive roll types may be mixed to suit particular requirements (example: V-Knurled roll in combination with U-Grooved).

Wire Diameter			Kit No.	Drive Roll		Inlet Wire Guide
Fraction	Decimal	Metric		Part No.	Type	
.023/.025 in.	.023/.025 in.	0.6 mm	087 131	087 130	V-Grooved	056 192
.030/.035 in.	.030/.035 in.	0.8/0.9 mm	204 579	203 526	V-Grooved	056 192
.030 in.	.030 in.	0.8 mm	079 594	053 695	V-Grooved	056 192
.035 in.	.035 in.	0.9 mm	079 595	053 700	V-Grooved	056 192
.045 in.	.045 in.	1.2 mm	079 596	053 697	V-Grooved	056 193

Ref. S-0026-B/7-91



# Owner's Record

Please complete and retain with your personal records.

Model Name

Serial/Style Number

Purchase Date

(Date which equipment was delivered to original customer.)

Distributor

Address

City

State

Zip



Thank you for purchasing Hobart. Our trained technical support team is dedicated to your satisfaction. For questions regarding performance, operation, or service, contact us!

## Resources Available

Always provide Model Name and Serial/Style Number.

### To locate a Service Center:

Call 1-800-332-3281

or visit our website at [www.HobartWelders.com/wheretobuy](http://www.HobartWelders.com/wheretobuy)

### For Technical Assistance:

Call 1-800-332-3281

8 AM to 5 PM EST – Monday through Friday

#### Miller Electric Mfg. LLC

An Illinois Tool Works Company  
1635 West Spencer Street  
Appleton, WI 54914 USA

#### For Assistance:

Call 1-800-332-3281

