



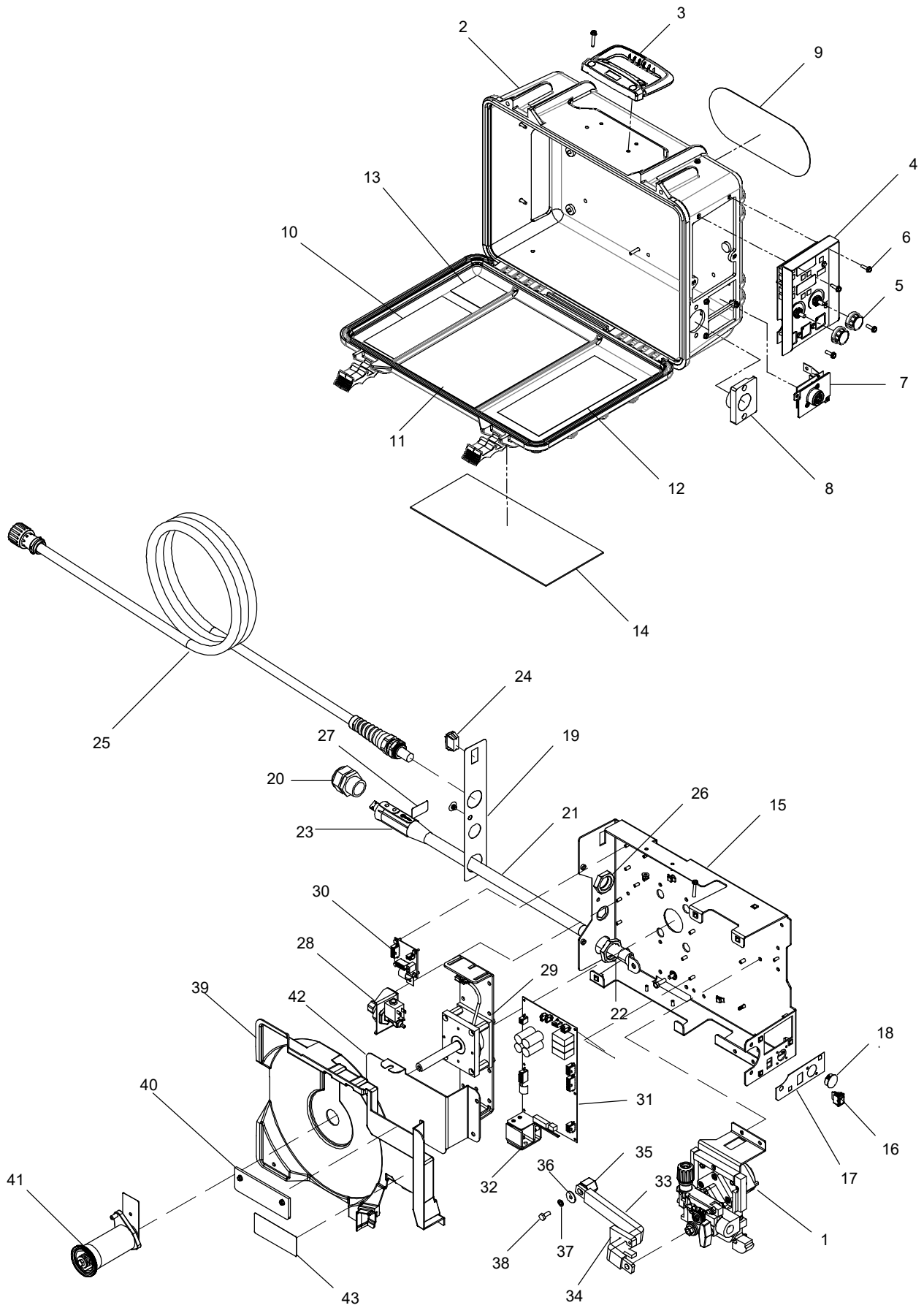
PM- 285785 E

# XR-AlumaFeed Suitcase CE And Non-CE Models

Effective with Serial Number  
NA141001V And Following



## PARTS MANUAL



Main Assembly

**Main Assembly**

| Item No. | Dia. Mkgs. | Part No. | Description  | Qty                   |   |
|----------|------------|----------|--|-----------------------|---|
| 1        |            |          | Drive Assembly, Wire w/Bracket (Figure 2)                            | 1                     |   |
| 2        |            | 289790   | Case, Assy Feeder XR   | 1                     |   |
| 3        |            | 276345   | Handle, Rubberized Carrying  | 1                     |   |
| 4        |            | 284683   | Panel Assy, Front  | 1                     |   |
| 5        |            | 174991   | Knob, Pointer 1.250 Dia X 250 Id W/Spring Clip-21                    | 1                     |   |
| 6        |            | 122210   | Screw, 010-32 x .62 Hexwhd.40d Stl Pld Siffmg Tap-Rw                 | 1                     |   |
| 7        |            | 284256   | Panel Assy, Control  | 1                     |   |
| 8        |            | 285774   | Bushing, Insulating Gun  | 1                     |   |
| 9        |            | 279856   | Label, Miller 10.000 X 4.227 Horizontal (Wht/Blk)                    | 1                     |   |
| 10       |            | 285984   | Label, XR-AlumaFeed SuitCase Consumables Chart                       | 1                     |   |
| 11       |            | 285983   | Label, Set-Up Procedure  | 1                     |   |
| 12       |            | 279671   | Label, Warning General Precautionary (EN/FR/SP-SYM)                  | 1                     |   |
| 13       |            |          | Label, Rating Card   | 1                     |   |
| 13       |            |          | Label, Rating Card CE  | 1                     |   |
| 14       |            | 285631   | Label, Warning/Miller  | 1                     |   |
| 15       |            | 284238   | Chassis, Control Box   | 1                     |   |
| 16       | S2         | 287022   | Switch, Rocker Spdt 15A 125VAC (ON)-OFF-(ON) .189T                   | 1                     |   |
| 17       |            | 284249   | Label, Jog/Purge (Front)   | 1                     |   |
| 18       |            | 000527   | Blank, Snap-In Nyl .875 Mtg Hole Black                               | 1                     |   |
| 19       |            | 284248   | Insulator, Rear Panel  | 1                     |   |
| 20       |            | 215980   | Bushing, Strain Relief .709/.984 Id X1.375 Mtg Hole                  | 1                     |   |
| 21       |            | 221346   | Lead List, Large   | 1                     |   |
| 22       |            | 234126   | Nut, Conduit 1.000 Npt Knurled                                       | 1                     |   |
| 23       |            | 242250   | Conn, TW LK Insul Male (Tweco/Lenco Type) HD 3/0-4/0                 | 1                     |   |
|          |            | 242251   | Conn, Tw Lk Insul Fem (Tweco/Lenco Type) Hd 3/0-4/0 (Loose Part)     | 1                     |   |
| 23       |            | 288412   | Conn, Tw Lk Insul Male (Dinse Type) Blk 3/0-4/0 (CE Model)           | 1                     |   |
|          |            | 138180   | Conn, Tw Lk Insul Fem (Dinse Type) 95 Series (CE Model) (Loose Part) | 1                     |   |
| 24       | S1         | 111997   | Switch, Rocker Spst 10A 250VAC On-Off Visi Red Rock                  | 1                     |   |
| 25       |            | 239885   | Cable, Power   | 1                     |   |
| 26       |            | 254843   | Nut, Pg21 1.50Hex X .375H Aluminum                                   | 1                     |   |
| 27       |            | 252410   | Label, Filter/Gas In   | 1                     |   |
| 28       | GS1        | 286314   | Valve Assy, Gas  | NA141001V - NC050668C | 1 |
| 28       | GS1        | 285815   | Kit, Gas Valve Assy  | NC050667C - ZZ222222Z | 1 |
| 29       | MP1        | 284233   | Brake Assy, Spool  | 1                     |   |
| 30       | PC5        | 254774   | Circuit Card Assy, 14 Pin Filter HF XR                               | 1                     |   |
| 31       | PC1        | 286745   | Circuit Card Assy, Motor Control W/Pgm Af Suitcase                   | 1                     |   |
| 32       |            | 239892   | Switch, Ground Current Sensor  | 1                     |   |
| 33       |            | 284241   | Bus Bar, Input   | 1                     |   |
| 34       |            | 285777   | Shroud, Secondary Left   | 1                     |   |
| 35       |            | 026947   | Stand-Off, Insul .250-20 x 1.000 Lg x .312 Thd                       | 1                     |   |
| 36       |            | 602233   | Washer, Flat .250IdX0.875OdX.062T Stl Pld                            | 1                     |   |
| 37       |            | 602207   | Washer, Lock .255idx0.489odx.062t Stl Pld Split.250                  | 1                     |   |
| 38       |            | 231212   | Screw, 250-20X .62 Hex Hd-PIn Gr5 Pld Lkg Patch                      | 1                     |   |

\*Recommended Spare Parts                      ~ Optional

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

Hardware is common and not available unless listed.

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.

**Main Assembly**

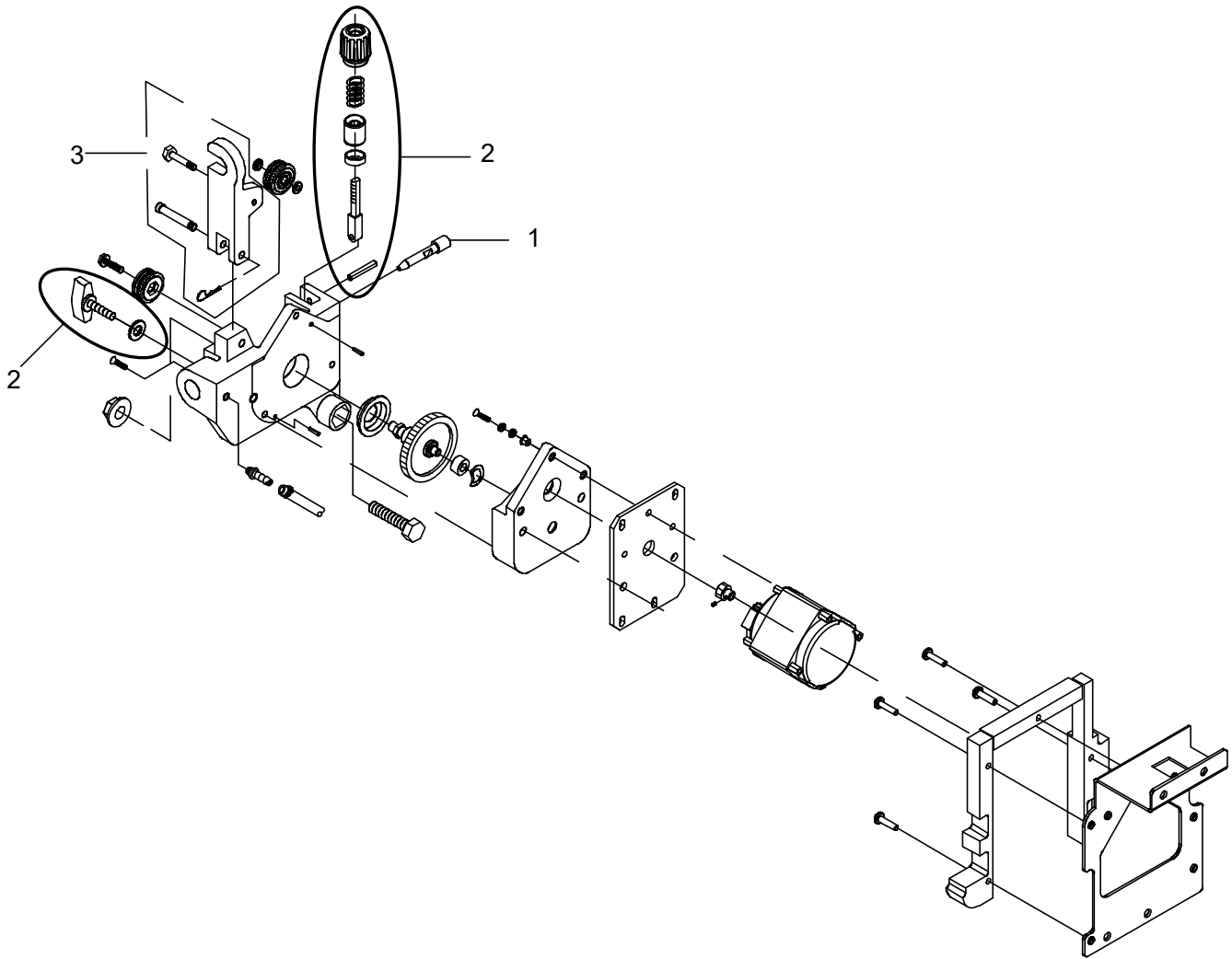
| <b>Item No.</b> | <b>Dia. Mkgs.</b> | <b>Part No.</b> | <b>Description</b>                              | <b>Qty</b> |
|-----------------|-------------------|-----------------|---|------------|
| 39              |                   | + 252186        | Shroud, Wire                                    | 1          |
| 40              |                   | 284245          | Plate, Mtg Shroud                               | 1          |
| 41              |                   |                 | Spool Hub Assembly (Figure 3)                   | 1          |
| 42              |                   | 288134          | Plate, Shielding Motor Control Board (CE Model) | 1          |
| 43              |                   | 275806          | Label, Warning Hot Surfaces And Moving Parts    | 1          |
|                 | PLG3, 25          | 115093          | Housing Plug+Pins (Service Kit)                 | 2          |
|                 | PLG4              | 131054          | Housing Rcpt + Skts, (Service Kit)              | 1          |
|                 | PLG5              | 201665          | Housing Plug + Skts (Service Kit)               | 1          |
|                 | PLG7              | 130203          | Housing Plug+Pins (Service Kit)                 | 1          |
|                 | PLG8              | 115091          | Housing Plug+Pins (Service Kit)                 | 1          |
|                 | PLG9, 21          | 131055          | Housing Rcpt+Skts, (Service Kit)                | 2          |
|                 | PLG10             | 131052          | Housing Rcpt+Skts, (Service Kit)                | 1          |
|                 | PLG17             | 222397          | Housing Plug+Skts, (Service Kit)                | 1          |
|                 | PLG22             | 115092          | Housing Plug+Pins (Service Kit)                 | 1          |
|                 | PLG23             | 208730          | Housing Plug+Skts, (Service Kit)                | 1          |
|                 | PLG24             | 131204          | Housing Plug + Skts, (Service Kit)              | 1          |
|                 | PLG111            | 256953          | Housing Plug+Skts, (Service Kit)                | 1          |
|                 | RC25              | 131059          | Housing Plug+Pins, (Service Kit)                | 1          |

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Wire Drive Assembly with Bracket

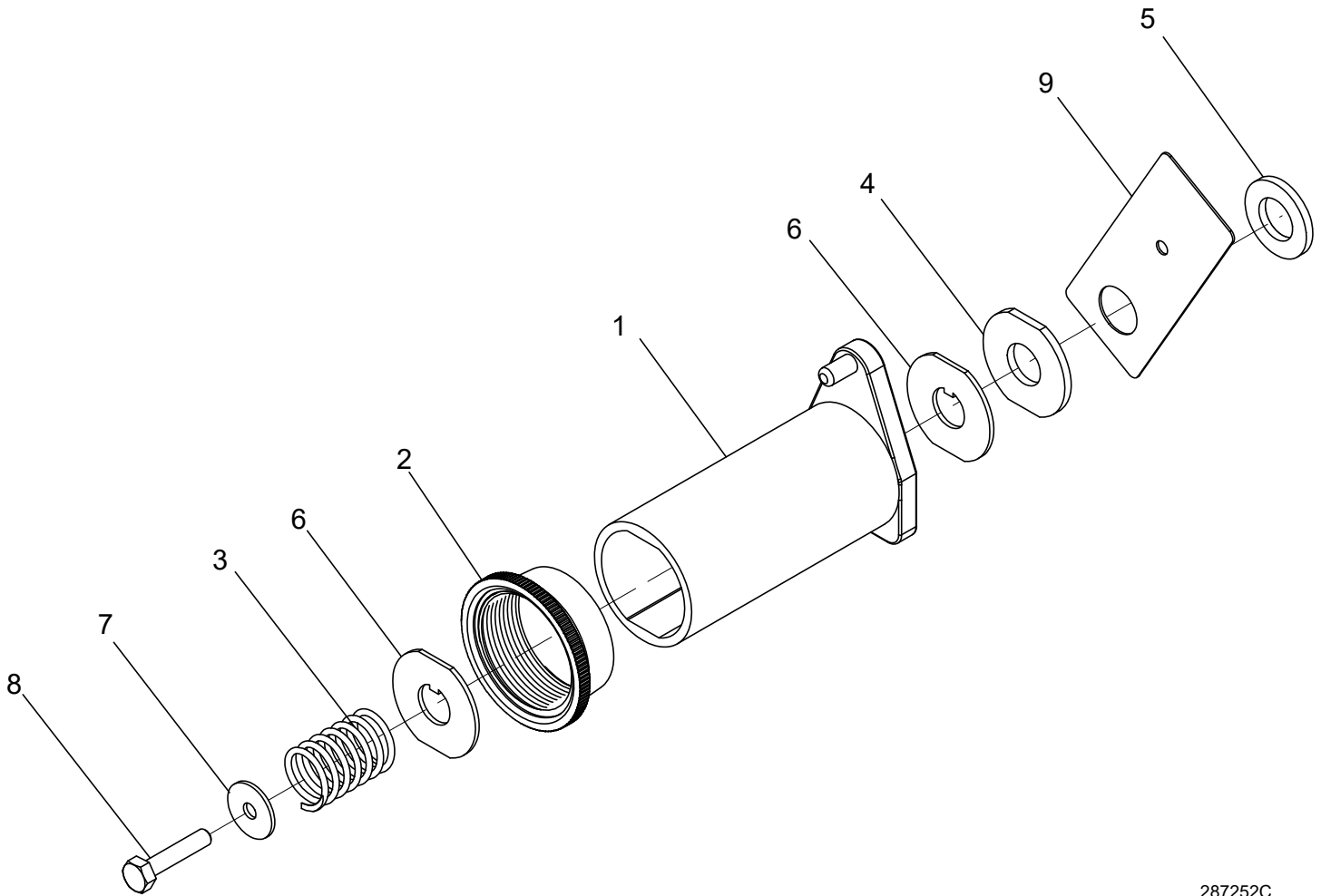
| Item No. | Dia. Mkgs. | Part No. | Description                              | Qty |
|----------|------------|----------|--|-----|
|          |            | 284663   | Drive Assy, Wire W/Bracket               | 1   |
| 1        |            | 058549   | Guide, Wire Inlet 1/16                   | 1   |
| 2        |            | 287269   | Kit, Tension Knobs                       | 1   |
| 3        |            | 287267   | Kit, Pressure Arm                        | 1   |
|          |            | 268847   | Kit, Drive Roll Polished XR .030-.035 Al | 1   |
|          |            | 268848   | Kit, Drive Roll Polished XR .040 Al      | 1   |
|          |            | 268849   | Kit, Drive Roll Polished XR .047 Al      | 1   |
|          |            | 268850   | Kit, Drive Roll Polished XR .062 Al      | 1   |

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287252C

### Spool Hub Assembly

| Item No. | Dia. Mkgs. | Part No. | Description  | Qty |
|----------|------------|----------|--|-----|
| 1        |            | 289738   | Hub, Spool w/Threads LH                            | 1   |
| 2        |            | 289739   | Nut, Hub LH  | 1   |
| 3        |            | 057543   | Spring, Cprsn 845 OD x 091 Wire x 1500 Pld         | 1   |
| 4        |            | 058424   | Washer, Fiber (Brake)                              | 1   |
| 5        |            | 284242   | Bushing, Stl .773 ID X 1.125 OD X .113 Lg          | 1   |
| 6        |            | 287193   | Washer, Locking                                    | 2   |
| 7        |            | 602233   | Washer, Flat .250ldX0.8750dX.062T Stl Pld          | 1   |
| 8        |            | 605518   | Bolt, Stl Tap Hexhd 250-20 x 1250 Gr5 Pld Full Thd | 1   |
| 9        |            | 289217   | Strip, Brake Surface Anti-Turn                     | 1   |

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