



PM-204456H

2024-06

Processes



Multiprocess Welding

Description



Arc Welding Power Source
Wire Feeder

PipeWorx 400 Welding System

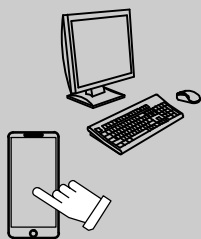
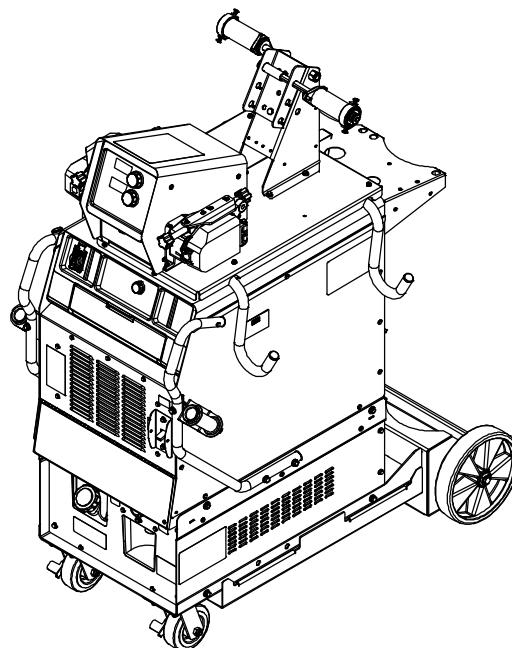
(230/460, 380-400, 380-400 CE, And
575 Volt Models)

PARTS LIST

Eff w/LJ320164G And Following

For OM236891 Revision A And Following


For OM253906 Revision A And Following



For product information,
Owner's Manual translations,
and more, visit

www.MillerWelds.com

SECTION 1 - PARTS LIST

 Hardware is common and not available unless listed.

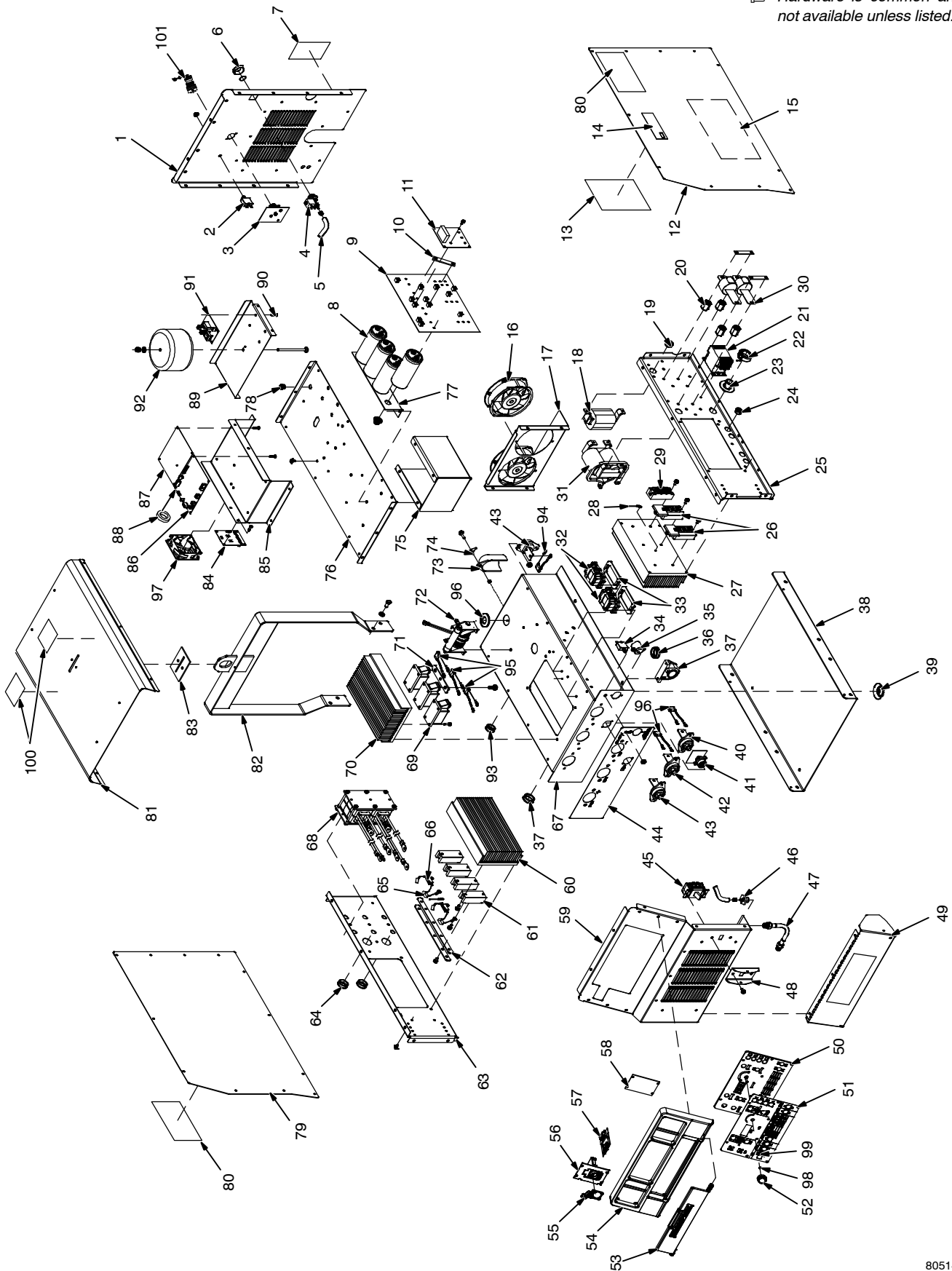


Figure 10-1. Main Assembly

805149H

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity | | |
|----------|------------|----------|-------------|----------|--------|--------|
| | | | | 907382 | 907384 | 907475 |

Figure 10-2. Main Assembly (non-CE)

| | | | | | | | | | | | |
|-------|----|----------------|---------|-----|--|--------|---|----------------------------------|---|---|---|
| ... | 1 | ... | +233480 | .. | Panel, Rear | 1 | 1 | 1 | | | |
| ... | 2 | ... | CB2 | ... | 093995 | .. | Supplementary Pro, Man Reset 1P 15A 250Vac Frict | 1 | 1 | 1 | |
| ... | 3 | .. | PC11 | ... | 244471 | .. | Circuit Card Assy, PS Feeder Interface | 1 | 1 | 1 | |
| ... | 4 | | | .. | 228036 | .. | Valve, 24Vac 1WAY .750-14 Thd 2.0mm Orf 100 Psi | 1 | 1 | 1 | |
| ... | 5 | | | .. | 252352 | .. | Hose Assy, Sae .187 Id x .410 Od x 40.000 w/Clamps | 1 | 1 | 1 | |
| | | | | .. | 236638 | .. | Hose, Nprn Brd No 1 x .187 Id x 40.000 | 1 | 1 | 1 | |
| | | | | .. | 149332 | .. | Clamp, Hose .405-.485 Clp Dia Slftng Olive Dra | 1 | 1 | 1 | |
| ... | 6 | | | .. | 272186 | .. | Nut, 750-14 Nps 1.312Hex .413H Nyl | 1 | 1 | 1 | |
| ... | 7 | | | .. | 181181 | .. | Label,Warning Electric Shock And Incorrect Input P (Prior to MG250019G) | 1 | 1 | 1 | |
| ... | 7 | | | .. | 274968 | .. | Label, Warning Electric Shock And Incorr (En/Fr/Sp) (Effective w/ MG250019G) | 1 | 1 | 1 | |
| | | | | .. | 237163 | .. | Label, MIG Output | 1 | 1 | 1 | |
| | | | | .. | 237157 | .. | Label, CB2 | 1 | 1 | 1 | |
| | | | | .. | 238560 | .. | Label, Tig Gas In | 1 | 1 | 1 | |
| | | | | .. | 237158 | .. | Label, To Wirefeeder | 1 | 1 | 1 | |
| ... | 8 | C3, C4, C5, C6 | 270608 | .. | Capacitor, Elctlt 2700 UF 450 Vdc Can 2.52 Dia | 4 | 4 | 4 | | | |
| ... | 8 | C3, C4, C5, C6 | 277164 | .. | Capacitor, Elctlt 1800 UF 500 Vdc Can 2.52 Dia | 4 | 4 | 4 | | | |
| | | | | .. | 219844 | .. | Label, Warning Electric Shock/Exploding Parts | 3 | 3 | 3 | |
| | | | | .. | 217040 | .. | Nut, Nylon M12 Thread Capacitor Mounting | 4 | 4 | 4 | |
| ... | 9 | .. | PC4 | ... | 187243 | .. | Circuit Card Assy, Interconnecting | 1 | 1 | 1 | |
| ... | 9 | .. | PC4 | ... | 187244 | .. | Circuit Card Assy, Interconnecting | 1 | 1 | 1 | |
| | | | | .. | PLG1111, PLG17 | 131054 | .. | Housing Rcpt+Skts, (Service Kit) | 1 | 1 | 1 |
| | | | | .. | PLG9 | 115091 | .. | Housing Plug+Skts, (Service Kit) | 1 | 1 | 1 |
| ... | 10 | | | .. | 185214 | .. | Bus Bar, Interconnecting 575 | 1 | 1 | 1 | |
| ... | 11 | .. | PC10 | ... | 245029 | .. | Circuit Card Assy, Relink 230/460 | 1 | 1 | 1 | |
| ... | 11 | .. | PC10 | ... | 246406 | .. | Circuit Card Assy, Relink Balance | 1 | 1 | 1 | |
| ... | 12 | | | .. | +233486 | .. | Panel, Side Rh 230/460 | 1 | 1 | 1 | |
| ... | 12 | | | .. | +240841 | .. | Panel, Side Rh 380-400 And 575 | 1 | 1 | 1 | |
| ... | 13 | | | .. | 237155 | .. | Label, Important Input Power/Relink Connections | 1 | 1 | 1 | |
| ... | 14 | | | .. | 274965 | .. | Label, Warning Match Input Power To Voltage Shown | 1 | 1 | 1 | |
| ... | 15 | | | .. | 234271 | .. | Sheet, Insulator Side Panel | 1 | 1 | 1 | |
| ... | 16 | FM1, FM2 | 291630 | .. | Fan, Muffin 24Vdc 4500 Rpm 352 Cfm 6.378 Mtg Holes | 2 | 2 | 2 | | | |
| ... | 17 | | | .. | 233501 | .. | Bracket, Fan | 1 | 1 | 1 | |
| ... | 18 | .. | L1 | ... | 180026 | .. | Inductor, Input | 1 | 1 | 1 | |
| | | | | .. | | .. | Windtunnel, Rh w/Cmpnts (Includes) | 1 | 1 | 1 | |
| ... | 19 | | | .. | 030170 | .. | Bushing, Snap-In Nyl .750 Id x 1.000 Mtg Hole | 2 | 2 | 2 | |
| ... | 20 | | | .. | 292960 | .. | Stand-Off, Insul .250-20 x 1.250 Lg x .312 Thd | 4 | 4 | 4 | |
| ... | 21 | .. | W1 | ... | 180270 | .. | Contact, Def Prp 40A 3P 24Vac Coil w/Boxlug | 1 | 1 | 1 | |
| ... | 22 | .. | CT1 | ... | 233620 | .. | Xfmr, Current 500 Turn Polarized | 1 | 1 | 1 | |
| ... | 23 | | | .. | 177547 | .. | Bushing, Snap-In Nyl CT-Mount 1.125 Mtg Hole | 1 | 1 | 1 | |
| ... | 24 | | | .. | 010493 | .. | Bushing, Snap-In Nyl .625 Id x .875 Mtg Hole | 4 | 4 | 4 | |
| ... | 25 | | | .. | 233462 | .. | Windtunnel, Rh | 1 | 1 | 1 | |
| ... | 26 | PM1, PM2 | 235309 | .. | Kit, Transistor IGBT Module | 1 | 1 | 1 | | | |
| ... | 27 | | | .. | 179930 | .. | Heat Sink, Power Module | 1 | 1 | 1 | |
| ... | 28 | .. | RT1 | ... | 199798 | .. | Thermistor, NTC 30k Ohm @ 25 Deg C 18 in. 2500 V | 1 | 1 | 1 | |
| ... | 29 | .. | SR1 | ... | 184260 | .. | Kit, Rectifier, Integ Bridge | 1 | 1 | 1 | |
| ... | 30 | .. | C1, C2 | ... | 280914 | .. | Capacitor, Polyp Film .34 uf 1700 Vrms +/-10% | 2 | 2 | 2 | |
| ... | 30 | .. | C1, C2 | ... | 283422 | .. | Capacitor, Polyp Film .22 uf 1700 Vrms +/-10% | 2 | 2 | 2 | |
| ... | 30 | .. | C1,C2 | ... | 283423 | .. | Capacitor, Polyp Film .5 uf 1000 Vrms +/-10% | 2 | 2 | 2 | |
| ... | 31 | .. | L2 | ... | 270740 | .. | Inductor, Output | 1 | 1 | 1 | |
| ... | 32 | .. | L3, L4 | ... | 233617 | .. | Inductor, DI-DT | 2 | 2 | 2 | |
| ... | 33 | | | .. | 218566 | .. | Gasket, Inductor Mounting E70 Ferrite Core | 2 | 2 | 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.

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity | | |
|----------|------------|----------|-------------|----------|--------|--------|
| | | | | 907382 | 907384 | 907475 |

Figure 10-2. Main Assembly (non-CE) (Continued)

| | | | | | | |
|-----------------------|------------|---------|---|---|---|---|
| ... 34 ... | CB1 | 083432 | Supplementary Pro, Man Reset 1P 10A 250VAC Frict .. | 1 | 1 | 1 |
| ... 35 ... | RC2 | 134837 | Rcpt, Str Grd 2P3W 15A 125V Single *5-15R | 1 | 1 | 1 |
| ... 36 | | 170647 | Bushing, Snap-In Nyl 1.312 Id x 1.500 Mtg Hole | 2 | 2 | 2 |
| ... 37 ... | HD1 | 168829 | Transducer, Current 1000A Module | 1 | 1 | 1 |
| ... 38 | | 234358 | Base, w/ Pem Nuts | 1 | 1 | 1 |
| ... 39 | | 229325 | Foot, Mtg Unit | 4 | 4 | 4 |
| ... 40 | | 241433 | Terminal, Pwr Output Black | 1 | 1 | 1 |
| ... 41 ... | PC6 | 244459 | Circuit Card Assy, Remote Interface | 1 | 1 | 1 |
| ... 42 | | 274843 | Terminal, Pwr Output Neutral | 1 | 1 | 1 |
| ... 43 | | 241432 | Terminal, Pwr Output Red | 2 | 2 | 2 |
| ... 44 | | 236968 | Overlay, Secondary Panel | 1 | 1 | 1 |
| ... 45 ... | S1 | 244920 | Switch, TGL 3Pst 40A 600Vac Scr Term Wide Tgl | 1 | 1 | 1 |
| ... 46 | | 203310 | Insulator, Switch Power | 1 | 1 | 1 |
| ... 47 | | 120854 | Ftg, Gas | 1 | 1 | 1 |
| ... 48 | | 237415 | Hose, Gas Braided 5 in. | 1 | 1 | 1 |
| ... 49 | | 236596 | Plate, Switch | 1 | 1 | 1 |
| ... 49 | | 241087 | Cover, Output Stud w/Labels (Includes) | 1 | 1 | 1 |
| ... 50 ... | PC3 | *267965 | Kit, Circuit Card Assy UI w/Program | 1 | 1 | 1 |
| ... 51 | | *266405 | Nameplate/Switch Membrane, Front Pnl Pwx | 1 | 1 | 0 |
| ... 51 | | *269062 | Overlay, Secondary Panel | 0 | 0 | 1 |
| ... 52 | | 174991 | Knob, Pointer 1.250 Dia x .250 Id w/Spring Clip-.21 | 1 | 1 | 1 |
| ... 53 | | 236828 | Door, Bezel, Mig Setup | 1 | 1 | 1 |
| ... 54 | | 234497 | Bezel, Power Source | 1 | 1 | 1 |
| ... 55 | | 236830 | Door, SD Reader | 1 | 1 | 1 |
| ... 56 | | 234344 | Bracket, SD Card Reader | 1 | 1 | 1 |
| ... 57 ... | PC12 | 244477 | Circuit Card Assy, SD Card | 1 | 1 | 1 |
| ... 58 | | 280660 | Plate, Mtg Front | 1 | 1 | 1 |
| ... 59 | | 233479 | Panel, Front | 1 | 1 | 1 |
| ... 59 | | 212810 | Label, On-Off w/Symbols | 1 | 1 | 1 |
| ... 60 | | 233910 | Windtunnel, Lh w/Cmpnts (Includes) | 1 | 1 | 1 |
| ... 60 | | 233910 | Heat Sink, Power Module | 1 | 1 | 1 |
| ... 61 D1, D2, D3, D4 | | 249053 | Diode, Ultra-Fast Recovery 300A 600V Dual | 4 | 4 | 4 |
| ... 62 | | 233490 | Bus Bar, Diode | 2 | 2 | 2 |
| ... 63 | | 233461 | Windtunnel, LH | 1 | 1 | 1 |
| ... 64 | | 057358 | Bushing, Snap-In Nyl 1.000 Id x 1.375 Mtg Hole | 2 | 2 | 2 |
| ... 65 ... | RT2 | 222327 | Thermistor, Ntc 30k Ohm @ 25 Deg C 24 in. Lead ... | 1 | 1 | 1 |
| ... 66 | | 232296 | Resistor/Capacitor Assy | 2 | 2 | 2 |
| ... 67 | | 233911 | Windtunnel Bottom, w/ Pem Nuts | 1 | 1 | 1 |
| ... 68 ... | T1 | 233413 | Xfmr, HF 230/460 Unit | 1 | | |
| ... 68 ... | T1 | 236304 | Xfmr, HF 575 Unit | | 1 | |
| ... 68 ... | T1 | 269566 | Xfmr, HF 380-400 Unit PipeWorx (CE) | | | 1 |
| ... 69 | SCR1,SCR2, | | | | | |
| ... 69 | SCR3 | 249352 | Thyristor, Scr Module 500A 800V Single | 3 | 3 | 3 |
| ... 70 | RT3,RT4 | 234339 | Thermistor, Ntc 30k ohm @ 25 Deg C12 in. Lead | 2 | 2 | 2 |
| ... 71 | | 234056 | Heat Sink, Scr Polarity Switching | 1 | 1 | 1 |
| ... 72 ... | T3 | 248818 | Kit, Field Pipeworx 400 HF Xfmr (Prior to MB300289G) . | 1 | 1 | 1 |
| ... 72 ... | T3 | 252521 | Xfmr, HF Coupling (Eff. w/MB300289G) | 1 | 1 | 1 |

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

*When ordering a PC3 or Nameplate/Switch Membrane for serial numbers prior to ME190042G for stock numbers 907382 and 907384 or ME020584G for stock number 907475, these parts need to be replaced together with new design parts. If the unit already has new design parts they can be replaced individually.

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.

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity | | |
|----------|------------|----------|-------------|--------------|--------|--------|
| | | | | Model 907382 | 907384 | 907475 |

Figure 10-2. Main Assembly (non-CE) (Continued)

| | | | | | | |
|-----|-----------|--------|--|----|----|----|
| 73 | | 186621 | Boot, Generic Output Stud | 1 | 1 | 1 |
| 74 | | 180735 | Washer, Output Stud | 1 | 1 | 1 |
| | | | Windtunnel, Top Assy (Includes) | 1 | 1 | 1 |
| 75 | | 234280 | Baffle, Windtunnel | 1 | 1 | 1 |
| 76 | | 233476 | Windtunnel, Top | 1 | 1 | 1 |
| 77 | | 233489 | Bracket, Capacitor Support | 1 | 1 | 1 |
| 78 | | 216366 | Bushing, Snap-In Nyl .500 Id x .625 Mtg Hole | 1 | 1 | 1 |
| | | 170647 | Bushing, Snap-In Nyl 1.312 Id x 1.500 Mtg Hole | 2 | 2 | 2 |
| | | 057358 | Bushing, Snap-In Nyl 1.000 Id x 1.375 Mtg Hole | 1 | 1 | 1 |
| | | 216596 | Strap, Grounding 4.50 in. Long | 1 | 1 | 1 |
| 79 | | 233485 | Panel, Side Lh | 1 | 1 | 1 |
| 80 | | 134327 | Label, Warning General Precautionary (Prior to MG250019G) | 2 | 2 | 2 |
| 80 | | 274964 | Label, Warning General Precautionary (En/Fr/Sp) (Effective w/MG250019G) | 2 | 2 | 2 |
| 81 | | 233483 | Cover, Top | 1 | 1 | 1 |
| 82 | | 233488 | Frame, Lifting | 1 | 1 | 1 |
| 83 | | 026627 | Gasket, Lifting Eye Cover | 1 | 1 | 1 |
| | | 236749 | Bracket, Mtg Circuit Cards Assy (Includes) | 1 | | |
| | | 236778 | Bracket, Mtg Circuit Cards Assy (Includes) | 1 | | |
| | | 247632 | Bracket, Mtg Circuit Cards Assy (Includes) | | | 1 |
| 84 | PC9 | 244465 | Circuit Card Assy, Secondary Gate Driver | 1 | 1 | |
| 85 | | 248768 | Bracket, Mtg Circuit Cards | 1 | 1 | |
| 86 | PC1 | 249095 | Circuit Card Assy, Process Control w/Program | 1 | 1 | 1 |
| 87 | PC2 | 273595 | Circuit Card Assy, Inverter Control 230/460V | 1 | | |
| 87 | PC2 | 273597 | Circuit Card Assy, Inverter Control 575V | | 1 | |
| 87 | PC2 | 270528 | Circuit Card Assy, Inverter Control w/Program | | | 1 |
| | | 198122 | Stand-Off Support, PC Card .250 w/Post And Lock | 10 | 10 | 10 |
| 88 | | 236299 | Choke, Common Mode | 1 | 1 | 1 |
| | | 236770 | Bracket, Mtg Xfmr Assy (Includes) | 1 | 1 | 1 |
| 89 | | 233478 | Bracket, Mtg Xfmr | 1 | 1 | 1 |
| 90 | | 198122 | Stand-Off Support, PC Card .250 w/Post And Lock | 4 | 4 | 4 |
| 91 | PC5 | 244452 | Circuit Card Assy, HF Arc Starter | 1 | 1 | 1 |
| 92 | T2 | 270096 | Kit, Xfmr Control Toroidal 230/460 Vac Pri (Prior to MH020060G) | 1 | | |
| 92 | T2 | 260739 | Xfmr, Control Toroidal 230/460 Vac Pri 1456 Va 60 Hz (Effective with MH020060G) | 1 | | |
| 92 | T2 | 256582 | Xfmr, Control Toroidal 575 Vac Pri 1456 Va 60 Hz | | 1 | |
| 92 | T2 | 256583 | Xfmr, Control 400 Vac Pri 1160 Va 50 Hz | | | 1 |
| 93 | | 057358 | Bushing, Snap-In Nyl 1.000 Id x 1.375 Mtg Hole | 1 | 1 | 1 |
| 94 | C7,8,11 | 236678 | Capacitor Assy | 3 | 3 | 3 |
| | C9 | 234338 | Capacitor Assy, TIG Output | 1 | 1 | 1 |
| 95 | C15,16,17 | 247825 | Capacitor Assy | 3 | 3 | 3 |
| 96 | | 253334 | Grommet, RBR 1.000 Id x 1.375 Mtg Hole | 1 | 1 | 1 |
| 97 | FM3 | 183918 | Fan, Muffin | | | 1 |
| 98 | | 255006 | Washer, Flat Seal .265 Id x 0.500 Od x .125T Epdm | 1 | 1 | 1 |
| 99 | | 269049 | Washer, Shldr .375 Id 0.750 Od | 1 | 1 | 1 |
| 100 | | 274966 | Label, Warning Falling Equipment (En/Fr/Sp-Sym) | 2 | 2 | 2 |
| 101 | | 224042 | Conn, Circ CPC Protective Cap Size 17 Plastic | 1 | 1 | 1 |

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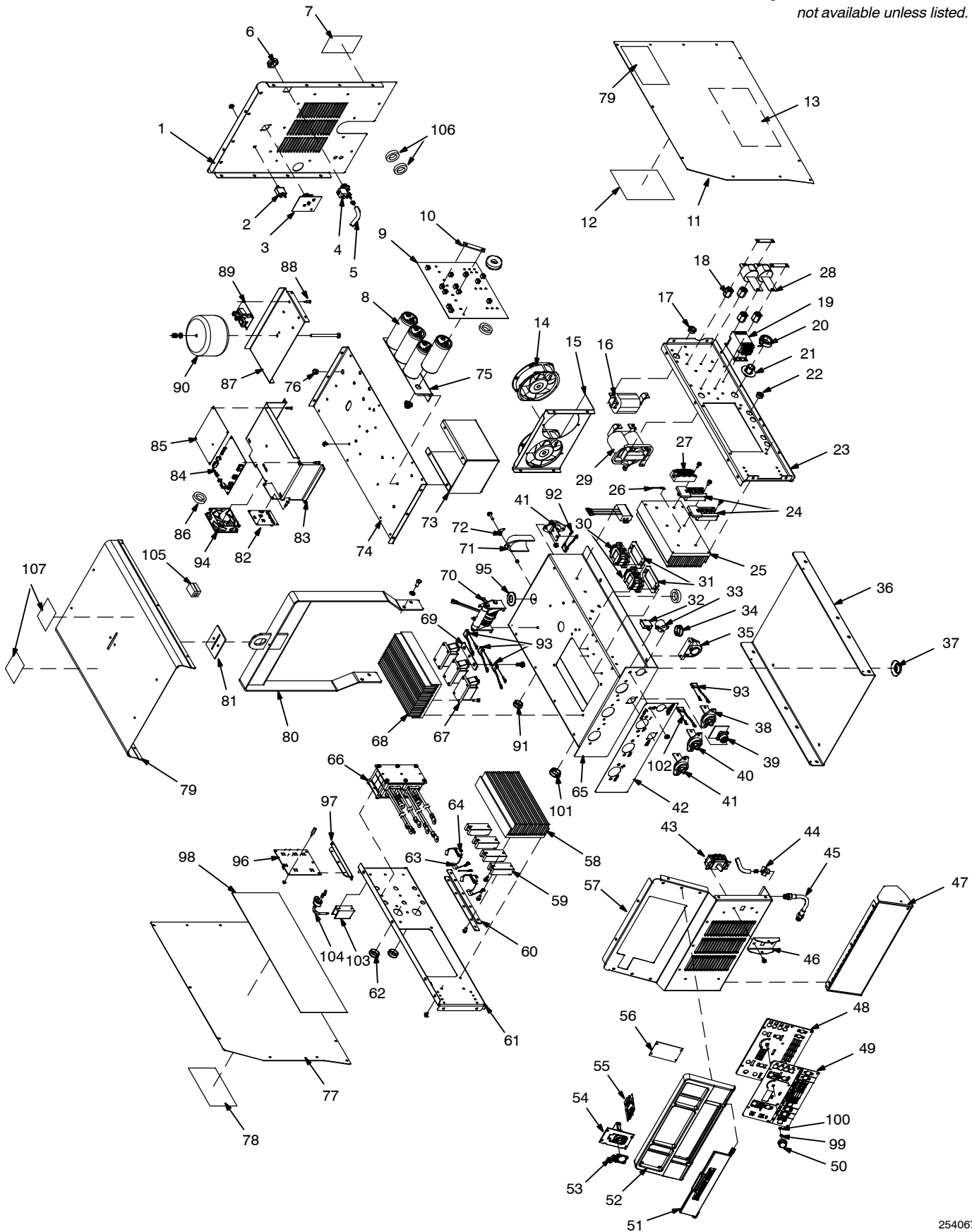


Figure 10-2. Main Assembly (CE)

254067-F

| Item No. | Dia. Mkgs. | Part No. | Description |
|----------|------------|----------|-------------|
|----------|------------|----------|-------------|

Figure 10-2. Main Assembly (CE)

| | | | | | | |
|-------|----|----------|----------------------|---|---|---|
| ... | 1 | ... | +250832 | .. Panel, Rear | 1 | |
| ... | 2 | ... | CB2 .. 093995 | .. Supplementary Pro, Man Reset 1P 15A 250Vac Frict | 1 | |
| ... | 3 | .. | PC11 .. 244471 | .. Circuit Card Assy, PS/Feeder Interface | 1 | |
| ... | 4 | ... | 228036 | .. Valve, 24Vac 1way .750-14 Thd 2.0mm Orf 100 Psi | 1 | |
| ... | 5 | ... | 236638 | .. Hose Assy, Sae .187 Id x .410 Od x 40.000 w/Clamps | 1 | |
| ... | 6 | ... | 272186 | .. Nut, 750-14 NPS 1.312Hex .413H Nyl | 1 | |
| ... | 7 | ... | 185526 | .. Label, Warning Electric Shock And Incorrect Input | 1 | |
| | | | 237163 | .. Label, MIG Output | 1 | |
| | | | 237157 | .. Label, CB2 | 1 | |
| | | | 238560 | .. Label, TIG Gas In | 1 | |
| | | | 254053 | .. Label, To Wirefeeder | 1 | |
| ... | 8 | .. | C3, C4, C5, C6 | 270608 | .. Capacitor, Elctlt 2700 uf 450 Vdc Can 2.52 Dia | 4 |
| | | | 219844 | .. Label, Warning Electric Shock/Exploding Parts | 3 | |
| | | | 217040 | .. Nut, Nylon M12 Thread Capacitor Mounting | 4 | |
| ... | 9 | .. | PC4 .. 236049 | .. Kit, Circuit Card Assy, Interconnecting w/cmpnts | 1 | |
| | | | Plg1111,Plg17 131054 | .. Housing Rcpt+Skts, (Service Kit) | 1 | |
| | | | PLG9 .. 115091 | .. Housing Plug+Skts, (Service Kit) | 1 | |
| ... | 10 | ... | 185214 | .. Bus Bar, Interconnecting | 1 | |
| ... | 11 | ... | +240841 | .. Panel, Side Rh | 1 | |
| ... | 12 | ... | 237155 | .. Label, Important Input Power/Relink Connections | 1 | |
| ... | 13 | ... | 234271 | .. Sheet, Insulator Side Panel | 1 | |
| ... | 14 | FM1, FM2 | 291630 | .. Fan, Muffin 24Vdc 4500 Rpm 352 Cfm 6.378 Mtg Holes | 2 | |
| ... | 15 | ... | 233501 | .. Bracket, Fan | 1 | |
| ... | 16 | .. | L1 .. 180026 | .. Inductor, Input | 1 | |
| | | | | .. Windtunnel, Rh w/Cmpnts (Includes) | 1 | |
| ... | 17 | ... | 030170 | Bushing, Snap-In Nyl .750 Id x 1.000 Mtg Hole | 2 | |
| ... | 18 | ... | 292960 | Stand-Off, Insul .250-20 x 1.250 Lg x .312 Thd | 4 | |
| ... | 19 | .. | W1 .. 180270 | Contactor, Def Prp 40A 3P 24Vac Coil w/Boxlug | 1 | |
| ... | 20 | .. | CT1 .. 233620 | Xfmr, Current 500 Turn Polarized | 1 | |
| ... | 21 | ... | 177547 | Bushing, Snap-In Nyl Ct-Mount 1.125 Mtg Hole | 1 | |
| ... | 22 | ... | 010493 | Bushing, Snap-In Nyl .625 Id x .875 Mtg Hole | 4 | |
| ... | 23 | ... | 233462 | Windtunnel, Rh | 1 | |
| ... | 24 | PM1, PM2 | 235309 | Kit, Transistor IGBT Module | 1 | |
| ... | 25 | ... | 179930 | Heat Sink, Power Module | 1 | |
| ... | 26 | .. | RT1 .. 199798 | Thermistor, Ntc 30k ohm @ 25 Deg C 18.00 in 2500 V | 1 | |
| ... | 27 | .. | SR1 .. 184260 | Kit, Rectifier, Integ Bridge | 1 | |
| ... | 28 | .. | C1, C2 283423 | .. Capacitor, Polyp Film .5 uf 1700 Vrms +/-10% | 2 | |
| ... | 29 | .. | L2 .. 270740 | .. Inductor, Output | 1 | |
| ... | 30 | .. | L3, L4 233617 | .. Inductor, DI-DT | 2 | |
| ... | 31 | ... | 218566 | .. Gasket, Inductor Mounting E70 Ferrite Core | 2 | |
| ... | 32 | .. | CB1 .. 083432 | .. Supplementary Pro, Man Reset 1P 10A 250Vac Frict | 1 | |
| ... | 33 | .. | RC2 .. 134837 | .. Rcpt, Str Grd 2P3W 15A 125V Single *5-15R | 1 | |
| ... | 34 | ... | 170647 | .. Bushing, Snap-In Nyl 1.312 Id x 1.500 Mtg Hole | 2 | |
| ... | 35 | .. | HD1 .. 168829 | .. Transducer, Current 1000A Module | 1 | |
| ... | 36 | ... | 234358 | .. Base, w/Pem Nuts | 1 | |
| | | | 241027 | .. Base, Core,Toroidal .748 Id x 1.142 Od x .600 Thk | 1 | |
| ... | 37 | ... | 229325 | .. Foot, Mtg Unit | 4 | |
| ... | 38 | ... | 241433 | .. Terminal, Pwr Output Black | 1 | |
| ... | 39 | .. | PC6 .. 244459 | .. Circuit Card Assy, Remote Interface | 1 | |

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| Item No. | Dia. Mkgs. | Part No. | Description | Quantity | Model |
|----------|------------|----------|-------------|----------|-------|
|----------|------------|----------|-------------|----------|-------|

Figure 10-2. Main Assembly (CE) (Continued)

| | | | | | |
|-----|----|---------------------------|--|---|--|
| ... | 40 | 274843 | .. Terminal, Pwr Output Neutral | 1 | |
| ... | 41 | 241432 | .. Terminal, Pwr Output Red | 2 | |
| ... | 42 | 236968 | .. Overlay, Secondary Panel | 1 | |
| ... | 43 | S1 244920 | .. Switch, Tgl 3Pst 40A 600Vac Scr Term Wide Tgl | 1 | |
| ... | | 203310 | .. Insulator, Switch Power | 1 | |
| ... | 44 | 120854 | .. Ftg, Gas | 1 | |
| ... | 45 | 237415 | .. Hose, Gas Braided 5 in | 1 | |
| ... | 46 | 236596 | .. Plate, Switch | 1 | |
| ... | 47 | 241087 | .. Cover, Output Stud w/Labels (Includes) | 1 | |
| ... | | 238535 | .. Nameplate, Pipeworx 400 | 1 | |
| ... | 48 | PC3 *267965 | .. Kit, Circuit Card Assy UI w/Program | 1 | |
| ... | 49 | *261114 | .. Nameplate/Switch Membrane, Front Pnl (CE) | 1 | |
| ... | 50 | 174991 | .. Knob, Pointer 1.250 Dia x .250 Id w/Spring Clip-.21 | 1 | |
| ... | 51 | 236828 | .. Door, Bezel, Mig Setup | 1 | |
| ... | 52 | 234497 | .. Bezel, Power Source | 1 | |
| ... | 53 | 236830 | .. Door, SD Reader | 1 | |
| ... | 54 | 234344 | .. Bracket, SD Card Reader | 1 | |
| ... | 55 | PC12 244477 | .. Circuit Card Assy, SD Card | 1 | |
| ... | 56 | 280660 | .. Plate, Mtg Front | 1 | |
| ... | 57 | 233479 | .. Panel, Front | 1 | |
| ... | | 212810 | .. Label, On-Off w/Symbols | 1 | |
| ... | | | .. Windtunnel, Lh w/Cmpnts (Includes) | 1 | |
| ... | 58 | 233910 | .. Heat Sink, Power Module | 1 | |
| ... | 59 | D1, D2, D3, D4 249053 | .. Kit, Diode, Ultra-Fast Recovery | 4 | |
| ... | 60 | 233490 | .. Bus Bar, Diode | 2 | |
| ... | 61 | 233461 | .. Windtunnel, Lh | 1 | |
| ... | 62 | 057358 | .. Bushing, Snap-In Nyl 1.000 ID x 1.375 Mtg Hole | 2 | |
| ... | 63 | RT2 222327 | .. Thermistor, NTC 30k ohm @ 25 Deg C 24.00 in Lead | 1 | |
| ... | 64 | 254046 | .. Resistor/Capacitor Assy | 2 | |
| ... | 65 | 233911 | .. Windtunnel Bottom, w/Pem Nuts | 1 | |
| ... | 66 | T1 269566 | .. Xfmr, HF | 1 | |
| ... | 67 | SCR1, SCR2,SCR3 249352 | .. Kit, Thyristor, SCR Module | 3 | |
| ... | | RT3,RT4 234339 | .. Thermistor, Ntc 30k Ohm @ 25 Deg C 12.00 in Lead | 2 | |
| ... | 68 | 234056 | .. Heat Sink, Scr Polarity Switching | 1 | |
| ... | 69 | 234279 | .. Bus Bar, Scr | 1 | |
| ... | 70 | T3 252521 | .. Xfmr, HF Coupling | 1 | |
| ... | 71 | 186621 | .. Boot, Generic Output Stud | 1 | |
| ... | 72 | 180735 | .. Washer, Output Stud | 1 | |

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

*When ordering a PC3 or Nameplate/Switch Membrane for serial numbers prior to ME170302G these parts need to be replaced together with new design parts. If the unit already has new design parts they can be replaced individually.

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.

| Item No. | Dia. Mkgs. | Part No. | Description |
|----------|------------|----------|-------------|
|----------|------------|----------|-------------|

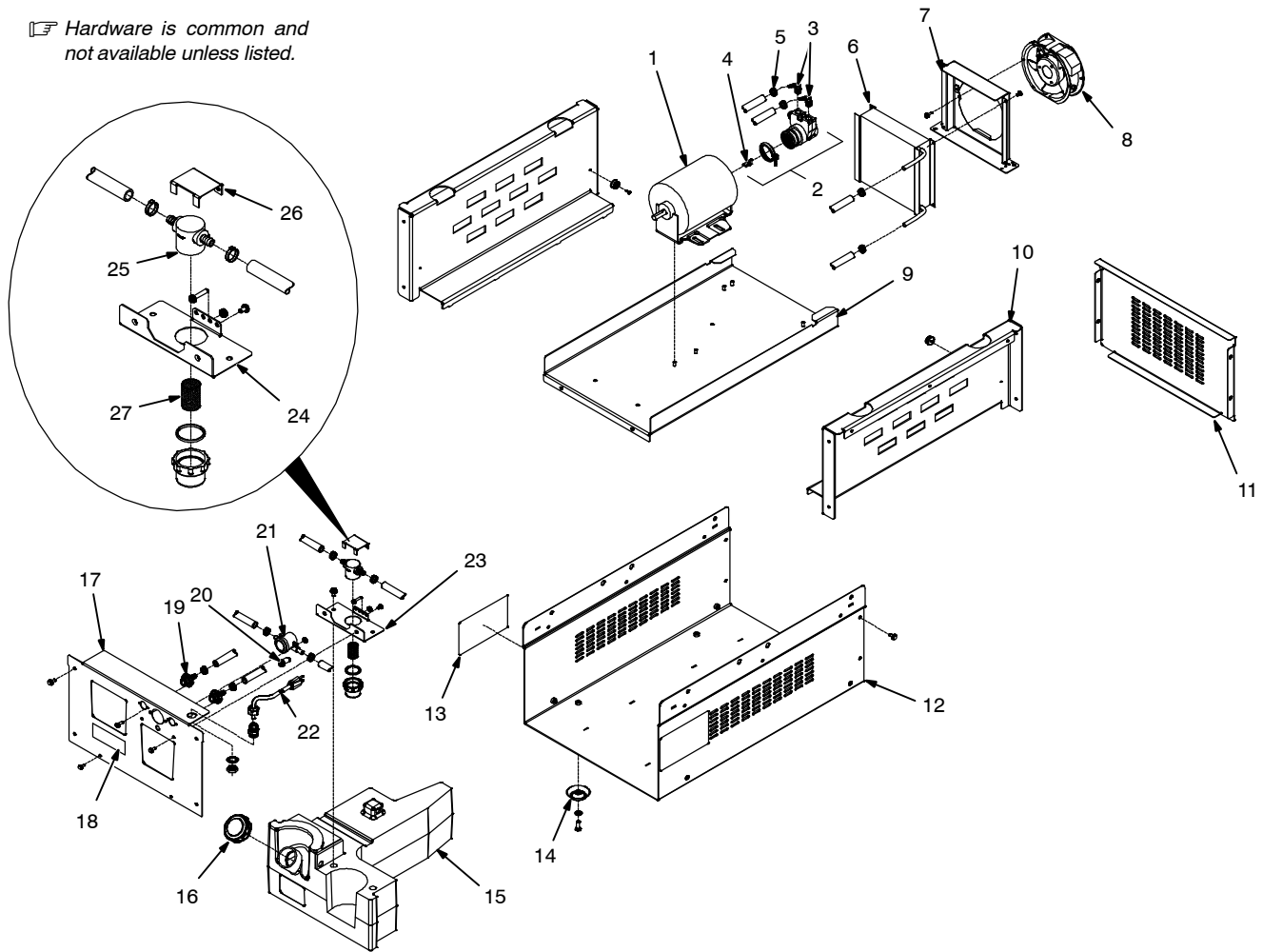
Figure 10-2. Main Assembly (CE) (Continued)

| | | | | |
|-----|-----------|--------|--|----|
| | | | Windtunnel, Top Assy (Includes) | 1 |
| 73 | | 234280 | Baffle, Windtunnel | 1 |
| 74 | | 233476 | Windtunnel, Top | 1 |
| 75 | | 233489 | Bracket, Capacitor Support | 1 |
| 76 | | 216366 | Bushing, Snap-In Nyl .500 Id x .625 Mtg Hole | 1 |
| | | 170647 | Bushing, Snap-In Nyl 1.312 Id x 1.500 Mtg Hole | 2 |
| | | 057358 | Bushing, Snap-In Nyl 1.000 Id x 1.375 Mtg Hole | 1 |
| | | 216596 | Strap, Grounding 4.50 in Long | 1 |
| 77 | | 233485 | Panel, Side Lh | 1 |
| 78 | | 179310 | Label, Warning General Precautionary Static | 2 |
| 79 | | 233483 | Cover, Top | 1 |
| 80 | | 233488 | Frame, Lifting | 1 |
| 81 | | 026627 | Gasket, Lifting Eye Cover | 1 |
| | | 270839 | Bracket Assy, Control Boards (Includes) | 1 |
| 82 | PC9 | 244465 | Circuit Card Assy, Secondary Gate Driver | 1 |
| 83 | | 248768 | Bracket, Mtg Circuit Cards | 1 |
| 84 | PC1 | 249095 | Circuit Card Assy, Process Control w/Program | 1 |
| 85 | PC2 | 270528 | Circuit Card Assy, Inverter Control w/Program | 1 |
| | | 198122 | Stand-Off Support, PC Card .250 w/Post&Lock | 10 |
| 86 | | 236299 | Choke, Common Mode | 1 |
| | | 236770 | Bracket, Mtg Xfmr Assy (Includes) | 1 |
| 87 | | 233478 | Bracket, Mtg Xfmr | 1 |
| 88 | | 198122 | Stand-Off Support, PC Card .250 w/Post&Lock | 4 |
| 89 | PC5 | 244452 | Circuit Card Assy, HF Arc Starter | 1 |
| 90 | T2 | 256583 | Xfmr, Control 380/400 Vac Pri 1589VA 50/60 Hz | 1 |
| 91 | | 057358 | Bushing, Snap-In Nyl 1.000 Id x 1.375 Mtg Hole | 1 |
| 92 | C7,8 | 236678 | Capacitor Assy | 2 |
| 93 | C15,16,17 | 247825 | Capacitor Assy | 3 |
| 94 | FM3 | 183918 | Fan, Muffin | 1 |
| 95 | | 253334 | Grommet, Rbr 1.000 Id x 1.375 Mtg Hole .063 Groove | 1 |
| 96 | PC13 | 231563 | Circuit Card Assy, Input Filter | 1 |
| 97 | | 253764 | Bracket, Mtg Filter Board | 1 |
| 98 | | 234271 | Sheet, Insulator Side Panel | 1 |
| 99 | | 255006 | Washer, Flat Seal .265 Id x 0.500 Od x .125T Epdm | 1 |
| 100 | | 269049 | Washer, Shldr.375id 0.750 Od | 1 |
| 101 | | 170647 | Bushing, Snap-In Nyl 1.312 Id x 1.500 Mtg Hole | 2 |
| 102 | R3/C11 | 272257 | Capacitor/Resistor | 1 |
| 103 | | 272482 | Block, Terminal 1 Pole | 1 |
| 104 | | 267037 | Lead w/Ferrite (Includes) | 1 |
| | | 241027 | Core, Toriodal .748 Id x 1.142 Od x .6000 Thk | 1 |
| 105 | | 255736 | Core, Ferrite Emi Snap-On .393 Id x .877 Od x 1.290L | 1 |
| 106 | | 255735 | Core, Toroidal .900Id x 1.400 Od x .500 Thk | 2 |
| 107 | | 272842 | Label, Warning Falling Equipment Can Injure-Wordles | 2 |

+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.

☐ Hardware is common and not available unless listed.



805300-A

Figure 10-3. Cooler

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------------------------|------------|----------|--|----------|
| Figure 10-3. Cooler | | | | |
| ... | 1 | MOT | 173263 .. Motor, 1/4 hp 115Vac 50/60 Hz 1425/1725 Rpm Dual | 1 |
| ... | 2 | | 263703 .. Pump, Coolant w/fittings (Includes) | 1 |
| ... | 3 | | 5523 Fitting | 2 |
| ... | 4 | | 134795 .. Coupler, Drive Pump | 1 |
| ... | 5 | | 094263 .. Clamp, 1-Ear Type NOM Dim .718 x .276 Wide | 10 |
| ... | | | 236814 .. Assy, Fan/Radiator (Includes) | 1 |
| ... | 6 | | 196515 .. Radiator, Heat Exchanger | 1 |
| ... | 7 | | 231341 Plenum, Air | 1 |
| ... | 8 | FM | 213072 Fan, Muffin 115V 60HZ 3400 Rpm 6.378 Mtg Holes | 1 |
| ... | 9 | | 236813 .. Base, w/Pem Studs | 1 |
| ... | 10 | | 236845 .. Side, Cooler Base | 2 |
| ... | 11 | | 236846 .. Panel, Rear Cooler Base | 1 |
| ... | 12 | | +236844 .. Shell, Cooler Base w/Pem Nuts | 1 |
| ... | 13 | | 274964 .. Label, Warning General Precautionary (En/Fr/Sp) | 2 |
| ... | 14 | | 229325 .. Foot, Mtg Unit | 4 |
| ... | 15 | | 173955 .. Tank, Water | 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.


| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

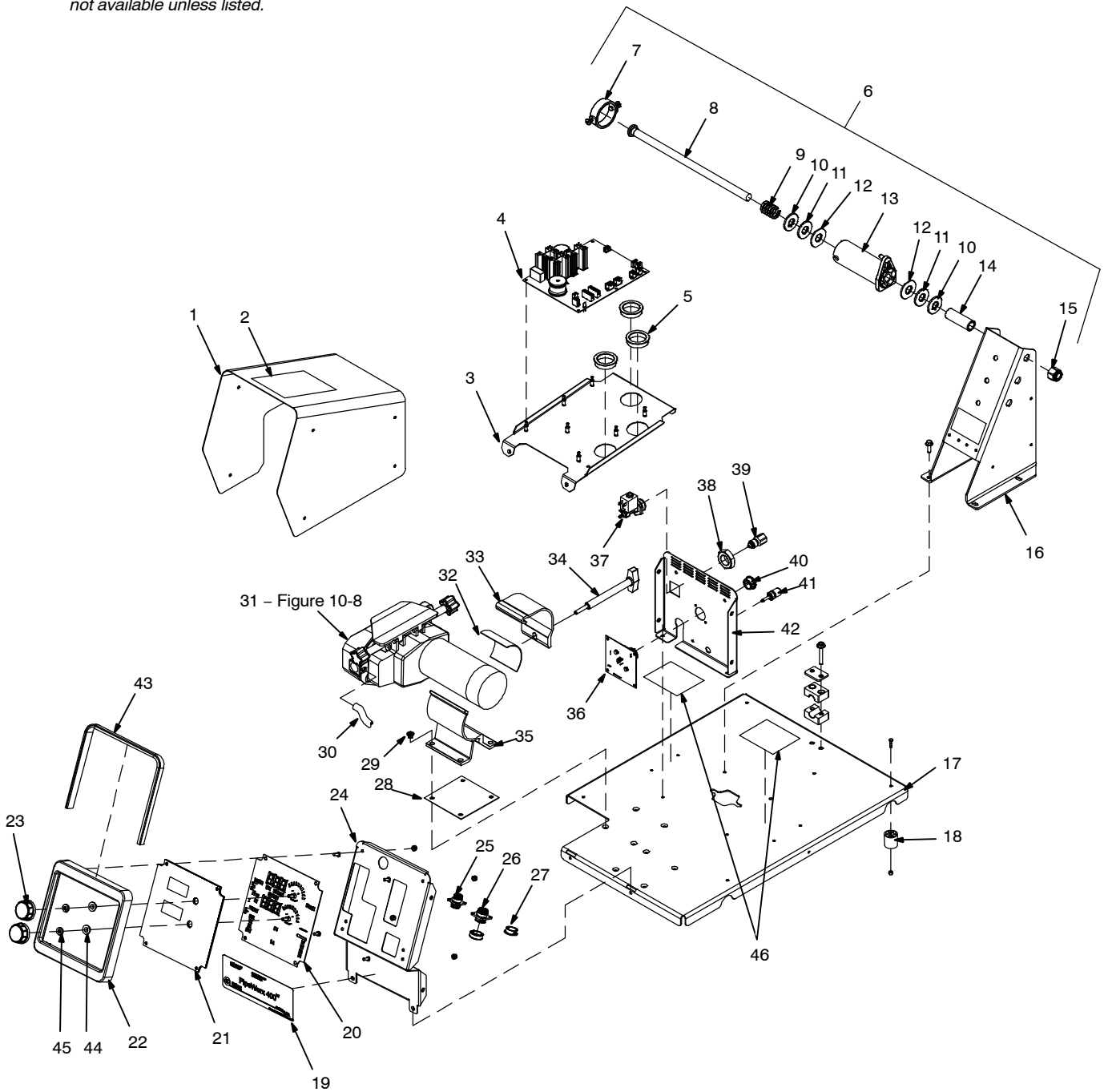
Figure 10-3. Cooler (Continued)

| | | | | |
|--------|--|---------|---|---|
| ... 16 | | 291082 | .. Cap,Tank Screw-On w/Vent | 1 |
| | | | Front Panel Assy, w/cmpnts (Includes) | 1 |
| ... 17 | | +236810 | ... Panel, Front w/Pem Studs | 1 |
| ... 18 | | 232925 | ... Label, Caution Incorrect Coolant (En/Fr/Sp) | 1 |
| ... 19 | | 081543 | ... Ftg, Coolant | 2 |
| ... 20 | | 238664 | ... Light, Ind Wht Lens 125Vac Snap-In Neon Non-Relampa | 1 |
| | | 233159 | ... Spacer, Nylon .312 Od x .194 Id x .500 Lg | 2 |
| ... 21 | | 215279 | ... Indicator, Flow | 1 |
| ... 22 | | 188082 | ... Cable, Power 2 Ft 7 in. 16Ga 3C | 1 |
| | | 204603 | .. Label, Coolant Out | 1 |
| | | 204604 | .. Label, Coolant In | 1 |
| ... 23 | | 236815 | .. Bracket, w/Filter (Includes) | 1 |
| ... 24 | | 236816 | ... Bracket, Tank Top | 1 |
| ... 25 | | 166564 | ... Filter, In-Line Low Profile 100 Screen 3/8 Hose Bar | 1 |
| ... 26 | | 178461 | ... Bracket, Filter | 1 |
| ... 27 | | 239494 | .. Screen, Filter Lp Cyl 100 x 100 x 0.0045 SST | 1 |
| | | 228529 | .. Hose, Rubber Braided .375 Id x .650 Od x 19.500 | 2 |
| | | 237152 | .. Hose, Rubber Braided .375 Id x .650 Od x 22.500 | 2 |
| | | 237416 | .. Hose, Coolant Braided 10 in. | 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.

 Hardware is common and not available unless listed.



805152-D

Figure 10-4. Single Wire Feeder (non-CE)

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|---|------------|-------------|--|----------|
| Figure 10-5. Single Wire Feeder (non-CE) | | | | |
| ... | 1 | ... | Wrapper, Single Feeder | 1 |
| ... | 2 | 274964 | Label, Warning General Precautionary (En/Fr/Sp) | 1 |
| ... | | | Panel Assy, Pcb Support (Includes) | 1 |
| ... | 3 | 236556 | Panel, PC Board Support | 1 |
| ... | | 198122 | Stand-Off Support, PC Card .250 w/Post&Lock .500 | 7 |
| ... | 4 | PC1 244483 | Circuit Card Assy, Pipeworx Feeder Mtr Ctrl | 1 |
| ... | 5 | 010494 | Bushing, Snap-In Nyl 1.375 Id x 1.750 Mtg Hole | 3 |
| ... | 6 | 143160 | Hub+Spindle Assy | 1 |
| ... | 7 | 058427 | Ring, Retaining Spool | 1 |
| ... | 8 | 180573 | Shaft Assy, Support Spool | 1 |
| ... | 9 | 010233 | Spring, Cprsn .970 Od x .120 Wire x 1.250 Pld | 1 |
| ... | 10 | 057971 | Washer, Flat .632 Id x 1.500 Od x .125t Stl Pld .175 key | 2 |
| ... | 11 | 010191 | Washer, Flat .656 Id x 1.500 Od x .125t Fbr | 2 |
| ... | 12 | 058628 | Washer, Brake Stl | 2 |
| ... | 13 | 058428 | Hub, Spool | 1 |
| ... | 14 | 071730 | Tubing, Stl .875 Od x 12Ga Wall x 2.500 | 1 |
| ... | 15 | 135205 | Nut, 625-11 .94Hex .77h Stl Pld Elastic Stop Nut | 1 |
| ... | 16 | 141411 | Support, Spool | 1 |
| ... | 17 | 233559 | Base, Feeder w/Pem Nuts | 1 |
| ... | 18 | 134306 | Foot, Rubber 1.250 Dia x 1.375 High No 10 Screw | 4 |
| ... | 19 | 238518 | Label, Single Feeder Lower | 1 |
| ... | | | Panel, Front w/Cmpnts Single Bench Feeder (Includes) | 1 |
| ... | 20 | PC2 *267543 | Kit, Circuit Card Assy UI w/Program | 1 |
| ... | 21 | *266044 | Nameplate/Switch Membrane, Single Feeder | 1 |
| ... | 22 | 234501 | Bezel, Feeder | 1 |
| ... | 23 | 213134 | Knob, Encoder 1.670 Dia x .250 Id Push On w/Spring | 2 |
| ... | 24 | 233560 | Panel, Front | 1 |
| ... | 25 | | Plug Assy, Trigger Lh (Includes) | 1 |
| ... | PLG17 | 115093 | Housing Plug+Skts, (Service Kit) | 1 |
| ... | RC2 | 048282 | Rcpt w/Skts, (Service Kit) | 1 |
| ... | 26 | | Plug Assy, Remote (Includes) | 1 |
| ... | RC4 | 222857 | Housing Plug+Skts, (Service Kit) | 1 |
| ... | PLG35 | 115093 | Housing Plug+Skts, (Service Kit) | 1 |
| ... | | 200822 | Housing Plug+Pins, (Service Kit) | 1 |
| ... | 27 | 000527 | Blank, Snap-In Nyl .875 Mtg Hole Black | 1 |
| ... | 28 | 159647 | Insulator, Motor Clamp | 1 |
| ... | 29 | 159360 | Insulator, Screw Machine | 4 |
| ... | 30 | 200814 | Hose, Sae .187 Id x .410 Od x 17.000 w/Clamps | 1 |
| ... | 31 | 201762 | Drive Assy, Wire S/L 4 Roll w/Tach | 1 |
| ... | 32 | 275686 | Pad, Neoprene .250 x 3.000 x 4.000 Du70a | 1 |
| ... | 33 | 156243 | Clamp, Motor Top | 1 |
| ... | 34 | 234426 | Knob, w/Extension (Lh) Clamp | 1 |
| ... | 35 | 159646 | Clamp, Motor Base | 1 |

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

*When ordering a PC2 or Nameplate/Switch Membrane for serial numbers prior to ME200035G these parts need to be replaced together with new design parts. If the unit already has new design parts they can be replaced individually.

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.


| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

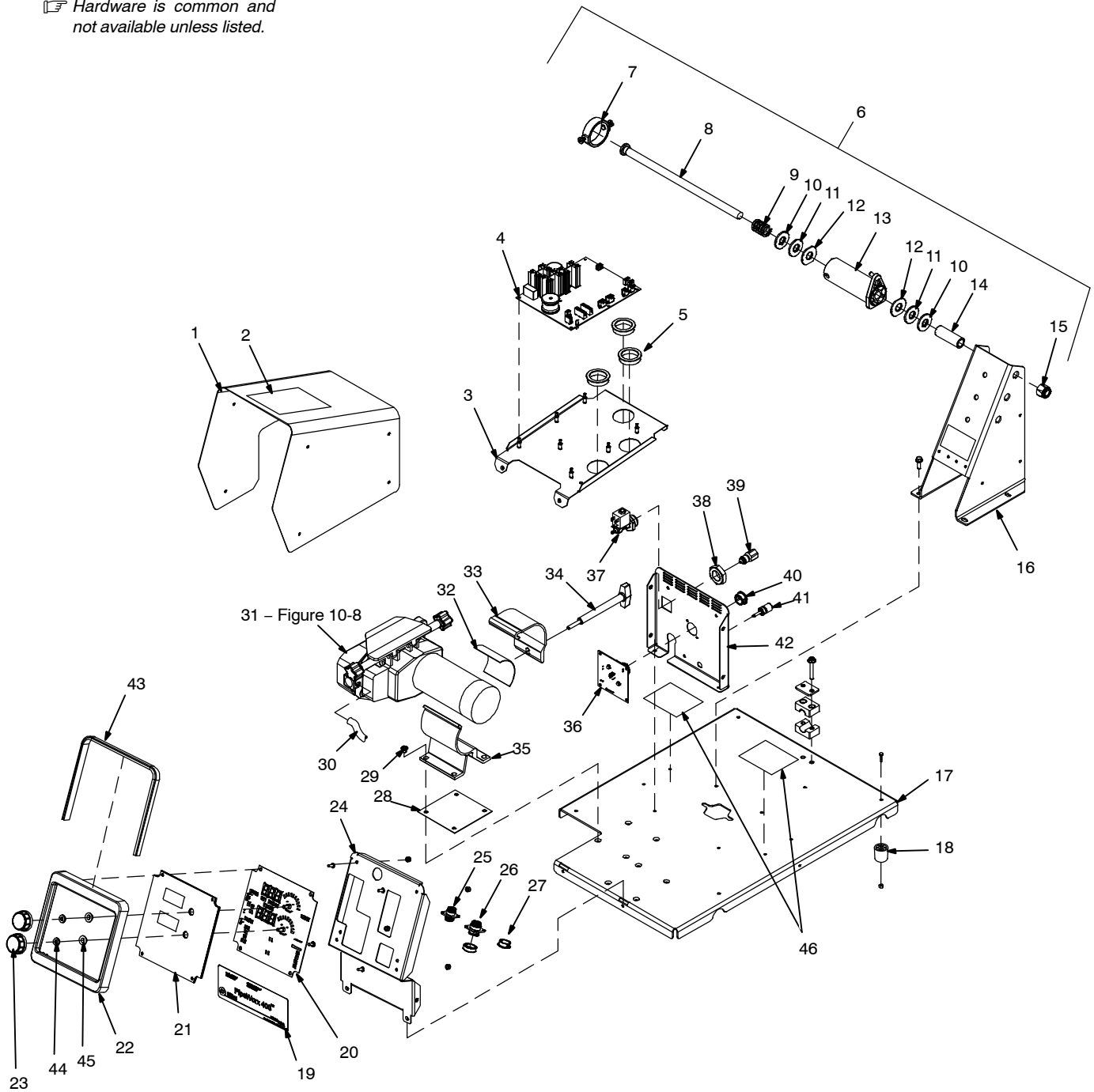
Figure 10-5. Single Wire Feeder (non-CE) (Continued)

| | | | | |
|----|-----|--------|---|---|
| | | | Rear Panel Assy, Single Feeder (Includes) | 1 |
| 36 | PC3 | 244471 | Circuit Card Assy, PS/Feeder Interface | 1 |
| 37 | GS1 | 228036 | Valve, 24Vac 1way .750-14 Thd 2.0mm Orf 100 Psi | 1 |
| 38 | | 220805 | Nut, 750-14 Nps 1.312Hex .413H Nyl | 1 |
| 39 | | 211989 | Fitting, w/Screen | 1 |
| 40 | | 030170 | Bushing, Snap-In Nyl .750 Id x 1.000 Mtg Hole | 2 |
| 41 | | 239737 | Receptacle, Banana Jack Blk 10-32 Binding Post | 1 |
| 42 | | 238498 | Enclosure, Rear Single Feeder | 1 |
| | | 074481 | Label, Left | 1 |
| | | 106410 | Label, To Power Source | 1 |
| | | 287140 | Label, Volt Sense | 1 |
| | | 209533 | Kit, .035/.045 4 Drive Roll | 1 |
| 43 | | 266171 | Seal, Cover UI Pipeworx Feeder | 1 |
| 44 | | 269049 | Washer, Shldr.375 Id 0.750 Od | 2 |
| 45 | | 255006 | Washer, Flat Seal .265 Id x 0.500 Od x .125T EPDM | 2 |
| 46 | | 274966 | Label, Warning Falling Equipment (En/Fr/Sp-Sym) | 2 |

+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.

 Hardware is common and not available unless listed.



254082-D

Figure 10-5. Single Wire Feeder (CE)

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|---|------------|----------|--|----------|
| Figure 10-5. Single Wire Feeder (CE) | | | | |
| ... | | 1 | Wrapper, Single Feeder | 1 |
| ... | | 2 | Label, Warning General Precautionary (En/Fr/Sp) | 1 |
| ... | | | Panel Assy, PCB Support (Includes) | 1 |
| ... | | 3 | Panel, PC Board Support | 1 |
| ... | | | Stand-Off Support, PC Card .250 w/Post&Lock .500 | 7 |
| ... | PC1 | 4 | Circuit Card Assy, Pipeworx Feeder Mtr Ctrl | 1 |
| ... | | 5 | Bushing, Snap-In Nyl 1.375 Id x 1.750 Mtg Hole | 3 |
| ... | | 6 | Hub+Spindle Assy | 1 |
| ... | | 7 | Ring, Retaining Spool | 1 |
| ... | | 8 | Shaft Assy, Support Spool | 1 |
| ... | | 9 | Spring, Cprsn .970 Od x .120 Wire x 1.250 Pld | 1 |
| ... | | 10 | Washer, Flat .632 Id x 1.500 Od x .125t Stl Pld .175 Key | 2 |
| ... | | 11 | Washer, Flat .656 Id x 1.500 Od x .125t Fbr | 2 |
| ... | | 12 | Washer, Brake Stl | 2 |
| ... | | 13 | Hub, Spool | 1 |
| ... | | 14 | Tubing, Stl .875 Od x 12Ga Wall x 2.500 | 1 |
| ... | | 15 | Nut, 625-11 .94Hex .77h Stl Pld Elastic Stop Nut | 1 |
| ... | | 16 | Support, Spool | 1 |
| ... | | 17 | Base, Feeder w/Pem Nuts | 1 |
| ... | | 18 | Foot, Rubber 1.250 Dia x 1.375 High No 10 Screw | 4 |
| ... | | 19 | Label, Single Feeder Lower | 1 |
| ... | | | Panel, Front w/Cmpnts Single Bench Feeder (Includes) | 1 |
| ... | PC2 | 20 | Kit, Circuit Card Assy UI w/Program | 1 |
| ... | | 21 | Nameplate/Switch Membrane, Dual Feeder | 1 |
| ... | | 22 | Bezel, Feeder | 1 |
| ... | | 23 | Knob, Encoder 1.670 Dia x .250 Id Push On w/Spring | 2 |
| ... | | 24 | Panel, Front | 1 |
| ... | | 25 | Plug Assy, Trigger Lh (Includes) | 1 |
| ... | PLG17 | | Housing Plug+Skts, (Service Kit) | 1 |
| ... | RC2 | | Rcpt w/Skts, (Service Kit) | 1 |
| ... | | 26 | Plug Assy, Remote (Includes) | 1 |
| ... | RC4 | | Housing Plug+Skts,(Service Kit) | 1 |
| ... | PLG35 | | Housing Plug+Skts,(Service Kit) | 1 |
| ... | | | Housing Plug+Pins,(Service Kit) | 1 |
| ... | | 27 | Blank, Snap-In Nyl .875 Mtg Hole Black | 1 |
| ... | | 28 | Insulator, Motor Clamp | 1 |
| ... | | 29 | Insulator, Screw Machine | 4 |
| ... | | 30 | Hose, SAE .187 Id x .410 Od x 17.000 w/Clamps | 1 |
| ... | | 31 | Drive Assy, Wire S/L 4 Roll w/Tach | 1 |
| ... | | 32 | Pad, Neoprene .250 x 3.000 x 4.000 Du70a | 1 |
| ... | | 33 | Clamp, Motor Top | 1 |
| ... | | 34 | Knob, w/Extension (Lh) Clamp | 1 |
| ... | | 35 | Clamp, Motor Base | 1 |

+When Ordering A Component Originally Displaying A Precautionary Label, The Label Should Also Be Ordered.

*When ordering a PC2 or Nameplate/Switch Membrane for serial numbers prior to ME170176G these parts need to be replaced together with new design parts. If the unit already has new design parts they can be replaced individually.

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.

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

Figure 10-5. Single Wire Feeder (CE) (Continued)

| | | | | |
|----|-----|--------|---|---|
| | | | Rear Panel Assy, Single Feeder (Includes) | 1 |
| 36 | PC3 | 244471 | Circuit Card Assy, PS/Feeder Interface | 1 |
| 37 | GS1 | 228036 | Valve, 24Vac 1way .750-14 Thd 2.0mm Orf 100 PSI | 1 |
| 38 | | 220805 | Nut, 750-14 Nps 1.312 Hex .413H Nyl | 1 |
| 39 | | 211989 | Fitting, w/Screen | 1 |
| 40 | | 030170 | Bushing, Snap-In Nyl .750 Id x 1.000 Mtg Hole | 2 |
| 41 | | 239737 | Receptacle, Banana Jack Blk 10-32 Binding Post | 1 |
| 42 | | 238498 | Enclosure, Rear Single Feeder | 1 |
| | | 074481 | Label, Left | 1 |
| | | 209533 | Kit, .035/.045 4 Drive Roll | 1 |
| | | 254054 | Label, To Power Source CE | 1 |
| | | 287140 | Label, Volt Sense | 1 |
| 43 | | 266171 | Seal, Cover UI | 1 |
| 44 | | 255006 | Washer, Flat Seal .265 Id x 0.500 Od x .125T EPDM | 2 |
| 45 | | 269049 | Washer, Shldr.375id 0.750 Od x .063t .500 Od x.188T Nyl | 2 |
| 46 | | 274966 | Label, Warning Falling Equipment (En/Fr/Sp-Sym) | 2 |

+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.

☞ Hardware is common and not available unless listed.

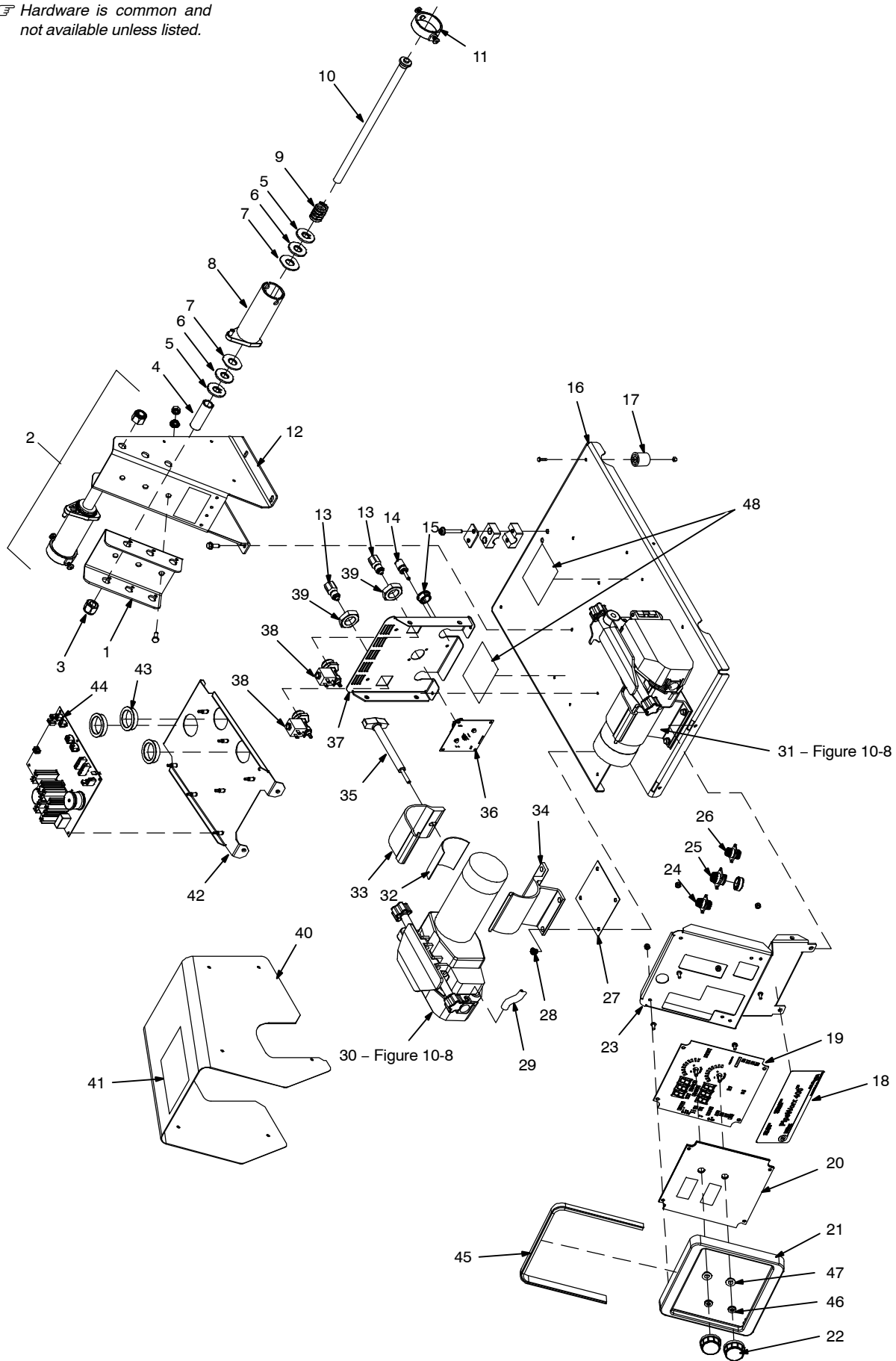


Figure 10-6. Dual Wire Feeder (non-CE)

805150-D

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|---|------------|----------|---|----------|
| Figure 10-7. Dual Wire Feeder (non-CE) | | | | |
| ... | 1 | 142838 | Bracket, Mtg Spool RH | 1 |
| ... | 2 | 143160 | Hub+Spindle Assy | 2 |
| ... | 3 | 135205 | Nut, 625-11 .94Hex .77h Stl Pld Elastic Stop Nut | 2 |
| ... | 4 | 071730 | Tubing, Stl .875 Od x 12ga Wall x 2.500 | 2 |
| ... | 5 | 057971 | Washer, Flat .632 Id x 1.500 Od x .125t Stl Pld .175key | 4 |
| ... | 6 | 010191 | Washer, Flat .656 Id x 1.500 Od x .125t Fbr | 4 |
| ... | 7 | 058628 | Washer, Brake Stl | 4 |
| ... | 8 | 058428 | Hub, Spool | 2 |
| ... | 9 | 010233 | Spring, Cprsn .970 Od x .120 Wire x 1.250 Pld | 2 |
| ... | 10 | 180573 | Shaft Assy, Support Spool | 2 |
| ... | 11 | 058427 | Ring, Retaining Spool | 2 |
| ... | 12 | 141411 | Support, Spool | 1 |
| ... | 13 | 211989 | Fitting, w/Screen | 2 |
| ... | 14 | 239737 | Receptacle, Banana Jack Blk 10-32 Binding Post | 1 |
| ... | 15 | 030170 | Bushing, Snap-In Nyl .750 Id x 1.000 Mtg Hole | 2 |
| ... | 16 | 233559 | Base, Feeder w/Pem Nuts | 1 |
| ... | 17 | 134306 | Foot, Rubber 1.250 Dia x 1.375 High No 10 Screw | 4 |
| ... | 18 | 238513 | Label, Dual Feeder Lower | 1 |
| ... | | | Panel, Front w/Cmpnts Dual Bench Feeder (Includes) | 1 |
| ... | 19 | PC2 | *267543 Kit, Circuit Card Assy UI w/Program | 1 |
| ... | 20 | | *266046 Nameplate/Switch Membrane, Dual Feeder Pwx | 1 |
| ... | 21 | 234501 | Bezel, Feeder | 1 |
| ... | 22 | 213134 | Knob, Encoder 1.670 Dia x .250 Id Push On w/Spring | 2 |
| ... | 23 | 233560 | Panel, Front | 1 |
| ... | 24 | | Plug Assy, Trigger Lh (Includes) | 1 |
| ... | | PLG17 | 115093 Housing Plug+Skts, (Service Kit) | 1 |
| ... | | RC2 | 048282 Rcpt w/Skts, (Service Kit) | 1 |
| ... | 25 | | Plug Assy, Remote (Includes) | 1 |
| ... | | RC4 | 222857 Housing Plug+Skts, (Service Kit) | 1 |
| ... | | PLG35 | 115093 Housing Plug+Skts, (Service Kit) | 1 |
| ... | | | 200822 Housing Plug+Pins, (Service Kit) | 1 |
| ... | 26 | | Plug Assy, Trigger Rh (Includes) | 1 |
| ... | | L 2 | 213030 Core, Toroidal 19.00mm Id x 29.01mm Od x 7.62mm Th | 1 |
| ... | | PLG16 | 115093 Housing Plug+Skts, (Service Kit) | 1 |
| ... | | RC3 | 048282 Rcpt w/Skts, (Service Kit) | 1 |
| ... | 27 | 159647 | Insulator, Motor Clamp | 2 |
| ... | 28 | 159360 | Insulator, Screw Machine | 8 |
| ... | 29 | 200814 | Hose, Sae .187 Id x .410 Od x 17.000 w/Clamps | 2 |
| ... | 30 | 201762 | Drive Assy, Wire S/L 4 Roll w/Tach | 1 |
| ... | 31 | 201768 | Drive Assy, Wire R 4 Roll w/Tach | 1 |
| ... | 32 | 275686 | Pad, Neoprene .250 x 3.000 x 4.000 Du70a | 2 |
| ... | 33 | 156243 | Clamp, Motor Top | 2 |
| ... | 34 | 159646 | Clamp, Motor Base | 2 |
| ... | 35 | 234424 | Knob, w/Extension (Rh) Clamp | 1 |
| ... | 35 | 234426 | Knob, w/Extension (Lh) Clamp | 1 |

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

*When ordering a PC2 or Nameplate/Switch Membrane for serial numbers prior to ME200035G these parts need to be replaced together with new design parts. If the unit already has new design parts they can be replaced individually.

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.

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

Figure 10-7. Dual Wire Feeder (non-CE) (Continued)

| | | | | |
|----|---------------|---------|--|---|
| | | | Rear Panel Assy, Dual Feeder (Includes) | 1 |
| 36 | PC3 | 244471 | Circuit Card Assy, PS/Feeder Interface | 1 |
| 37 | | 233561 | Enclosure, Rear Dual Feeder | 1 |
| 38 | GS 1, GS 2 | 228036 | Valve, 24Vac 1way .750-14 Thd 2.0mm Orf 100 Psi | 2 |
| 39 | | 272186 | Nut, 750-14 Nps 1.312Hex .413H Nyl | 2 |
| | | 074479 | Label, Right | 1 |
| | | 074481 | Label, Left | 1 |
| | | 106410 | Label, To Power Source | 1 |
| | | 287140 | Label, Volt Sense | 1 |
| 40 | | +233562 | Wrapper, Dual Feeder | 1 |
| 41 | | 274964 | Label, Warning General Precautionary Static&Wire Fe | 1 |
| | | | Panel Assy, PCB Support (Includes) | 1 |
| 42 | | 236556 | Panel, PC Board Support | 1 |
| | | 198122 | Stand-Off Support, PC Card .250 w/Post&Lock .500 | 7 |
| 43 | | 010494 | Bushing, Snap-In Nyl 1.375 Id x 1.750 Mtg Hole | 3 |
| 44 | PC1 | 244483 | Circuit Card Assy, Pipeworx Feeder Mtr Ctrl | 1 |
| | | 237210 | Hose Assy, Gas Y | 1 |
| | | 143838 | Cable, Weld 26 in. 4/0 w/Terms | 1 |
| | | 209533 | Kit, .035/045 4 Drive Roll | 1 |
| | | 151053 | Kit, Drive Roll .045 VK-Gr 4 Roll | 1 |
| 45 | | 266171 | Seal, Cover UI Pipeworx Feeder | 1 |
| 46 | | 255006 | Washer, Flat Seal .265 Id x 0.500 Od x .125T Epdm | 2 |
| 47 | | 269049 | Washer, Shldr .375 Id 0.750 Od x .063T .500 Od x .188t Nyl | 2 |
| 48 | | 274966 | Label, Warning Falling Equipment (En/Fr/Sp-Sym) | 2 |

+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.

☐ Hardware is common and not available unless listed.

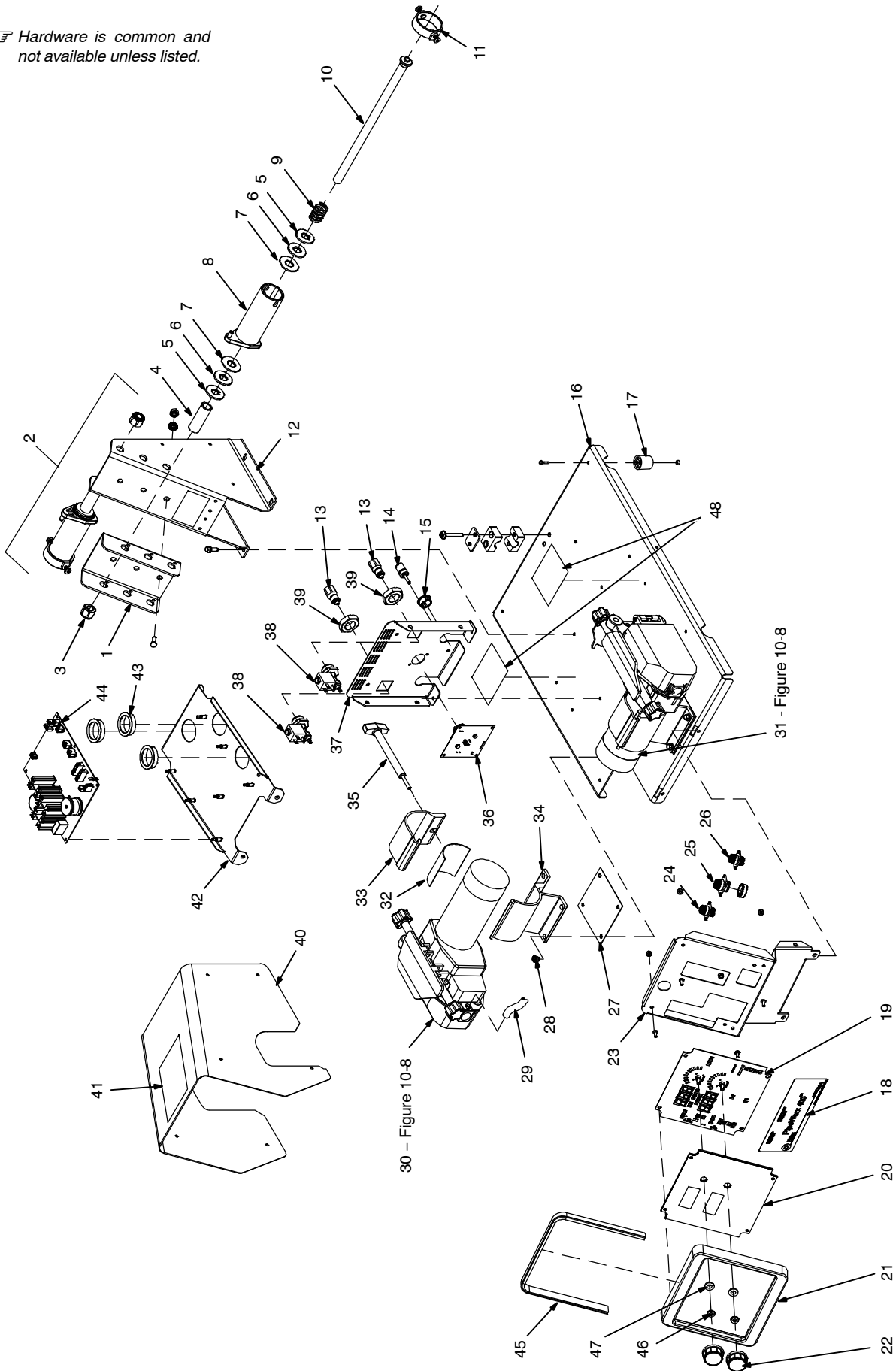


Figure 10-7. Dual Wire Feeder (CE)

254081-D

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|---|------------|----------|---|----------|
| Figure 10-7. Dual Wire Feeder (CE) | | | | |
| ... | 1 | 142838 | .. Bracket, Mtg Spool Rh | 1 |
| ... | 2 | 143160 | .. Hub+Spindle Assy | 2 |
| ... | 3 | 135205 | Nut, 625-11 .94hex .77h Stl Pld Elastic Stop Nut | 2 |
| ... | 4 | 071730 | Tubing, Stl .875 Od x 12ga Wall x 2.500 | 2 |
| ... | 5 | 057971 | Washer, Flat .632 Id x1.500 Od x.125t Stl Pld .175 Key | 4 |
| ... | 6 | 010191 | Washer, Flat .656 Id x1.500 Od x.125t Fbr | 4 |
| ... | 7 | 058628 | Washer, Brake Stl | 4 |
| ... | 8 | 058428 | Hub, Spool | 2 |
| ... | 9 | 010233 | Spring, Cprsn .970 Od x .120 Wire x 1.250 Pld | 2 |
| ... | 10 | 180573 | Shaft Assy, Support Spool | 2 |
| ... | 11 | 058427 | Ring, Retaining Spool | 2 |
| ... | 12 | 141411 | .. Support, Spool | 1 |
| ... | 13 | 211989 | Fitting, w/Screen | 2 |
| ... | 14 | 239737 | Receptacle, Banana Jack Blk 10-32 Binding Post | 1 |
| ... | 15 | 030170 | Bushing, Snap-In Nyl .750 Id x 1.000 Mtg Hole | 2 |
| ... | 16 | 233559 | .. Base, Feeder w/Pem Nuts | 1 |
| ... | 17 | 134306 | .. Foot, Rubber 1.250 Dia x 1.375 High No 10 Screw | 4 |
| ... | 18 | 238513 | .. Label, Dual Feeder Lower | 1 |
| | | | Panel, Front w/Cmpnts Dual Bench Feeder (Includes) | 1 |
| | | 254048 | .. Label, Miller Pipeworx Dual Feeder CE Lower | 1 |
| ... | 19 | PC2 | *267543 Kit, Circuit Card Assy UI w/Program | 1 |
| ... | 20 | | *266047 Nameplate/Switch Membrane, Dual Feeder CE | 1 |
| ... | 21 | 234501 | Bezel, Feeder | 1 |
| ... | 22 | 213134 | Knob, Encoder 1.670 Dia x .250 Id Push On W/Spring | 2 |
| ... | 23 | 233560 | Panel, Front | 1 |
| ... | 24 | | Plug Assy, Trigger Lh (Includes) | 1 |
| | PLG17 | 115093 | Housing Plug+Skts, (Service Kit) | 1 |
| | RC2 | 048282 | Rcpt w/Skts, (Service Kit) | 1 |
| ... | 25 | | Plug Assy, Remote (Includes) | 1 |
| | RC4 | 222857 | Housing Plug+Skts, (Service Kit) | 1 |
| | PLG35 | 115093 | Housing Plug+Skts, (Service Kit) | 1 |
| | | 200822 | Housing Plug+Pins, (Service Kit) | 1 |
| ... | 26 | | Plug Assy, Trigger Rh (Includes) | 1 |
| | L2 | 213030 | Core, Toroidal 19.00mm Id x 29.01mm Od x 7.62mm Th | 1 |
| | PLG16 | 115093 | Housing Plug+Skts, (Service Kit) | 1 |
| | RC3 | 048282 | Rcpt w/Skts, (Service Kit) | 1 |
| ... | 27 | 159647 | .. Insulator, Motor Clamp | 2 |
| ... | 28 | 159360 | .. Insulator, Screw Machine | 8 |
| ... | 29 | 200814 | .. Hose, SAE .187 Id x .410 Od x 17.000 w/Clamps | 2 |
| ... | 30 | 201762 | .. Drive Assy, Wire S/L 4 Roll w/Tach | 1 |
| ... | 31 | 201768 | .. Drive Assy, Wire R 4 Roll w/Tach | 1 |
| ... | 32 | 275686 | .. Pad, Neoprene .250 x 3.000 x 4.000 Du70a | 2 |
| ... | 33 | 156243 | .. Clamp, Motor Top | 2 |
| ... | 34 | 159646 | .. Clamp, Motor Base | 2 |
| ... | 35 | 234424 | .. Knob, w/Extension (Rh) Clamp | 1 |
| ... | 35 | 234426 | .. Knob, w/Extension (Lh) Clamp | 1 |

+When Ordering A Component Originally Displaying A Precautionary Label, The Label Should Also Be Ordered.

*When ordering a PC2 or Nameplate/Switch Membrane for serial numbers prior to ME170176G these parts need to be replaced together with new design parts. If the unit already has new design parts they can be replaced individually.

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.

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

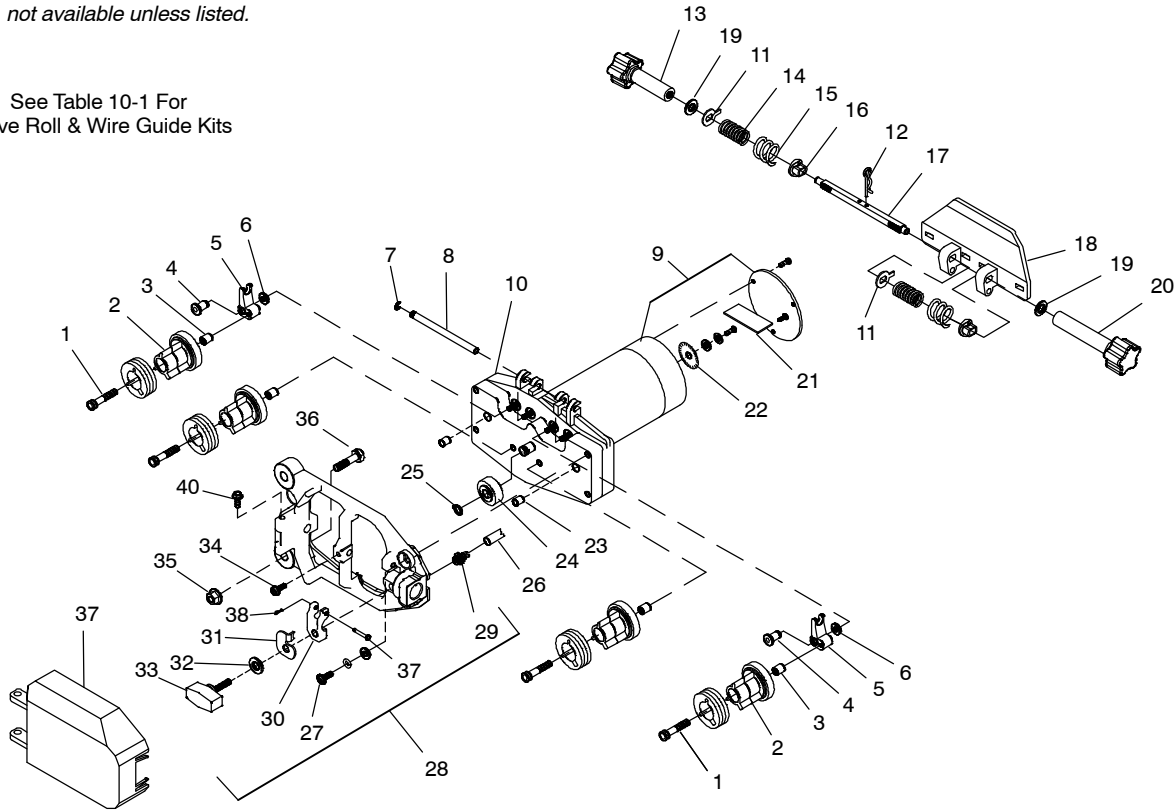
Figure 10-7. Dual Wire Feeder (CE) (Continued)

| | | | | |
|----|------------|---------|---|---|
| | | | Rear Panel Assy, Dual Feeder (Includes) | 1 |
| 36 | PC3 | 244471 | Circuit Card Assy, PS/Feeder Interface | 1 |
| 37 | | 233561 | Enclosure, Rear Dual Feeder | 1 |
| 38 | GS 1, GS 2 | 228036 | Valve, 24Vac 1way .750-14 Thd 2.0mm Orf 100 Psi | 2 |
| 39 | | 272186 | Nut, 750-14 Nps 1.312Hex .413H Nyl | 2 |
| | | 074479 | Label, Right | 1 |
| | | 074481 | Label, Left | 1 |
| | | 254054 | Label, To Power Source (CE) | 1 |
| | | 287140 | Label, Volt Sense | 1 |
| 40 | | +233562 | Wrapper, Dual Feeder | 1 |
| 41 | | 274964 | Label, Warning General Precautionary (En/Fr/Sp) | 1 |
| | | | Panel Assy, PCB Support (Includes) | 1 |
| 42 | | 236556 | Panel, PC Board Support | 1 |
| | | 198122 | Stand-Off Support, PC Card .250 w/Post&Lock .500 | 7 |
| 43 | | 010494 | Bushing, Snap-In Nyl 1.375 Id x 1.750 Mtg Hole | 3 |
| 44 | PC1 | 233967 | Circuit Card Assy, Pipeworx Feeder Mtr Ctrl | 1 |
| | | 237210 | Hose Assy, Gas Y | 1 |
| | | 143838 | Cable, Weld 26 in. 4/0 w/Terms | 1 |
| | | 209533 | Kit, .035/.045 4 Drive Roll | 1 |
| | | 151053 | Kit, Drive Roll .045 Vk-Gr 4 Roll | 1 |
| 45 | | 266171 | Seal, Cover UI | 1 |
| 46 | | 255006 | Washer, Flat Seal .265 Id x 0.500 Od x .125T Epdm | 2 |
| 47 | | 269049 | Washer, Shldr .375 Id 0.750 Od x .063T .500 Od x.188T Nyl | 2 |
| 48 | | 274966 | Label, Warning Falling Equipment (En/Fr/Sp-Sym) | 2 |

+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.

☞ Hardware is common and not available unless listed.

See Table 10-1 For Drive Roll & Wire Guide Kits



Ref. 245244F

Figure 10-8. Drive Assembly, Wire

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|--|------------|----------|---|----------|
| Figure 10-8. Drive Assembly, Wire (Figure 10-5 Item 31 And Figure 10-7 Items 30 And 31) | | | | |
| ... | 1 | 010668 | .. Screw, Cap Stl Sch .250-20 x 1.500 | 4 |
| ... | 2 | 172075 | .. Carrier, Drive Roll w/Components | 4 |
| ... | 3 | 149962 | .. Spacer, Carrier Drive Roll | 4 |
| ... | 4 | 149486 | .. Pin, Rotation Arm Rocker | 2 |
| ... | 5 | 132750 | .. Arm, Pressure | 2 |
| ... | 6 | 150520 | .. Spacer, Flat Stl .257 Id x .619 Od x .105 | 2 |
| ... | 7 | 133493 | .. Ring, Retaining Ext .250 Shaft x .025Thk | 2 |
| ... | 8 | 133350 | .. Pin, Hinge | 1 |
| ... | 9 | M1,101 | .. Motor, Gear 1/8Hp 24Vdc Standard Speed | 1 |
| ... | | 167387 | .. Spacer, Locating | 2 |
| ... | | 133493 | Ring, Rtnng Ext .250 Shaft Grv x .025Thk | 1 |

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|--|------------|----------|---|--------------|
| Figure 10-8. Drive Assembly, Wire (Figure 10-5 Item 31 And Figure 10-7 Items 30 And 31) | | | | |
| | | 203642 | .. Pressure Arm, R & Vert L 4 Roll (Includes) | 1 |
| | | 203631 | .. Pressure Arm, S/L & Vert S/R 4 Roll (Includes) | 1 |
| .. 11 | | 203641 | Washer, Flat Indicator Spring Tension | 2 |
| .. 12 | | 182415 | Pin, Cotter Hair | 1 |
| .. 13 | | 203640 | Knob, w/Extension Short Pressure Arm | 1 |
| .. 14 | | 182156 | Spring, Cprsn | 2 |
| .. 15 | | 182155 | Spring | 2 |
| .. 16 | | 132746 | Bushing, Spring | 2 |
| .. 17 | | 203633 | Shaft, Spring | 1 |
| .. 18 | | 203632 | Carrier, Shaft | 1 |
| .. 19 | | 133739 | Washer, Flat Buna .375 Id x .625 Od x .062Thk | 2 |
| .. 20 | | 203637 | Knob, w/Extension Long Pressure Arm | 1 |
| .. 21 .. | PC51,151 | 237048 | .. Circuit Card Assy, Digital Tach (Includes) | 2 |
| | PLG5 | 131204 | Connector & Sockets | 1 |
| | | 604311 | Grommet, Rbr .250 Id x .375 Mtg Hole .062 Groove | 1 |
| .. 22 | | 132611 | .. Optical Encoder Disc | 1 |
| | | 279896 | .. Weather Stripping, Adh .125 Thk x 2.4375 Dia | 1 |
| .. 23 | | 167387 | .. Spacer, Locating | 2 |
| .. 24 | | 168825 | .. Drive, Pinion | 1 |
| .. 25 | | 133308 | .. Ring, Retaining Ext .375 Shaft x .025Thk | 1 |
| .. 26 | | 134834 | .. Hose, SAE .187 Id x .410 Od (order by ft) | 2 ft (0.6 m) |
| .. 27 | | 108940 | .. Screw, Cap Stl Hexhd .250-20 x .750 | 4 |
| .. 28 | | 281132 | .. Adapter, Gun/Feeder Lh Accu-Mate (Includes) | 1 |
| .. 28 | | 281131 | .. Adapter, Gun/Feeder Rh Accu-Mate (Includes) | 1 |
| .. 29 | | 149959 | Fitting, Brs Barbed M 3/16Tbg x .312-24 | 1 |
| .. 30 | | 278295 | Clamp, Power Pin | 1 |
| .. 31 | | 242261 | Lock, Power Pin | 1 |
| .. 32 | | 231232 | Washer, Flat .344 Id x 0.688 Od x .065 Thk Stl Pld Ansi .312 | 1 |
| .. 33 | | 151437 | Knob, Plstc T 1.125 Lg x .312-18 x 1.500 | 1 |
| .. 34 | | 151290 | Screw, 010-32 x .50 Hexwhd.40d Stl | 2 |
| .. 35 | | 167788 | Nut, 375-16 .56Hex .34h Stl Pld Sem Cone | 1 |
| .. 36 | | 601966 | Screw, Cap Stl Hexhed .375-16 x 1.250 | 1 |
| .. 37 | | 234073 | .. Pin, Hinge | 1 |
| .. 38 | | 280558 | .. Pin, Cotter Hair .047 x 0.625 Zinc Pld | 1 |
| .. 39 | | 179263 | .. Cover, Drive Roll (Includes) | 1 |
| | | 275806 | Label, Warning Hot Surfaces And Moving Parts | 1 |
| .. 40 | | 284419 | Screw, 006-32 x .37 Soc Hd-Hex Stl Pln | 1 |

*Recommended Spare Parts.

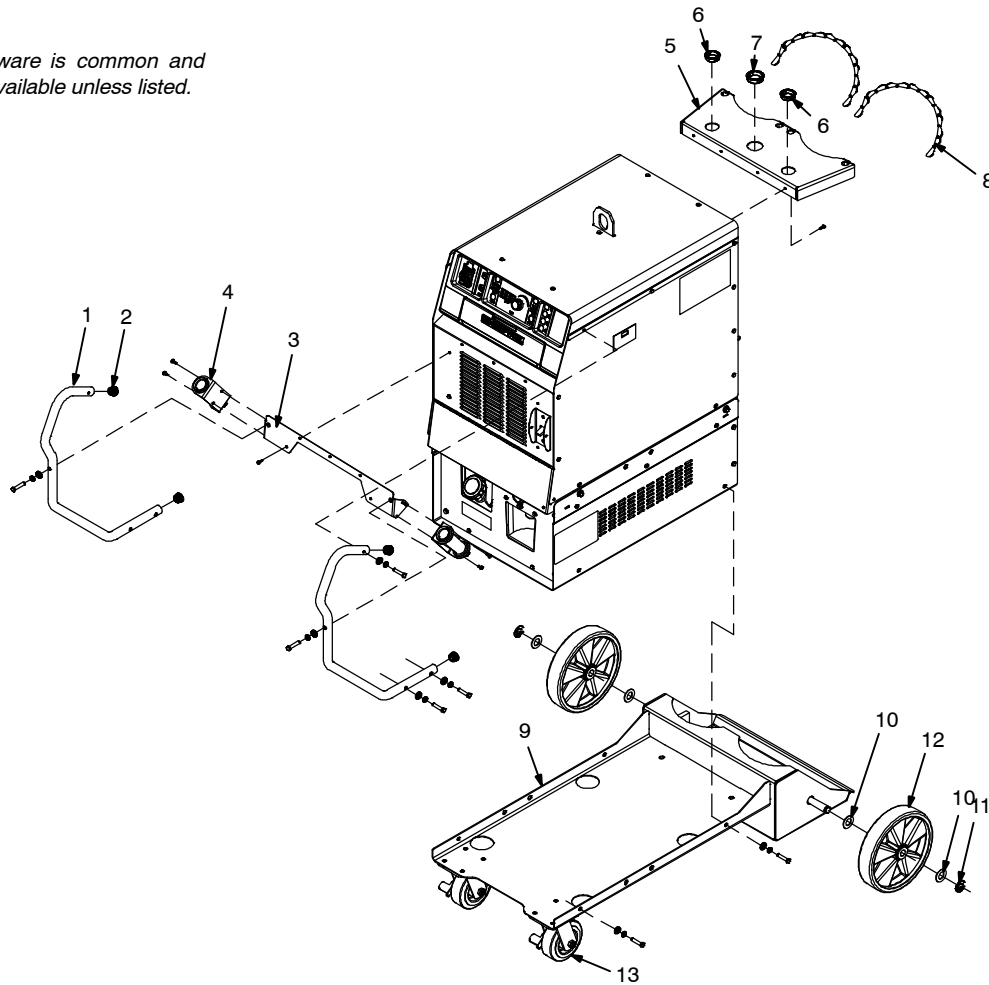
To Maintain The Factory Original Performance Of Your Equipment, Use Only Manufacturer'S Suggested Replacement Parts. Model And Serial Number Required When Ordering Parts From Your Local Distributor.

Table 10-1. Drive Roll And Wire Guide Kits

| Wire Size | | Inlet Guide | Intermediate Guide | V-GROOVE | | VK-GROOVE | |
|------------------------|------------|-------------|--------------------|------------|------------|------------|------------|
| Fraction | Metric | | | 4 Roll Kit | Drive Roll | 4 Roll Kit | Drive Roll |
| .035 in. | 0.9 mm | 150993 | 149518 | 151026 | 053700 | 151052 | 132958 |
| .045 in. | 1.1/1.2 mm | 150994 | 149519 | 151027 | 053697 | 151053 | 132957 |
| .052 in. | 1.3/1.4 mm | 150994 | 149519 | 151028 | 053698 | 151054 | 132956 |
| 1/16 in. (.062 in.) | 1.6 mm | 150995 | 149520 | 151029 | 053699 | 151055 | 132955 |
| .068-.072 in. | 1.8 mm | 150995 | 149520 | | | 151056 | 132959 |
| 5/64 in. (.079 in.) | 2.0 mm | 150995 | 149520 | | | 151057 | 132960 |
| 3/32 in. (.094 in.) | 2.4 mm | 150996 | 149521 | | | 151058 | 132961 |

Each Kit Contains An Inlet Guide, Intermediate Guide, And 045233 Antiwear Guide With 604612 Setscrew 8-32 x .125, Along With 4 Drive Rolls.

☞ Hardware is common and not available unless listed.



805302-D

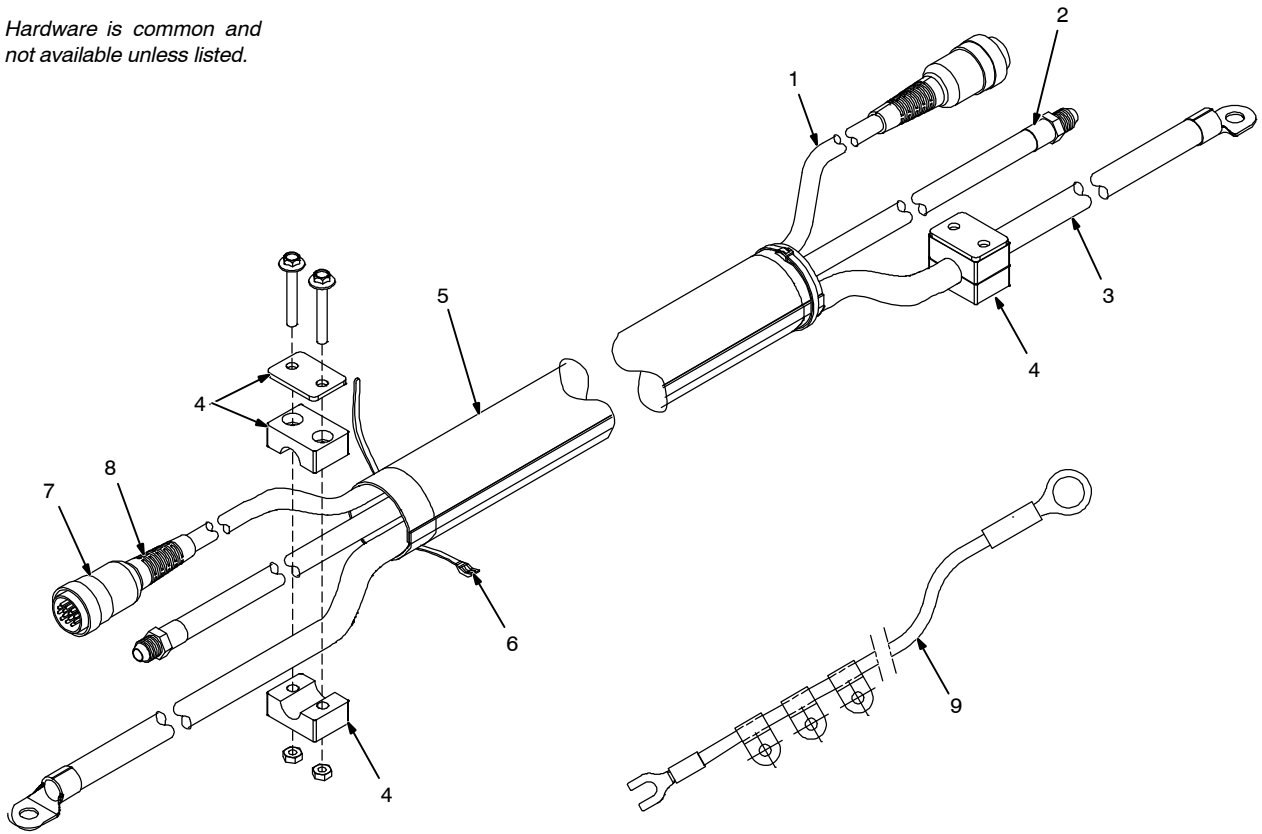
Figure 10-9. Running Gear

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------------------------------|------------|----------|---|----------|
| Figure 10-9. Running Gear | | | | |
| ... | 1 | 236827 | .. Handle, Power Source | 2 |
| ... | 2 | 238611 | .. Cap, Tube .865 Od | 4 |
| ... | 3 | 273522 | .. Bracket, PipeWorx 400 Gun Holder | 1 |
| ... | 4 | | .. Gun Holder Assembly (Includes) | 2 |
| ... | | 273518 | .. Bracket, Gun Holder | 1 |
| ... | | 273519 | .. Cap, Gun Holder | 1 |
| ... | | 271830 | .. Tube, Gun Holder | 1 |
| ... | | 273520 | .. Grommet, Rbr 1.375 Id x 1.625 Mtg Hole .125 Groove | 2 |
| ... | 5 | +233666 | .. Bracket, Support Cylinder Dual | 1 |
| ... | | 200285 | .. Label, Warning Cylinder May Explode If Damaged | 1 |
| ... | 6 | 170647 | .. Bushing, Snap-In Nyl 1.312 Id x 1.500 Mtg Hole | 2 |
| ... | 7 | 004214 | .. Bushing, Snap-In Nyl 1.625 Id x 2.000 Mtg Hole | 1 |
| ... | 8 | 188441 | .. Chain, Weldless 2/0 x 31. Bright Zinc Pld | 2 |
| ... | 9 | 234359 | .. Rack Wheel Assy, Running Gear | 1 |
| ... | 10 | 602250 | .. Washer, Flat .812 Id x 1.469 Od x.134T Stl Pld ANSI .750 | 4 |
| ... | 11 | 121614 | .. Ring, Rtnng Ext .750 Shaft x .085 Thk E Style Pld | 2 |
| ... | 12 | 163463 | .. Wheel, Rbr Tire 10.000 Od x 2.000 Wide x .750 Bore | 2 |
| ... | 13 | 209479 | .. Caster, Swvl 5.00 in. Urethane w/Brake 2.000 in. Wide | 2 |

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

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☞ Hardware is common and not available unless listed.



805301-A / Ref. 239780-C

Figure 10-10. Composite Cables

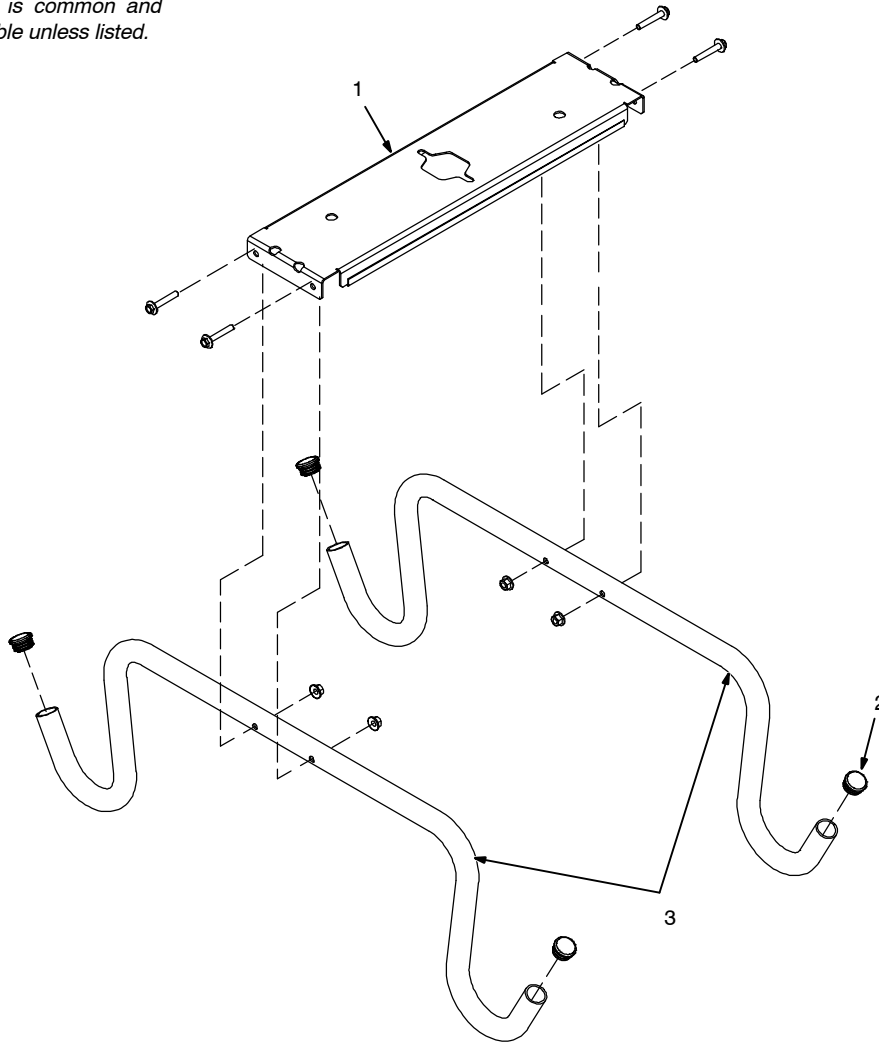
| Item No. | Dia. Mkgs. | Part No. | Description | Quantity | | |
|----------|------------|----------|-------------|----------------|-----------------|-----------------|
| | | | | 5 ft 300367 | 25 ft 300454 | 50 ft 300456 |

Figure 10-10. Composite Cables

| | | | | | | |
|-----|---|--------|---------------------------------------|---|---|---|
| ... | 1 | 300508 | .. Cable, Interconnecting 5 ft | 1 | | |
| ... | 1 | 300465 | .. Cable, Interconnecting 31 ft | 1 | | |
| ... | 1 | 300466 | .. Cable, Interconnecting 50 ft | | | 1 |
| ... | 2 | 238108 | .. Hose Assy, Gas 33 ft | 1 | | |
| ... | 2 | 238109 | .. Hose Assy, Gas 58 ft | | | 1 |
| ... | 3 | 238110 | .. Cable, Weld 4.5 ft 2/0 w/Terms | 1 | | |
| ... | 3 | 238111 | .. Cable, Weld 31 ft 2/0 w/Terms | | 1 | |
| ... | 3 | 238112 | .. Cable, Weld 56 ft 2/0 w/Terms | | | 1 |
| ... | 4 | 238432 | .. Clamp, Strain Relief | 2 | 2 | |
| ... | 5 | 238263 | .. Cover, Cable 28 ft (Black) | 1 | | |
| ... | 5 | 238264 | .. Cover, Cable 53 ft (Black) | | | 1 |
| ... | 6 | 210253 | .. Cable Tie, 0-1.750 Bundle Dia | 2 | 2 | |
| ... | 7 | 047636 | .. Housing Plug + Pins, (Service Kit) | 2 | 2 | 2 |
| ... | 8 | 143922 | .. Conn, Circ Cpc Clamp Str Rlf | 2 | 2 | 2 |
| ... | 9 | 300461 | .. Cable, Volt Sense | 1 | 1 | |
| ... | 9 | 300462 | .. Cable, Volt Sense | | | 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.

☞ Hardware is common and not available unless listed.



805148-B

Figure 10-11. Cable Hanger Assembly

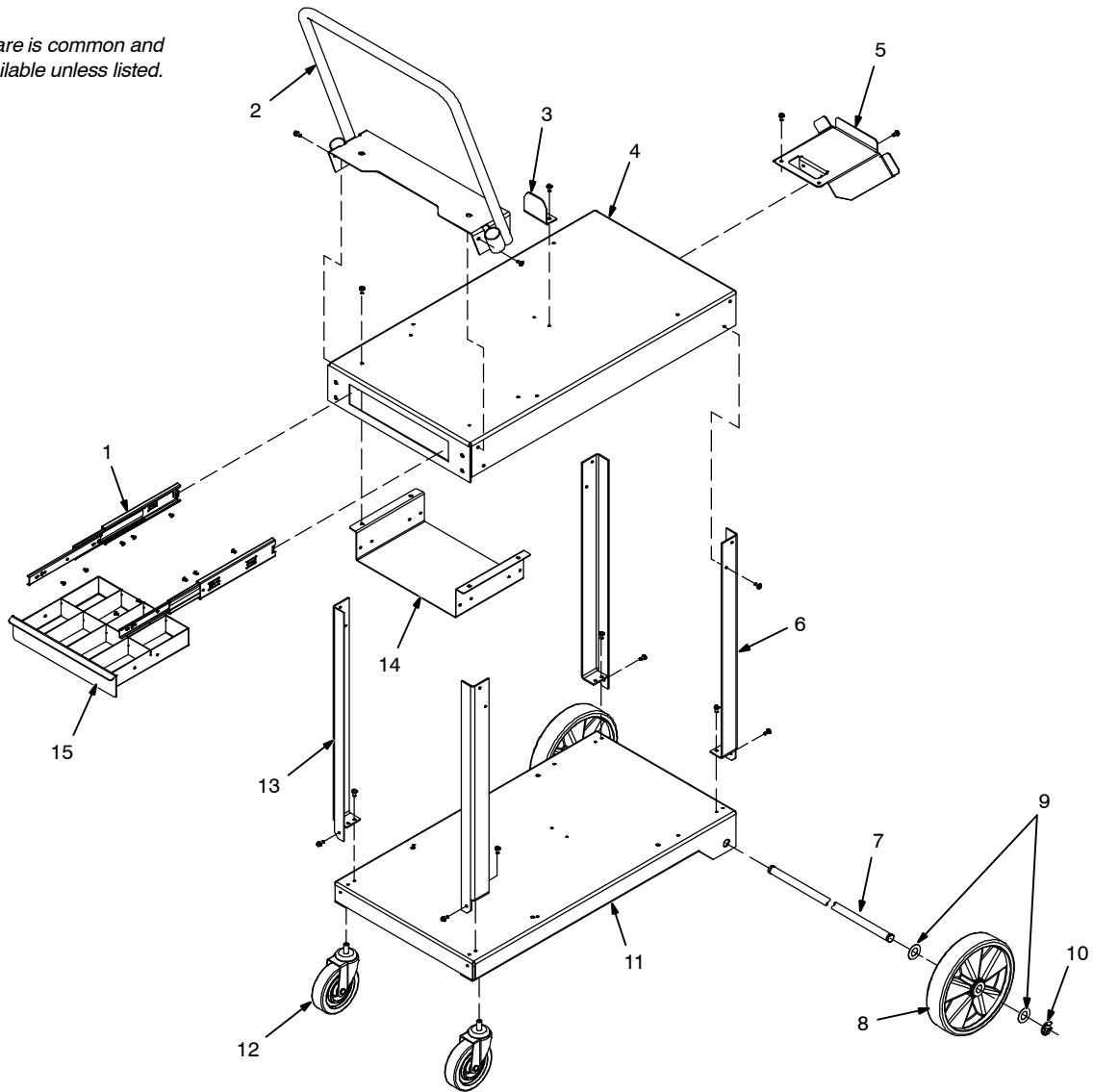
| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

Figure 10-11. Cable Hanger Assembly

| | | | | |
|-----|---|--------|--------------------------------------|---|
| ... | 1 | 285304 | .. Bracket, Cable Holder w/Edge Trim | 1 |
| ... | 2 | 238611 | .. Cap, Tube .865 Od | 4 |
| ... | 3 | 236826 | .. Tube, Cable Holder | 2 |

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.



805318-A

Figure 10-12. Feeder Cart

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

Figure 10-11. Cable Hanger Assembly

| | | | | |
|-----|----|--------|---|---|
| ... | 1 | 217255 | .. Slide, Drawer | 2 |
| ... | 2 | 234505 | .. Handle Assy, Feeder Cart | 1 |
| ... | 3 | 234546 | .. Tab, Lift Slot | 1 |
| ... | 4 | 234554 | .. Shelf, Upper,Feeder Cart | 1 |
| ... | 5 | 235121 | .. Holder, Cable Gun | 1 |
| ... | 6 | 234556 | .. Leg, Rear Rh Cart | 2 |
| ... | 7 | 234553 | .. Axle, Cart | 1 |
| ... | 8 | 163463 | .. Wheel, Rbr Tire 10.000 Od x 2.000 Wide x .750 Bore | 2 |
| ... | 9 | 602250 | .. Washer, Flat .812 Id x 1.469 Od x .134T Stl Pld | 4 |
| ... | 10 | 121614 | .. Ring, Rtnng Ext .750 Shaft x .085 Thk E Style Pld | 2 |
| ... | 11 | 234545 | .. Shelf, Lower,Feeder Cart | 1 |
| ... | 12 | 123557 | .. Caster, Swvl 5.00 in. Polyolefin x 1.375 x .437-14 | 2 |
| ... | 13 | 234555 | .. Leg, Rear Lh Cart | 2 |
| ... | 14 | 237215 | .. Bracket, Drawer Lh | 1 |
| ... | 15 | 232470 | .. Drawer, Assy | 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.

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