



TM-234 163C

2011-07

Processes



Air Plasma Cutting
and Gouging

Description

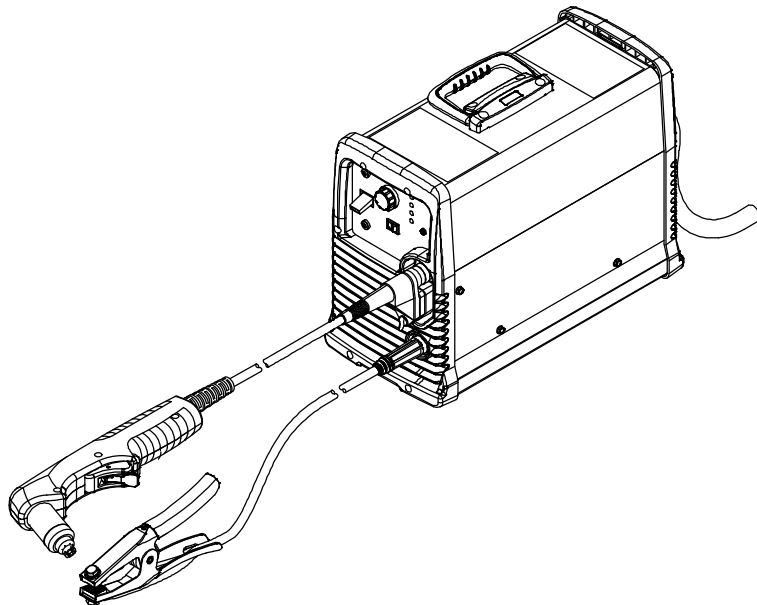


Air Plasma Cutter

Spectrum[®] 875 And ICE-60T Torch

PARTS LIST

Eff w/LJ350001P And Following
For OM-234 163 Revision A And Following




TECHNICAL MANUAL

File: Plasma Cutters



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SECTION 1 – PARTS LIST

 Hardware is common and not available unless listed.

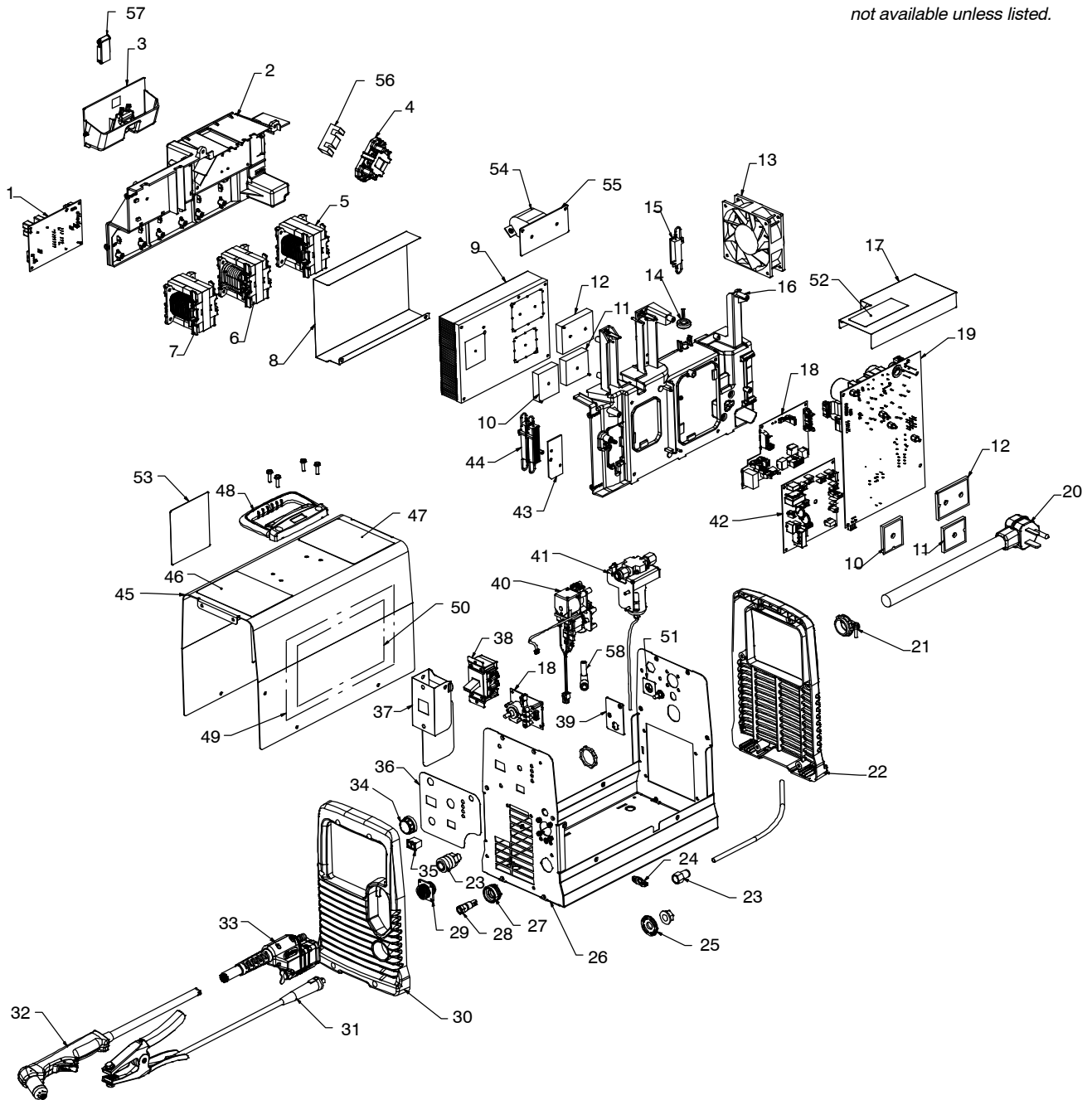


Figure 11-1. Main Assembly

805 214-B

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
Figure 11-1. Main Assembly					
...	1	PC3	235639	CIRCUIT CARD ASSY,FLYBACK PWR SUPPLY 875 208/230V	1
...	2		235574	WINDTUNNEL,MAGNETICS (INCLUDING)	1
...	3		235579	DOOR,CONSUMABLE STORAGE BOX W/LATCH	1
...	4	L2	234905	INDUCTOR,DI/DT BOOST	1
...	5	L1	234920	INDUCTOR,INPUT	1
...	6	T1	234810	XFMR,HF	1
...	7	L3	234924	INDUCTOR,OUTPUT	1
...	8		237138	INSULATOR,HEAT SINK	1
...	9		234818	HEAT SINK,PRIMARY/SECONDARY	1
...	10	PM3	250931	KIT,SECONDARY INTERCONNECT BD REPLACEMENT (Prior to MB270001P)	1
...	10	PM3	247083	KIT,MODULE OUTPUT RCTIFIER/PILOT IGBT (Eff w/MB270001P)	1
...	11	PM2	234847	KIT,INVERTER IGBT W/COVER	1
...	12	PM1	234846	KIT,INPUT RECTIFIER/BOOST IGBT W/COVER	1
...	13	FM1	246973	FAN,MUFFIN W/LEADS & GUARD	1
...	14	CT1	236848	XFMR,CURRENT SENSING 200/1 W/6IN LEADS	1
...	15	R3	238142	RESISTOR,WW FXD 50 W 25 OHM NI 5%	1
...	16		235573	WINDTUNNEL,HEAT SINK	1
...	17		+237137	INSULATOR,VALVE BRACKET	1
...	18	PC1	234183	CIRCUIT CARD ASSY,CNTRL W/PGM W/LED ASSY NON-CE	1
...	19	PC2	234922	PRIMARY INTERCONNECT BD ASSY,60AMP 230V W/HARDWARE	1
...	19	PC2	245756	KIT, PRIMARY INTRCNCT BD ASSY,60AMP 230V W/HARDWARE (Eff w/MA080001P thru MA180107P)	1
...	20		234828	CABLE,POWER 10 FT 8GA 3C	1
...	21		604102	CONN,CLAMP CABLE 1.000	1
...	22		234806	PANEL,REAR PLASTIC	1
...	23		249590	KIT,REPLACEMENT AIR FITTINGS (INCLUDING) FTG,PLSTC/BRS STRAIGHT QDISC 1/4RC METRIC X 8MM OD FTG,AIR QUICK DISCONNECT FEMALE METRIC	1
...	24		235580	RECEPTACLE,FASTENER QUARTER TURN STUD RIVETED	1
...	25		237021	WASHER,INSULATOR KEYED TWIST LOCK RECEPTACLE	1
...	26		+234797	CASE SECTION,BASE/FRONT/REAR	1
...	27		237020	INSULATOR,RECEPTACLE TWIST LOCK (MINI-DINSE TYPE)	1
...	28		234841	RECEPTACLE,TWIST LOCK BRASS FEM PANEL MTG (MINI DINSE)	1
...	29		234895	LEAD ASSY,ELECT (TORCH RECPT TO CNTRL/SECNDRY BDS)	1
...	30		234805	PANEL,FRONT PLASTIC	1
...	31		234838	CABLE,WORK 20 FT 6 GA W/MALE (DINSE TYPE) CONN & CLAMP (INCLUDING)	1
...			213619	CLAMP,WORK 300 AMP STL CHROME PLD W/COP CONTACTS	1
...			213620	CONTACT TIP,WORK CLAMP 300AMP COPPER	2
...			127836	CONN,TW LK INSUL MALE(DINSE TYPE)25 SERIES	1
...			605520	STRIP,COP .010 X .750 XCOIL DEAD SOFT	1
...	31		234930	CABLE,WORK 50 FT 6 GA W/MALE (DINSE TYPE) CONN & CLAMP (INCLUDING)	1
...			213619	CLAMP,WORK 300 AMP STL CHROME PLD W/COP CONTACTS	1
...			213620	CONTACT TIP,WORK CLAMP 300AMP COPPER	2
...			127836	CONN,TW LK INSUL MALE(DINSE TYPE)25 SERIES	1
...			605520	STRIP,COP .010 X .750 XCOIL DEAD SOFT	1
...	32		234132	ICE- 60T,20FT HAND HELD TORCH (REPLACEMENT)	1
...	32		234134	ICE- 60T,50FT HAND HELD TORCH (REPLACEMENT)	1
...	33		234829	KIT,ICE- 60T QUICK DISCONNECT HOUSING REPLACEMENT (W/O PINS)	1
...	34		174992	KNOB,POINTER .840 DIA X .250 ID W/SPRING CLIP-.21	1
...	35		238453	SWITCH,CUT/GOUGE W/LEADS	1
...	36		234155	NAMEPLATE	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.
Serial number is on rating card located on bottom (outside) of unit. Model number is on nameplate located on front of unit.

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
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Figure 11-1. Main Assembly (Continued)

... 37		238770	.. INSULATOR, SWITCH POWER	1
... 38	S1	128755	.. SWITCH, POWER	1
... 39		237651	.. PLATE, COVER REMOTE	1
... 40	PV1	238537	.. VALVE ASSY, W/TRANSDUCER (INCLUDING)	1
		234169	.. VALVE ASSY W/O TRANSDUCER	1
	PC5	241301	.. KIT, REPLACEMENT CIRCUIT CARD ASSY PRESSURE SWITCH	1
	PS1	236003	.. SENSOR, PRESSURE 0-100MV DC/0-100PSI	1
... 41		236002	.. FILTER, AIR W/FTG & BRACKET	1
		227877	.. FILTER, AIR ELEMENT	1
... 42	PC4	250931	.. KIT, SECONDARY INTERCONNECT BD REPLACEMENT (Prior to MB270001P)	1
... 42	PC4	249920	.. CIRCUIT CARD ASSY, INTRCNCTNG SECONDARY 60A (Eff w/MB270001P)	1
... 43		238275	.. BRACKET, RESISTOR SECONDARY SNUBBER	1
... 44	R2	236234	.. RESISTOR, WW FXD 75 W 25 OHM NI 5% W/LEADS (Prior to MB270001P)	1
... 44	R2	251703	.. RESISTOR, WW FXD 50 W 25 OHM NI 5% W/STAND-OFFS (Eff w/MB270001P)	1
		236918	.. COVER ASSY (INCLUDING)	1
... 45		+234893	.. WRAPPER	1
... 46		234129	.. LABEL, WARNING PRECAUTIONARY PLASMA CUTTING EQUIP.	1
... 47		234130	.. LABEL, WARNING PRECAUTION PLASMA CTNG EQUIP SPANISH	1
... 48		208015	.. HANDLE, RUBBERIZED CARRYING	1
... 49		189784	.. INSULATOR, WRAPPER	1
... 50		247822	.. CKT, SPECTRUM 875	1
... 51		237017	.. LABEL, AIR PRESSURE 90-120PSI/621-827kPa	1
... 52		208622	.. LABEL, WARN ELECT SHOCK/EXPLOD PARTS/DO NOT REMOVE	1
... 53		234843	.. LABEL, ICE- 60T CONSUMABLES	1
... 54		196143	.. CAPACITOR, POLYP MET FILM 16. UF 400 VDC 10%	1
... 55		247530	.. BRACKET, CAPACITOR	1
... 56		109056	.. CORE, FERRITE E 2.164 LG X 1.094 HIGH X .826 WIDE	1
... 57		089899	.. LATCH, SLIDE FLUSH STYLE SERIES 40	1
... 58		234837	.. FTG, PLSTC/BRS ELBOW QDISC 3/8 OD X 5/16 OD TBG	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered. Serial number is on rating card located on bottom (outside) of unit. Model number is on nameplate located on front of unit.

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.

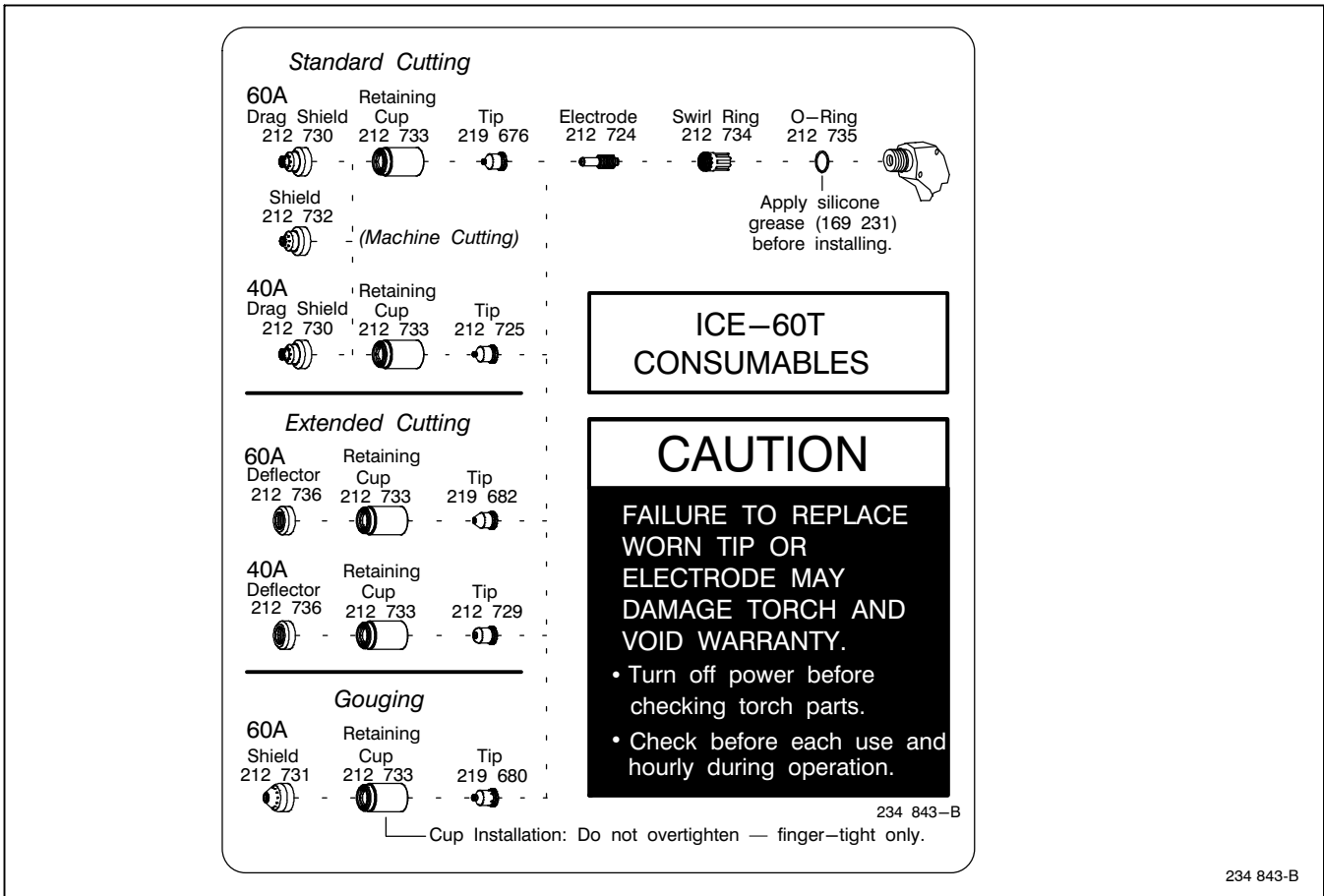


Figure 11-2. Consumable Parts For ICE-60T

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model (located on nameplate on front of unit) and serial number (located on outside bottom of plasma cutter base) is required when ordering parts from your local distributor.

Item No.	Part No.	Description
1	215 594	Handle w/Screws (1)
2	215 478	Kit, cup sensor (1)
3	215 479	Torch Head Repair Kit (1)
4	185 833	Switch Assy w/Spring (1)
5	190 220	Trigger Spring (1)
6	215 592	Switch Trigger (1)
7	215 477	Main Body (1)
8	234 170	Torch Lead, replacement w/quick disconnect 20ft (1)
8	234 171	Torch Lead, replacement w/quick disconnect 50ft (1)

Item No.	Part No.	Description
9	215 606	Clip, retaining (1)
10	212 735	O-Ring, main body (1)
11	234 829	Kit, ICE 60T/TM quick connect w/wing head fastener (1)
	169 231	Grease, silicon
	234 132	Torch, replacement 20ft (1)
	234 134	Torch, replacement 50ft (1)

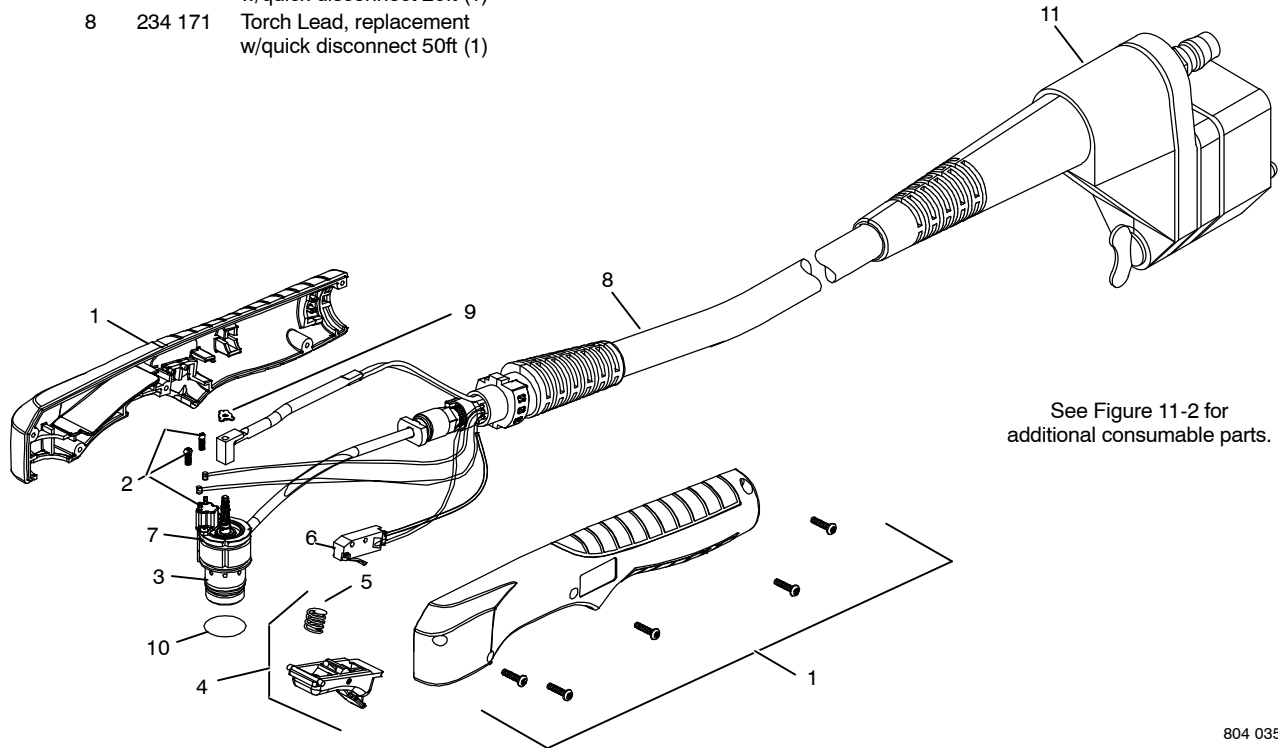


Figure 11-3. Torch, ICE-60T

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model (located on nameplate on front of unit) and serial number (located on outside bottom of plasma cutter base) is required when ordering parts from your local distributor.

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