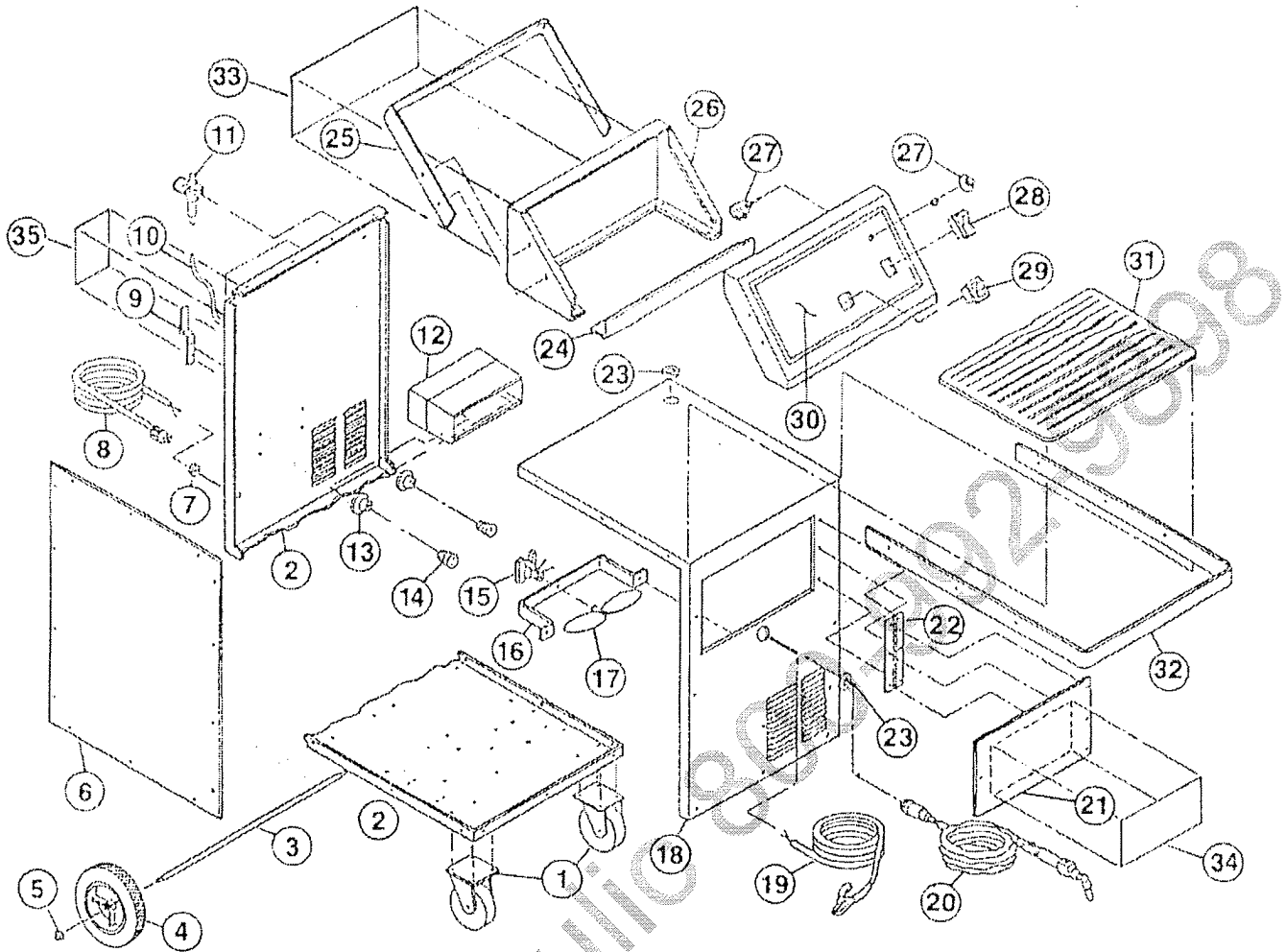


CONTROL PANEL & GENERAL CABINET

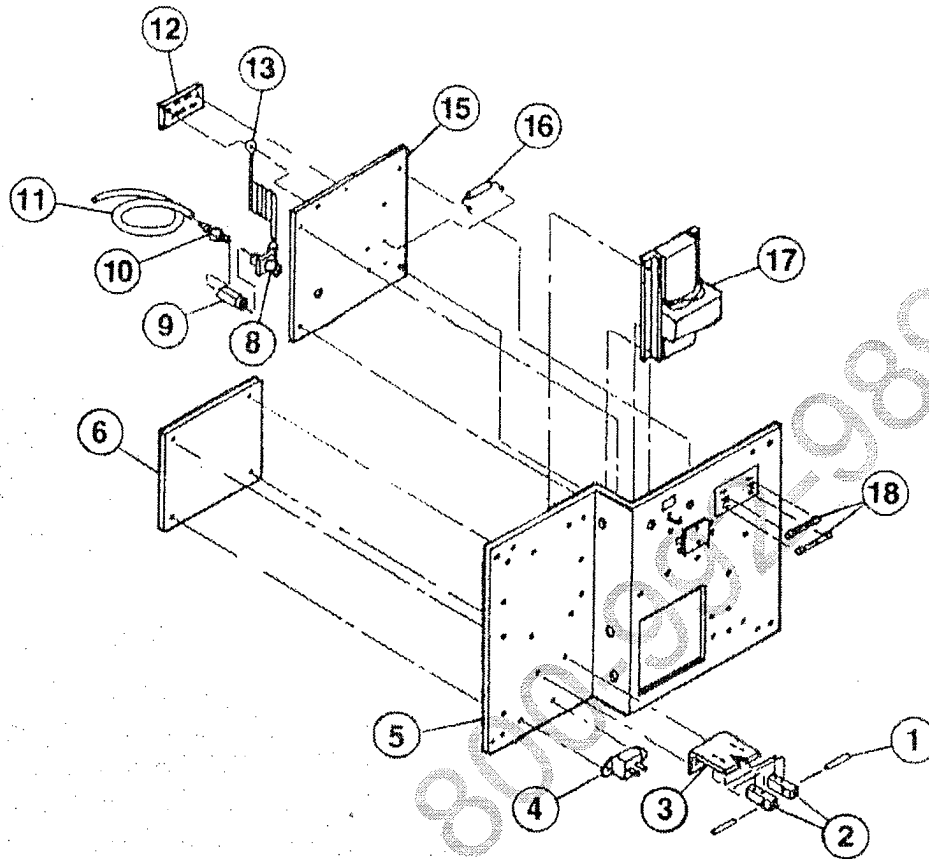


Code No.	Part Number	Description	No. Req.
1	32900029	Caster	2
2	B7172950	Cabinet Base & Back (Marquette)	1
	B7173950	Cabinet Base & Back (NAPA)	1
3	20700055	Axle	1
4	62964321	Wheel	2
5	69940980	Palnut	2
6	B7367619	L.H. Panel (Marquette)	1
6	B7366619	R.H. Panel (Marquette)	1
	B7001360	L.H. Panel (NAPA)	1
	B7000360	R.H. Panel (NAPA)	1
7	48000008	Strain Relief	1
8	47000009	Power Cord	1
9	21000702	Power Cord Hook	2
10	38100024	Outer Hose	1
11	35000337	Pressure Regulator	1
	32300003	Pressure Gauge Only	1
12	95081856	Glocoil Shield	1
13	44000004	Receptacle	2
14	44000003	Glocoil Heater	2
15	44200016	Fan Motor	1
16	21000365	Fan Bracket	1
17	39900159	Fan Blade	1

Code No.	Part Number	Description	No. Req.
18	B7114210	Cabinet Front & Top (Marquette)	1
	B7115210	Cabinet Front & Top (NAPA)	1
19	93460368	Negative Cable Assembly	1
20	15559	Torch Assembly (Marquette)	1
	83339	Torch Assembly (NAPA)	1
21	B7118210	Access Panel (Marquette)	1
	B7119210	Access Panel (NAPA)	1
22	B7120210	Hinge (Marquette)	1
	B7121210	Hinge (NAPA)	1
23	31100033	Grommet	2
24	B7116210	Angle	1
25	B7103201	Handie	1
26	B7117210	Control Panel	1
27	44800005	Neon Lamp	1
28	43600028	Power Switch	1
29	43600045	Setup/Run Switch	1
30	61986731	Switch Plate (Marquette)	1
	61986806	Switch Plate (NAPA)	1
31	39900182	Rubber Mat	1
32	B7104201	Cabinet Handle	1
33	61986918	Warning Decal	1
34	61986919	Warning Decal	1
35	61986766	Input/Output Decal	1

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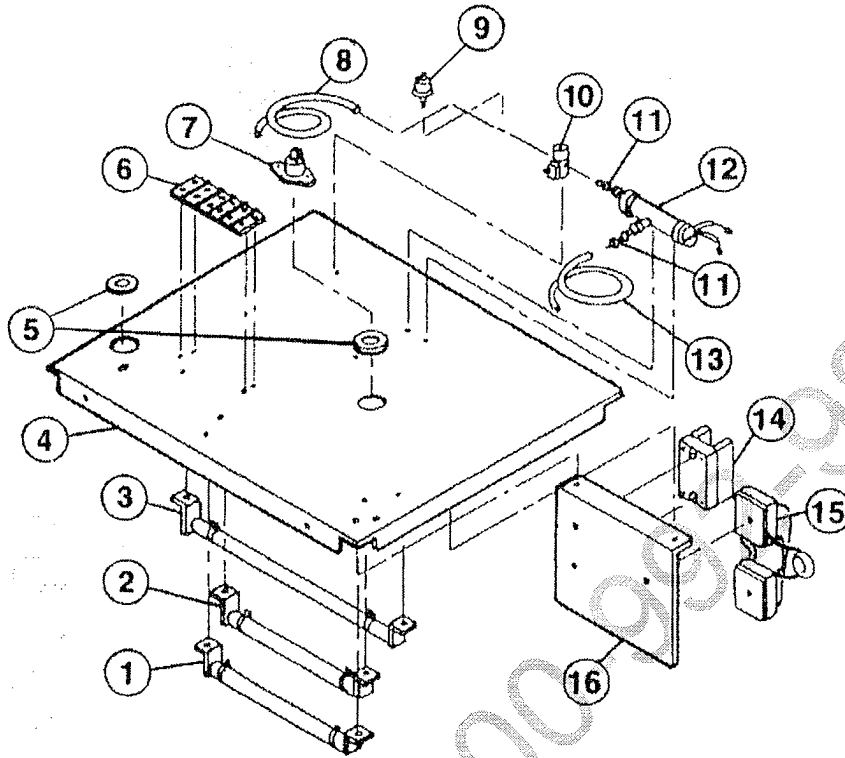
INTERFACE PANEL ASSEMBLY



Code No.	Part Number	Description	No. Req.
1	19000021	Spark Gap Electrode	2
2	21101066	Spark Block	2
3	21500047	Mounting Bracket	1
4	40400032	Mica Capacitor	1
5	95081837-191	Interface Panel	1
6	37001199	Control Board	1
8	37100018	Torch Connector	1
9	37100024	Coupling	1
10	37100016	Hose Connector	1
11	38100023	Inner Hose	1
12	B7005935	Sense Coil Assy. - PCB	1
13	95081882	Air Coil Assembly	1
15	21500040	Mounting Plate	1
16	95081839	0.1 mfd Capacitor	4
17	41300022	Hi-Frequency Transformer	1
18	43900010	3.0 Amp Fuse, AGC, 250 V	2

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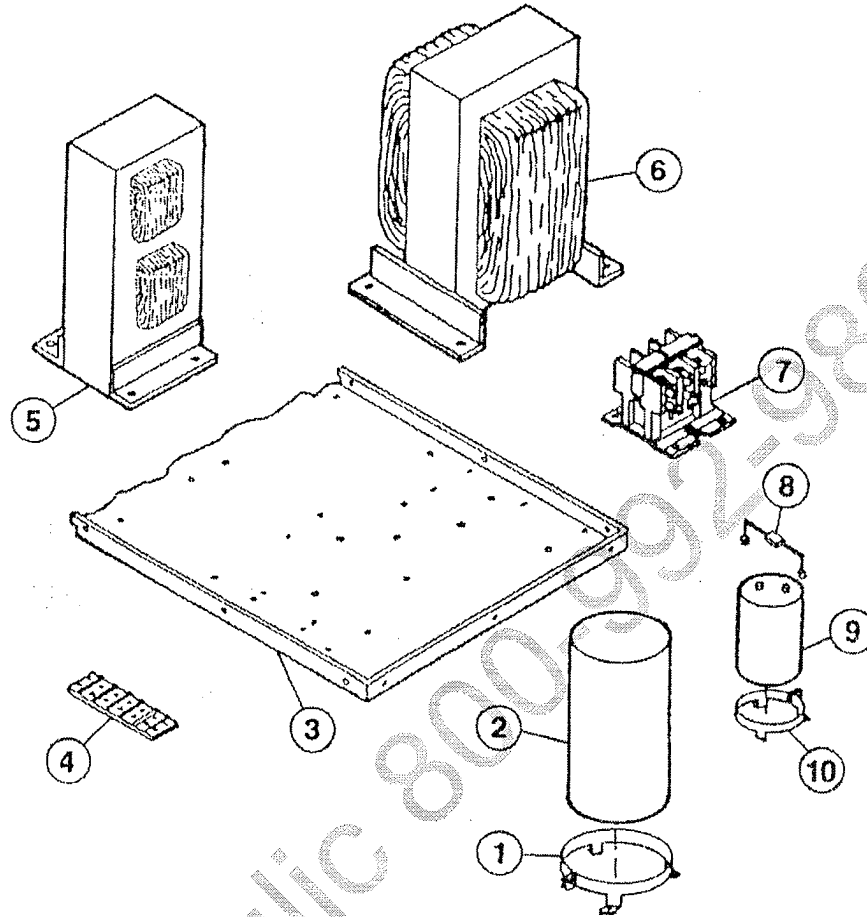
CENTER SHELF



Code No.	Part Number	Description	No. Req.
1	40000093	Resistor 100 OHM, 100W	1
2	40000094	Resistor 60 OHM, 100W	1
3	40000095	Resistor 160 OHM, 375W	1
4	21000666-191	Center Shelf	1
5	66540686	Grommet	2
6	46500034	Terminal Block	1
7	43600046	Thermal Switch	1
8	38100024	Outer Hose	1
9	43600039	Pressure Switch	1
10	43700009	Solenoid	1
11	37100017	Reducer	2
12	95081920	Flow Switch	1
13	38100023	Inner Hose	1
14	216-055-666	Solid State Relay	1
15	B7004935	Bridge Rectifier Assy.	1
16	21000706	Heat Sink	1

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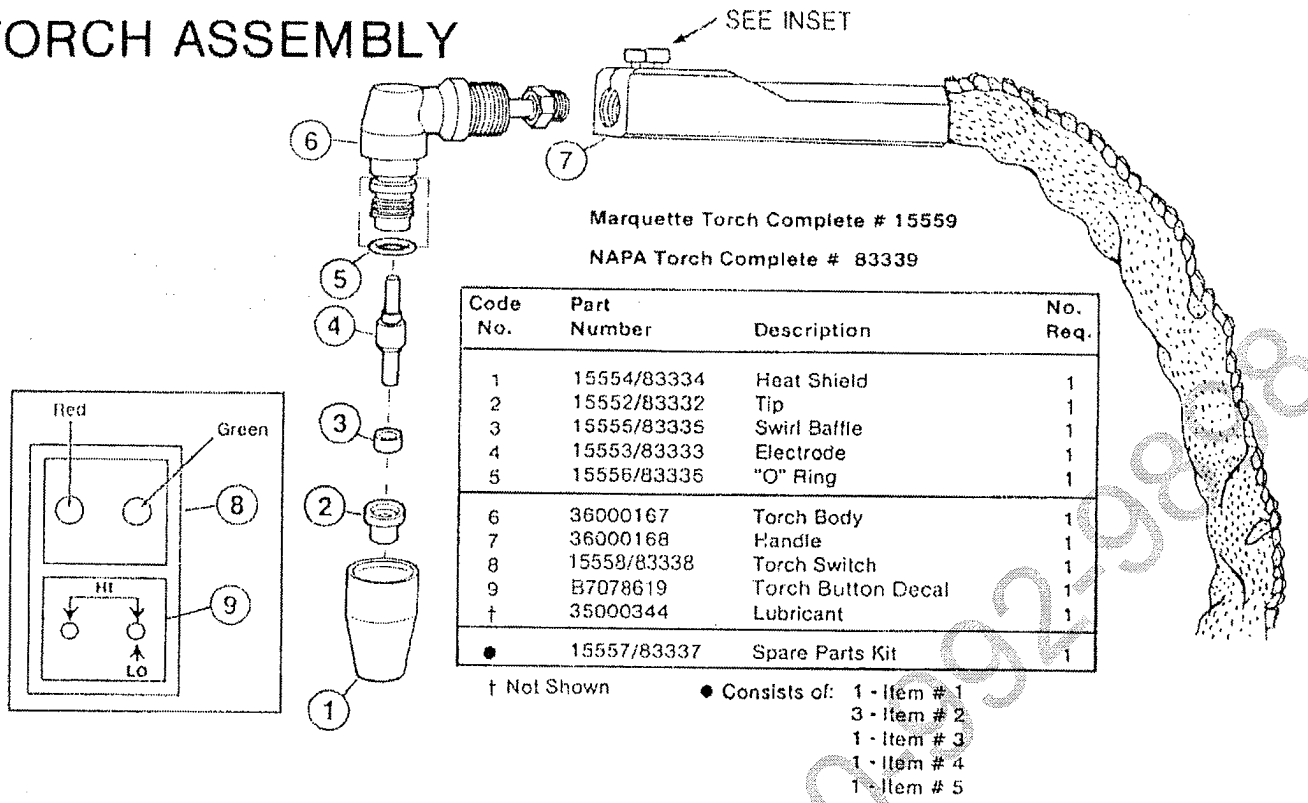
BOTTOM SHELF



Code No.	Part Number	Description	No. Req.
1	40400028	Capacitor Mfg Bracket	1
2	40400030	Capacitor	1
3	87172950	Cabinet Base & Back (Marquette)	1
	87173950	Cabinet Base & Back (NAPA)	1
4	46500034	Terminal Block	1
5	95081578	Transformer Assembly	1
6	95081565	Reactor Assembly	1
7	43700019	Contactor	1
8	95081900	Resistor Assembly	1
9	40400035	Capacitor	1
10	40400037	Capacitor Mtg. Bracket	1

M12-200, 83-330, 4015, P10

TORCH ASSEMBLY



Marquette Torch Complete # 15559
 NAPA Torch Complete # 83339

Code No.	Part Number	Description	No. Req.
1	15554/83334	Heat Shield	1
2	15552/83332	Tip	1
3	15555/83335	Swirl Baffle	1
4	15553/83333	Electrode	1
5	15556/83336	"O" Ring	1
6	36000167	Torch Body	1
7	36000168	Handle	1
8	15558/83338	Torch Switch	1
9	B7078619	Torch Button Decal	1
†	35000344	Lubricant	1
●	15557/83337	Spare Parts Kit	1

† Not Shown

● Consists of: 1 - Item # 1
 3 - Item # 2
 1 - Item # 3
 1 - Item # 4
 1 - Item # 5

UNIT MAINTENANCE AND ADJUSTMENTS

The only routine maintenance required for the Plasma Cutting System is a thorough cleaning and inspection. The inspection and cleaning should be done on a regular basis, the frequency depending on the amount of usage and the environment in which the unit is operated.



WARNING

Power must be turned OFF and the unit DISCONNECTED from the wall receptacle before performing the following operations!

Clean the Unit

To clean the unit, remove the front handle, both side panels and blow out any accumulated dirt and dust with compressed air. If necessary, solvents that are suitable for cleaning electrical apparatus may be used.

Inspect Components

While the side panels are off, inspect the wiring in the unit, looking for any frayed

wires or loose connections that should be repaired. When checking interior components, pay particular attention to the area around the high frequency spark gap points since accumulated dirt in this area can weaken the high frequency starting cycle and cause poor main arc starting.

Adjust Spark Gap

To adjust the spark gap setting, open the front access door and with an offset screwdriver, loosen the set screw on bottom of the brass block until the electrode can be moved. Adjust one electrode until the proper gap of 0.022 inch (0.56 mm) is obtained. Secure the electrode by tightening the set screw. Close the front access door and keep it closed at all times.

Service Air Supply Regulator

Check the sediment bowl in the air supply regulator for water accumulation. Water may be drained out by pressing in on the stem of the drain valve. The filter inside the sediment bowl should be checked often and cleaned as required. If cleaning does not suffice, replace the filter.