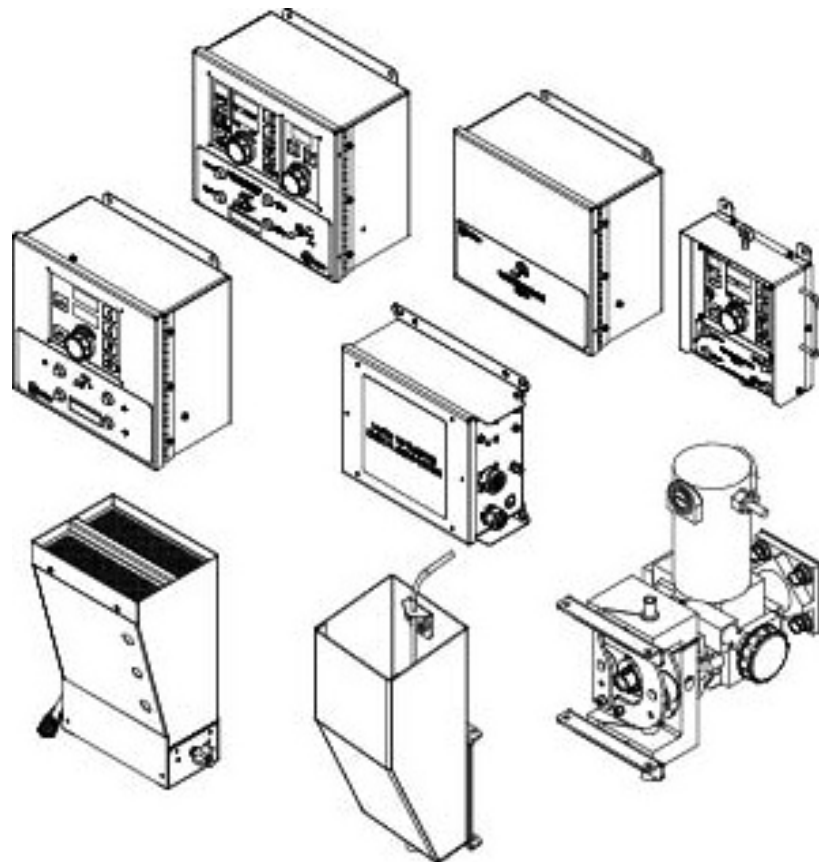




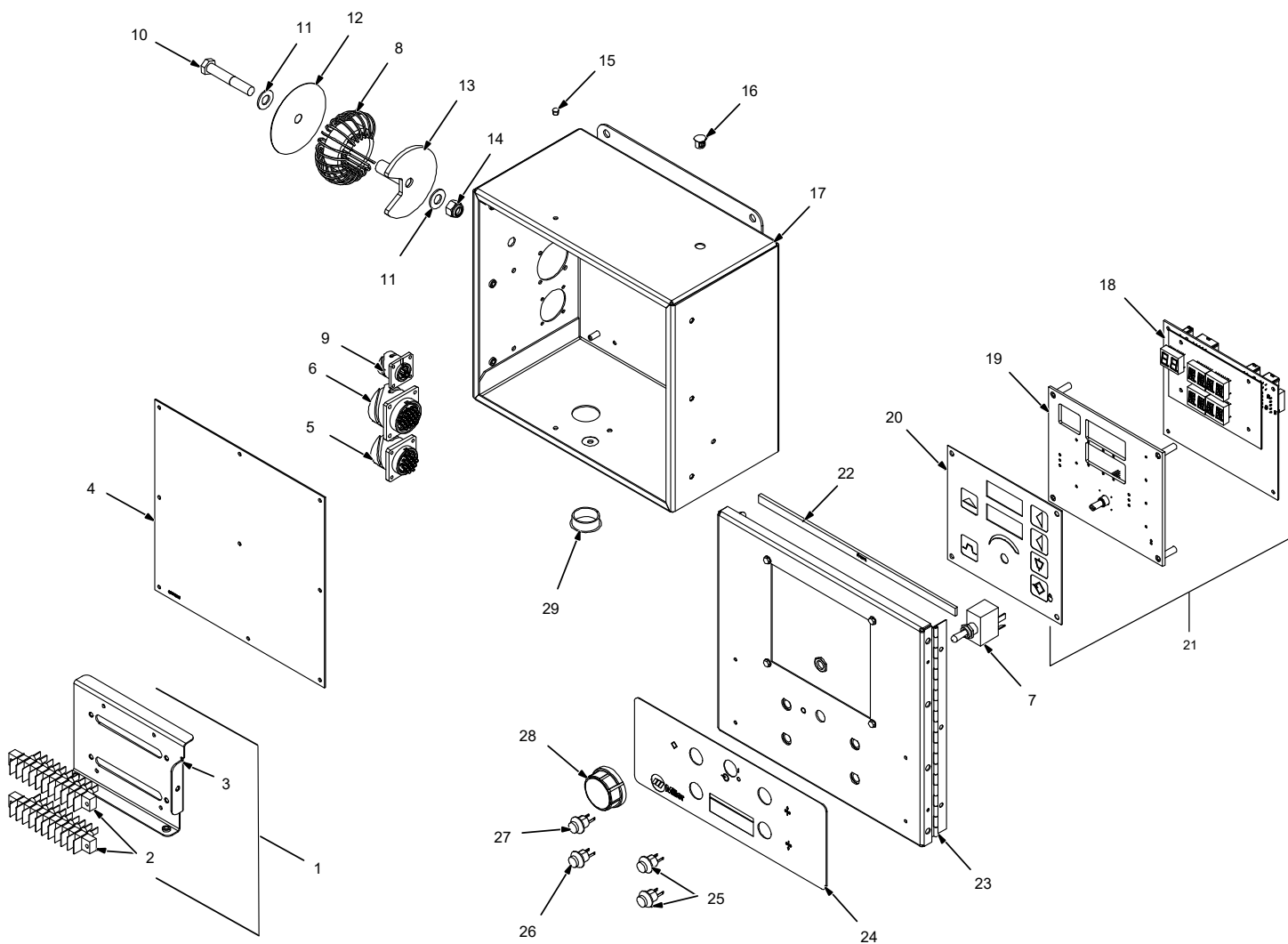
PM- 266727 D

SubArc System Digital Accessories CE

Effective with Serial Number
ME160358V - ZZ222222



PARTS MANUAL



SubArc Interface Digital

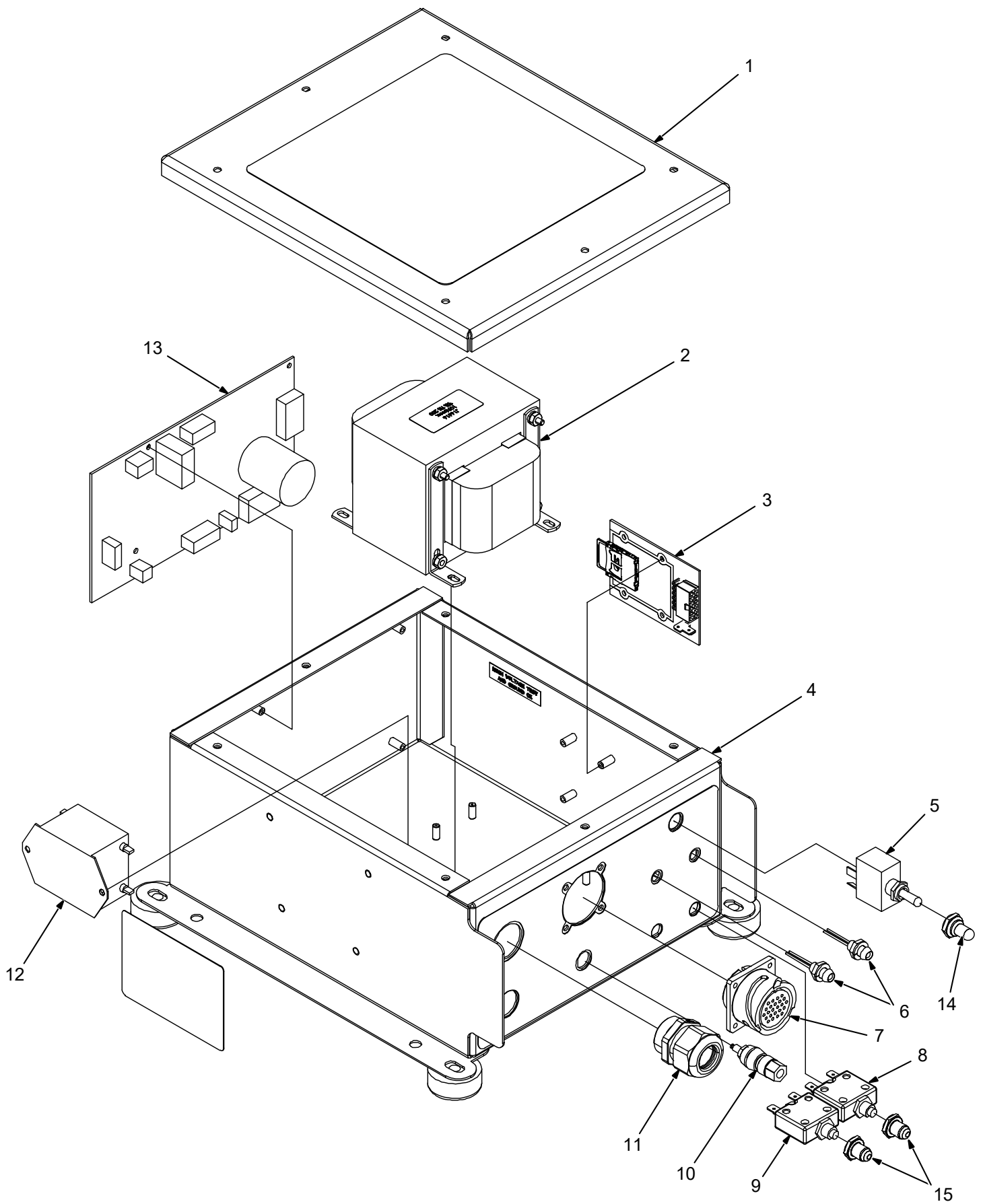
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		261083	↓ Assy, Terminal Blocks, Plugs & Bracket Subrc Intrfc (Includes)	1
2		261089	→ Block, Term 20 Amp 10 Pole Screw Term	2
3		261717	→ Bracket, Terminal Strip	1
4	PC1	253778	Circuit Card Assy, Motor Control w/Prgm SubArc Inte	1
5	RC2	260834	Plug Assy, Motor	1
6	RC1	260832	↓ Plugs & Receptacle Assy (Includes)	1
7	S1	028111	→ Switch, Tgl Dpst 20A 250V Spd Term	1
8			→ Choke, Common Mode Subarc Interface Digital	1
9	RC3	260870	Receptacle, w/Leads Flux Hopper	1
10		208794	Screw, .375-16 x .225 Hex Hd-pln Gr5 Pld	1
11		010910	Washer, Flat .406 Id x 0.812 Od x .065T Stl Pld Ansi .375	2
12		267778	Insulator, Mylar .014 x 3.000 Od x .375 Id	1
13		262545	Bracket, Mtg Common Mode Choke	1
14		010909	Nut, .375-16 .56Hex .46h Stl Pld Elastic Stop Nut	1
15		117860	Blank, Snap-in Nyl .187 Mtg Hole Black	5
16		057359	Blank, Snap-In Nyl .375 Mtg Hole Black	1
17		253833	Box Assy, Enclosure Subarc Controller	1
18	PC20	263963	Circuit Card Assy, Display/Micro w/Program →MH220169G	1
19	PC21	238273	Circuit Card Assy, Switches →MH220169G	1
20		236564	Overlay, Front Panel →MH220169G	1
21		279466	Kit, Circuit Card Assy Subarc UI MH220170H - ZZ222222	1
22		228274	Weatherstripping, Adh .125 x .375 x 10.750	1
23		265935	↓ Cover Assy, Box Enclosure Subarc System Interface D	1
24			→ Nameplate Order by Model and Serial Number	1
25	PB3, 4	202944	Switch, PB MC NO SPST 5A 115 Vac (Gray)	2
26	PB2	202945	Switch, PB MC NO SPST 5A 115 Vac (Red)	1
27	PB1	202946	Switch, PB MC NO SPST 5A 115 Vac (Green)	1
28		179851	Knob, Pointer 1.670 Dia x .250 Id Push On w/Spring	1
29		070371	Blank Snap-In Nyl 1.093/1.125Mtg Hole	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

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

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14-Pin To SubArc Digital Converter

14-Pin To SubArc Digital Converter

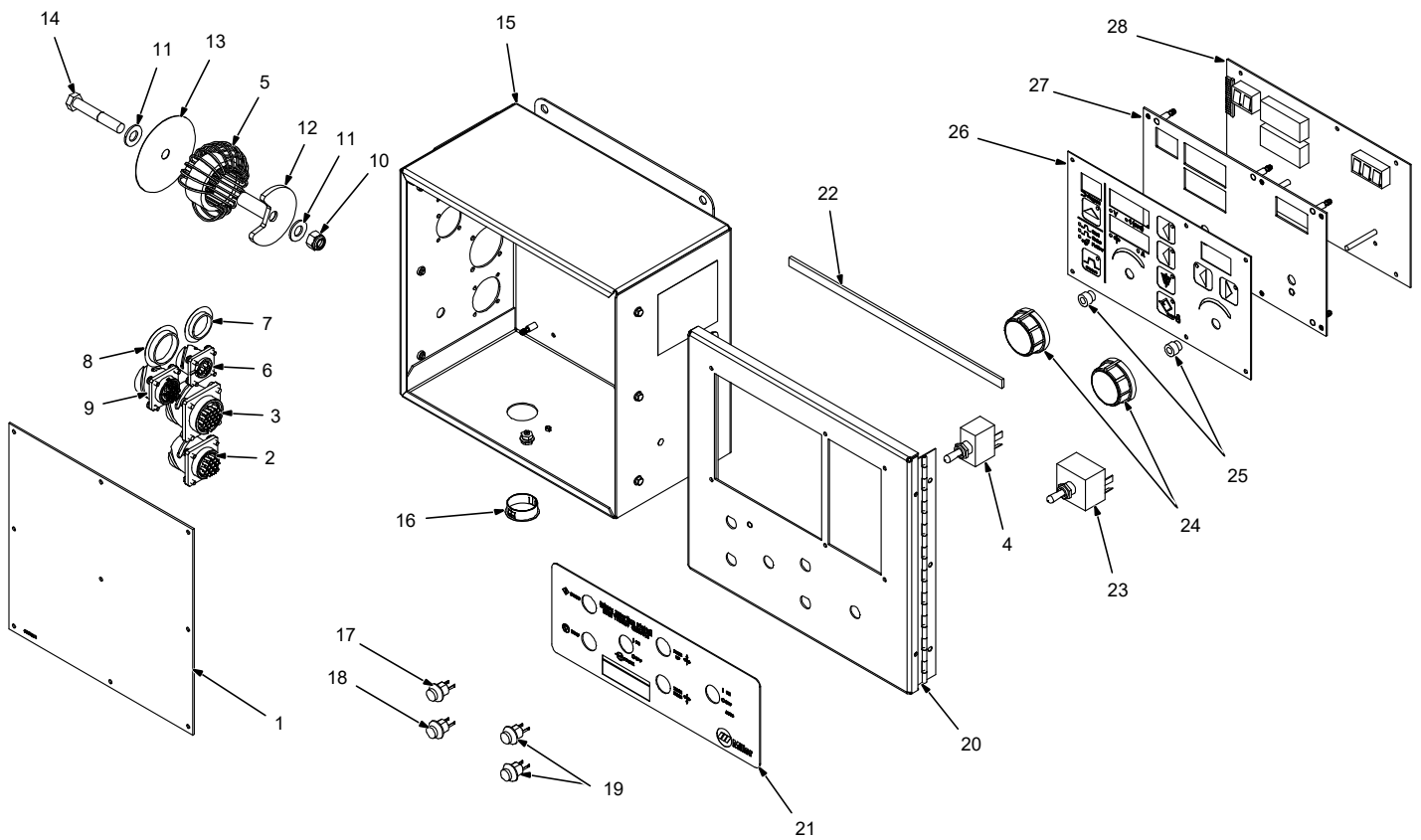
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		288068	Cover, Enclosure 14-Pin To SubArc Digital Converter	1
2		288259	Xfmr, 120 Vac Pri 24 Vac Sec 500Va	1
3	PC2	244477	Circuit Card Assy, SD Card	1
4		288066	Enclosure, 14-Pin To SubArc Digital Converter	1
5	S1	028111	Switch, Tgl Dpst 20A 250V Spd Term	1
6	LED1,LED2	288263	LED Assy, Plugs & Receptacle	2
7		260802	Conn, Circ Ms/Met 24Skt Size 24 Rcpt Pnl Sldr B/L	1
8	CB2	093996	Supplementary Pro, Man Reset 1P 20A 250 Vac Frict	1
9	CB1	083431	Circuit Breaker, Man Reset 1p 5A 250 Vac Frict	1
10		239737	Receptacle, Banana Jack Blk 10-32 Binding Post	1
11		139041	Bushing, Strain Relief .450/.709 Id x 1.115 Mtg Hole	1
12		289191	Filter, Line, Emi	1
13	PC1	286517	Circuit Card Assy, Control Board w/Program	1
14		021385	Boot, Toggle Switch Lever	1
15		190323	Boot, Circuit Breaker Clear Hex Nut	2
		288676	Cable, Power 47 Inches w/Strain Relief	1
		288264	Cable, Plug Assy, 14-Pin 53 Inches	1

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SubArc Tractor Interface Digital

SubArc Tractor Interface Digital

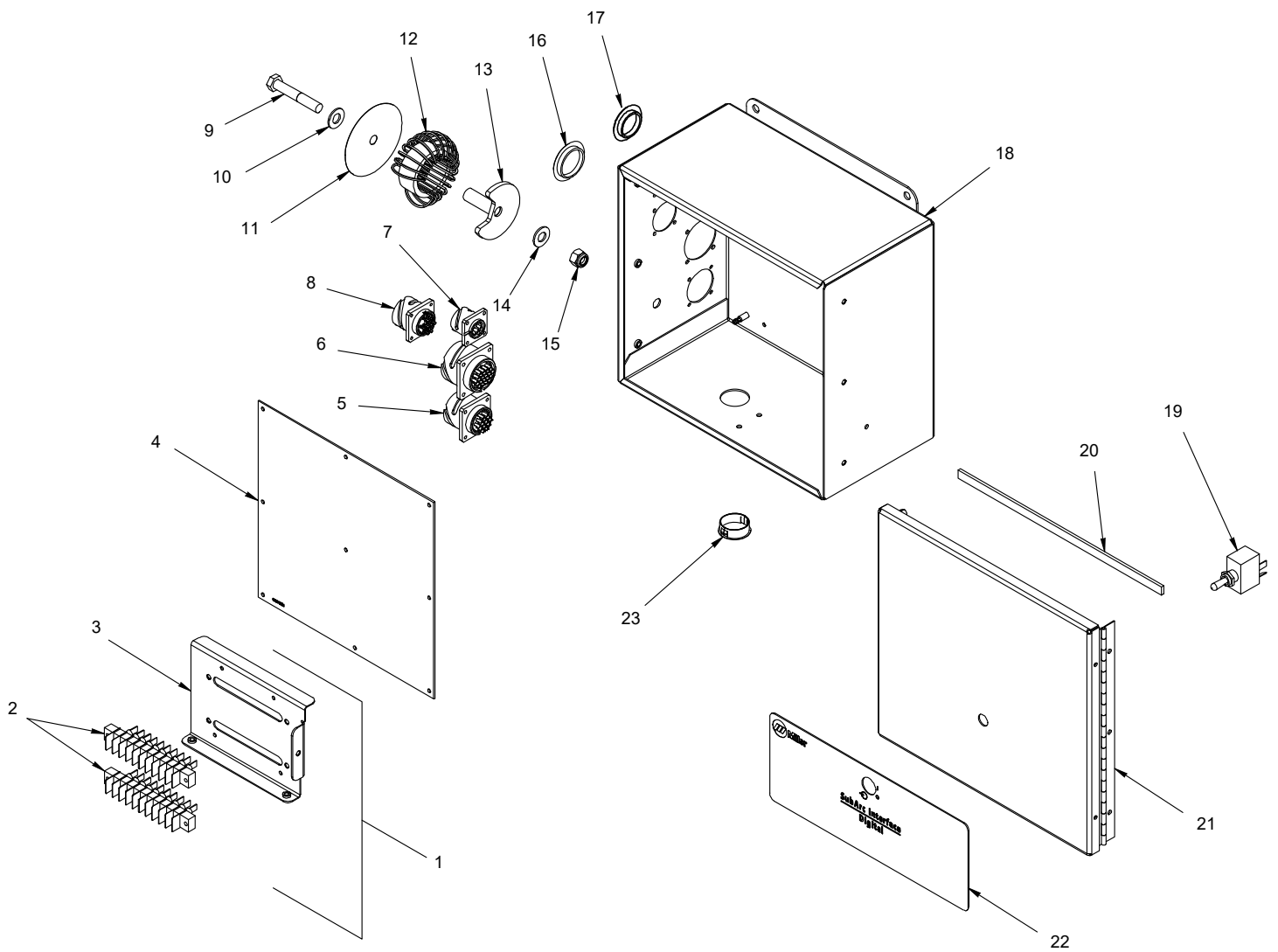
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1	PC1	253778	Circuit Card Assy, Motor Control w/Prgm SubArc Inte	1
2	RC2	260834	Plug Assy, Motor	1
3	RC1	260832	↓ Plugs & Receptacle Assy (Includes)	1
4		028111	→ Switch, Tgl Dpst 20A 250V Spd Term	1
5		267007	→ Choke, Common Mode	1
6	RC3	260870	Receptacle, w/Leads Flux Hopper	1
7		278356	Blank, Snap-In Nyl 1.000 Mtg Hole Black	1
8		277339	Blank, Snap-In Nyl 1.250 Mtg Hole Black	1
9		278201	Plug Assy, Tractor	1
10		010909	Nut, .375-16 .56Hex .46h Stl Pld Elastic Stop Nut	1
11		010910	Washer, Flat .406 Id x 0.812 Od x .065T Stl Pld Ansi .375	2
12		275199	Bracket, Mtg Common Mode Choke	1
13		267778	Insulator, Mylar .014 x 3.000 Od x .375 Id	1
14		208794	Screw, .375-16 x .225 Hex Hd-pln Gr5 Pld	1
15		277767	Box Assy, Enclosure Subarc Controller	1
16		070371	Blank Snap-In Nyl 1.093/1.125Mtg Hole	1
17	PB1	202946	Switch, PB MC NO SPST 5A 115 Vac (Green)	1
18	PB2	202945	Switch, PB MC NO SPST 5A 115 Vac (Red)	1
19	PB3-PB4	202944	Switch, PB MC NO SPST 5A 115 Vac (Gray)	2
20		265935	↓ Cover Assy, Box Enclosure Subarc System Interface D	1
21			→ Nameplate Order by Model and Serial Number	1
22		228274	Weatherstripping, Adh .125 x .375 x 10.750	1
23		011610	Switch, Tgl Spdt 15A 125 Vac	1
24		179851	Knob, Pointer 1.670 Dia x .250 Id Push On w/Spring	2
25		277995	Washer, Shldr .253 Id .370 Od x .2T .469 Od x .250T	2
26		275233	Overlay, Front Panel Tractor	1
27		277724	Backing Plate Assy, Membrane Panel SubArc Tractor	1
28		275111	Circuit Card Assy, Tractor Control w/Program	1

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SubArc Motor Control Digital

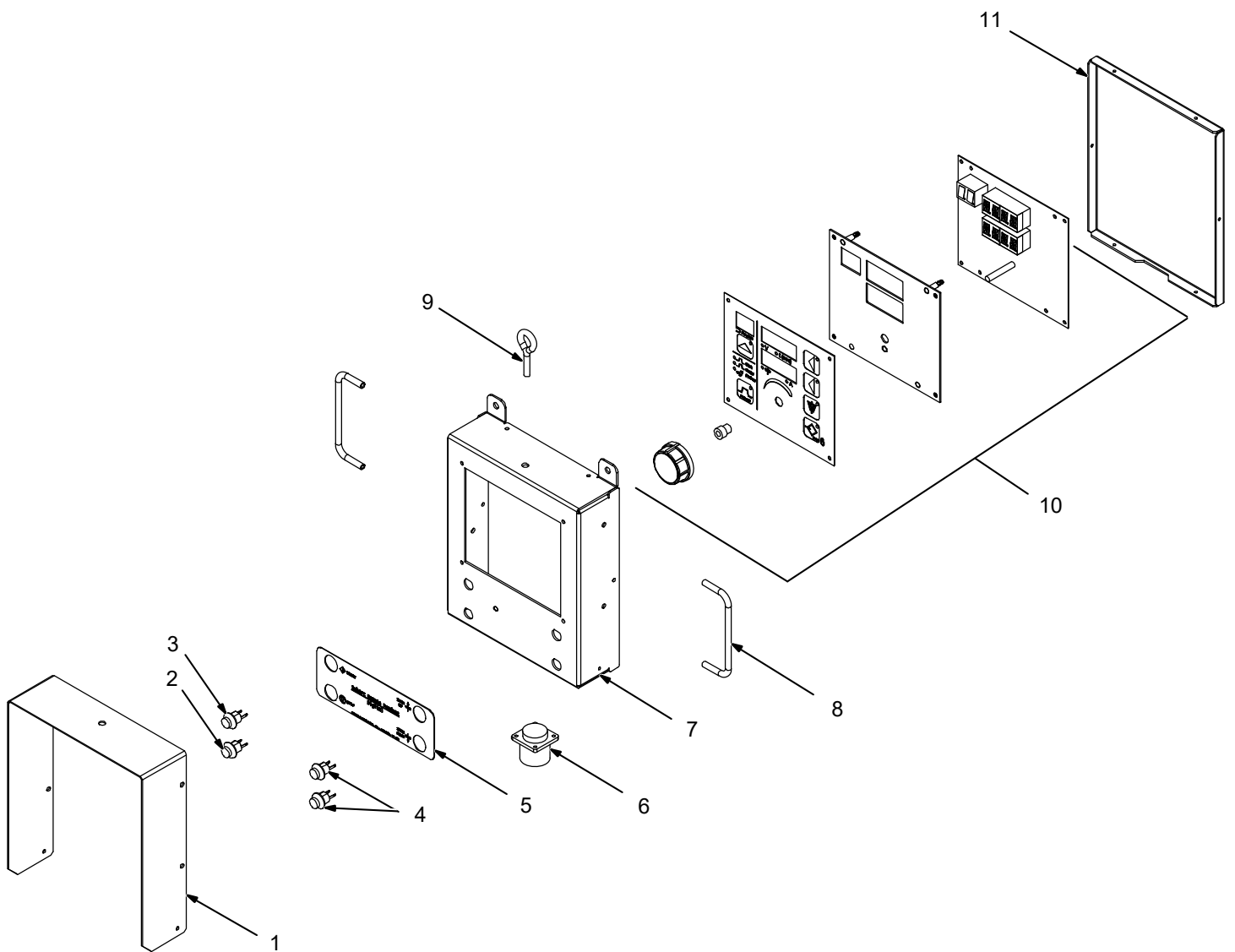
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		261083	Assy, Terminal Blocks, Plugs & Bracket Subrc Intrfc (Includes)	1
2		261089	Block, Term 20 Amp 10 Pole Screw Term	2
3		261717	Bracket, Terminal Strip	1
4	PC1	253778	Circuit Card Assy, Motor Control w/Prgm SubArc Inte	1
5	RC2	260834	Plug Assy, Motor	1
6	RC1	260832	Plugs & Receptacle Assy (Includes) (Includes Items 12 And 19)	1
7	RC3	260870	Receptacle, w/Leads Flux Hopper	1
8		277412	Plug Assy, Pendant Connector	1
9		208794	Screw, .375-16 x .225 Hex Hd-pln Gr5 Pld	1
10		010910	Washer, Flat .406 Id x 0.812 Od x .065T Stl Pld Ansi .375	2
11		267778	Insulator, Mylar .014 x 3.000 Od x .375 Id	1
12		267007	Choke, Common Mode (Included w/No6)	1
13		275199	Bracket, Mtg Common Mode Choke	1
14		010910	Washer, Flat .406 Id x 0.812 Od x .065T Stl Pld Ansi .375	2
15		010909	Nut, .375-16 .56Hex .46h Stl Pld Elastic Stop Nut	1
16		277339	Blank, Snap-In Nyl 1.250 Mtg Hole Black	1
17		278356	Blank, Snap-In Nyl 1.000 Mtg Hole Black	1
18		277767	Box Assy, Enclosure Subarc Controller	1
19	S1	028111	Switch, Tgl Dpst 20A 250V Spd Term (Included w/No6)	1
20		228274	Weatherstripping, Adh .125 x .375 x 10.750	1
21		277341	Cover Assy, w/Label Sbrc Mtr Cntrl Dgtl Ce	1
22			Nameplate, Order By Model And Serial Number	1
23		070371	Blank Snap-In Nyl 1.093/1.125Mtg Hole	1

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SubArc Remote Pendant Digital

SubArc Remote Pendant Digital

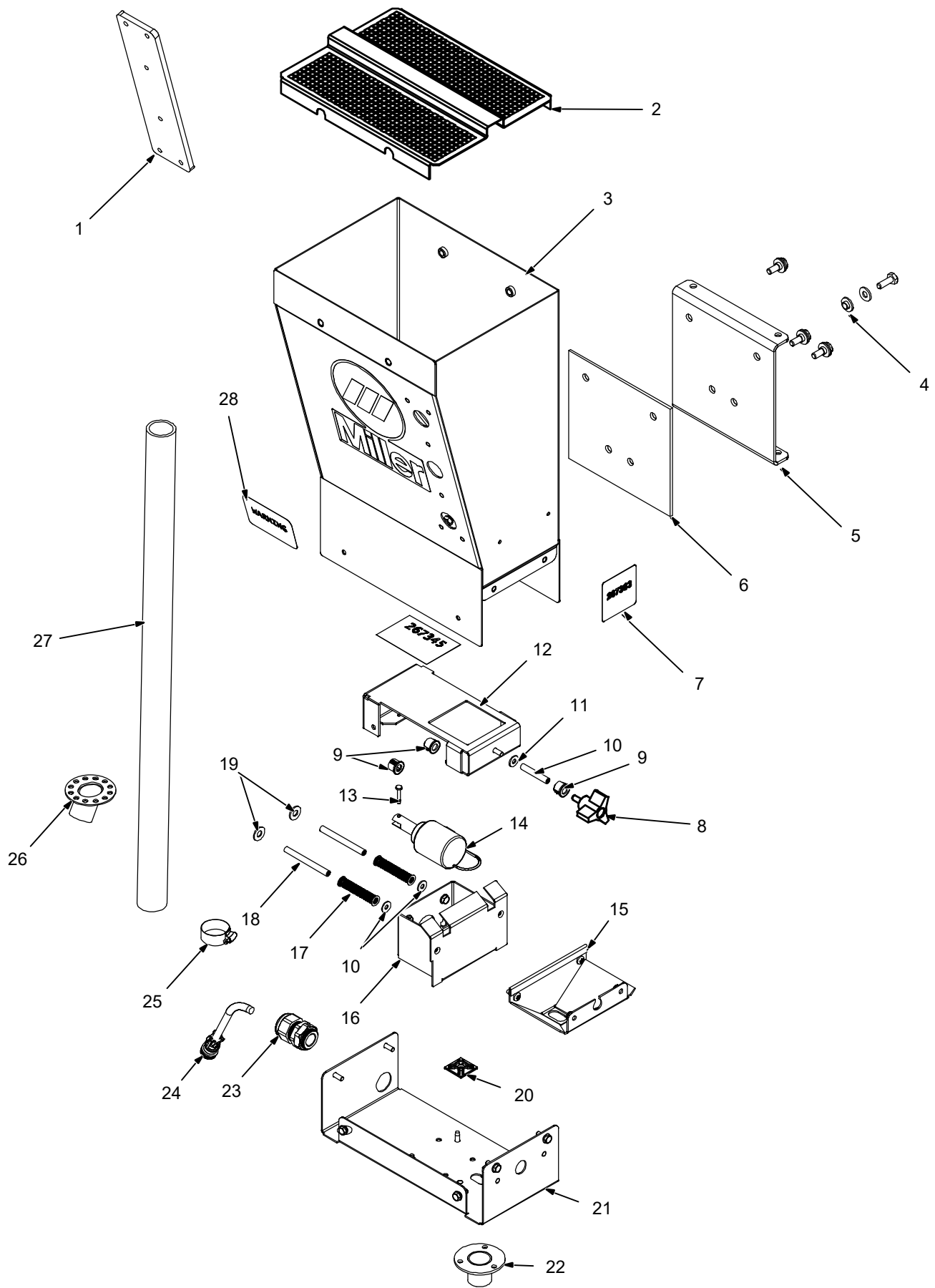
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		277388	Shield, Bezel Subarc Remote Pendant Digital	1
2		202945	Switch, PB MC NO SPST 5A 115 Vac (Red)	1
3		202946	Switch, PB MC NO SPST 5A 115 Vac (Green)	1
4		202944	Switch, PB MC NO SPST 5A 115 Vac (Gray)	2
5			Nameplate (Order by Model and Serial No.)	1
6		277466	Plug Assy, Filter Board To Display Board & PB Switch	1
7		277394	Case Assy, Subarc Remote Pendant Digital	1
8		239978	Handle, Round Wire	2
9		277981	Eye Bolt, .250-20 x 1.00	1
10		277933	Assy, Subarc UI	1
11		277389	Cover, Rear Subarc Remote Pendant Digital	1

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Flux Hopper Main Assembly

Flux Hopper Main Assembly

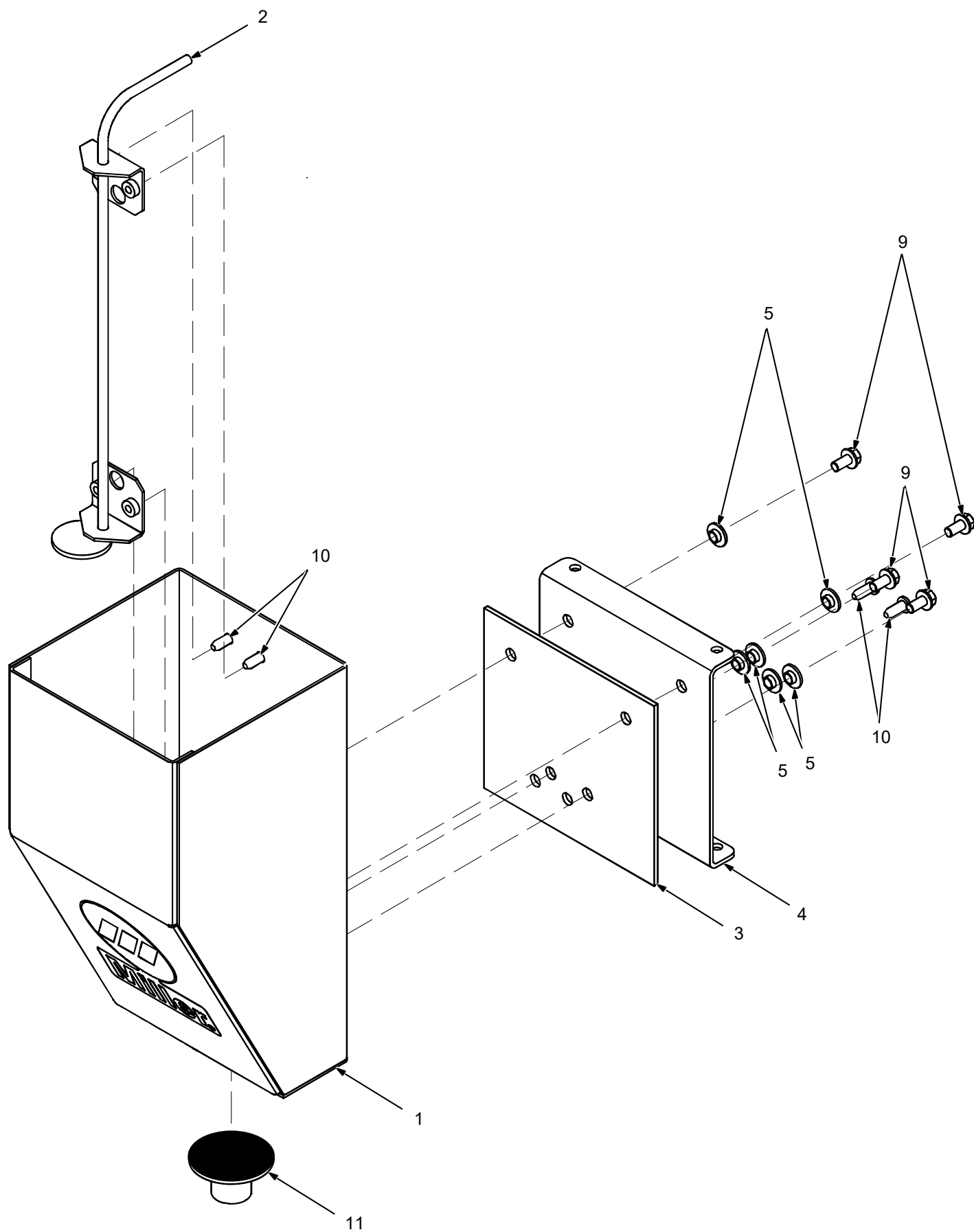
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		262464	Window, Flux Hopper	1
2		263002	Filter, Hopper	1
3		+ 265224	Weldment, Reservoir/Rear w/Front	1
4		208000	Washer, Shldr .260 Id 0.630 Od x .125T .327 Od x .062T Nyl	4
5		267490	Bracket, Mtg Flux Hopper	1
6		261088	Insulator, Phenolic	1
7		267363	Label, Caution Moving Parts	1
8		280232	Knob, Phenolic .875 Dia Fluted 10-32 x .750Lg Stl Stud	1
9		262983	Bushing, Snap-In Nyl .313 Id x .500 Mtg Hole	3
11		602238	Washer, Flat	3
12		266603	Valve Plate	1
13		262222	Pin, Clevis .12 Id x .750 Lg Ss	1
/		262223	Pin, Cotter Hair .125 Dia x 0.47 Wire x .500 Lg Sst	1
14		262984	Solenoid, DC w/Receptacle	1
15		262238	Collector, Flux	1
16		265203	Bracket, Flux Hopper Solenoid	1
17		262230	Spring, Cprsn .260 Id x .200 Lg .276 Lb/In Sst	2
18		262229	Stand-off, No 10-32 x 2.500 Lg .250 Od Sst Fem	2
19		163174	Washer, Flat .281 Id x 0.625 Od x.050T Sst	2
20		265229	Mount, Wire Adhesive	2
21		265225	Base, Valve Assy w/Pems	1
22		267539	Outlet, Hopper Straight	1
23		257544	Bushing, Strain Relief .230/.530 Id x .886 Mtg Hole D	1
24		267429	Cable, Flux Hopper Low Voltage	1
25		189674	Clamp, Hose .687 - 1.500 Clp Dia Sae #16	1
26		200439	Hose, 1.000 Id x 1/8 In Wall Flux Hopper	1
27		267536	Outlet, Hopper 30 Degrees	1
28		096858	Label, Warning Exposed Rays Can Burn Eyes And Etc	1

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Manual Flux Hopper Main Assembly

Manual Flux Hopper Main Assembly

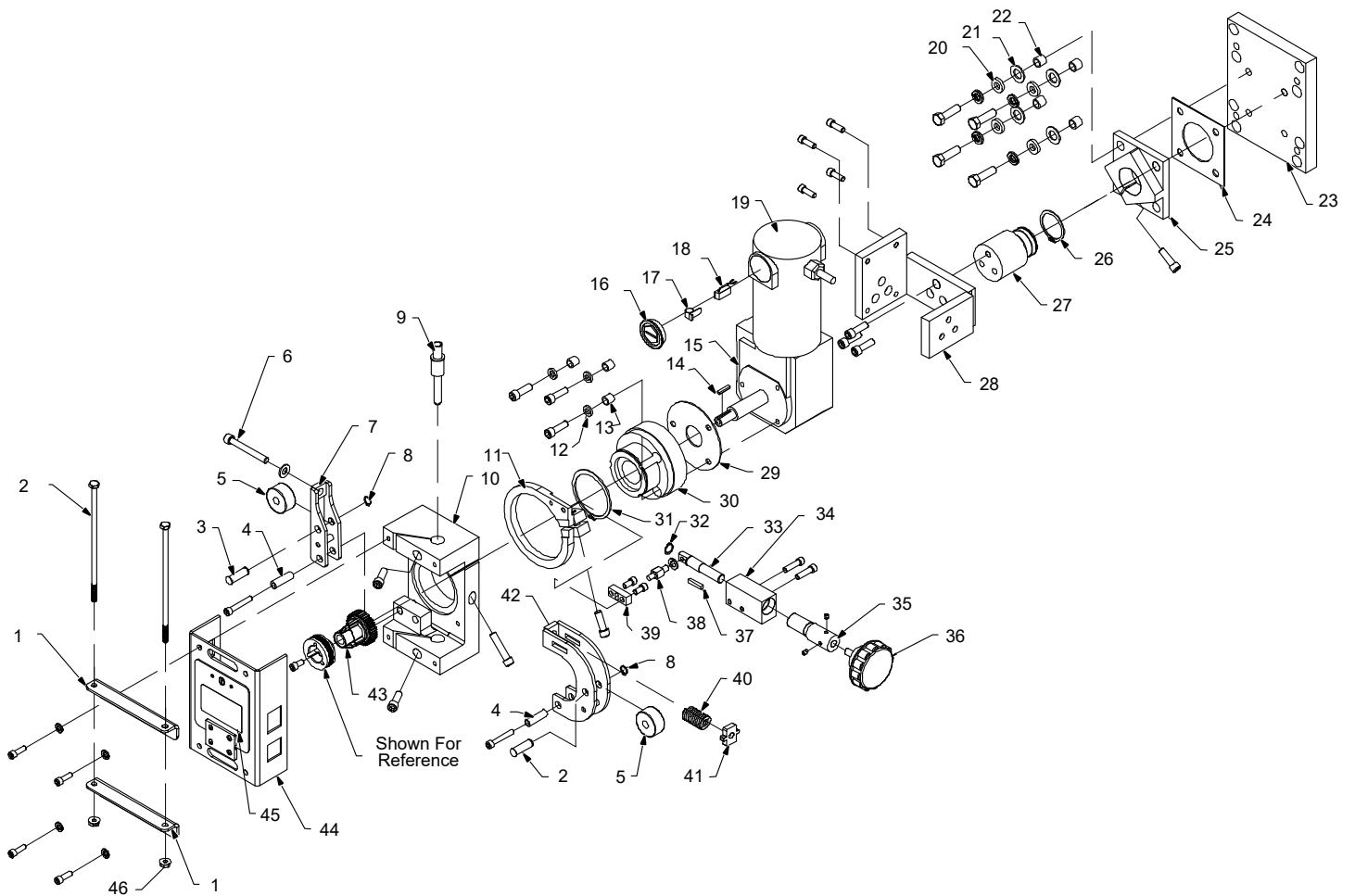
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		278468	Weldment, Reservoir/Rear w/Front	1
2		278476	Handle, Shutoff Assy	1
3		261088	Insulator, Phenolic	1
4		267490	Bracket, Mtg Flux Hopper	1
5		208000	Washer, Shldr .260 Id 0.630 Od x .125T .327 Od x .062T Nyl	6
/		601847	Nut, 010-32 .38 Hex .24H Stl Pld Elastic Stop Nut Blk	3
9		602154	Screw, .250-20 x .50 Hexwhd .50D Stl Pld Slffmg Tap-Rw	4
10		227147	Screw, .250-20 x .62 Pan Hd-Torx Stl Pld Blk Tap-R	4
11		267536	Outlet, Hopper 30 Degrees	1

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Wire Drive Main Assembly

Wire Drive Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		253407	Bracket, Mounting Flux Hopper	2
2		198680	Screw, 250-20 x .700 Hex Hd-Pln Gr5 Pld	2
3		253194	Pin, Bearing	2
4		253248	Standoff, Pressure Arm	2
5		199416	Ball Bearing, .750 x 1.378 x .394	2
6		253340	Screw, .312-18 x 250 Soc Hd-Hex Gr8 Pln	1
7		253217	Reaction Arm Assembly	1
8		198504	Ring, Retaining 5100-39	2
9			Inlet Wire Guide (Part Of Wire Straightener Kit 199733)	
10		253231	Block, SubArc Feed Head	1
11		232126	Assembly, Clamp Hub Rh	1
12		198508	Washer, Flat Nylon	3
13		198509	Spacer, Nylon	3
14		255068	Key, Stl .125 x .125 x .750	1
15		253235	↓ Motor, 1/5HP 38 Vdc 85 RPM 30:1 Ratio (Includes)	1
16		208089	→ Brush Cap, Motor	1
17		208088	→ Spring, Motor	1
18		255064	→ Brush, Motor	1
19		254790	→ End Shield, Motor w/Hall Effect Bd w/Leads	1
20		253258	Washer, Flat .375 Id x 0.750 Od x .156T Stl Pld Clr	4
21		253250	Washer, Insulating .515 Id x .938 Od x 0.62 Thk	4
22		253254	Insulator, Mtg Motor Hub Bracket	4
23		199414	Plate, Mtg Adapter	
24		253251	Insulator, Motor Hub SubArc	1
25		253249	Bracket, Motor Hub	1
26		198502	Ring, Retaining 5100-150	1
27		209665	Hub, Mounting Motor	1
28		209498	Assembly, Mounting Motor	1
29		198484	Insulator, Motor SubArc	1
30		198485	Hub, Motor Mount	1
31		198503	Ring, Retaining 5100-250	1
32		605308	Ring, Rtnng Ext .500 Shaft x .035 Thk	1
33		208391	Shaft, Manipulator	1
34		232125	Block, Handle Rh	1
35		198596	Adapter, Handle	1
36		199889	Knob	1
37		198590	Key, Stl .184 x .184 x .875	1
38		208392	Pin, Manipulator	1
39		198656	Insert, Manipulator	1
40		198507	Spring, .750 Od x .125	1
41		253192	Retainer, Spring	1
42		253179	Pressure Arm Assembly	1
43		172076	Carrier, Drive Roll w/Components Keyed 24 Pitch	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

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Wire Drive Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Qty
44		+ 253294	Guard Assy, Feed Roller	1
45		196956	Label, Warning Pinchless	1
46		089800	Nut, 250-20 .44Hex .22H Stl Pld .58D Flange Defor	2
/		199733	Wire Straightener 1/16-3/16 Wire, SAW	1

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Wire Size		Drive Roll Part No.
Fraction	Metric	
1/16 in. (.062 in.)	1.6 mm	132955
5/64 in. (.079 in.)	2.0 mm	132960
3/32 in. (.094 in.)	2.4 mm	132961
7/64 in. (.110 in.)	2.8 mm	132962
1/8 in. (.125 in.)	3.2 mm	132963
5/32 in. (.156 in.)	4.0 mm	193700
3/16 in. (.188 in.)	4.8 mm	193701