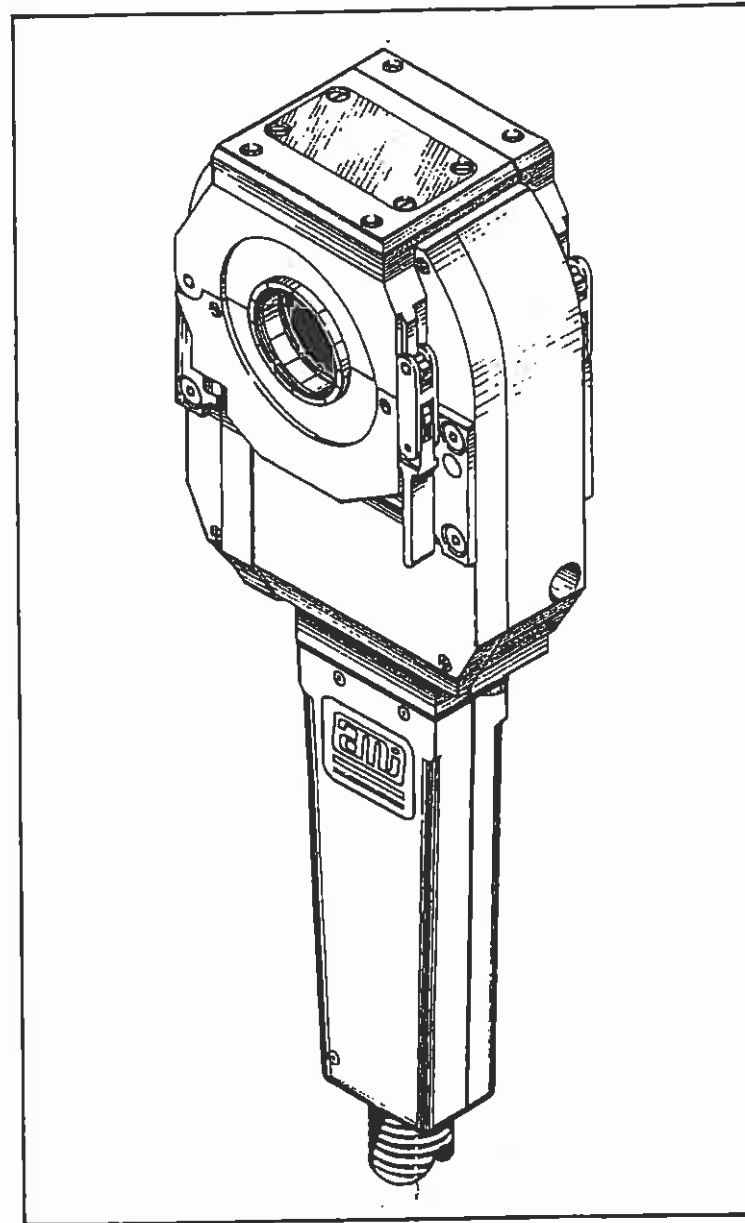




ARC MACHINES INC.



MODEL 9-2500

To be used for reference only
ILLUSTRATED PARTS BREAKDOWN


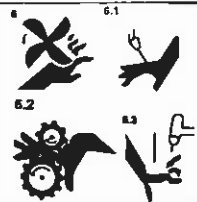

Property of Arc Machines, Inc.

MODEL 9-2500
IPB Notice and Revision History

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The nature of the GTAW process creates some POTENTIAL HAZARDS. In accordance with international safety regulations the EXCLAMATION SYMBOL indicates that this equipment is considered HAZARDOUS. The LIGHTNING FLASH SYMBOL indicates that there are potential electrical hazards. The display of these symbols makes it the OPERATOR'S RESPONSIBILITY TO ENSURE THAT THEY HAVE BEEN MADE AWARE OF and shall observe the hazardous conditions.

| | |
|---|--|
|  | WARNING: AMI factory training is essential for all Maintenance Technicians who operate AMI equipment. Do not operate or service this equipment without proper AMI approved training. |
|  | WARNING: Keep hands and fingers clear from moving parts such as fans, gears, rotors, Wire Feed, Weld Head Travel, i.e. Oscillation (OSC) and Arc Voltage Control (AVC) mechanisms Weld Head AVC and Oscillator Slide Assemblies develop high forces and it is possible, by their nature of operation, to harm any object or body part that may get into these areas. USE EXTREME CAUTION! |
|  | Electrical Shock Hazard: Always disconnect weld heads when servicing internal components or opening housing covers for access. |

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| REV | ECO # | CHANGE DESCRIPTION | DATE | BY | APR |
|-----|-------|---|---------|----|-----|
| A | 4678 | On 090114 Change Item 6 & 23 | 3/7/08 | SO | BF |
| B | 4784 | On IPB 090114, changed Item 129 to 13090124-02 was 42090174-11 | 5/21/08 | SO | BF |
| C | 4779 | Added rev D of 750015 | 5/26/08 | SO | BF |
| D | 5579 | Added rev F of 750015 and Wiring Diagram | 1/13/10 | CB | DC |
| E | 5753 | Added IPBs 090206-02 & -03, 0907128, 0907136 & 090800; Deleted IPB 090811, pg 4 of 090114 and removed cable parts | 10/6/10 | GB | DC |

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TABLE OF CONTENTS

DATE EFFECTIVE: 13 Jun 1994

PRODUCT MODEL: 9-2500
MANUAL NUMBER: 730018

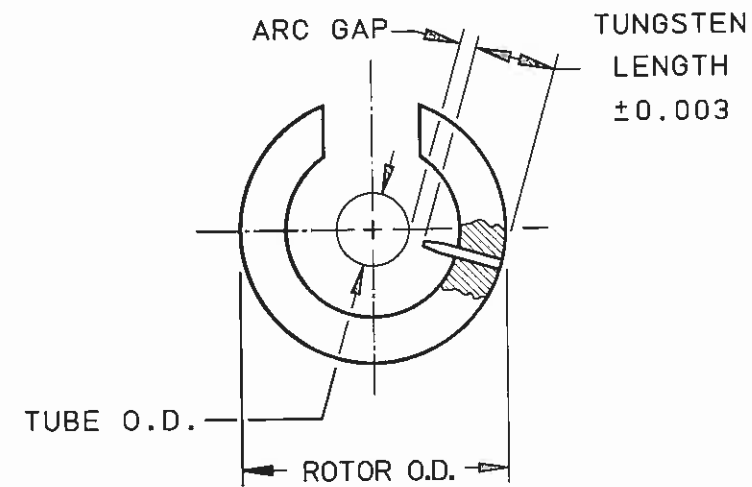
| IPB NUMBER | DESCRIPTION |
|-------------------|--|
| 750015 | MODEL 9 ELECTRODE DIMENSIONS |
| 090114 | MAIN ASSEMBLY |
| 090169 | M9AF-2500 WELD HEAD ASSEMBLY |
| 090514 | LOCATING ARM KIT |
| 090103 | MODEL 9E CONFIGURATION |
| 750031 | MODEL 9 CONVERSION TO MODEL 9E |
| 0901116 | MODEL 9EDL-2500 WELD HEAD ASSEMBLY |
| 090611 | MODEL 9EDL-2500 DRIVE UNIT ASSEMBLY |
| 090206 | MODEL 9EDL-2500 HOUSING UPPER ASSEMBLY |
| 090206-02 | MODEL 9-2500 (BOEING) HOUSING UPPER ASSEMBLY |
| 0907128 | MODEL 9-2500 (BOEING) ROTOR, 360 DEG SOLID ASSY |
| 090206-03 | MODEL 9-2500 (BOEING) HOUSING UPPER ASSEMBLY |
| 0907136 | MODEL 9-2500 (BOEING) ROTOR ASSY, 360 DEG (TUBIFLEX) |
| 090800 | MODEL 9 CABLE ASSEMBLY 10 FT |
| 175144-04 | MODEL 9 WELD HEAD WIRING DIAGRAM |

To be used for reference only

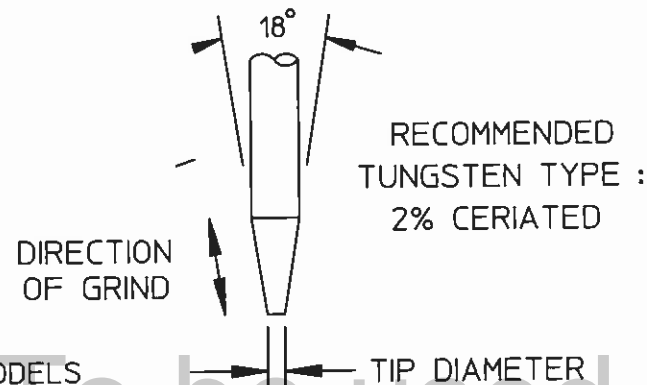
ELECTRODE DIMENSIONS

| ROTOR DIAMETER | |
|---|------------|
| MODEL NO. | ROTOR O.D. |
| 9-250 | 0.802 |
| 9-500/4-500 | 1.388 |
| 9-675 | 1.715 |
| 9M-750 | 1.312 |
| 9-750 | 2.000 |
| | |
| 9-1500 | 3.187 |
| 9AF-1500 | 2.252 |
| 9E-1500 | 2.687 |
| 8-2000 | 3.450 |
| 9-2500 | 4.380 |
| 9AF-2500 | 3.156 |
| 9E-2500 | 4.280 |
| | |
| * 9-3500 | 5.380 |
| 9E-3500 | 5.310 |
| 8-4000 | 5.310 |
| * 9-4500 | 6.875 |
| 9ER-4500 | 5.776 |
| 8-6625 | 8.094 |
| * 9-7500 | 10.440 |
| 9E-7500 | 9.375 |
| * FOR HEADS USING OPTIONAL TUNGSTEN EXTENDER, SEE PAGE 2. | |

$$\frac{\text{ROTOR O.D.} - \text{TUBE O.D.}}{2} - \text{ARC GAP} = \text{TUNGSTEN LENGTH}$$



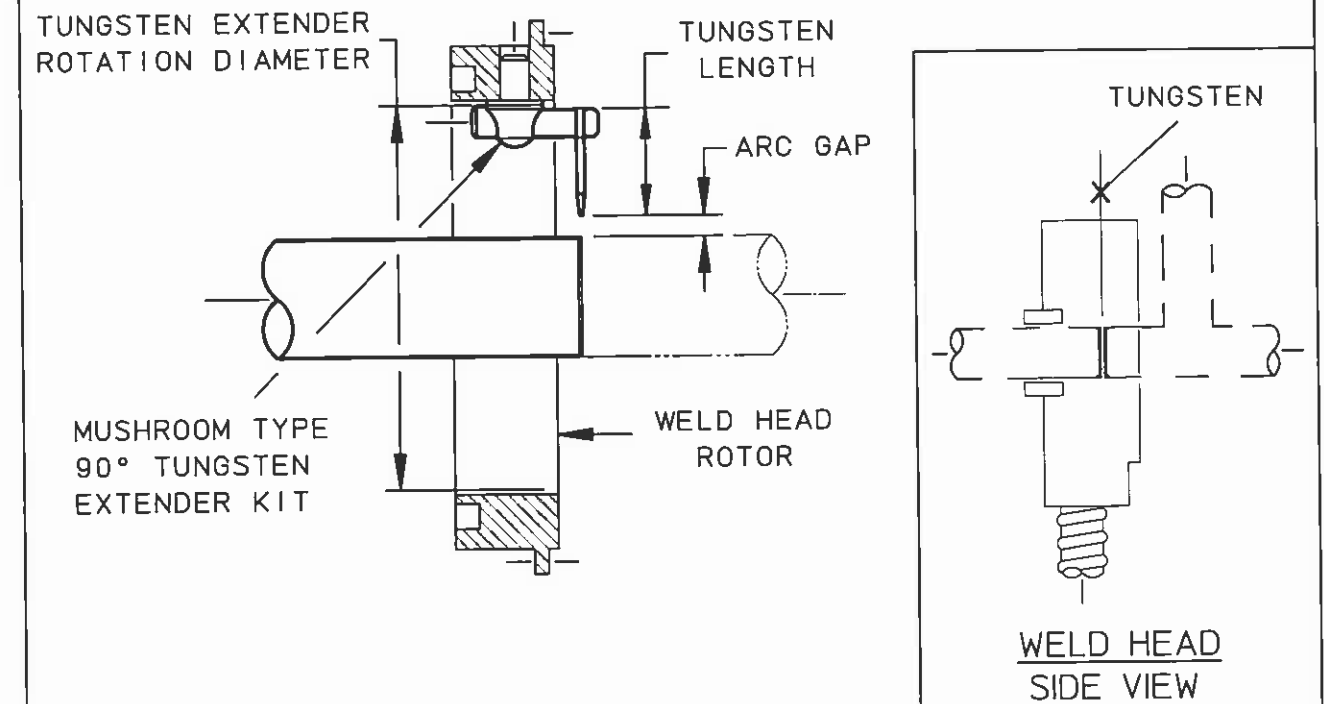
| TUBE/PIPE WALL THICKNESS | RECOMMENDED ARC GAP | RECOMMENDED TIP DIA. |
|--------------------------|---------------------|----------------------|
| 0.020/0.035 | 0.030 | 0.020 |
| 0.049/0.085 | 0.050 | 0.030 |
| 0.091/0.154 | 0.070 | 0.040 |



- NOTES:
1. RECOMMENDED ARC GAP FOR MODELS 4-500, 9-250 & 9-500 IS 0.045 MAXIMUM.
 2. IN INSTANCES WHERE OUT-OF-ROUNDNESS ON THIN-WALLED TUBING OCCURS (NORMALLY 2.500 O.D. OR LARGER), A 0.070 ARC GAP IS RECOMMENDED.
 3. DIMENSIONS ARE IN INCHES.

TUNGSTEN LENGTH CALCULATION FOR TUNGSTEN EXTENDERS

$$\frac{\text{EXT. ROTATION DIA} - \text{TUBE O.D.}}{2} - \text{ARC GAP} = \text{TUNGSTEN LENGTH} \pm 0.003$$



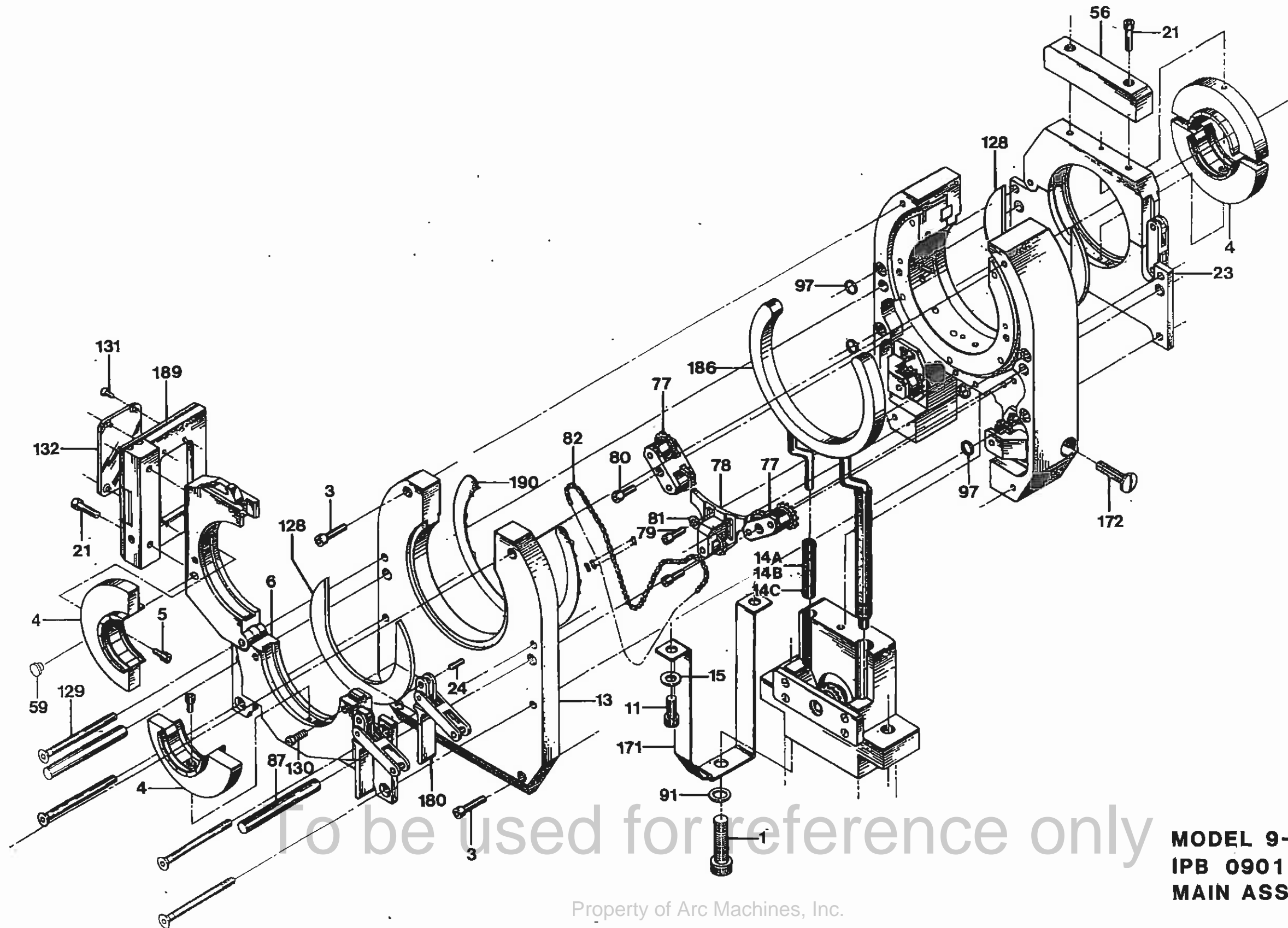
| WELD HEAD MODEL NO. | KIT WITH 1/16 TUNGSTEN HOLDER PART NO. | KIT WITH 3/32 TUNGSTEN HOLDER PART NO. | TUNGSTEN EXTENDER ROTATION DIA. |
|---------------------|--|--|---------------------------------|
| 9-1500 | 13090796-01 | 13090796-02 | 2.031 |
| 9-2500 | 13090796-05 | 13090796-06 | 3.156 |
| 9-3500 | 13090796-05 | 13090796-06 | 4.031 |
| 9-4500 | 13090796-03 | 13090796-04 | 4.920 |
| 9-7500 | 13090796-05 | 13090796-06 | 8.280 |

NOTES:

1. PART NUMBERS SHOWN ARE FOR REFERENCE ONLY AND ARE SUBJECT TO CHANGE.
2. CONTACT AMI SALES OR SERVICES FOR SPECIFIC PART NUMBER.

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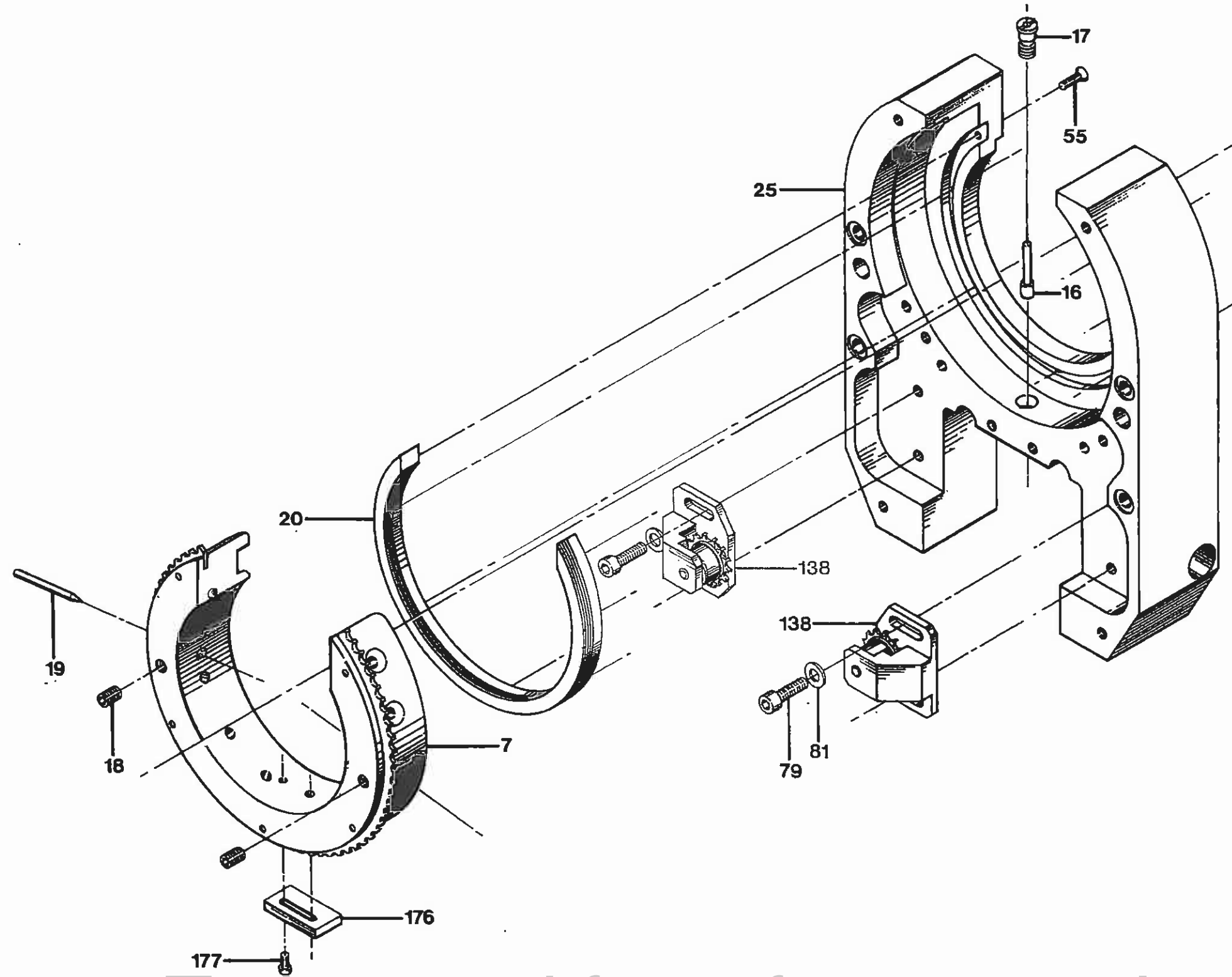
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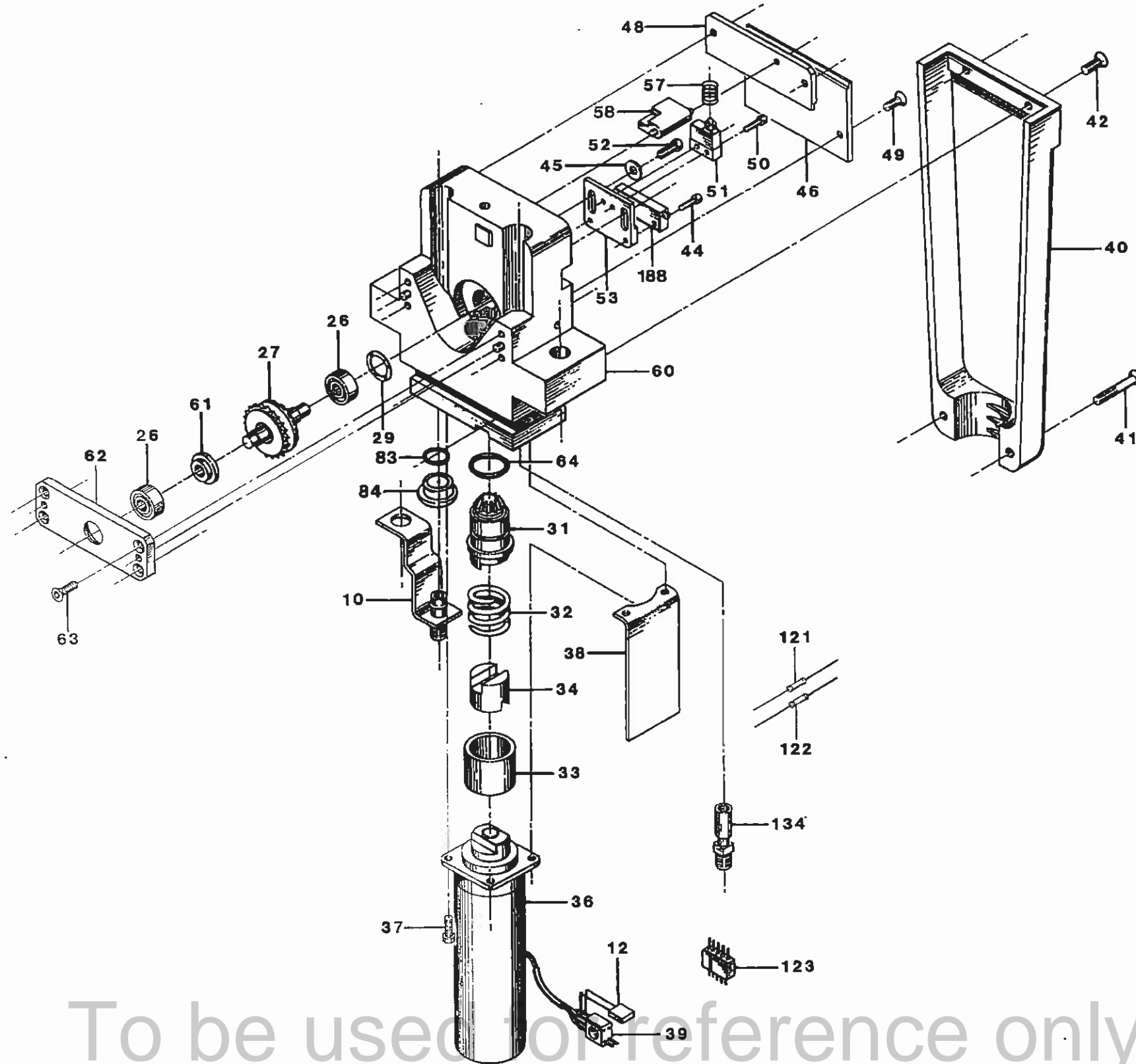
MODEL 9-2500
IPB 090114
MAIN ASSEMBLY



To be used for reference only

MODEL 9-2500
IPB 090114
HOUSING ASSEMBLY

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To be used for reference only

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MODEL 9-2500
IPB 090114
DRIVE ASSEMBLY

IPB NUMBER: 090114

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.
PRODUCT MODEL: M9-2500
DESCRIPTION: MAIN ASSEMBLY
MANUAL NUMBER: 730018
NOTES:

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION | |
|-----------------|------|-----|-----------------|--------------------------------|--------------------------------|
| 1 | 2 | EA | SCS31-18-1.25NP | SCREW CAP SKT 5/16-18 1-1/4 L | |
| 2 | 0 | - | - | ----- | |
| 3 | 4 | EA | SCS08-32-0.87NP | SCREW CAP SKT 8-32 7/8 L | |
| 4 | 0 | - | - | ----- | |
| 5 | 4 | EA | SCS06-32-0.37NP | SCREW CAP SKT 6-32 3/8 L | |
| 6 | 1 | EA | 130905271-01 | CLAMP HSG COVER SIDE | ITEMS 24, 59 & 180 INCLUDED |
| 7 | 1 | EA | 13090774-01 | ROTOR 9-2500 | ITEMS 18, 176 AND 177 INCLUDED |
| 8 | 0 | - | - | ----- | |
| 10 | 1 | EA | 13090723-01 | GROUND STRAP | |
| 11 | 2 | EA | SCS25-20-0.62SP | SCREW CAP SKT 1/4-20 5/8 L SP | |
| 12 | 1 | EA | CK06BX104K | CAP 0.1MF 100V 10% | |
| 13 | 1 | EA | 42090152-01 | COVER | |
| 14A | 0.5 | FT | 029173 | TBG SILICONE 1/8ID 1/4OD RED | |
| 14B | 0.08 | FT | FP-301-0.25 | TBG SHRINK | |
| 14C | 18 | IN | MS20995C25 | LOCKWIRE 1LB SPOOL .025D 304SS | |
| 15 | 2 | EA | W25NP-FL | WASHER FL 1/4 | |
| 16 | 1 | EA | 42091109-04 | PIN ACT 9-2500 | |
| 17 | 1 | EA | 42091110-01 | BUSHING ACTUATOR | |
| 18 | 3 | EA | SSS06-32-18NPCU | SCREW SET SKT 6-32 3/16 L CUPT | |
| 19 | 0 | - | - | ----- | |
| 20 | 1 | EA | 42090758-01 | GUIDE RING | TUNGSTEN |
| 21 | 4 | EA | SCS08-32-0.75NP | SCREW CAP SKT 8-32 3/4 L | |
| 22 | 0 | EA | - | ----- | |
| 23 | 1 | EA | 130905270-01 | CLAMP HSG HSG SIDE | ITEMS 180 & 24 INCLUDED |
| 24 | 2 | EA | PD12-0.31SS | PIN DOWEL 1/8D 5/16L SST | |
| 25 | 1 | EA | 42090153-01 | HOUSING UPPER | ITEMS 16,17,60 & 172 INCLUDED |
| 26 | 2 | EA | SSR-3LLRA3P2 [| BEARING BALL .18 .50 [5LY-101] | |
| 27 | 1 | EA | 13090613-01 | GEAR BEVEL | |
| 28 | 0 | - | - | ----- | |
| 29 | 1 | EA | SV-8 | SPRING WAVE WASHER .351D .44 | |
| 30 | 0 | - | - | ----- | |
| 31 | 1 | EA | 13090602-07 | GEAR PINION DRIVE | |
| 32 | 1 | EA | 15156 | SPRING CPRSN .81D .70L .067W | |
| 33 | 1 | EA | 42090602-04 | SPACER SPRING | |
| 34 | 1 | EA | 42090602-03 | COUPLING INSULATING DELRIN | |
| 35 | 1 | EA | 13090800-01 | CABLE M9 10 FT | |
| 36 | 1 | EA | 13090602-03 | MOTOR DRIVE PINION 81 RPM | ITEMS 12 AND 39 INCLUDED |

To be used for reference only

PRICE, PART NUMBER AND DESCRIPTION SUBJECT TO CHANGE WITHOUT NOTICE

IPB NUMBER: 090114

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: M9-2500
DESCRIPTION: MAIN ASSEMBLY
MANUAL NUMBER: 730018
NOTES:

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION |
|--------------------|-----|-----|-----------------|--------------------------------|
| 37 | 4 | EA | SCS04-40-0.31NP | SCREW CAP SKT 4-40 5/16 L |
| 38 | 1 | EA | 42091102-04 | INSULATOR SKIRT |
| 39 | 1 | EA | JF2P2SCD | CONN 4 PIN PLUG MINIATURE |
| 40 | 2 | EA | 42090104-01 | HANDLE |
| 41 | 2 | EA | SFS04-40-1.00NP | SCREW FLH SKT 4-40 1.00 L |
| 42 | 4 | EA | SFS04-40-0.37NP | SCREW FLH SKT 4-40 3/8 L |
| 43 | 0 | - | - | ----- |
| 44 | 2 | EA | SCS02-56-0.25NP | SCREW CAP SKT 2-56 1/4 L |
| 45 | 1 | EA | W04-FL | WASHER FLAT #4 |
| 46 | 1 | EA | 42090619-02 | COVER PLATE BOT LIMIT SW |
| 47 | 0 | - | - | ----- |
| 48 | 1 | EA | 42090619-01 | COVER PLATE TOP LIMIT SW |
| 49 | 4 | EA | SFS04-40-0.31NP | SCREW FLH SKT 4-40 5/16 L |
| 50 | 2 | EA | SCS02-56-0.25NP | SCREW CAP SKT 2-56 1/4 L |
| 51 | 1 | EA | MMGGD1DOC | SWITCH LIMIT PLUNGER |
| 52 | 2 | EA | SCS04-40-0.25NP | SCREW CAP SKT 4-40 1/4 L |
| 53 | 1 | EA | 42090616-05 | PLATE LIMIT SWITCH |
| 54 | 0 | - | - | ----- |
| 55 | 7 | EA | SFL06-32-0.50NY | SCREW FLH SLT 6-32 1/2 L NYL |
| 56 | 1 | EA | 42090501-02 | CLOSURE END |
| 57 | 1 | EA | L-14 | SPRING CPRSN .25D .43L .020W |
| 58 | 1 | EA | 42091108-03 | LEVER LIMIT SW ACTR |
| 59 | 1 | EA | 650 | PLUG 1/4 DIA HOLE |
| 60 | 1 | EA | 42090146-01 | HOUSING DRIVE |
| 61 | 1 | EA | 42090617-02 | SPACER BEVEL GEAR |
| 62 | 1 | EA | 42090548-02 | RETAINER PLATE |
| 63 | 4 | EA | SFS04-40-0.37NP | SCREW FLH SKT 4-40 3/8 L |
| 64 | 1 | EA | 2-014 | O RING .489 ID .070 W |
| 65 | 1 | EA | JF2S2PCD | CONN 4 SOCKET RECEPTACLE MINTR |
| 66 | 0 | - | - | ----- |
| 67 | 0 | - | - | ----- |
| 77 | 2 | EA | 13090622-01 | BRACKET DRIVE SPROCKET |
| 78 | 1 | EA | 13090623-01 | TENSIONER CENTER |
| 79 | 6 | EA | SCS08-32-0.37NP | SCREW CAP SKT 8-32 3/8 L |
| 80 | 2 | EA | SCS08-32-0.75NP | SCREW CAP SKT 8-32 3/4 L |
| 81 | 6 | EA | W08NP-FL | WASHER FLAT #8 |
| 82 | 1 | EA | RC14SS-117 | OBS USE P/N 47SS-117 |

To be used for reference only

PRICE, PART NUMBER AND
DESCRIPTION SUBJECT TO
CHANGE WITHOUT NOTICE

Page 5 of 7

IPB NUMBER: 090114

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: M9-2500
DESCRIPTION: MAIN ASSEMBLY
MANUAL NUMBER: 730018
NOTES:

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION |
|-----------------|--------------|---------------|-------------------------|--|
| 83 | 1 | EA | 2-010-S604-70 | O RING .238 ID .070 W SILICONE |
| 84 | 1 | EA | 420901126-02 | GROMMET |
| 87 | 2 | EA | 42090164-03 | PIN .312D 2.45L 9-2500 |
| 88 | 0 | - | - | ----- |
| 89 | 0 | - | - | ----- |
| 91 | 2 | EA | W31SS-FL | WASHER FL 5/16 SIZE SST |
| 92 | 1 | EA | 42060000 02 | COUPLING Q/D CONN (SM-251B) |
| 93 | 1 | EA | SM252B | COUPLING |
| 94 | 1 | EA | 294 PMB 04 | DO NOT BELL USE. 1351109 01 |
| 95 | 1 | EA | M8310GB18 1P | CONN 18 PIN PLUG |
| 96 | 1 | EA | G1501N186A3A | CONN BACKSHELL |
| 97 | 4 | EA | 2-106-S604-70 | O RING .174 ID .103 W SILICONE |
| 98 | 0 | - | - | ----- |
| 99 | 1 | EA | MS39056 3 | CONN TELESCOPIC BUSHING |
| 105 | 0 | - | - | ----- |
| 106 | 0 | - | - | ----- |
| 107 | 0 | - | - | ----- |
| 121 | 1 | EA | RN55D1300F | RES 130 OHMS 1/4W |
| 122 | 1 | EA | RN55D7871F | RES 7.87K |
| 123 | 1 | EA | 5PM | OBS USE 7051 |
| 124 | 1 | EA | 5PF | OBS USE 7052 |
| 125 | 0 | - | - | ----- |
| 126 | 1 | EA | 2PF1 | FTG 1/4 20 FEMALE |
| 127 | 2 | EA | 42060000 01 | OBS (USE ARC-1001) |
| 128 | 2 | EA | 420907159-02 | HEAT SHIELD 9-2500 |
| 129 | 4 | EA | 13090124-02 | SCREW INSULATED |
| 130 | 4 | EA | SCS04-40-0.50NP | SCREW CAP SKT 4-40 1/2 L |
| 131 | 4 | EA | SFL06-32-0.37NY | SCREW FLH SLT 6-32 3/8 L NYL |
| 132 | 1 | EA | 42090501-03 | WINDOW |
| 134 | 1 | EA | 13090803-01 | TUBE FTG GAS |
| 135 | 1 | EA | R61002GSB | TERM 16-14 AWG #6 |
| 136 | 0 | - | - | ----- |
| 138 | 2 | EA | 13090623-02 | TENSIONER SIDE |
| 139 | 0 | - | - | ----- |
| 140 | 0 | - | - | ----- |
| 144 | 1 | EA | 42060005 04 | BOOT MALE GAS |
| 145 | 2 | EA | 42060004 01 | BOOT MALE POWER/GROUND |

To be used for reference only

PRICE, PART NUMBER AND
DESCRIPTION SUBJECT TO
CHANGE WITHOUT NOTICE

IPB NUMBER: 090114

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: M9-2500
DESCRIPTION: MAIN ASSEMBLY
MANUAL NUMBER: 730018
NOTES:

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION |
|--------------------|--------------|---------------|---------------------------|---|
| 146 | 2 | EA | 42060800-07 | PTG COUPLING HOSE/CABLE |
| 147 | 0 | - | - | ----- |
| 148 | 0 | - | - | ----- |
| 171 | 1 | EA | 42090749-01 | CONDUCTOR GND STRAP |
| 172 | 1 | EA | SPL25-20-0.50NY | SCREW PNH SLT 1/4-20 1/2 L NYL |
| 173 | 0 | - | - | ----- |
| 174 | 1 | EA | 261 PG 04 | PTG NUT/SLEEVE SPRING 1/4 TUBE |
| 175 | 1 | EA | AG200718 | SPRING GUARD .34 OD 18.00 LG |
| 176 | 1 | EA | 42090548-05 | CAM SWITCH |
| 177 | 2 | EA | SCS04-40-0.31NP | SCREW CAP SKT 4-40 5/16 L |
| 178 | 0 | - | - | ----- |
| 180 | 2 | EA | 13090565-01 | LATCH ASSY M9-1500, 2500, 3500 |
| 185 | 1 | EA | 1350110-04 | DUST CAP ASSY W/CHAIN(MALE10D) |
| 186 | 1 | EA | 13090769-01 | CONDUCTOR RING 9-2500 |
| 187 | 0 | - | - | ----- |
| 188 | 1 | EA | 3057L-1-202 | POT TRIM 2K OHM 5% |
| 189 | 1 | EA | 130905214-02 | CLOSURE FLIP-TOP 9-2500 |
| 190 | 1 | EA | 420907214-01 | PLATE BACKING M9-2500 |
| 200 | 9 | FT | DUCT 0.87 50 W | CONDUIT WHT 0.87 ID |
| 201 | 6 | IN | M23053/5-111-0 | TBC SHRINK 1 1/3 ID BLK |

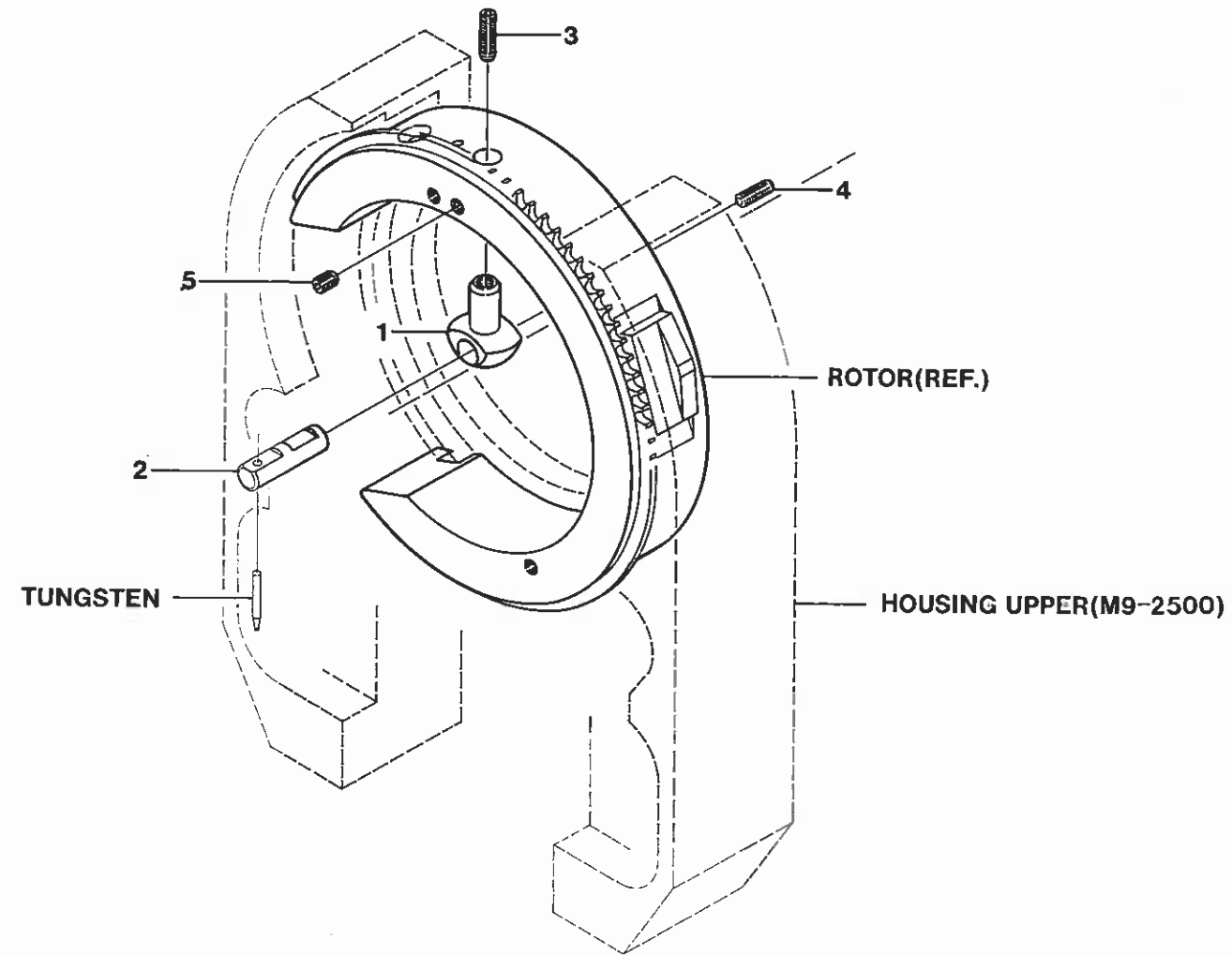
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PRICE, PART NUMBER AND
DESCRIPTION SUBJECT TO
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Page 7 of 7

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NOTE: USE STANDARD M9-2500 IPB
FOR ALL OTHER PARTS

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MODEL 9AF-2500
IPB 090169
WELD HEAD ASSEMBLY

IPB NUMBER: 090169

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: 9-2500
DESCRIPTION: WELD HEAD ASSEMBLY
MANUAL NUMBER: 730018
NOTES:

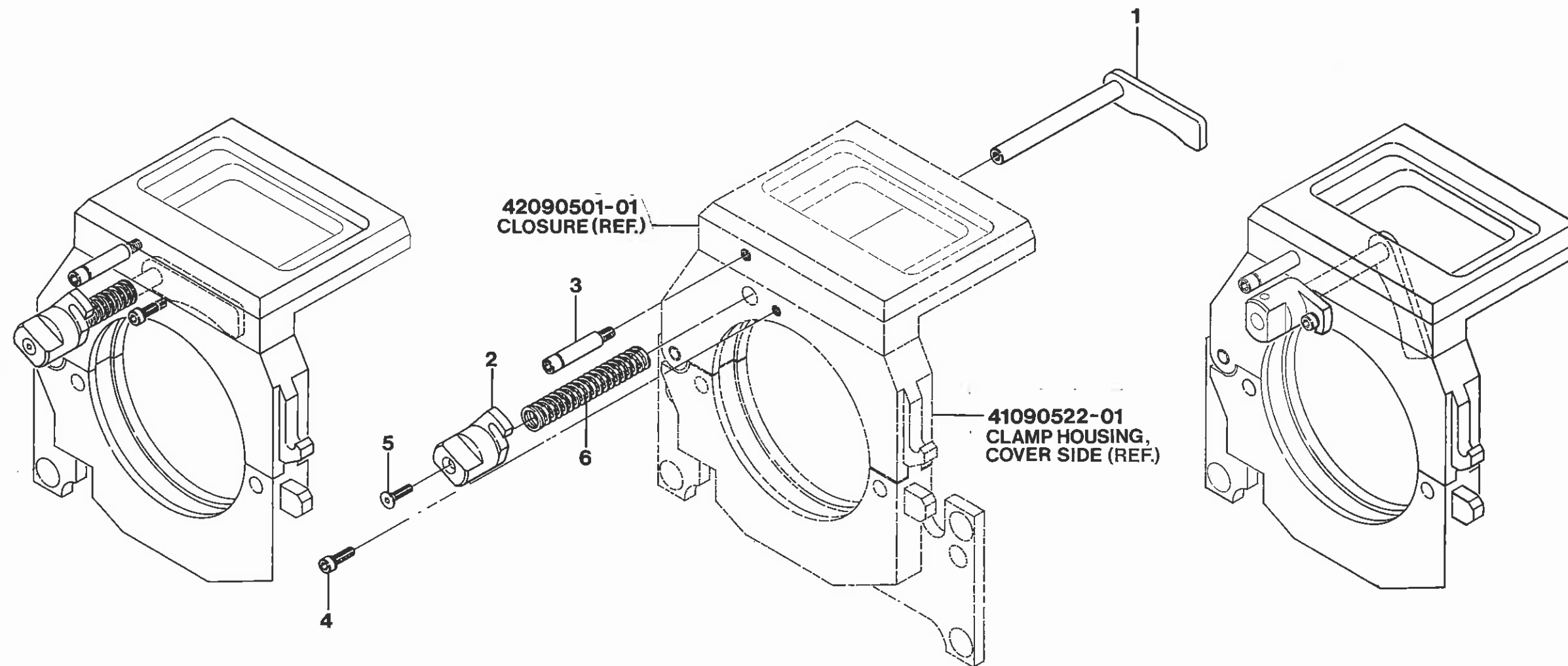
| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION |
|--------------------|-----|-----|--------------|--------------------------------|
| 1 | 1 | EA | 420907155-01 | HOUSING TUNGSTEN HOLDER STD |
| 2 | 1 | EA | 420907155-04 | HOLDER TUNG .062 DIA |
| 2A | 1 | EA | 420907155-05 | HOLDER TUNG .093 DIA |
| 3 | 1 | EA | 420907144-13 | SCREW SET SKT 6-32 1/2 L FLPT |
| 4 | 1 | EA | 420907144-12 | SCREW SET SKT 6-32 3/8 L FLPT |
| 5 | 1 | EA | 420907144-09 | SCREW SET SKT 6-32 3/16 L FLPT |

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PRICE, PART NUMBER AND
DESCRIPTION SUBJECT TO
CHANGE WITHOUT NOTICE

Page 2 of 2

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MODEL 9-2500
IPB 090514
ARM LOCATING KIT

IPB NUMBER: 090514

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: 9-2500
DESCRIPTION: LOCATING ARM KIT
MANUAL NUMBER: 730018
NOTES:

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION |
|--------------------|-----|-----|-----------------|-------------------------------|
| 1 | 1 | EA | 130905123-01 | ARM LOCATING BRAZED |
| 2 | 1 | EA | 130905108-01 | KNOB ASSY 1500 2500 3500 4500 |
| 3 | 1 | EA | 420905277-04 | STOP (44D22) |
| 4 | 1 | EA | SCS04-40-0.37NP | SCREW CAP SKT 4-40 3/8 L |
| 5 | 1 | EA | SFS02-56-0.31NP | SCREW FLH SKT 2-56 5/16 L |
| 6 | 1 | EA | S-910 | SPRING CPRSN .31D 2.00L .024W |

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PRICE, PART NUMBER AND
DESCRIPTION SUBJECT TO
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Page 2 of 2

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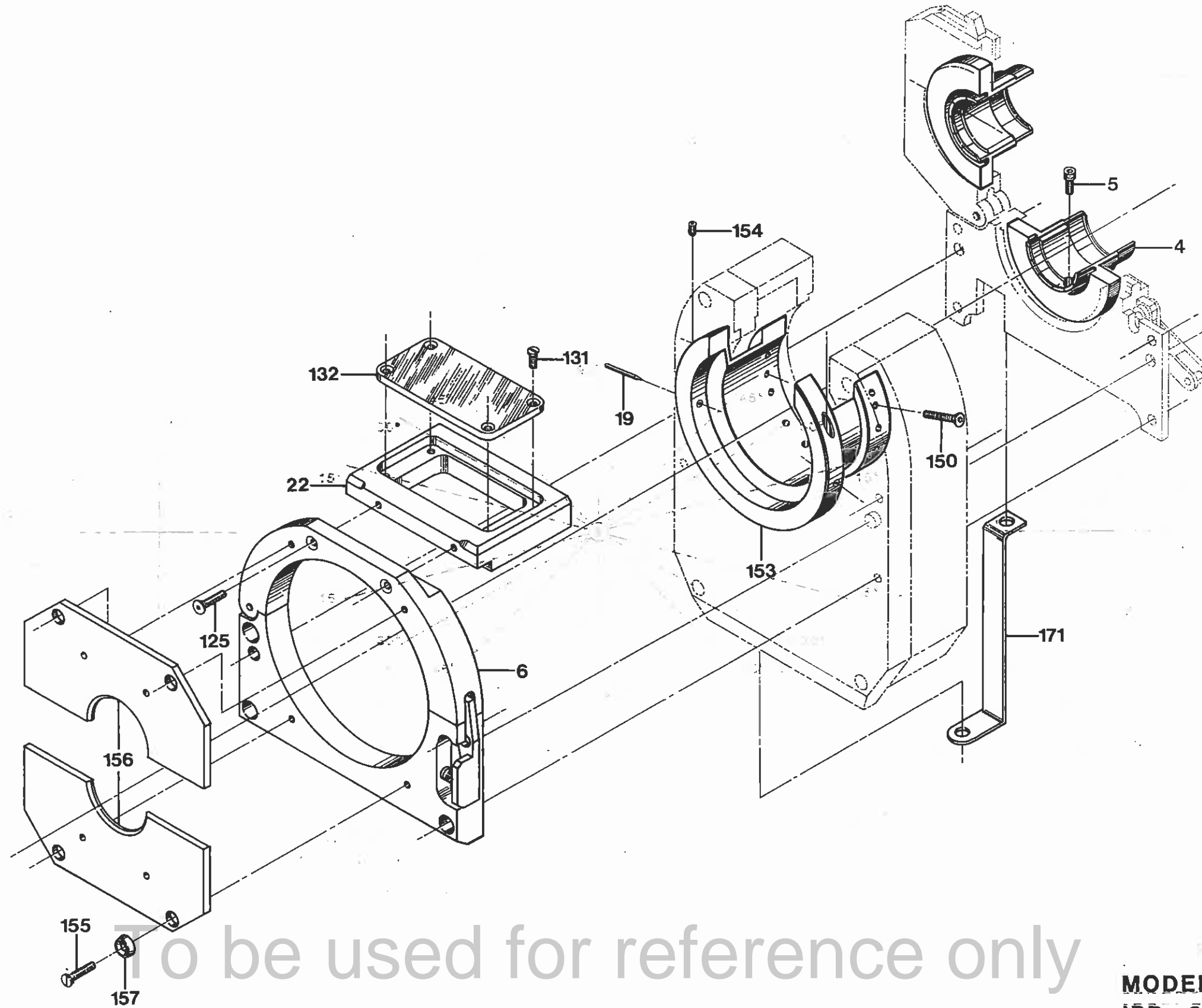
BASIC USE 10 POINT
HELVETICA REGULAR



ARC MACHINES INC.

ART No.
USE 10 POINT HELVETICA REGULAR ONLY

USE 10 POINT
HELVETICA REGULAR ONLY



To be used for reference only

USE 10 POINT
HELVETICA MEDIUM ONLY

MODEL 9E-2500
IPB 090103
MODEL 9E CONFIGURATION

Property of Arc Machines, Inc.

DESCRIPTION

PAGE 1 OF 2

IPB NUMBER: 090103

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: 9-2500
DESCRIPTION: MODEL 9E CONFIGURATION
MANUAL NUMBER: 730018
NOTES:

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION | |
|--------------------|-----|-----|-----------------|-------------------------------|-------------------------------|
| 1 | 0 | - | - | ----- | |
| 4 | 0 | - | - | ----- | WIDE CLAMP INSERT-ORD BY SIZE |
| 5 | 2 | EA | SCS06-32-0.37NP | SCREW CAP SKT 6-32 3/8 L | |
| 6 | 1 | EA | 13090551-01 | HOUSING GAS SEAL 9E-2500 | |
| 7 | 0 | - | - | ----- | |
| 19 | 0 | - | - | ----- | |
| 22 | 1 | EA | 420905177-01 | CLOSURE 9E-2500 | ITEMS 131 AND 132 INCLUDED |
| 23 | 0 | - | - | ----- | |
| 125 | 2 | EA | SFS08-32-0.62NP | SCREW FLH SKT 8-32 5/8 L | |
| 126 | 0 | - | - | ----- | |
| 131 | 4 | EA | SFL06-32-0.31NY | SCREW FLH SLT 6-32 5/16 L NYL | |
| 132 | 1 | EA | 42090501-03 | WINDOW | |
| 133 | 0 | - | - | ----- | |
| 150 | 2 | EA | SFS06-32-0.75NP | SCREW FLH SKT 6-32 3/4 L | |
| 151 | 0 | - | - | ----- | |
| 153 | 1 | EA | 13090738-01 | ROTOR EXTENSION 9E-2500 | |
| 154 | 2 | EA | 420907144-12 | SCREW SET SKT 6-32 3/8 L FLPT | |
| 155 | 4 | EA | SFL08-32-0.50NY | SCREW FLH SLT 8-32 1/2 L NYL | |
| 156 | 0 | - | - | ----- | GAS SEAL-ORD BY SIZE |
| 157 | 4 | EA | 11SFW0008 | WASHER NYLON FINISHING #8 | |
| 158 | 0 | - | - | ----- | |
| 171 | 1 | EA | 42090749-04 | GROUND STRAP | |
| 172 | 0 | - | - | ----- | |
| 180 | 1 | EA | 13090158-02 | KIT CVRSN M9-2500 TO M9E-2500 | |

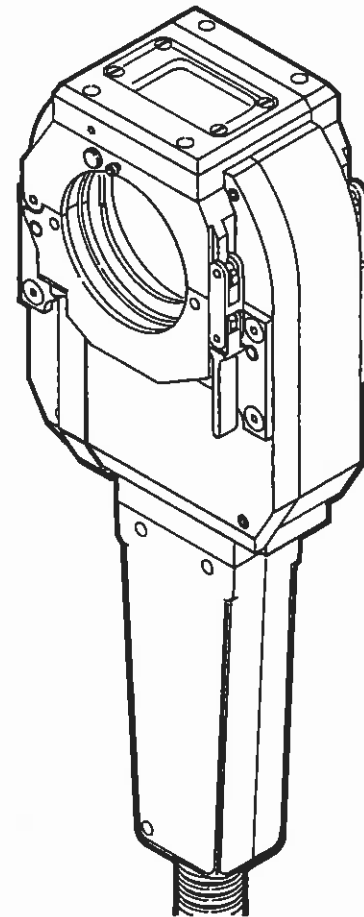
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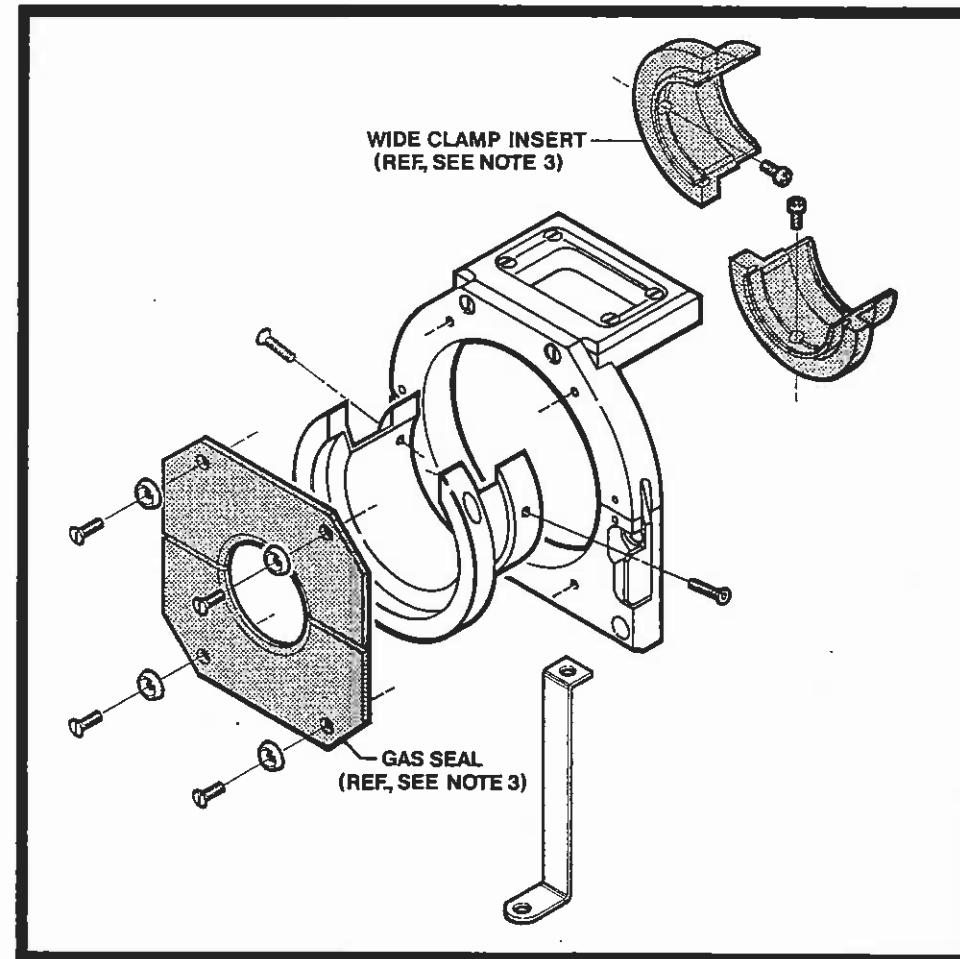
MODEL 9 CONVERSION TO MODEL 9E INSTRUCTIONS

P/N 750031

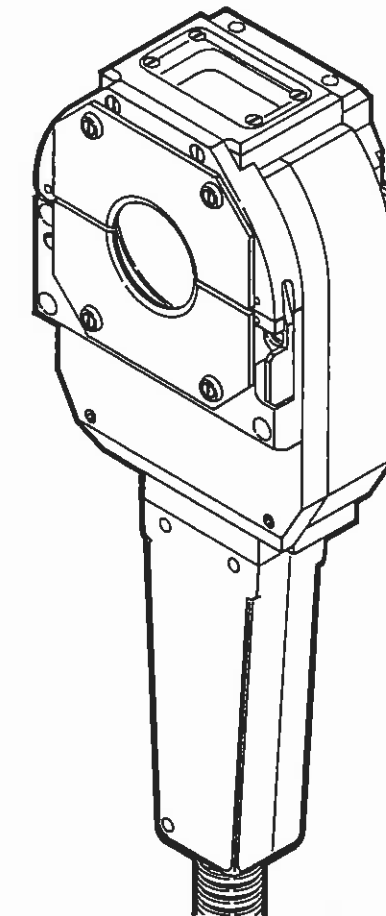
(MODELS 9-1500, 9-2500, 9-3500, 9-4500 AND 9-7500)



MODEL 9

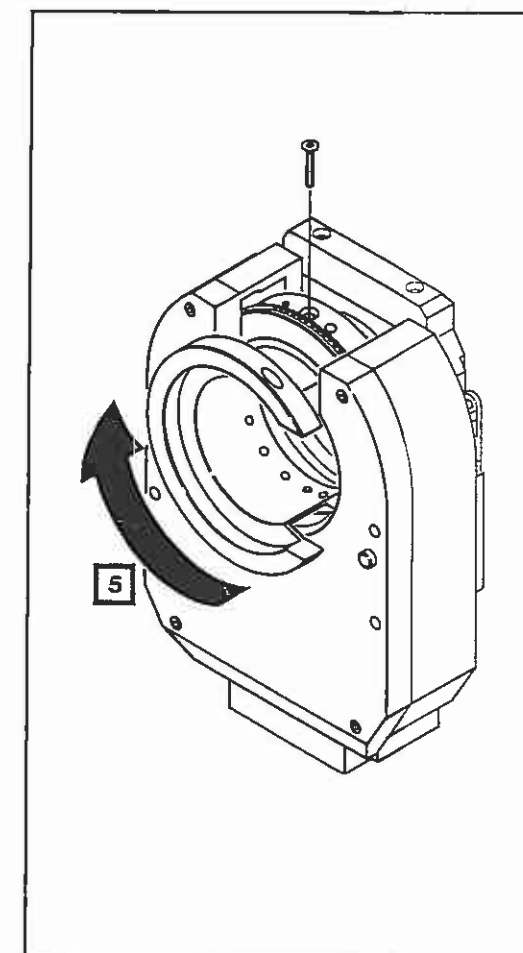
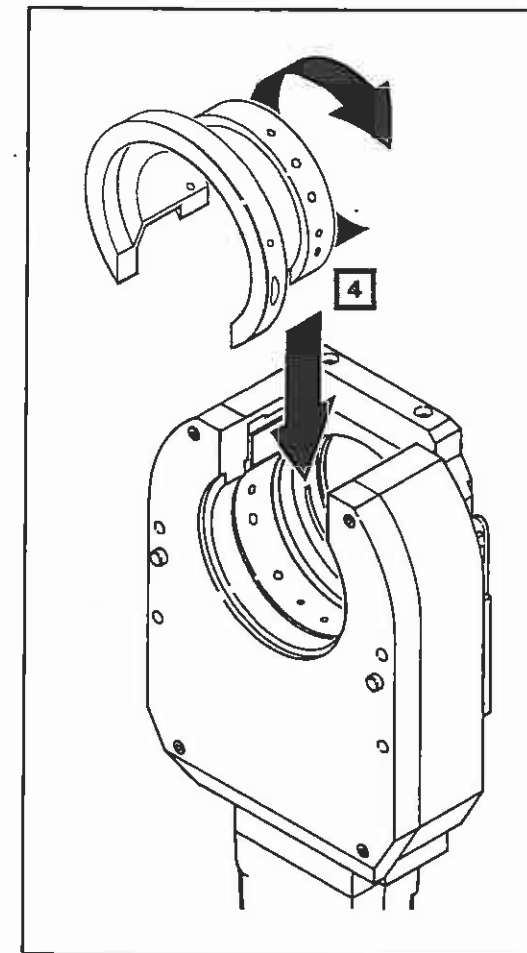
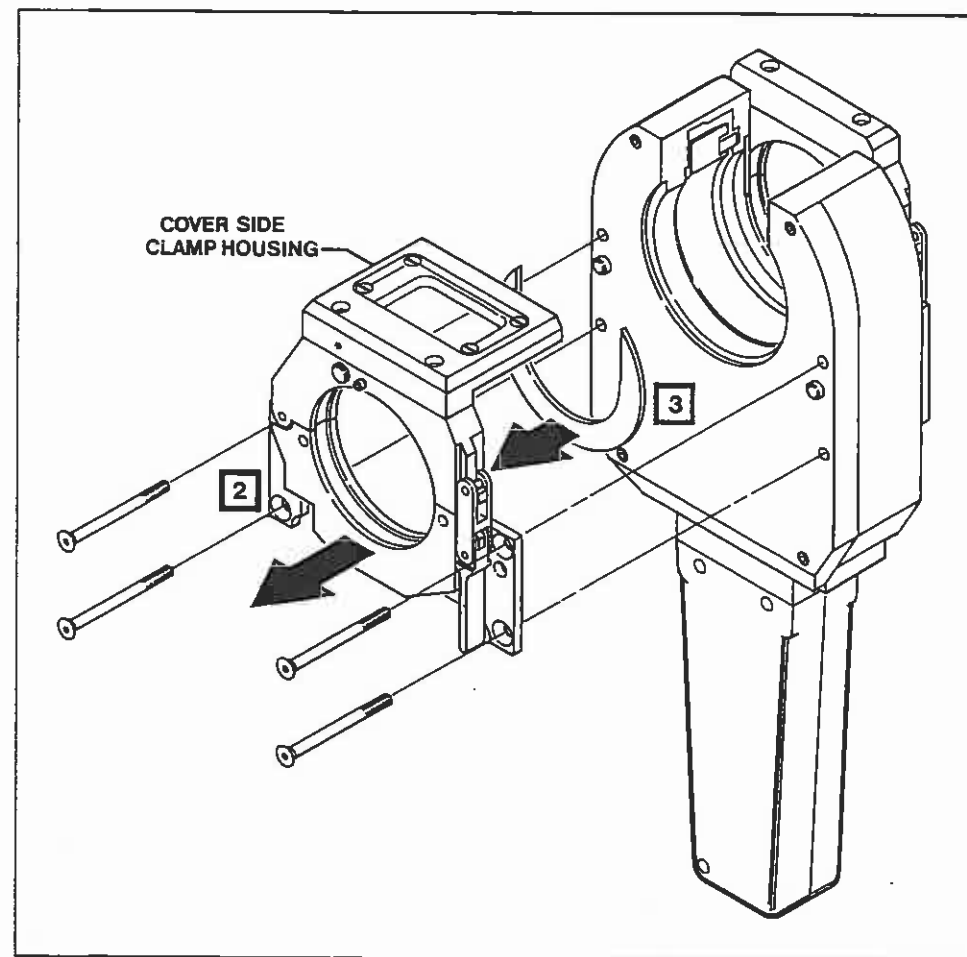
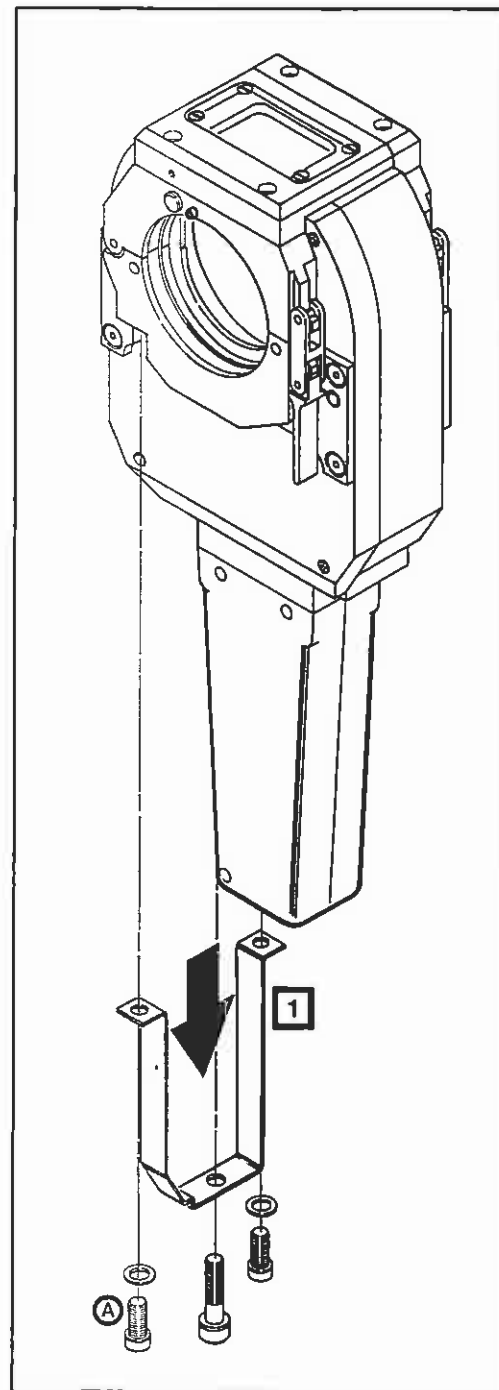


MODEL 9E KIT
(OPTION)

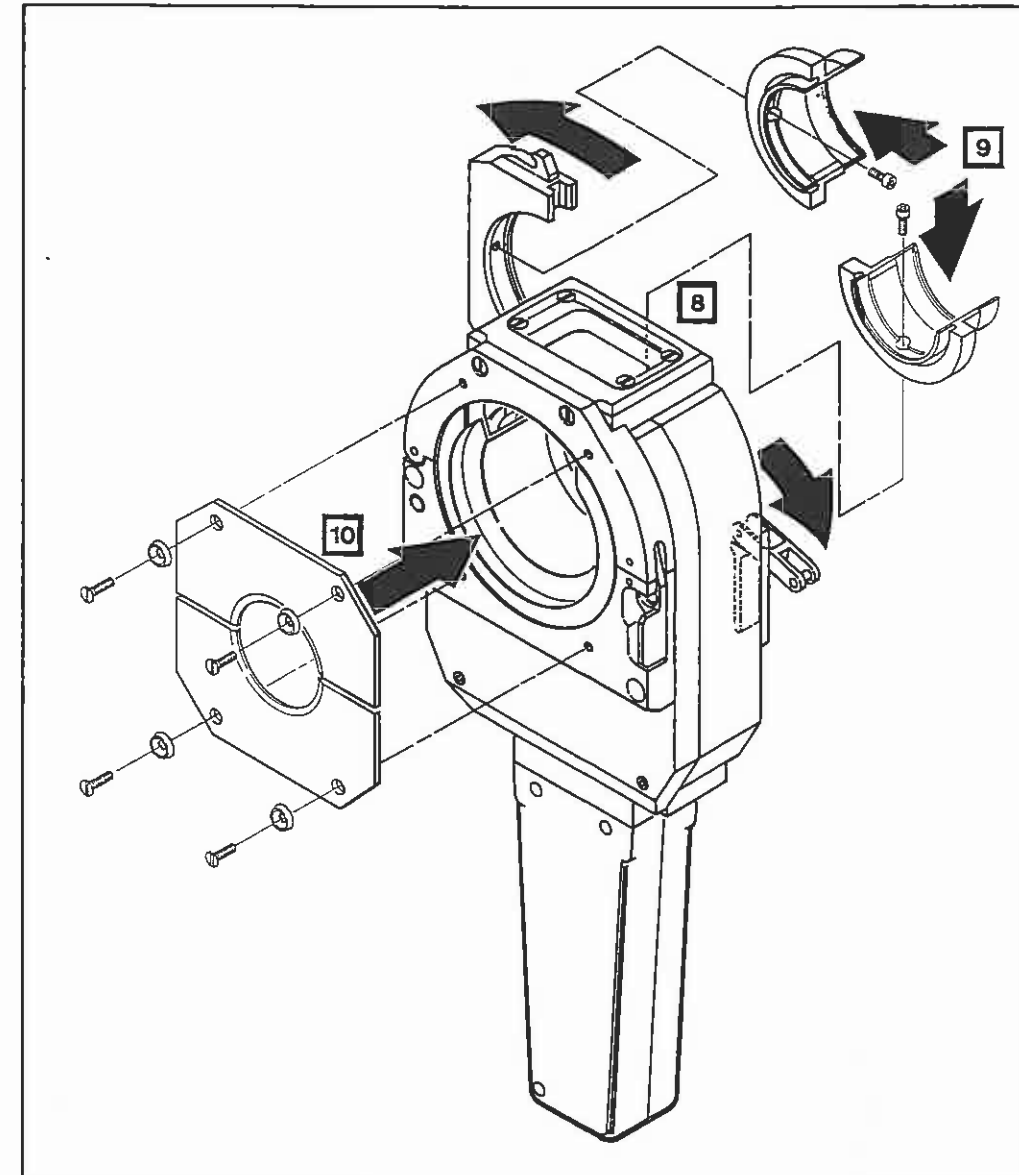
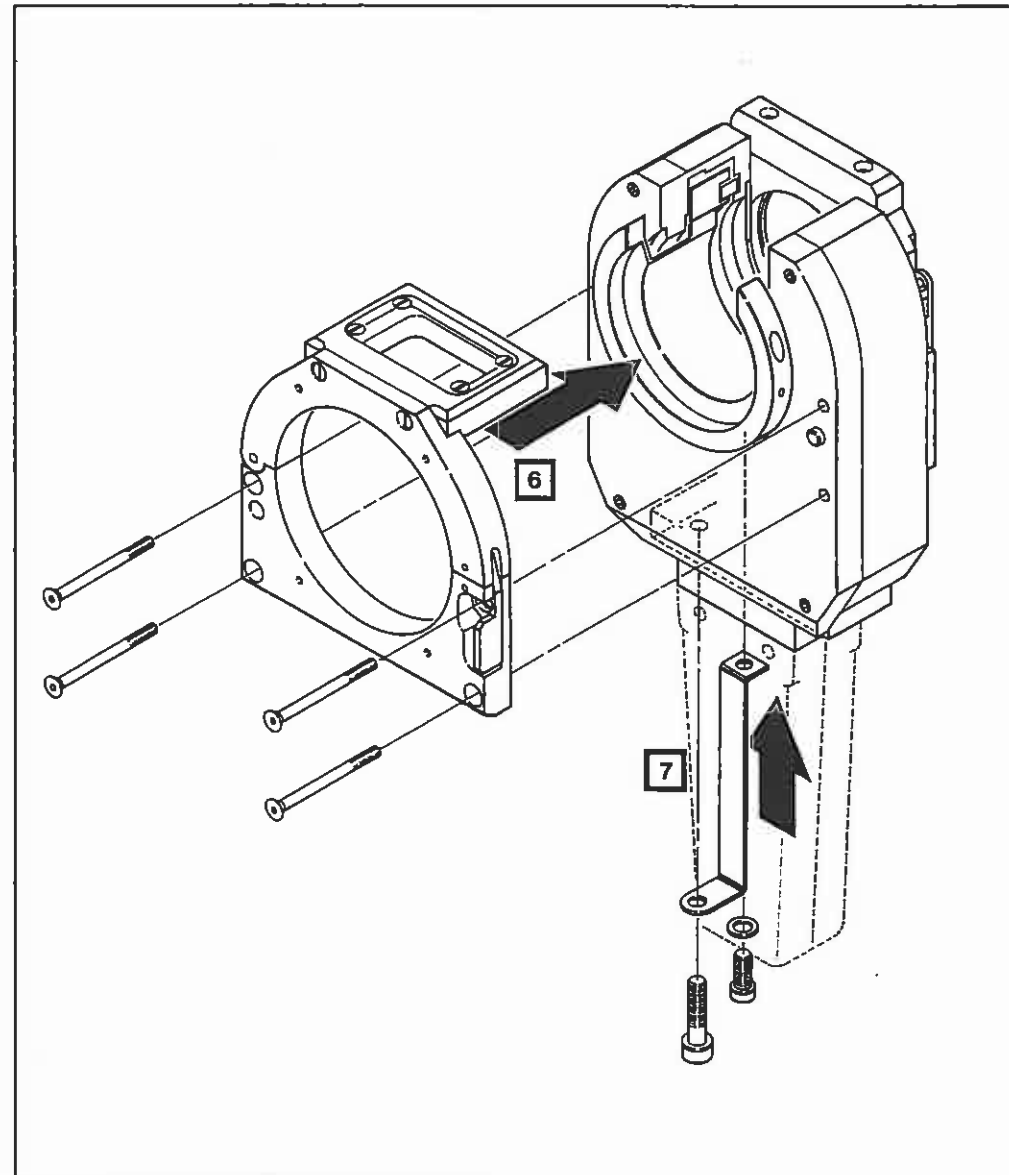


MODEL 9E

- NOTES :**
1. TO ORDER MODEL 9E KIT SPECIFY WELD HEAD MODEL NUMBER.
 2. MODEL 9-2500 USED FOR ILLUSTRATION.
 3. WIDE CLAMP INSERT AND GAS SEAL ARE NOT INCLUDED IN KIT.
TO ORDER WIDE CLAMP INSERT AND GAS SEAL SPECIFY TUBE SIZE (O.D.).



- 1** REMOVE ORIGINAL GROUND STRAP EXCEPT ON MODEL 9-1500 REMOVE SCREW **A** ONLY (ORIGINAL GROUND STRAP IS USED).
- 2** REMOVE COVER SIDE CLAMP HOUSING.
- 3** REMOVE HEAT SHIELD.
- 4** INSTALL ROTOR EXTENSION FROM THE KIT.
- 5** CONNECT WELD HEAD TO POWER SUPPLY AND JOG ROTOR UNTIL ROTOR EXTENSION MOUNTING SCREW HOLE IS ACCESSIBLE. INSTALL MOUNTING SCREWS (2 TO 4 EACH DEPENDING ON MODEL #) AND TIGHTEN.



- 6** MOUNT THE GAS SEAL HOUSING ASSEMBLY FROM THE KIT TO THE WELD HEAD USING ORIGINAL SCREWS.
- 7** INSTALL GROUND STRAP FROM THE KIT USING ORIGINAL SCREWS, EXCEPT FOR MODEL 9-1500 USE ORIGINAL GROUND STRAP AND SCREWS.
- 8** OPEN HOUSING SIDE CLAMP.
- 9** INSTALL WIDE CLAMP INSERT ASSEMBLY (NOT PROVIDED IN CONVERSION KIT).
- 10** INSTALL GAS SEAL ASSEMBLY (NOT PROVIDED IN CONVERSION KIT).

To be used for reference only

IPB NUMBER: 0901116

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: M9-2500
DESCRIPTION: MAIN ASSEMBLY MODEL 9EDL
MANUAL NUMBER: 730018
NOTES:

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION | |
|-----------------|-----|-----|-----------------|--------------------------------|----------------------------------|
| 1 | 1 | EA | 13090611-01 | DRIVE ASSY M9-2500 -3500 -4500 | |
| 2 | 1 | EA | 13090206-01 | HOUSING UPPER 9-2500 | |
| 3 | 1 | EA | 130905208-01 | HOUSING GAS SEAL M9EDL-2500 | |
| 4 | 1 | EA | 130905206-01 | CLAMP HSG ASSY M9EDL-2500 | |
| 5 | 1 | EA | 13090769-01 | CONDUCTOR RING 9-2500 | |
| 7 | 1 | EA | 13090800-01 | CABLE M9 10 FT | |
| 8 | 4 | EA | 13090124-02 | SCREW INSULATED | |
| 9 | 1 | EA | 13090738-01 | ROTOR EXTENSION 9E-2500 | |
| 10 | - | - | - | ----- | |
| 12 | 1 | EA | 420907159-02 | HEAT SHIELD 9-2500 | |
| 13 | 1 | EA | 42090152-01 | COVER | |
| 14 | 1 | EA | 420905177-01 | CLOSURE 9E-2500 | |
| 15 | 1 | EA | 42090501-02 | CLOSURE END | |
| 16 | 1 | EA | 42090501-03 | WINDOW | |
| 17 | 1 | EA | 42090749-04 | GROUND STRAP | |
| 18 | - | - | - | ----- | |
| 24 | 2 | EA | 42090164-03 | PIN .312D 2.45L 9-2500 | |
| 25 | - | - | - | ----- | |
| 29 | 4 | EA | 2-106-S604-70 | O RING .174 ID .103 W SILICONE | |
| 30 | 1 | EA | RC14SS-117 | CHAIN .1475 PITCH 117 LINK | |
| 31 | 1 | EA | RC14SS-CL | CHAIN CONNECTOR | |
| 34 | 1 | SET | SCS06-32-0.31NP | SCREW CAP SKT 6-32 5/16 L | (SET OF 2) |
| 35 | 1 | SET | SCS08-32-0.75NP | SCREW CAP SKT 8-32 3/4 L | (SET OF 2) |
| 36 | 1 | SET | SFL06-32-0.37NY | SCREW FLH SLT 6-32 3/8 L NYL | (SET OF 2) |
| 37 | - | - | - | ----- | |
| 38 | 1 | SET | SCS04-40-0.50NP | SCREW CAP SKT 4-40 1/2 L | (SET OF 2) |
| 39 | 1 | EA | SCS25-20-0.50SP | SCREW CAP SKT 1/4-20 1/2 L SIL | |
| 40 | 1 | SET | SCS31-18-1.00NP | SCREW CAP SKT 5/16-18 1.00 L | (SET OF 2) |
| 41 | 1 | EA | W25NP-FL | WASHER FL 1/4 | |
| 42 | 2 | EA | W31ZP-FL | WASHER FL 5/16 | |
| 43 | 1 | SET | SFS08-32-0.62NP | SCREW FLH SKT 8-32 5/8 L | (SET OF 2) |
| 44 | 1 | SET | SFS06-32-0.75NP | SCREW FLH SKT 6-32 3/4 L | (SET OF 2) |
| 45 | 1 | SET | SFL08-32-0.50NY | SCREW FLH SLT 8-32 1/2 L NYL | (SET OF 4) |
| 46 | 4 | EA | 11SFW0008 | WASHER NYLON FINISHING #8 | |
| 47 | - | - | - | ----- | |
| 48 | - | - | - | ----- | GAS SEAL-ORD BY SIZE TUNGSTEN |
| 49 | 1 | SET | SSS06-32-18NPCU | SCREW SET SKT 6-32 3/16 L CUPT | (SET OF 4) |

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IPB NUMBER: 0901116

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: M9-2500
DESCRIPTION: MAIN ASSEMBLY MODEL 9EDL
MANUAL NUMBER: 730018
NOTES:

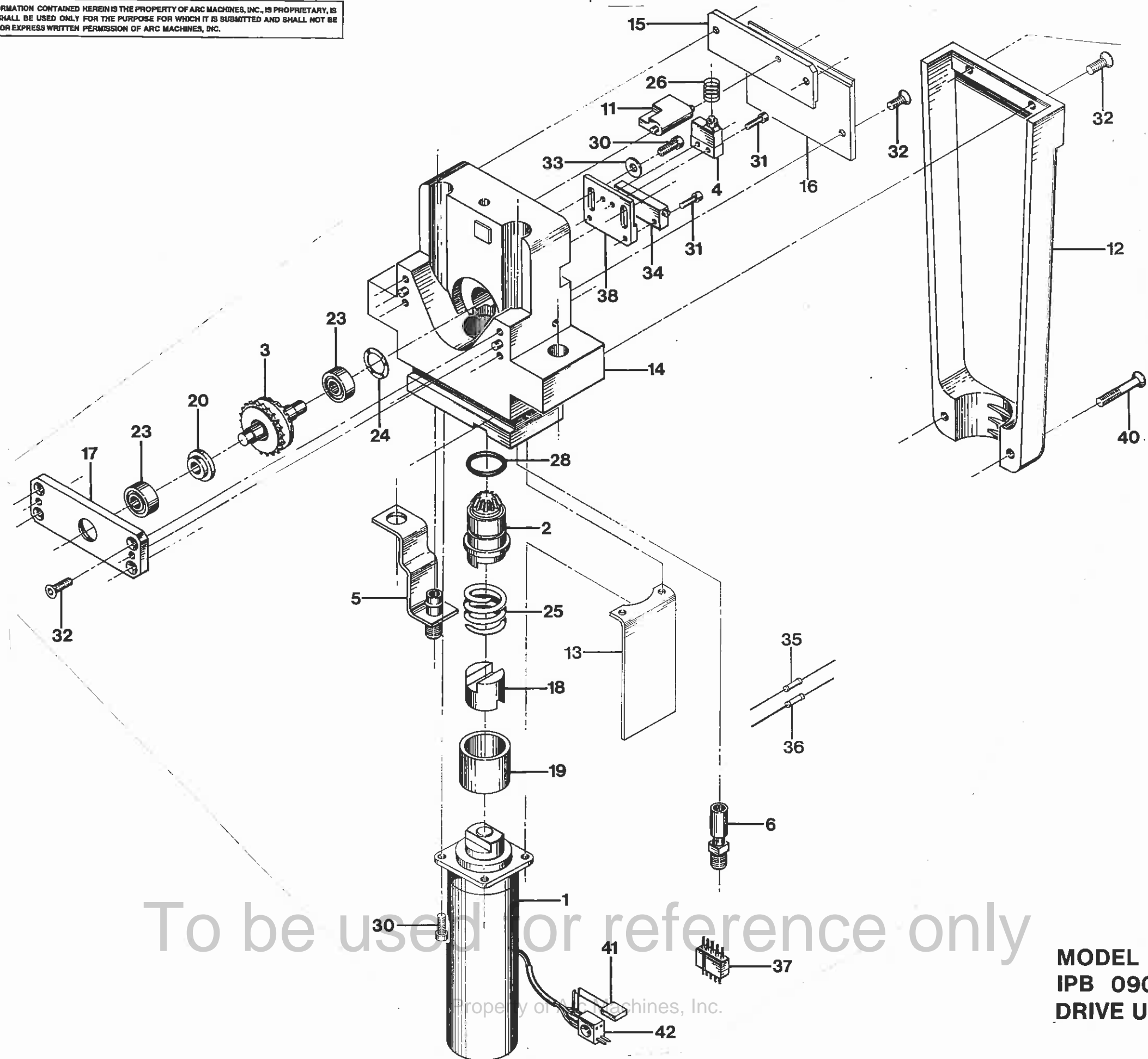
| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION | |
|--------------------|-----|-----|-----------------|--------------------------------|-------------------------------|
| 50 | 1 | EA | SPL25-20-0.50NY | SCREW PNH SLT 1/4-20 1/2 L NYL | |
| 51 | | - | - | ----- | WIDE CLAMP INSERT-ORD BY SIZE |
| 52 | 1 | EA | 420907214-01 | PLATE BACKING M9-2500 | |

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DESCRIPTION SUBJECT TO
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MODEL 9EDL-2500
IPB 090611
DRIVE UNIT ASSEMBLY

IPB NUMBER: 090611

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: 9-2500
DESCRIPTION: DRIVE UNIT ASSEMBLY
MANUAL NUMBER: 730018
NOTES: 9EDL-2500

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION | |
|--------------------|-----|-----|-----------------|------------------------------|--------------------------|
| 1 | 1 | EA | 13090602-03 | MOTOR DRIVE PINION 81 RPM | (ITEMS 41 & 42 INCLUDED) |
| 2 | 1 | EA | 13090602-07 | GEAR PINION DRIVE | |
| 3 | 1 | EA | 13090613-01 | GEAR BEVEL | |
| 4 | 1 | EA | 13090613-02 | SWITCH LIMIT | |
| 5 | 1 | EA | 13090723-01 | GROUND STRAP | |
| 6 | 1 | EA | 13090803-01 | TUBE FTG GAS | |
| 7 | - | - | - | ----- | |
| 11 | 1 | EA | 42091108-03 | LEVER LIMIT SW ACTR | |
| 12 | 2 | EA | 42090104-01 | HANDLE | |
| 13 | 1 | EA | 42091102-04 | INSULATOR SKIRT | |
| 14 | 1 | EA | 42090146-01 | HOUSING DRIVE | |
| 15 | 1 | EA | 42090619-01 | COVER PLATE TOP LIMIT SW | |
| 16 | 1 | EA | 42090619-02 | COVER PLATE BOT LIMIT SW | |
| 17 | 1 | EA | 42090548-02 | RETAINER PLATE | |
| 18 | 1 | EA | 42090602-03 | COUPLING INSULATING DELRIN | |
| 19 | 1 | EA | 42090602-04 | SPACER SPRING | |
| 20 | 1 | EA | 42090617-02 | SPACER BEVEL GEAR | |
| 21 | - | - | - | ----- | |
| 23 | 2 | EA | SSR-3LLRA3P25 [| BEARING BALL .18 .50 [LY13] | |
| 24 | 1 | EA | SV-8 | SPRING WAVE WASHER .351D .44 | |
| 25 | 1 | EA | 15156 | SPRING CPRSN .81D .70L .067W | |
| 26 | 1 | EA | L-14 | SPRING CPRSN .25D .43L .020W | |
| 27 | - | - | - | ----- | |
| 28 | 1 | EA | 2-014-V747-75 | O RING .489 ID .070 W VITON | |
| 29 | - | - | - | ----- | |
| 30 | 1 | SET | SCS04-40-0.31NP | SCREW CAP SKT 4-40 5/16 L | (SET OF 6) |
| 31 | 1 | SET | SCS02-56-0.25NP | SCREW CAP SKT 2-56 1/4 L | (SET OF 4) |
| 32 | 1 | SET | SFS04-40-0.37NP | SCREW FLH SKT 4-40 3/8 L | (SET OF 12) |
| 33 | 2 | EA | W04ZP-FL | WASHER FLAT #4 | |
| 34 | 1 | EA | 3057L-1-202 | POT TRIM 2K OHM 5% | |
| 35 | 1 | EA | RN55D7871F | RES 7.87K | |
| 36 | 1 | EA | RN55D1300F | RES 130 OHMS 1/4W | |
| 37 | 1 | EA | 5PM | CONN 5 PIN MALE | |
| 38 | 1 | EA | 42090616-05 | PLATE LIMIT SWITCH | |
| 39 | - | - | - | ----- | |
| 40 | 1 | SET | SFS04-40-1.00NP | SCREW FLH SKT 4-40 1.00 L | (SET OF 2) |
| 41 | 1 | EA | CK06BX104K | CAP 0.1MF 100V 10% | |

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DESCRIPTION SUBJECT TO
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IPB NUMBER: 090611

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

PRODUCT MODEL: 9-2500
DESCRIPTION: DRIVE UNIT ASSEMBLY
MANUAL NUMBER: 730018
NOTES: 9EDL-2500

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION |
|--------------------|-----|-----|-------------|---------------------------|
| 42 | 1 | EA | JF2P2SCD | CONN 4 PIN PLUG MINIATURE |

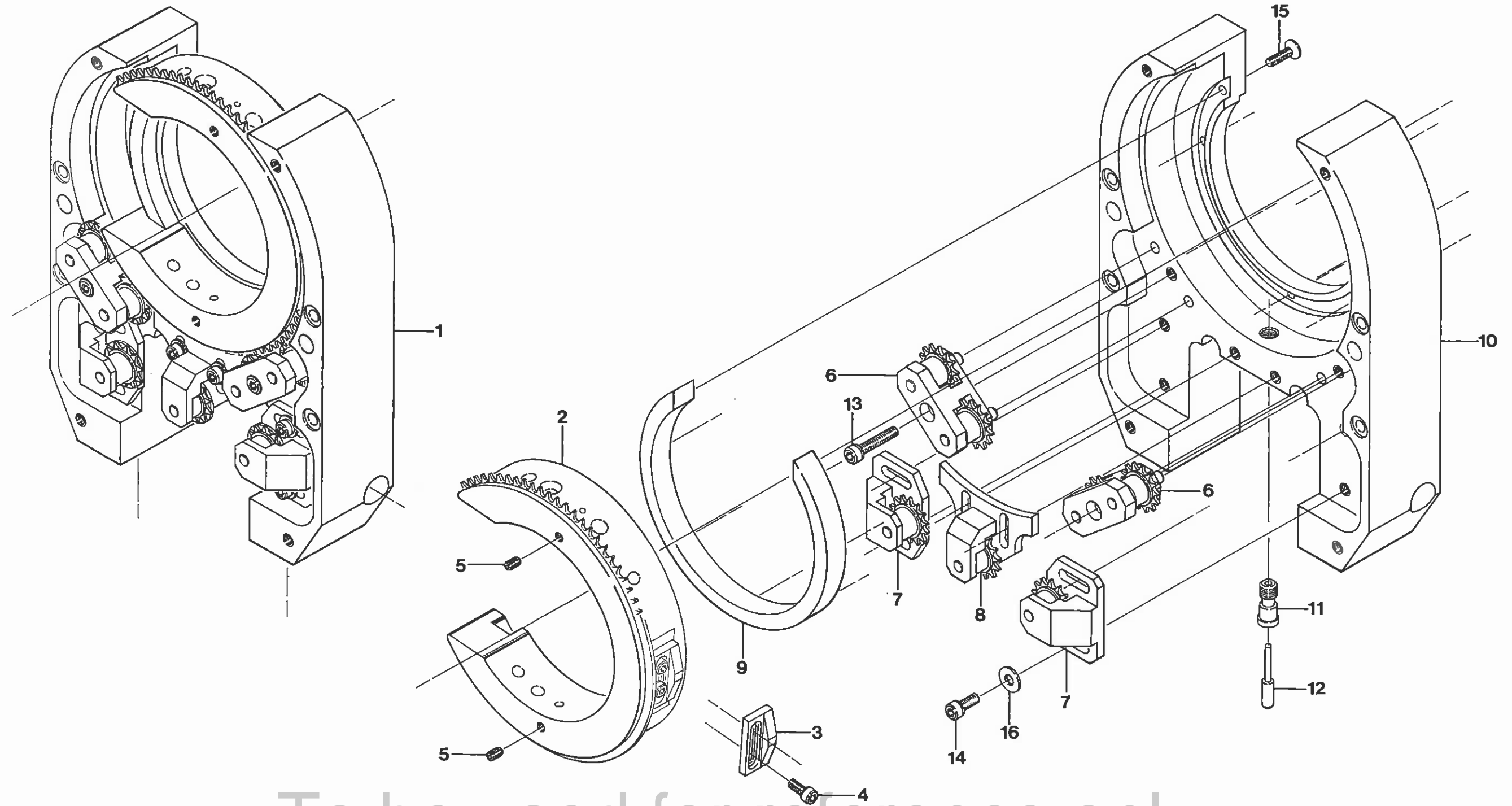
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Page 3 of 3

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MODEL 9EDL-2500
IPB 090206
HOUSING UPPER ASSEMBLY

IPB NUMBER: 090206

TO ORDER
USE PART NUMBER
DO NOT USE IPB
ITEM NUMBER

ARC MACHINES, INC.

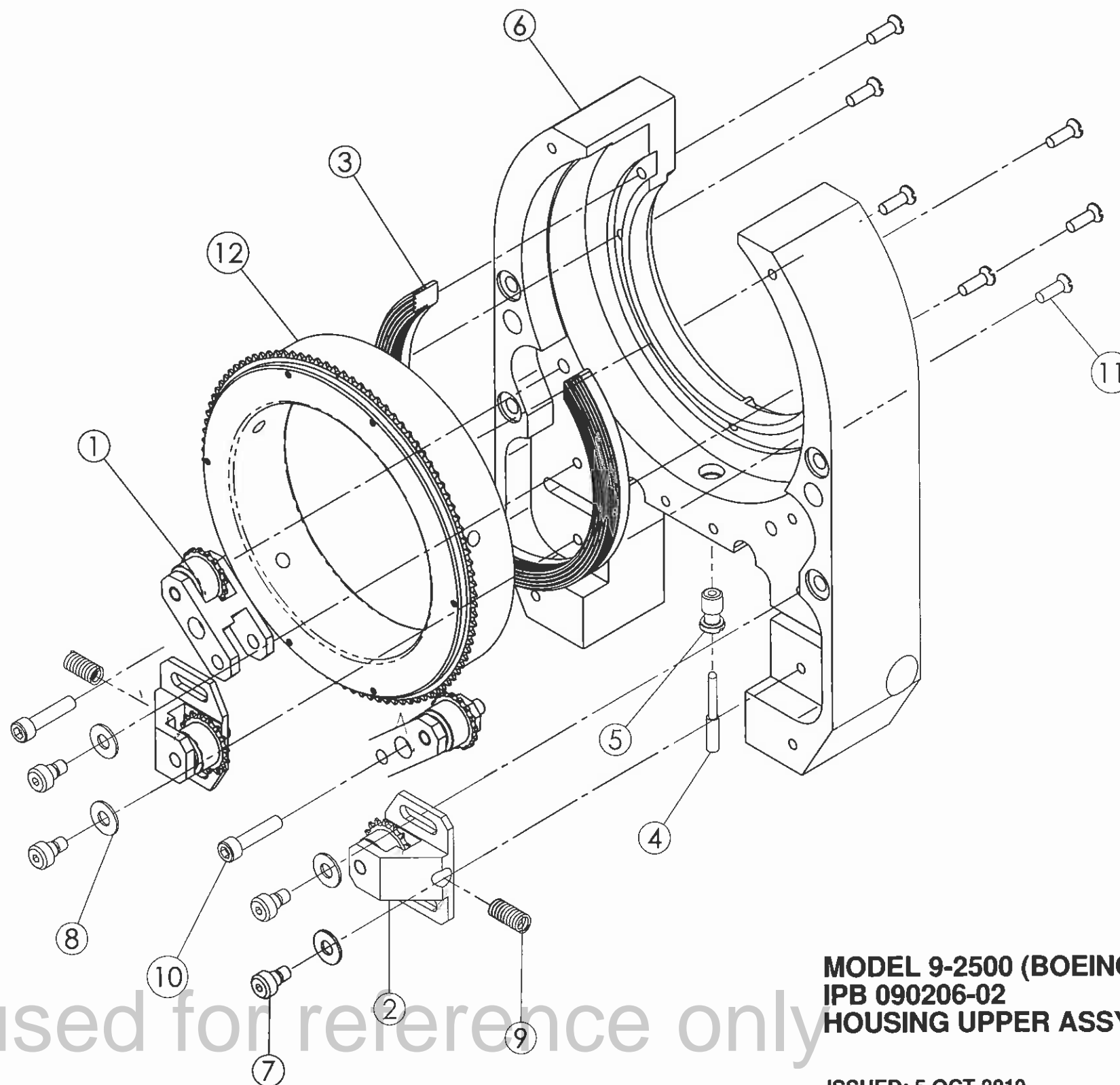
PRODUCT MODEL: 9-2500
DESCRIPTION: HOUSING UPPER ASSEMBLY
MANUAL NUMBER: 730018
NOTES: 9EDL-2500

| IPB ITEM NUMBER | QTY | U/M | PART NUMBER | DESCRIPTION | |
|--------------------|-----|-----|-----------------|--------------------------------|--------------------------|
| 1 | 1 | EA | 13090206-01 | HOUSING UPPER 9-2500 | |
| 2 | 1 | EA | 13090774-01 | ROTOR 9-2500 | (ITEMS 3,4 & 5 INCLUDED) |
| 3 | 1 | EA | 42090548-05 | CAM SWITCH | |
| 4 | 1 | SET | SCS04-40-0.31NP | SCREW CAP SKT 4-40 5/16 L | (SET OF 2) |
| 5 | 1 | SET | SSS06-32-18NPCU | SCREW SET SKT 6-32 3/16 L CUPT | (SET OF 2) |
| 6 | 2 | EA | 13090622-01 | BRACKET DRIVE SPROCKET | |
| 7 | 2 | EA | 13090623-02 | TENSIONER SIDE | |
| 8 | 1 | EA | 13090623-01 | TENSIONER CENTER | |
| 9 | 1 | EA | 42090758-01 | GUIDE RING | |
| 10 | 1 | EA | 42090153-01 | HOUSING UPPER | |
| 11 | 1 | EA | 42091110-01 | BUSHING ACTUATOR | |
| 12 | 1 | EA | 42091109-04 | PIN ACT 9-2500 | |
| 13 | 1 | SET | SCS08-32-0.75NP | SCREW CAP SKT 8-32 3/4 L | (SET OF 2) |
| 14 | 1 | SET | SCS08-32-0.37NP | SCREW CAP SKT 8-32 3/8 L | (SET OF 6) |
| 15 | 1 | SET | SFL06-32-0.50NY | SCREW FLH SLT 6-32 1/2 L NYL | (SET OF 7) |
| 16 | 6 | EA | W08ZP-FL | WASHER FL # 8 .30 THK | |

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| ITEM NO | QTY | PART NO. | DESCRIPTION |
|---------|-----|-----------------|------------------------------|
| 1 | 2 | 13090622-02 | BRACKET DRIVE SPROCKET |
| 2 | 2 | 13090623-03 | TENSIONER SIDE |
| 3 | 1 | 42090758-01 | GUIDE RING |
| 4 | 1 | 42091109-04 | PIN ACTUATOR 9-2500 |
| 5 | 1 | 42091110-01 | BUSHING ACTUATOR |
| 6 | 1 | 220901149-01 | HOUSING UPPER M9-2500 MODIF |
| 7 | 4 | 44D15 | SCREW SHLDR 8-32 3/16D .12L |
| 8 | 4 | 5720-17-32 | WASHER .19 ID .44 D .032 T |
| 9 | 2 | O-112 | SPRING CPRSN .37D .50L .055W |
| 10 | 2 | SCS08-32-0,75NP | SCREW CAP SKT 8-32 3/4 L |
| 11 | 7 | SFL06-32-0,50NY | SCREW FLH SLT 6-32 1/2L NYL |
| 12 | 1 | 130907128-01 | ROTOR, 360 DEG SOLID ASSY |



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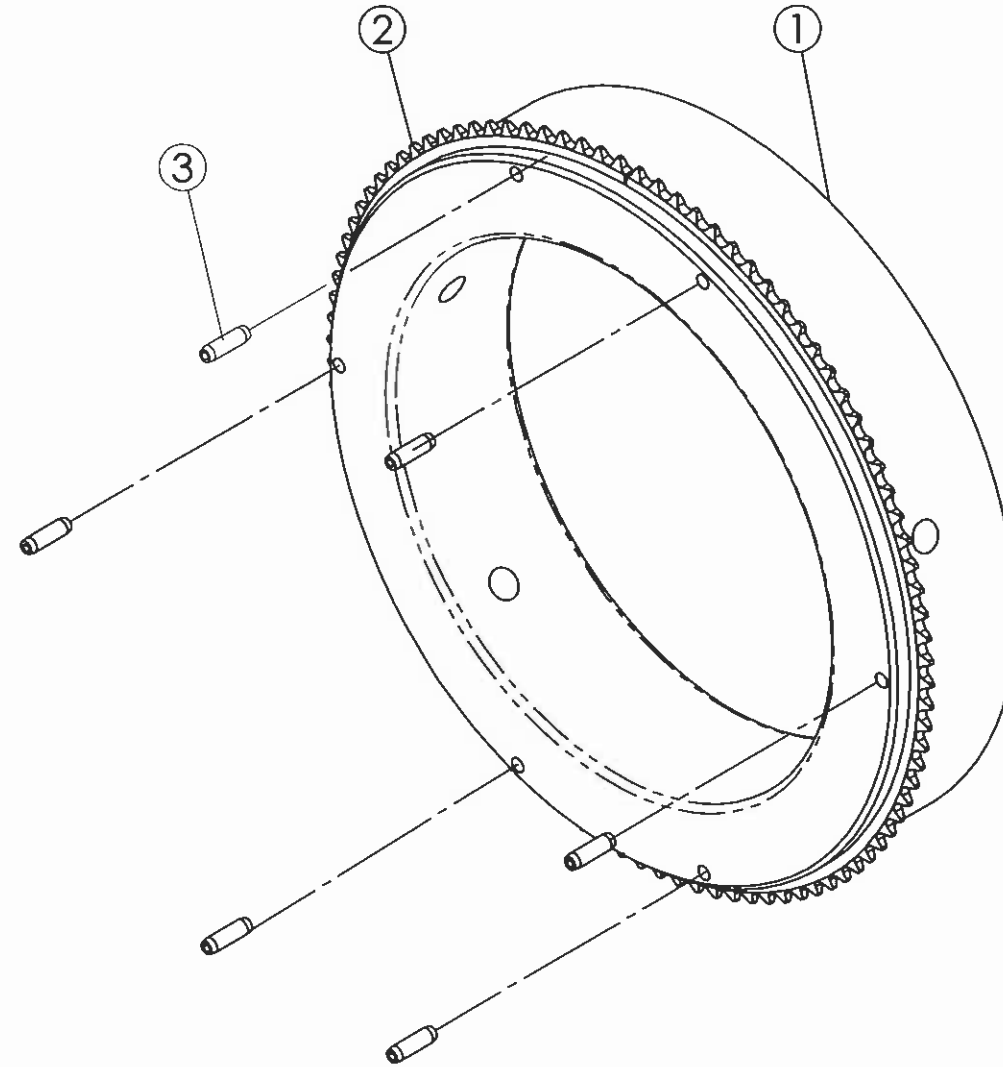
MODEL 9-2500 (BOEING)
IPB 090206-02
HOUSING UPPER ASSY

ISSUED: 5 OCT 2010
REVISED:

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TO ORDER USE PART NUMBER.
PRICE, PART NUMBER AND DESCRIPTION
SUBJECT TO CHANGE WITHOUT NOTICE.

| ITEM NO. | QTY. | PART NO. | DESCRIPTION |
|----------|------|--------------|---|
| 1 | 1 | 420907245-01 | HUB, ROTOR 360 DEG BOEING SPEC. M9-2500 |
| 2 | 1 | 420907245-02 | SPROCKET M9-2500 360 DEG |
| 3 | 6 | PR09-0,31NP | PIN ROLL 3/32D 5/16L |



To be used for reference only

MODEL 9-2500 (BOEING)
IPB 0907128
ROTOR, 360 DEG SOLID ASSY

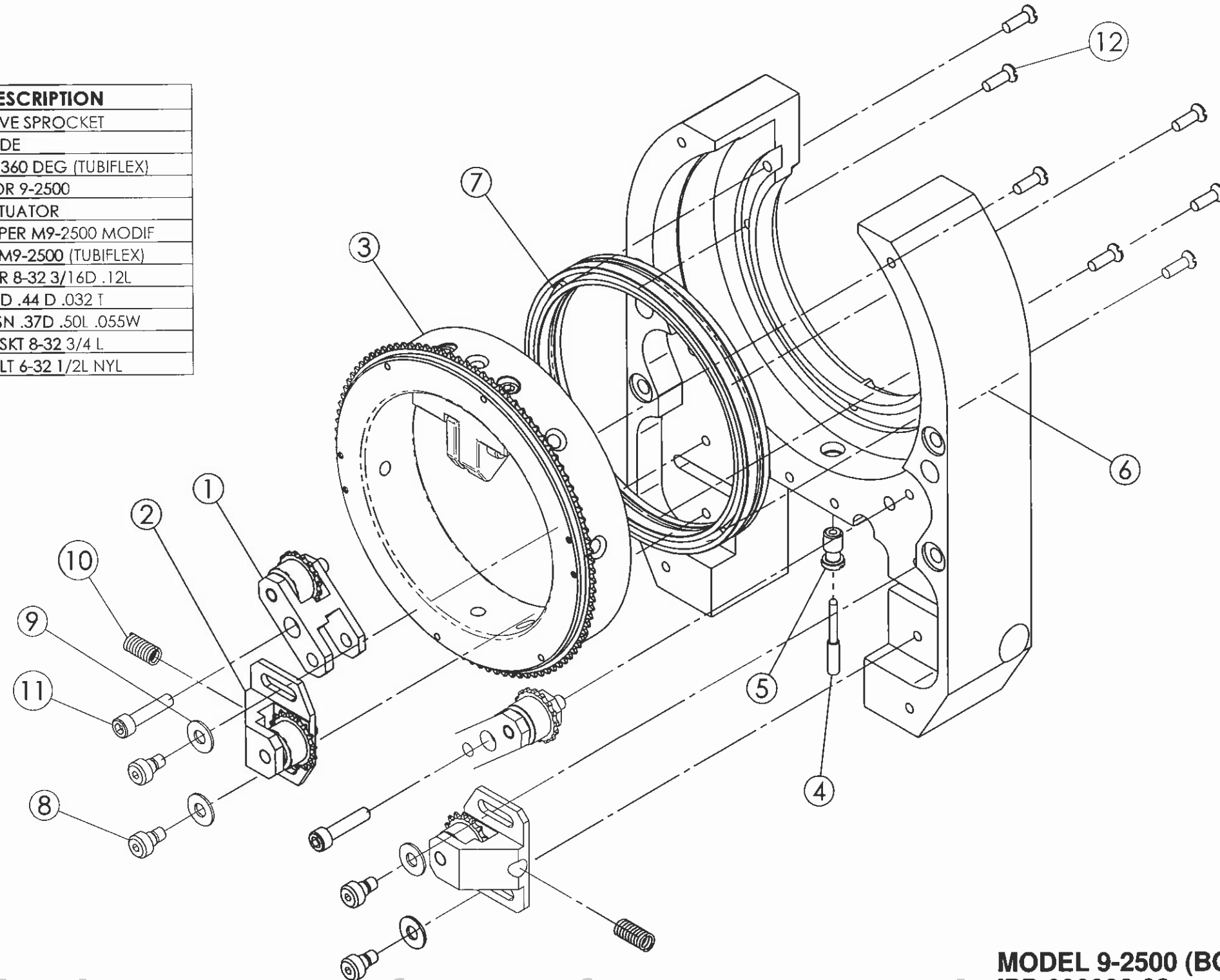
ISSUED: 27 SEPT 2010
REVISED:

TO ORDER USE PART NUMBER.
PRICE, PART NUMBER AND DESCRIPTION
SUBJECT TO CHANGE WITHOUT NOTICE.

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PAGE 1 OF 1

| ITEM NO | QTY | PART NO. | DESCRIPTION |
|---------|-----|-----------------|-------------------------------|
| 1 | 2 | 13090622-02 | BRACKET DRIVE SPROCKET |
| 2 | 2 | 13090623-03 | TENSIONER SIDE |
| 3 | 1 | 130907136-01 | ROTOR ASSY 360 DEG (TUBIFLEX) |
| 4 | 1 | 42091109-04 | PIN ACTUATOR 9-2500 |
| 5 | 1 | 42091110-01 | BUSHING ACTUATOR |
| 6 | 1 | 220901149-01 | HOUSING UPPER M9-2500 MODIF |
| 7 | 1 | 220907261-01 | GUIDE RING M9-2500 (TUBIFLEX) |
| 8 | 4 | 44D15 | SCREW SHLDR 8-32 3/16D .12L |
| 9 | 4 | 5720-17-32 | WASHER .19 ID .44 D .032 T |
| 10 | 2 | O-112 | SPRING CPRSN .37D .50L .055W |
| 11 | 2 | SCS08-32-0.75NP | SCREW CAP SKT 8-32 3/4 L |
| 12 | 7 | SFL06-32-0.50NY | SCREW FLH SLT 6-32 1/2L NYL |



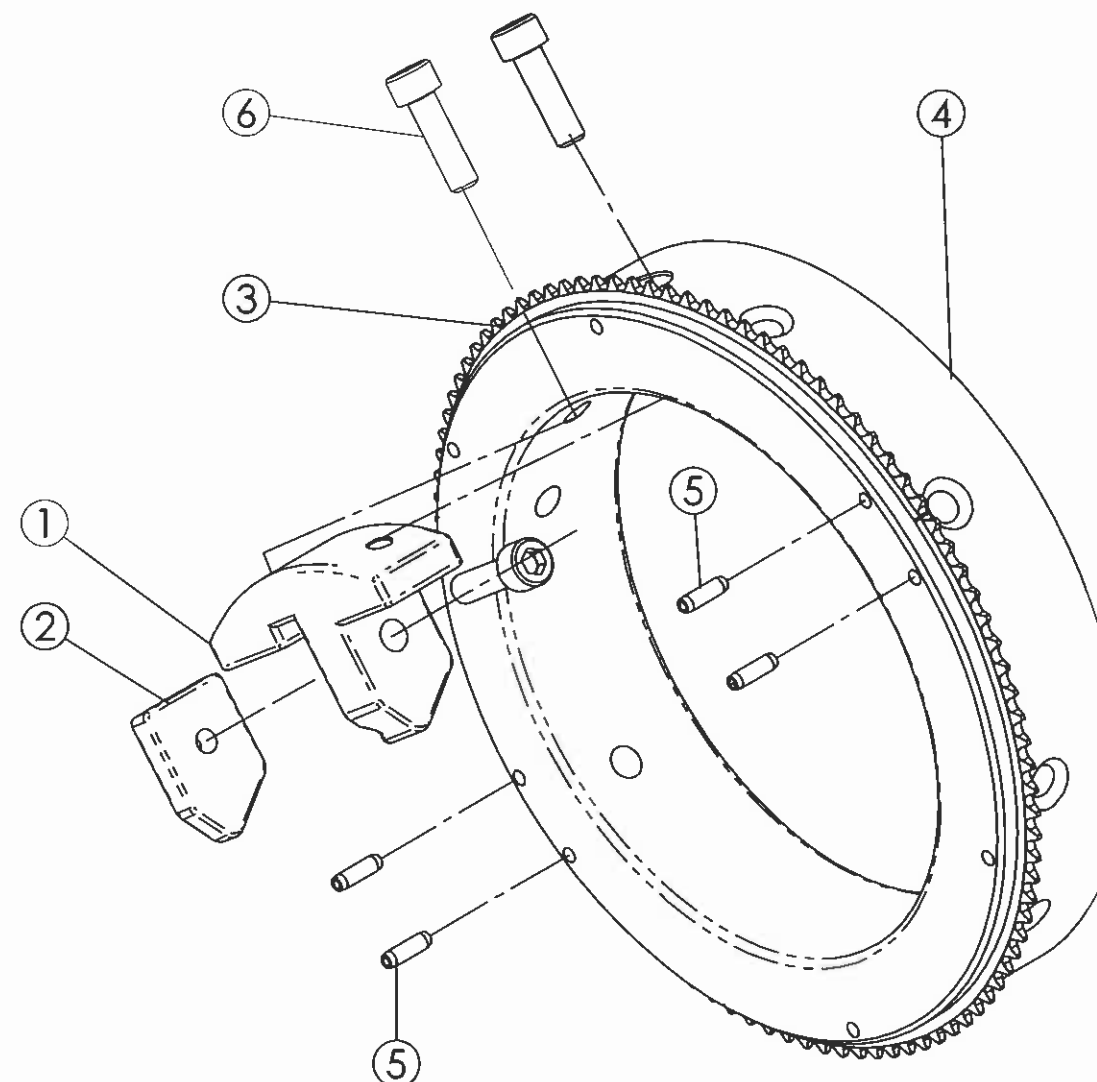
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MODEL 9-2500 (BOEING)
IPB 090206-03
HOUSING UPPER ASSY

ISSUED: 5 OCT 2010
REVISED:

TO ORDER USE PART NUMBER.
PRICE, PART NUMBER AND DESCRIPTION
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| ITEM NO. | QTY. | PART NO. | DESCRIPTION |
|----------|------|-----------------|-------------------------------------|
| 1 | 1 | 220907265-01 | BRACKET ELECTRODE HOLDER (TUBIFLEX) |
| 2 | 1 | 220907266-01 | CLAMP ELECTRODE HOLDER |
| 3 | 1 | 420907245-02 | SPROCKET M9-2500 360 DEG |
| 4 | 1 | 220907260-01 | ROTOR 360 DEG M9-2500 |
| 5 | 4 | PR09-0,31NP | PIN ROLL 3/32D 5/16L |
| 6 | 3 | SCS08-32-0,56NP | SCREW CAP SKT 8-32 9/16 L |

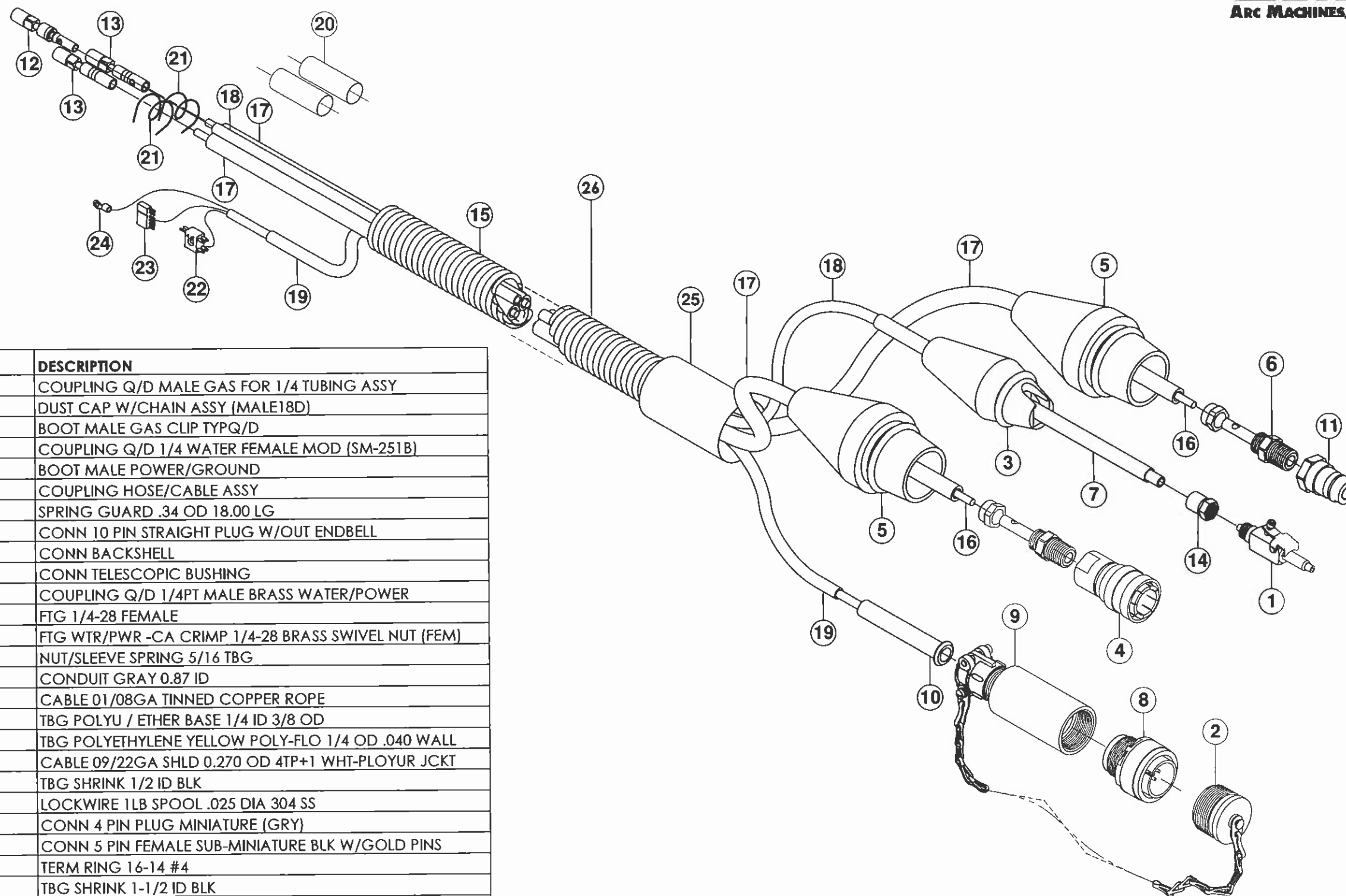
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MODEL 9-2500 (BOEING)
IPB 0907136
ROTOR ASSY 360 DEG (TUBIFLEX)

ISSUED: 5 OCT 2010
REVISED:

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PRICE, PART NUMBER AND DESCRIPTION
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| ITEM NO. | QTY. | PART NO. | DESCRIPTION |
|----------|------|-----------------|---|
| 1 | 1 | 1351109-01 | COUPLING Q/D MALE GAS FOR 1/4 TUBING ASSY |
| 2 | 1 | 1350110-04 | DUST CAP W/CHAIN ASSY (MALE18D) |
| 3 | 1 | 42060805-04 | BOOT MALE GAS CLIP TYPQ/D |
| 4 | 1 | 42060800-02 | COUPLING Q/D 1/4 WATER FEMALE MOD (SM-251B) |
| 5 | 2 | 42060804-01 | BOOT MALE POWER/GROUND |
| 6 | 2 | 42060800-07 | COUPLING HOSE/CABLE ASSY |
| 7 | 1 | AS200718 | SPRING GUARD .34 OD 18.00 LG |
| 8 | 1 | MS3106E18-1PF42 | CONN 10 PIN STRAIGHT PLUG W/OUT ENDBELL |
| 9 | 1 | G1501N186A3A | CONN BACKSHELL |
| 10 | 1 | MS39056-3 | CONN TELESCOPIC BUSHING |
| 11 | 1 | SM-252B | COUPLING Q/D 1/4PT MALE BRASS WATER/POWER |
| 12 | 1 | 2PF1 | FTG 1/4-28 FEMALE |
| 13 | 2 | ARC-1881 | FTG WTR/PWR -CA CRIMP 1/4-28 BRASS SWIVEL NUT (FEM) |
| 14 | 1 | 261-PG-04 | NUT/SLEEVE SPRING 5/16 TBG |
| 15 | 1 | DUCT-0,87-50-G | CONDUIT GRAY 0.87 ID |
| 16 | 2 | NER7-95-36T | CABLE 01/08GA TINNED COPPER ROPE |
| 17 | 2 | 42090806-01 | TBG POLYU / ETHER BASE 1/4 ID 3/8 OD |
| 18 | 1 | 44-P-YELLOW | TBG POLYETHYLENE YELLOW POLY-FLO 1/4 OD .040 WALL |
| 19 | 1 | CWT11943 | CABLE 09/22GA SHLD 0.270 OD 4TP+1 WHT-PLOYUR JCKT |
| 20 | 2 | M23053/5-108-0 | TBG SHRINK 1/2 ID BLK |
| 21 | 2 | MS20995C25 | LOCKWIRE 1LB SPOOL .025 DIA 304 SS |
| 22 | 1 | JF2P2SCD | CONN 4 PIN PLUG MINIATURE (GRY) |
| 23 | 1 | 7052 | CONN 5 PIN FEMALE SUB-MINIATURE BLK W/GOLD PINS |
| 24 | 1 | 34119 | TERM RING 16-14 #4 |
| 25 | 1 | M23053/5-111-0 | TBG SHRINK 1-1/2 ID BLK |
| 26 | - | 13090800-01 | CABLE ASSEMBLY 10 FT M9 GENERIC |

To be used for reference only

MODEL 9
IPB 090800
CABLE ASSEMBLY

ISSUED: 3 JAN 2005
REVISED: 5 OCT 2010

TO ORDER USE PART NUMBER.
PRICE, PART NUMBER AND DESCRIPTION
SUBJECT TO CHANGE WITHOUT NOTICE.

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THIS IPB SUPERSEDES ALL OTHER IPB'S
REFERENCING 13090800-01 CABLE ASSEMBLY

