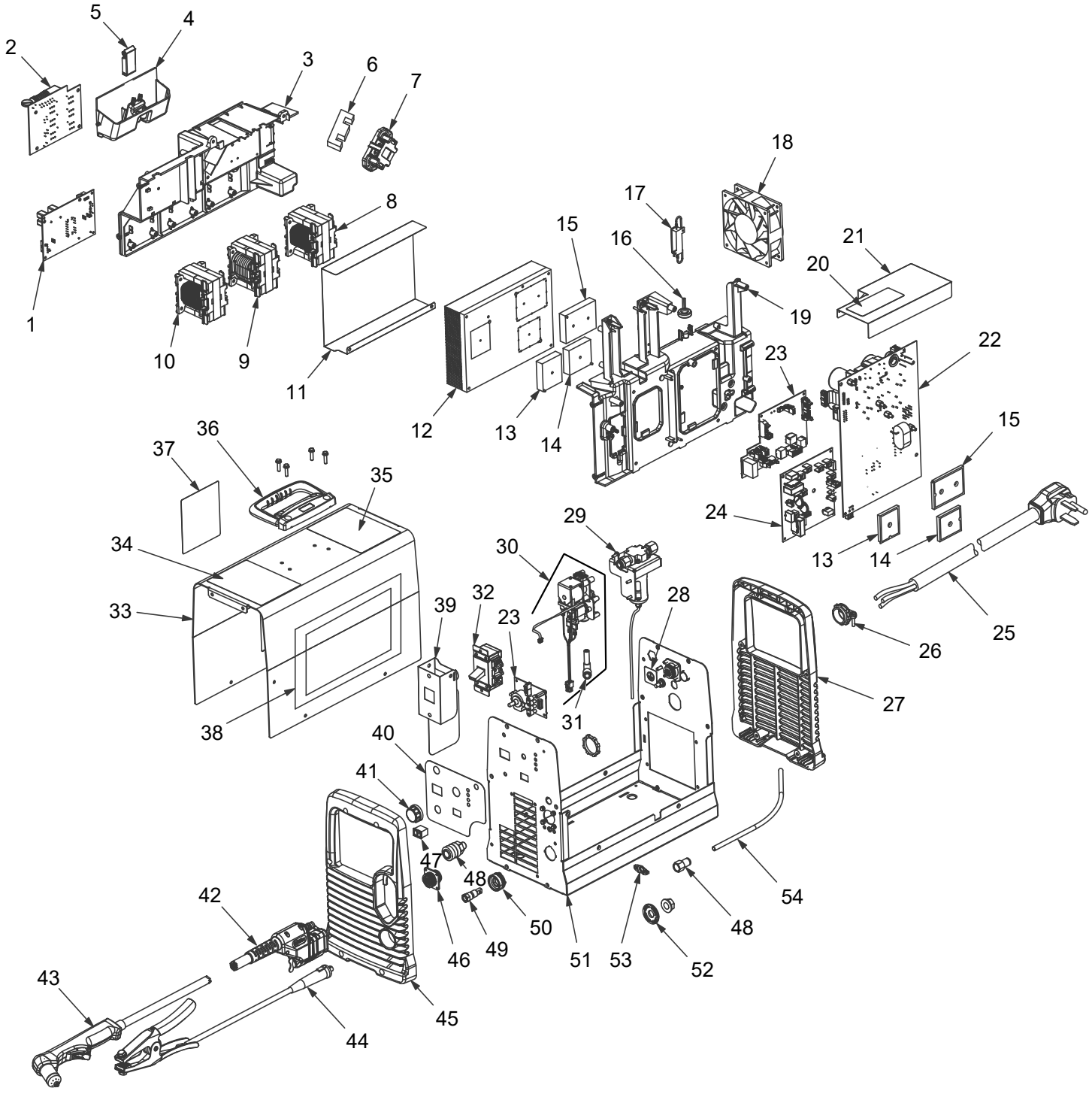
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Spectrum 875
Spectrum 875 Auto-Line
XT60 Torch



PARTS MANUAL

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Main Assembly, Spectrum 875 (Eff. with NF444004P)

Main Assembly, Spectrum 875 (Eff. with NF444004P)

Item No.	Dia. Mkgs.	Part No.	Description	Qty
1	PC3	235639	Circuit Card Assy, Flyback Pwr Supply 875 208/230V	1
2	PC6	290182	Circuit Card Assy, Input Filter	1
3		235574	↓ Windtunnel, Magnetics	1
4		235579	→ Door, Consumable Storage Box w/Latch	1
5		089899	→ Latch, Slide Flush Style Series 40	1
6		109056	Core, Ferrite E 2.164 Lg x 1.094 High x .826 Wide	1
7	L2	234905	Inductor, Dl/DT Boost	1
8	L1	234920	Inductor, Input	1
9	T1	234810	Xfmr, HF	1
10	L3	234924	↓ Inductor, Output	1
/	RT1	237787	→ Thermistor, NTC 10K Ohm @ 25 Deg C	1
11		237138	Insulator,Heat Sink	1
12		234818	Heat Sink, Primary/Secondary	1
13	PM3	247083	Kit, Output Rectifier/Pilot IGBT	1
14	PM2	234847	Kit, Inverter IGBT w/Cover	1
15	PM1	234846	Kit, Input Rectifier/Boost IGBT w/Cover	1
16	CT1	236848	Xfmr, Current Sensing 200/1 w/6in Leads	1
17	R3	238142	Resistor, WW Fxd 50 W 25 Ohm Ni 5%	1
18	FM1	246973	Fan, Muffin w/Leads & Guard	1
19		235573	Windtunnel, Heat Sink	1
20		208622	Label, Warn Elect Shock/Explod Parts/Do Not Remove	1
21		237137	Insulator, Valve Bracket	1
22	PC2	245756	Kit, Primary Intrcnnct Bd Assy, 60Amp 230V w/Hardware (Does not include PM1 and PM2)	1
23	PC1	292301	Circuit Card Assy, Control Spectrum 875 w/Program	1
24	PC4	298306	Circuit Card Assy, Intrcnctng Secondary 60A (R)	1
25		269483	Cable, Power 10 Ft 8ga 3c	1
26		604102	Conn, Clamp Cable 1000	1
27		234806	Panel, Rear Plastic	1
28		237017	Label, Air Pressure 90-120Psi/621-827kPA	1
29		236002	Filter, Air w/Ftg & Bracket	1
30	PV1	238537	↓ Valve Assy, w/Transducer	1
/		234169	→ Valve Assy w/o Transducer	1
/	PC5	241301	→ Kit, Replacement Circuit Card Assy Pressure Switch	1
/	PS1	285400	→ Sensor, Pressure 0-100mV DC/0-100Psi	1
31		234837	Ftg, Plstc/Brs Elbow Qdisc 3/8 Od x 5/16 Od Tbg	1
32	S1	250006	Switch, Power	1
/		276667	↓ Cover Assy	1
33		234893	→ Wrapper	1
34		234129	→ Label, Warning Precautionary Plasma Cutting Equip	1
35		234130	→ Label, Warning Precaution Plasma Ctng Equip Spanish	1
36		276345	→ Handle, Rubberized Carrying	1
37		265172	→ Label, XT60 Consumables	1
38		189784	→ Insulator, Wrapper	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.

Hardware is common and not available unless listed.

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.

Main Assembly, Spectrum 875 (Eff. with NF444004P)

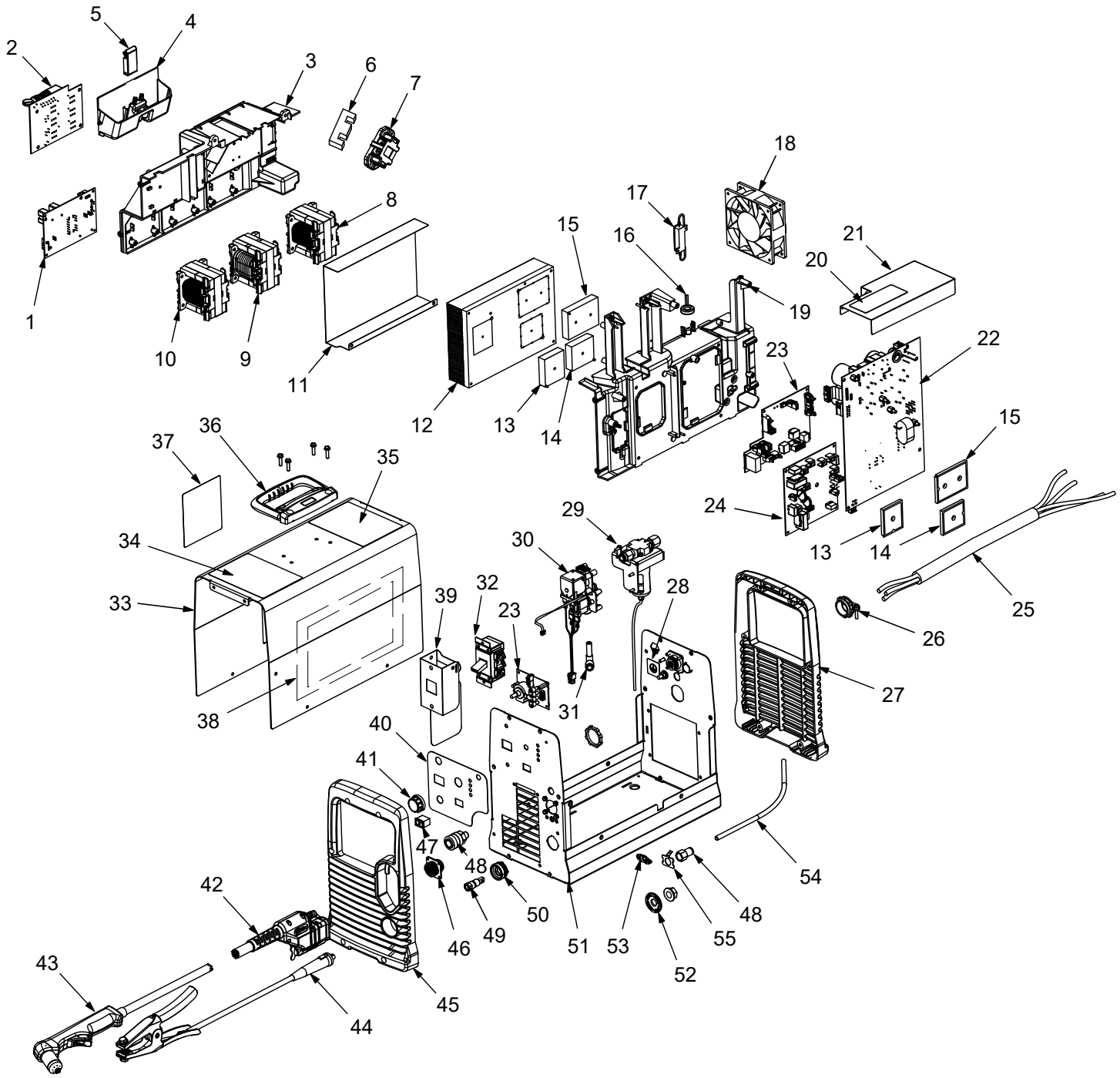
Item No.	Dia. Mkgs.	Part No.	Description	Qty
39		238770	Insulator, Switch Power	1
40		234155	Nameplate	1
41		174991	Knob, Pointer 1.250 Dia x .250 Id w/Spring Clip-.21	1
42		234754	Kit, XT60 QD w/Wing Head Fastener	1
43		249953	XT60, 20ft Hand Held Torch (Replacement)	1
43		249954	XT60, 50ft Hand Held Torch (Replacement)	1
44		234838	↓ Cable, Work 20 Ft 6Ga w/Male (Dinse Type) Conn & Clamp	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 0.10 x .750 x Coil Dead Soft	1
44		234930	↓ Cable, Work 50 Ft 6Ga w/Male (Dinse Type) Conn & Clamp	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 0.10 x .750 x Coil Dead Soft	1
45		234805	Panel, Front Plastic	1
46		234895	Lead Assy, Elect (Torch Recpt To Cntrl/Secndry Bds)	1
47		238453	Switch, Cut/Gouge w/Leads	1
48		249590	Kit, Replacement Air Fittings	1
49		234841	Receptacle, Twist Lock Brass Fem Panel Mtg (Mini Dinse)	1
50		237020	Insulator, Receptacle Twist Lock (Mini-Dinse Type)	1
51		292940	Case Section, Base/Front/Rear	1
52		237021	Washer, Insulator Keyed Twist Lock Receptacle	1
53		235580	Receptacle, Fastener Quarter Turn Stud Riveted	1
54		234833	Tubing, Pneumatic .312 Od x .236 Id x 13.125	1

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

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Main Assembly, Spectrum 875 Auto-Line (Eff. with NF454006P)

Main Assembly, Spectrum 875 Auto-Line (Eff. with NF454006P)

Item No.	Dia. Mkgs.	Part No.	Description	Qty
1	PC3	234179	Circuit Card Assy, Flyback Pwr Supply	1
2	PC6	242280	Circuit Card Assy, Input Filter	1
3		243959	↓ Windtunnel, Lh w/Cmpnts	1
4		235579	→ Door, Consumable Storage Box w/Latch	1
5		089899	→ Latch, Slide Flush Style Series 40	1
6		109056	Core, Ferrite E 2.164 Lg x 1.094 High x .826 Wide	1
7	L2	243337	Inductor, Dl/DT Boost	1
8	L1	243339	Inductor, Input	1
9	T1	242583	Xfmr, HF	1
10	L3	245556	↓ Inductor, Output	1
/	RT1	237787	→ Thermistor, NTC 10K Ohm @ 25 Deg C	1
11		237138	Insulator,Heat Sink	1
12		234818	Heat Sink, Primary/Secondary	1
13	PM3	247083	Kit, Output Rectifier/Pilot IGBT	1
14	PM2	242877	Kit, Inverter IGBT	1
15	PM1	242878	Kit, Input Rectifier/Boost IGBT	1
16	CT1	236848	Xfmr, Current Sensing 200/1 w/6in Leads	1
17	R3	238142	Resistor, WW Fxd 50 W 25 Ohm Ni 5%	1
18	FM1	246973	Fan, Muffin w/Leads & Guard	1
19		235573	Windtunnel, Heat Sink	1
20		208622	Label, Warn Elect Shock/Explod Parts/Do Not Remove	1
21		237137	Insulator, Valve Bracket	1
22	PC2	245756	Kit, Primary Intrcnnct Bd Assy, 60Amp 230V w/Hardware (Does not include PM1 and PM2)	1
23	PC1	292304	Circuit Card Assy, Cntrl Spect 875W/Pgm (Auto-Line)	1
24	PC4	298306	Circuit Card Assy, Intrcnctng Secondary 60A (R)	1
25		243613	Cable, Power 10Ft 8Ga 4C	1
26		604102	Conn, Clamp Cable 1000	1
27		234806	Panel, Rear Plastic	1
28		237017	Label, Air Pressure 90-120Psi/621-827kPA	1
29		236002	Filter, Air w/Ftg & Bracket	1
30	PV1	238537	↓ Valve Assy, w/Transducer	1
/		234169	→ Valve Assy w/o Transducer	1
/	PC5	241301	→ Kit, Replacement Circuit Card Assy Pressure Switch	1
/	PS1	285400	→ Sensor, Pressure 0-100mV DC/0-100Psi	1
31		234837	Ftg, Plstc/Brs Elbow Qdisc 3/8 Od x 5/16 Od Tbg	1
32	S1	245907	Switch Assy, Power	1
/		276667	↓ Cover Assy	1
33		234893	→ Wrapper	1
34		234129	→ Label, Warning Precautionary Plasma Cutting Equip	1
35		234130	→ Label, Warning Precaution Plasma Ctng Equip Spanish	1
36		276345	→ Handle, Rubberized Carrying	1
37		265172	→ Label, XT60 Consumables	1
38		189784	→ Insulator, Wrapper	1

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

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Main Assembly, Spectrum 875 Auto-Line (Eff. with NF454006P)

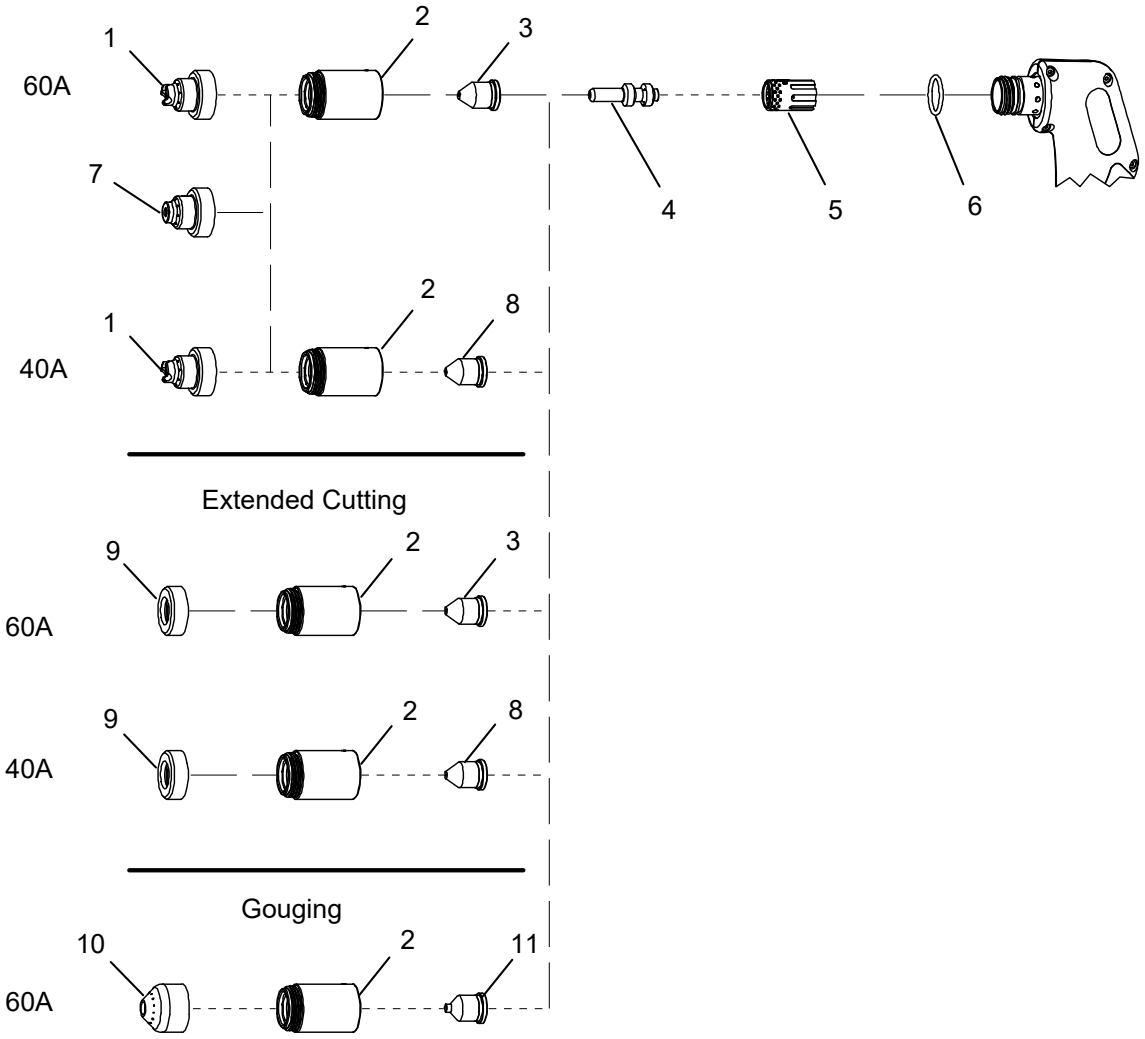
Item No.	Dia. Mkgs.	Part No.	Description	Qty
39		238770	Insulator, Switch Power	1
40		237141	Nameplate	1
41		174991	Knob, Pointer 1.250 Dia x .250 Id w/Spring Clip-.21	1
42		234754	Kit, XT60 QD w/Wing Head Fastener	1
43		249953	XT60, 20ft Hand Held Torch (Replacement)	1
43		249954	XT60, 50ft Hand Held Torch (Replacement)	1
44		234838	↓ Cable, Work 20 Ft 6Ga w/Male (Dinse Type) Conn & Clamp	1
/		213619	→Clamp, Work 300 Amp Stl Chrome Pld w/Cop Contacts	1
/		213620	→Contact Tip, Work Clamp 300amp Copper	1
/		127836	→Conn, Tw Lk Insul Male (Dinse Type) 25 Series	1
/		605520	→Strip, Cop 0.10 x .750 x Coil Dead Soft	1
44		234930	↓ Cable, Work 50 Ft 6Ga w/Male (Dinse Type) Conn & Clamp	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 0.10 x .750 x Coil Dead Soft	1
45		234805	Panel, Front Plastic	1
46		234895	Lead Assy, Elect (Torch Recpt To Cntrl/Secndry Bds)	1
47		238453	Switch, Cut/Gouge w/Leads	1
48		249590	Kit, Replacement Air Fittings	1
49		234841	Receptacle, Twist Lock Brass Fem Panel Mtg (Mini Dinse)	1
50		237020	Insulator, Receptacle Twist Lock (Mini-Dinse Type)	1
51		292940	Case Section, Base/Front/Rear	1
52		237021	Washer, Insulator Keyed Twist Lock Receptacle	1
53		235580	Receptacle, Fastener Quarter Turn Stud Riveted	1
54		234833	Tubing, Pneumatic .312 Od x .236 Id x 13.125	1
55		237130	Clip, Grd .250 x .032 Frict Term Male w/.575 Mtg Hole	1

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

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Consumable Parts for XT60

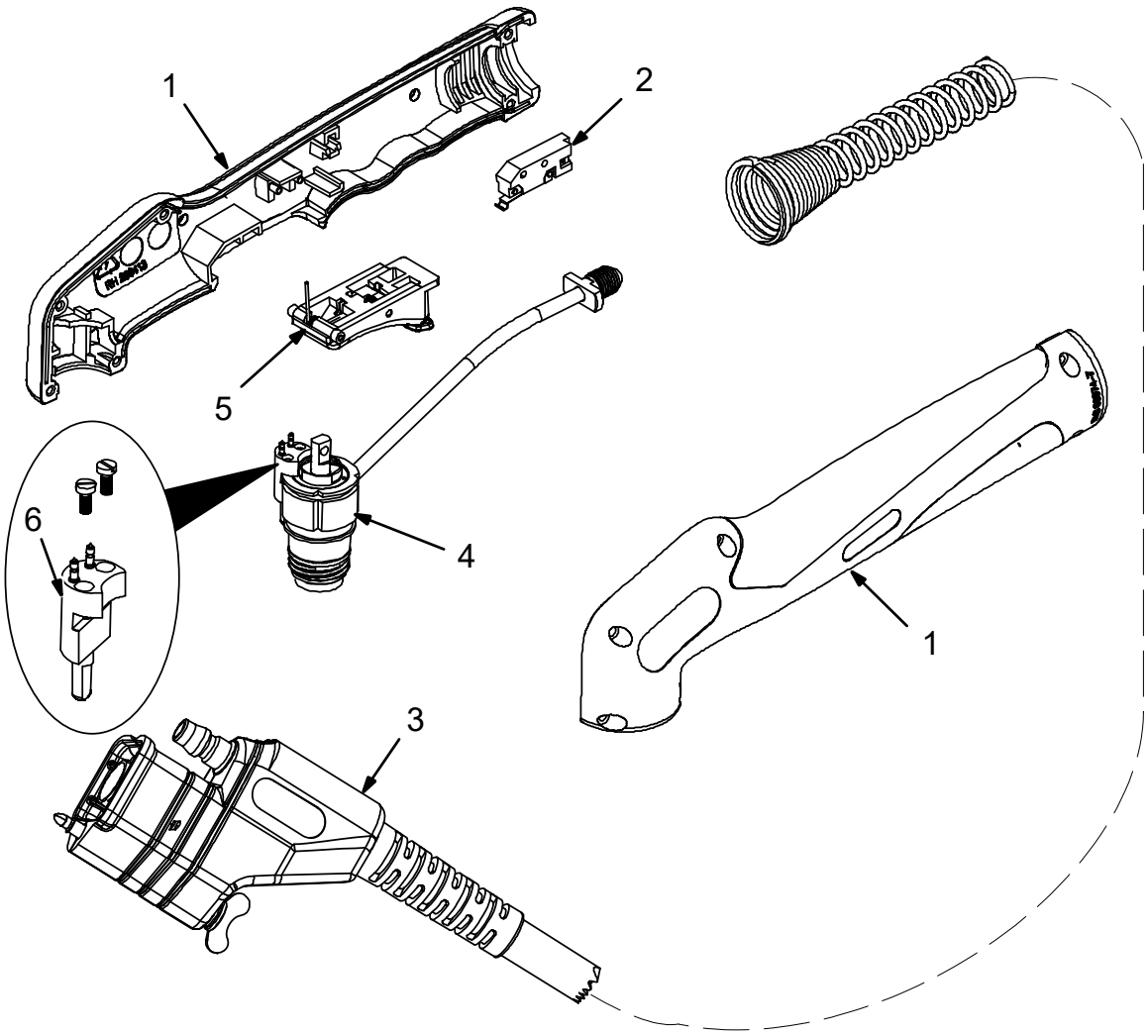
	Item No.	Dia. Mkgs.	Part No.	Description	Qty
*	1		256027	40/60A Drag Shield, Standard Cutting	
*	2		256029	40/60A Retaining Cup, Standard Cutting/Extended Cutting/Gouging	
*	3		249929	60A Tip, Standard Cutting/Extended Cutting	
*	4		256026	Electrode	
*	5		256028	Swirl Ring	
*	6		263834	O-Ring	
*	7		265226	60A Shield, Machine Cutting	
*	8		262643	40A Tip, Standard Cutting/Extended Cutting	
*	9		256030	40/60A Deflector, Extended Cutting	
*	10		256031	60A Shield, Gouging	
*	11		249935	60A Tip, Gouging	

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Torch, XT60

Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		263950	Torch Handle Kit	1
2		249971	Torch Trigger Microswitch	1
3		249961	Leads, 20 Ft w/Quick Disconnect	1
3		249962	Leads, 50 Ft w/Quick Disconnect	1
4		256039	Torch Body Kit	1
5		249972	Torch Trigger Assembly w/Spring	1
6		249973	Cup Detect Switch w/Screws 30-60Amp	1
/		252951	Grease, Silicone	1
/		249953	XT60, 20ft Hand Held Torch (Replacement)	1
/		249954	XT60, 50ft Hand Held Torch (Replacement)	1

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