

POWERTEC® i250C, i320C STANDARD POWERTEC® i250C, i320C ADVANCED POWERTEC® i380C, i450C ADVANCED

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CODE: 50559	10



Spare Parts

SP50607, SP50555, SP50608, SP50557, SP50558, SP50559 REV02
03/2022

ASSEMBLY PAGE NAME			Machine Assembly	Inside Machine Assembly	Inside Machine Assembly	Wire Drive Assembly	Front Assembly	Miscellaneous Items
CODE NO.:	K NO.:	FIGURE NO.:	A	B	C	D	E	
50607	K14284-1	POWERTEC® i250C STANDARD	1	1	-	1	1	1
50555	K14285-1	POWERTEC® i250C ADVANCED	2	2	-	2	2	2
50608	K14286-1	POWERTEC® i320C STANDARD	3	3	-	3	3	3
50557	K14287-1	POWERTEC® i320C ADVANCED	4	4	-	4	4	4
50558	K14288-1	POWERTEC® i380C ADVANCED	5	5	-	5	5	5
50559	K14289-1	POWERTEC® i450C ADVANCED	6	-	6	6	6	6

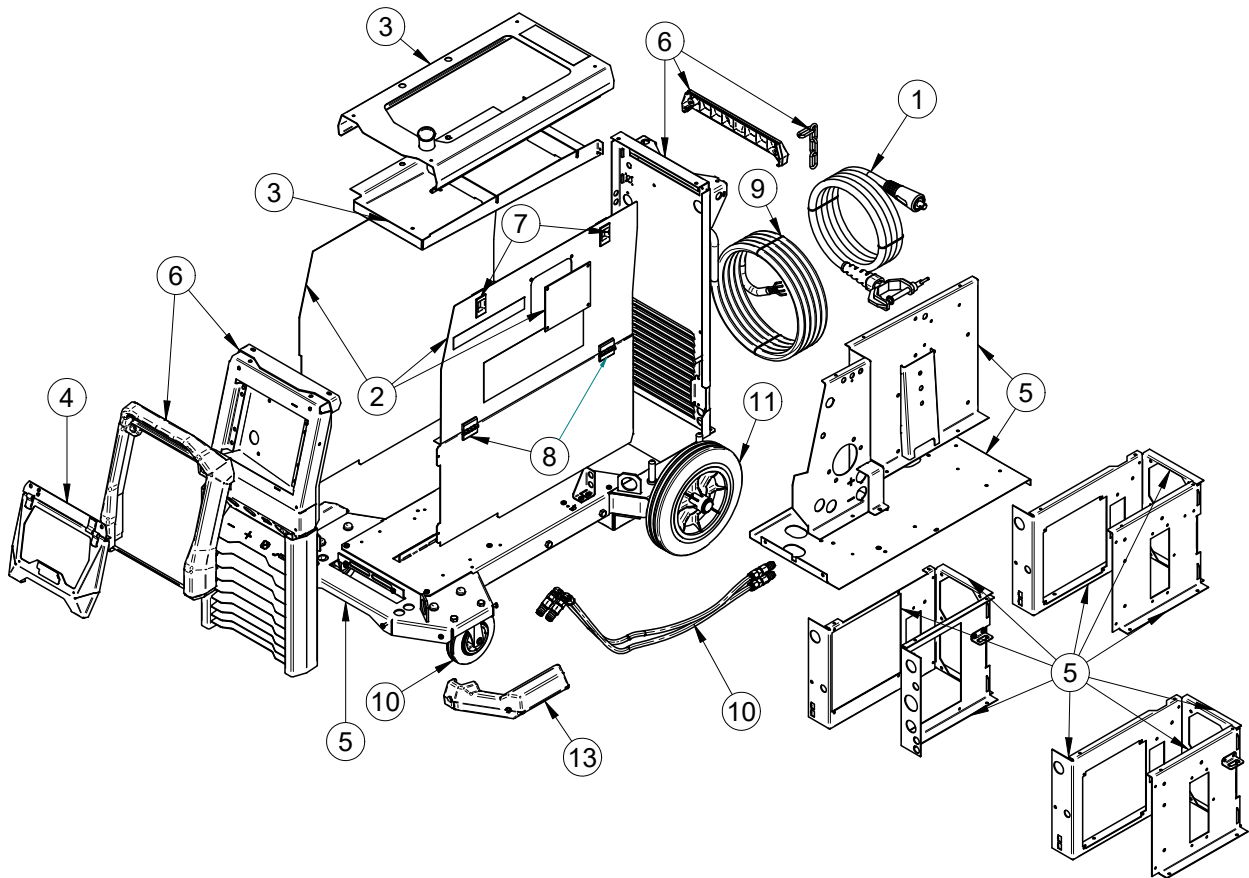


Figure A

Figure A: Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
1	WELDING CABLE	D-5578-176-4R	1	X	X	X	X			
	WELDING CABLE	R-5041-024-1R	1					X		
	WELDING CABLE	R-5041-024-2R	1						X	
2	SIDE PANEL KIT includes:	T-8040-077-1R	1	X	X	X	X	X	X	
	LEFT SIDE PANEL		1	X	X	X	X	X	X	
	UPPER SIDE PANEL		1	X	X	X	X	X	X	
	BOTTOM SIDE PANEL		1	X	X	X	X	X	X	
	PLATE		1	X	X	X	X	X	X	
	LABEL - ROLLS COLOURS		1	X	X	X	X	X	X	
	LABEL - POWERTEC®		2	X	X	X	X	X	X	
	LABEL - LINCOLN ELECTRIC		2	X	X	X	X	X	X	
3	COVER KIT includes:	T-8040-078-1R	1	X	X	X	X	X	X	
	COVER		1	X	X	X	X	X	X	
	SHELF		1	X	X	X	X	X	X	
	WARNING LABEL		1	X	X	X	X	X	X	
4	CONTROL PANEL COVER	T-8040-079-1R	1					X	X	
5	BASE, PARTITION, SHELF KIT includes:	T-8040-080-1R	1	X	X	X	X			
	BASE ASSEMBLY		1	X	X	X	X			
	PARTITION ASSEMBLY		1	X	X	X	X			
	USB LABEL		1	X	X	X	X			
	WARNING LABEL		1	X	X	X	X			
	SHELF		1	X	X	X	X			
	FUSE LABEL		1	X	X	X	X			
	BRACKET		1	X	X	X	X			
5	BASE, PARTITION, SHELF KIT includes:	T-8040-091-1R	1					X		
	BASE ASSEMBLY		1					X		
	PARTITION ASSEMBLY		1					X		
	USB LABEL		1					X		
	WARNING LABEL		1					X		
	SHELF		1					X		
	FUSE LABEL		1					X		
	BRACKET		1					X		
5	BASE, PARTITION, SHELF KIT includes:	T-8040-081-1R	1						X	
	BASE ASSEMBLY		1						X	
	PARTITION ASSEMBLY		1						X	
	USB LABEL		1						X	
	WARNING LABEL		1						X	
	SHELF		1						X	
	FUSE LABEL		1						X	
	BRACKET		1						X	

6	FRONT AND REAR PANEL KIT:	T-8040-082-1R	1	X	X	X	X			
	FRONT PANEL ASSEMBLY		1	X	X	X	X			
	REAR PANEL ASSEMBLY		1	X	X	X	X			
	FRONT HANDLE COMPLETE		1	X	X	X	X			
	BACK PANEL		1	X	X	X	X			
	COVER		1	X	X	X	X			
	GAS LABEL		1	X	X	X	X			
	CHAIN		1	X	X	X	X			
6	FRONT AND REAR PANEL KIT:	T-8040-083-1R	1					X		
	FRONT PANEL ASSEMBLY		1					X		
	REAR PANEL ASSEMBLY		1					X		
	FRONT HANDLE COMPLETE		1					X		
	IN LABEL		1					X		
	OUT LABEL		1					X		
	IN/OUT LABEL		1					X		
	BACK PANEL		1					X		
	COVER		1					X		
	GAS LABEL		1					X		
	CHAIN		1					X		
6	FRONT AND REAR PANEL KIT:	T-8040-092-1R	1						X	
	FRONT PANEL ASSEMBLY		1						X	
	REAR PANEL ASSEMBLY		1						X	
	FRONT HANDLE COMPLETE		1						X	
	IN LABEL		1						X	
	OUT LABEL		1						X	
	IN/OUT LABEL		1						X	
	BACK PANEL		1						X	
	COVER		1						X	
	GAS LABEL		1						X	
	CHAIN		1						X	
7	LOCK	0654-610-004R	2	X	X	X	X	X	X	
8	LEAF HINGE	0654-610-007R	2	X	X	X	X	X	X	
9	MAIN INPUT CORD	R-5041-497-1R	1	X	X	X	X	X		
9	MAIN INPUT CORD	R-5041-497-2R	1						X	
10	WHEELS	1029-660-127R	2	X	X	X	X	X	X	
11	WHEELS	1029-660-250R	2	X	X	X	X	X	X	
12	WATER CONNECTION KIT:	T-8040-084-1R	1					X	X	
	COOLING HOSES		2					X	X	
	COUPLING RECTUS		4					X	X	
	THREAD ADAPTER		4					X	X	
	ORIENTING ELBOW MALE ADAPTOR		2					X	X	
	STRAIGHT MALE ADAPTOR		2					X	X	
13	BUMPER KIT	T-8040-047-1R	2					X	X	

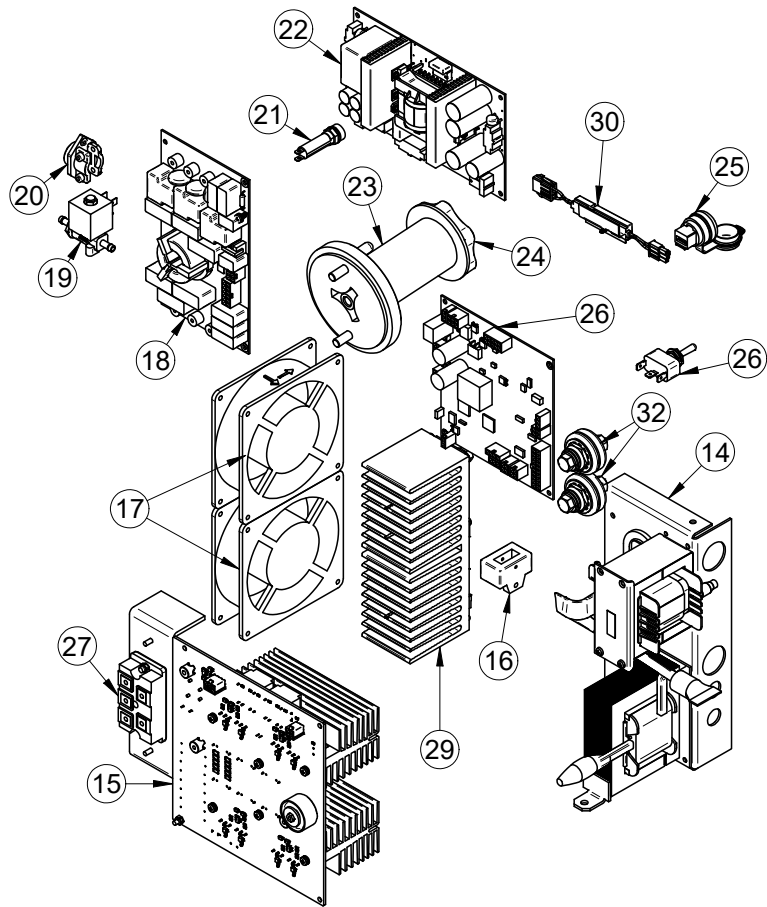


Figure B

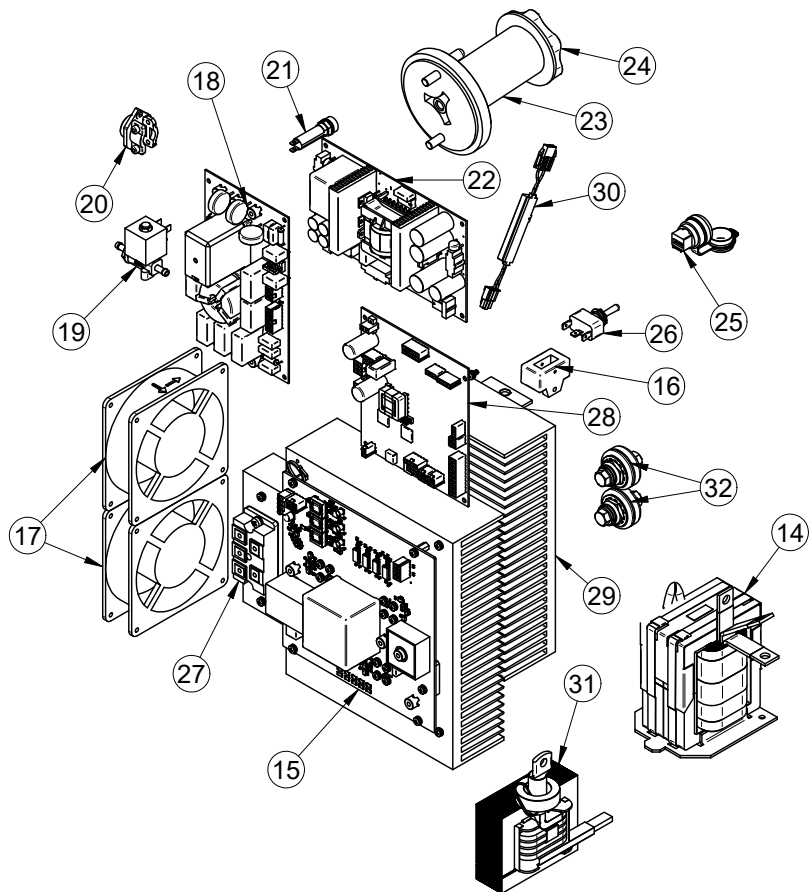


Figure C

Figure B, C: Inside Machine Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
14	TRANSFORMER AND CHOKE	R-8040-420-1R	1	X	X	X	X	X		
	TRANSFORMER	R-4034-175-2R	1						X	
15	INVERTER BOARD	R-6042-079-1R	1	X	X	X	X	X		
	INVERTER BOARD	T-8040-022-1R	1						X	
16	HALL SENSOR	W4900004R	1	X	X	X	X	X	X	
17	FAN	W66X1369R	2	X	X	X	X		X	
	FAN	R-8040-433-1R	2					X		
18	INPUT FILTER	Y051-1R	1	X	X	X	X	X		
	INPUT FILTER	Y056-1R	1						X	
19	SOLENOID	0972-423-040R	1	X	X	X	X	X	X	
20	CABLE RELIEF	1361-599-674R	1	X	X	X	X	X	X	
21	FUSE SOCKET	1158-632-032R	1	X	X	X	X	X	X	
	FUSE 1A 400V	1158-660-010R	1	X	X	X	X			
	FUSE 2A 400V	1158-660-003R	1					X	X	
22	PC BOARD	R-6042-081-1R	1	X	X	X	X	X	X	
23	WIRE SPOOL HUB	0744-000-335R	1	X	X	X	X	X	X	
24	PLASTIC NUT	0744-000-336R	1	X	X	X	X	X	X	
25	USB SOCKET	1158-641-061R	1		X		X	X	X	
26	SWITCH	1115-280-004R	1	X	X	X	X	X	X	
27	THREE PHASE BRIDGE	W4100021R	1	X	X	X	X	X	X	
28	CONTROL BOARD	R-6042-080-1R	1				X			
	CONTROL BOARD	R-6042-080-2R	1			X				
	CONTROL BOARD	R-6042-082-1R	1		X					
	CONTROL BOARD	R-6042-082-2R	1	X						
	CONTROL BOARD	R-6042-087-1R	1					X		
	CONTROL BOARD	R-6042-089-1R	1						X	
29	OUTPUT BRIDGE	R-8040-388-1R	1	X	X	X	X	X		
	OUTPUT BRIDGE	T-8040-023-1R	1						X	
30	LED MODULE	R-5041-508-1R	2	X	X	X	X	X	X	
31	CHOKE	R-8040-441-1R	1						X	
32	SOCKET ASSEMBLY	T-8040-085-1R	2					X	X	

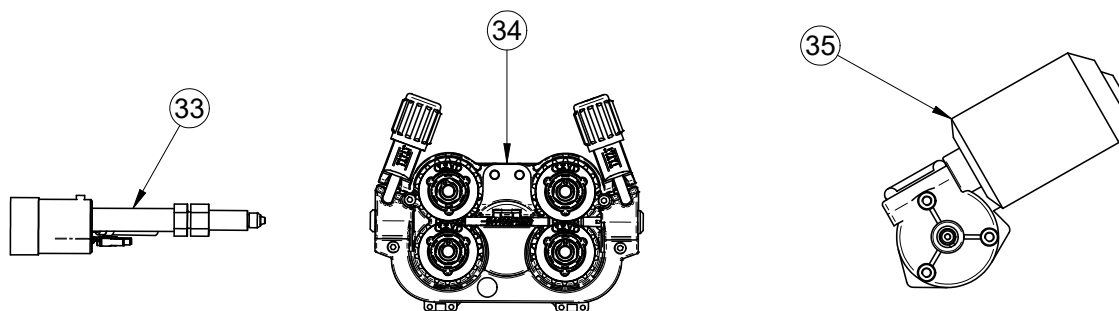


Figure D

Figure D: Wire Drive Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
33	EURO SOCKET	R-8040-389-1R	1	X	X	X	X	X		
	EURO SOCKET	T-8040-021-1R	1						X	
34	COMPLETE FEED PLATE ASSEMBLY (INCLUDES 1.0/1.2 MM DRIVE ROLLS AND WIRE GUIDE KIT)	0744-000-009R	1	X	X	X	X	X	X	
35	WIRE DRIVE MOTOR	1111-722-048R	1	X	X	X	X	X	X	

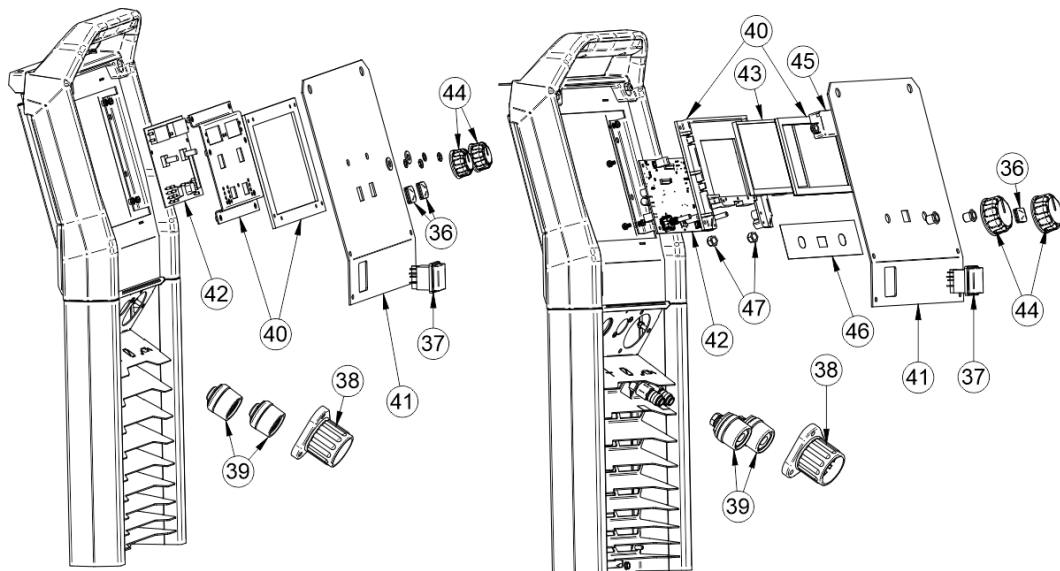


Figure E

Figure E: Front Assembly

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
36	BUTTON	9SS23055	1		X		X	X	X	
	BUTTON	9SS23055	2	X		X				
37	MAIN SWITCH	1115-270-022R	1	X	X	X	X	X	X	
38	EURO SLEEVE	C-1891-006-1R	1	X	X	X	X	X	X	
39	SOCKET	2EINN0500FR	2	X	X	X	X	X		
	SOCKET	90000595PR	2						X	
40	DISPLAY KIT includes:	T-8040-089-1R	1	X		X				
	BRACKET		1	X		X				
	BRACKET		1	X		X				
40	DISPLAY KIT includes:	T-8040-090-1R	1		X		X	X	X	
	FRAME		1		X		X	X	X	
	GASKET		1		X		X	X	X	
41	FRONT PANEL	R-0000-245-1R	1	X						
	FRONT PANEL	R-0000-245-2R	1			X				
	FRONT PANEL	R-0000-246-1R	1		X					
	FRONT PANEL	R-0000-246-2R	1				X			
	FRONT PANEL	R-0000-246-3R	1					X		
	FRONT PANEL	R-0000-246-4R	1						X	
42	USER INTERFACE PCB	R-6042-078-1R	1	X		X				
	USER INTERFACE PCB	Y063-1TR	1		X		X	X	X	
43	LCD	0942-177-002R	1		X		X	X	X	
44	KNOB	9SM22778-2	2	X		X				
	KNOB	9SM22778-3	2		X		X	X	X	
45	SPEAKER	0943-719-016R	1		X		X	X	X	
46	COPPER LABEL	R-0000-341-1R	1		X		X	X	X	
47	PIPE	R-2031-267-1R	2		X		X	X	X	

Miscellaneous Items (not shown in figure A, B, C, D, E, F)

Item	Description	Part Number	QTY	1	2	3	4	5	6	7
48	HARNESSES KIT	T-8040-086-1R	1	X	X	X	X			
49	HARNESSES KIT	T-8040-087-1R	1					X		
50	HARNESSES KIT	T-8040-088-1R	1						X	

Electrical Schematic

CODE: 50607, 50608

