


## CODE 50090, 50106, 50107

ASSEMBLY PAGE NAME			Machine Assembly	Machine Assembly	Machine Assembly (Wire feed chamber)	Machine Assembly (Wire feed chamber)	Feeding Unit Assembly
CODE NO.:	K NO.:	FIGURE NO.:	A	B	C	D	E
50090	K14040-1	POWERTEC 161C	1	-	1	-	1
50110	K14040-2	POWERTEC 161C	2	-	2	-	1
50106	K14045-1	POWERTEC 191C	-	1	-	1	1
50107	K14046-1	POWERTEC 231C	-	2	-	2	1
50108	K14047-1	POWERTEC 271C	-	3	-	3	1

 - recommended parts

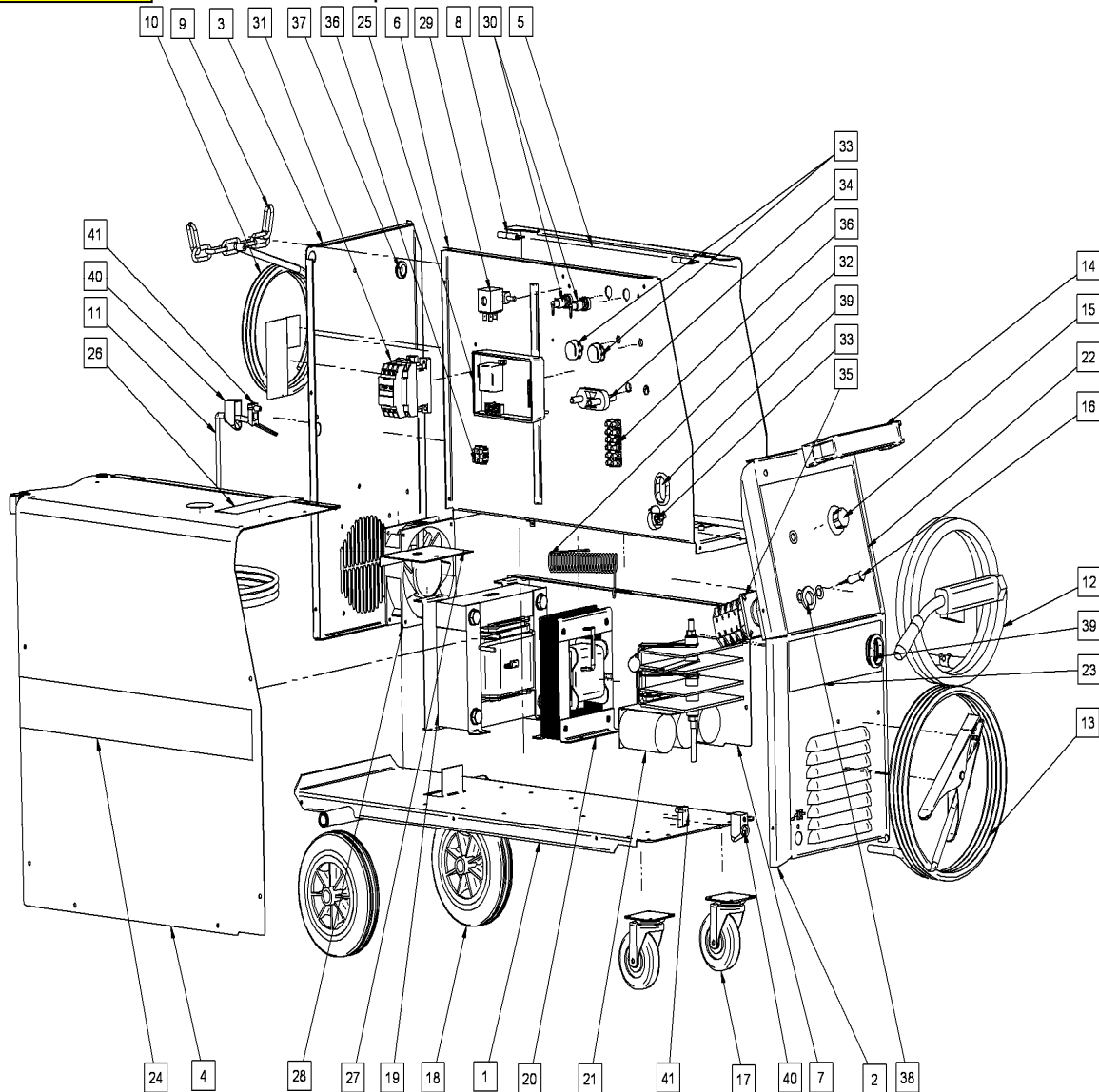


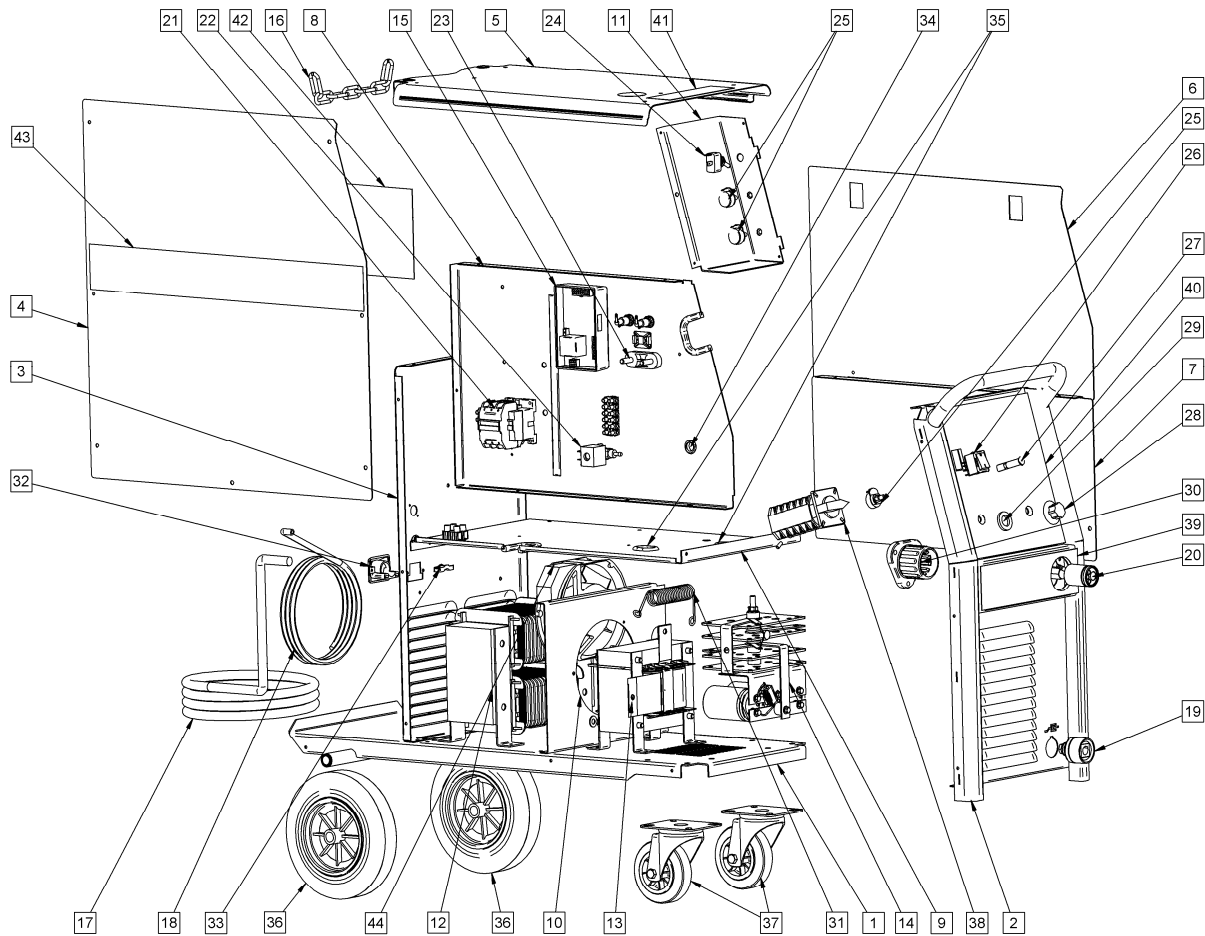
Figure A

**Figure A: Machine Assembly**

Item	Description	Part Number	QTY	1	2	3
1	BOTTOM PANEL	R-3019-098-1/08R	1	X	X	
2	FRONT PANEL	R-3019-101-1/08R	1	X	-	
	FRONT PANEL	R-3019-101-2/08R	1	-	X	
3	BACK PANEL	R-3019-099-1/08R	1	X	X	
4	TOP/LEFT PANEL	R-3019-102-1/02R	1	X	X	
5	RIGHT SIDE DOOR PANEL	R-3019-103-1/02R	1	X	X	
6	DIVIDER PANEL	R-3019-100-1/08R	1	X	X	
7	RIGHT SIDE LOWER PANEL	R-3019-104-1/02R	1	X	X	
8	HINGE	D-3574-007-1/33R	1	X	X	
9	CHAIN	0652-410-003R	1	X	X	
10	GAS HOSE	1361-410-005R	1	X	X	
11	MAINS CABLE	R-5041-049-2R	1	X	X	
12	WELDING TORCH	K10413-14D	1	X	-	
13	GROUND CABLE X3	D-5578-049-5R	1	X	X	
14	HANDLE	1361-598-186R	1	X	X	
15	KNOB $\Phi$ 38	9ET10491R	1	X	X	
16	LAMP H1	0917-421-024R	1	X	X	
17	TURNING WHEEL	1029-660-004R	2	X	X	
18	WHEEL	1029-660-007R	2	X	X	
19	TRANSFORMER T1	R-4034-048-1R	1	X	X	
	TEMPERATURE SENSOR	1115-769-123R	1	X	X	
20	CHOKE L1	R-4034-049-1R	1	X	X	
21	RECTIFIER V1 (COMPLETE)	1156-112-015R	1	X	X	
	RECTIFIER CAPACITOR	1158-125-332R	3	X	X	
	RECTIFIER RESISTOR	1158-112-015R	1	X	X	
22	FRONT UPPER LABEL	2719-107-542R	1	X	X	
23	FRONT LOWER LABEL	2719-107-554R	1	X	-	
	FRONT LOWER LABEL	2719-107-156R	1	-	X	
24	LEFT SIDE LABEL	2719-107-531R	1	X	X	
25	PC BOARD US-70	0918-432-009R	1	X	X	
26	WARNING LABEL	2719-107-728R	1	X	X	
27	COVER	R-1019-111-1/08R	1	X	X	
28	FAN M1	0873-100-032R	1	X	X	
29	SOLENOID VALVE K2	0972-423-004R	1	X	X	
30	FUSE SOCKET	1158-632-009R	2	X	X	
	FUSE F1 1A	1158-660-022R	1	X	X	
	FUSE F2 4A	1158-660-037R	1	X	X	
31	CONTACTOR K1	1115-212-213R	1	X	X	
32	POWER RESISTOR R4	1158-112-014R	1	X	X	
33	POTENTIOMETERS R1,R2,R3	1158-113-304R	3	X	X	
34	TERMINAL BLOCK X4	1361-599-328R	1	X	X	
35	VOLTAGE SWITCH K3	1115-260-006R	1	X	X	
36	TERMINAL BLOCK X2	1131-990-005R	8	X	X	
37	RUBBER CABLE BUSH	1373-182-002R	2	X	X	
38	WASHER	1362-211-003R	1	X	X	
39	RUBBER CABLE BUSH	1373-111-331R	2	X	X	
40	STRAIN RELIEF	1361-599-399R	2	X	X	
41	CABLE BUSHING / STRAIN RELIEF	1361-599-398R	2	X	X	

**Not Illustrated Parts**

Item	Description	Part Number	QTY	1	2	3
	PCB HARNESS	R-7040-212-1R	1	X	X	
	MACHINE HARNESS	R-7040-213-1R	1	X	X	



**Figure B**

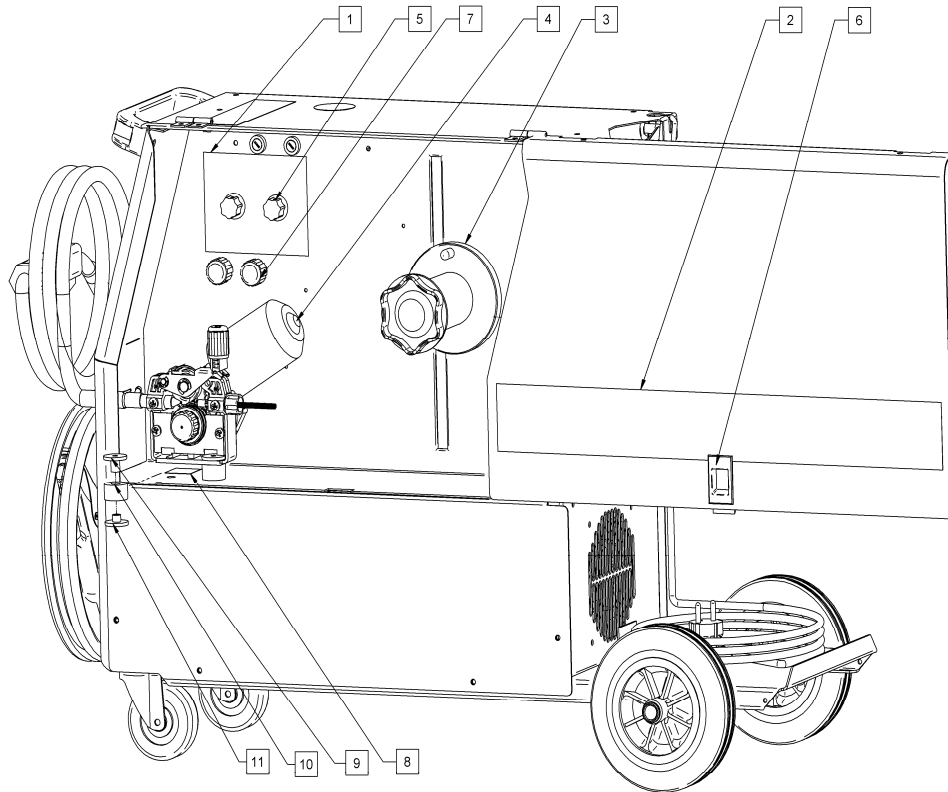
**Figure B: Machine Assembly**

Item	Description	Part Number	QTY	1	2	3	4
1	BOTTOM PANEL	R-3019-121-1/08R	1	X	X	X	
2	FRONT PANEL	R-3019-120-1/08R	1	X	X	X	
3	BACK PANEL	R-1012-202-1/08R	1	X	X	-	
	BACK PANEL	R-1012-202-2/08R	1	-	-	X	
4	LEFT PANEL	R-1012-210-1/02R	1	X	X	X	
5	TOP PANEL	R-1012-209-1/02R	1	X	X	X	
6	RIGHT SIDE DOOR PANEL	R-3019-124-1/02R	1	X	X	X	
7	RIGHT SIDE LOWER PANEL	R-3019-122-1/02R	1	X	X	X	
8	DIVIDER PANEL	R-1012-207-1/08R	1	X	X	X	
9	SHELF	R-3019-123-1/08R	1	X	X	X	
10	WALL RING	R-1012-208-1/08R	1	X	X	X	
11	COVER	R-1019-129-1/08R	1	X	X	X	
12	TRANSFORMER T1	R-4034-061-1R	1	X	-	-	
	TRANSFORMER T1	R-4034-070-1R	1	-	X	-	
	TRANSFORMER T1	R-4034-062-1R	1	-	-	X	
	TEMPERATURE SENSOR	1115-769-124R	1	X	X	X	
13	CHOKE L1	R-4034-067-1R	1	X	X	X	
14	RECTIFIER V1 (COMPLETE)	1156-112-205R	1	X	-	-	
	RECTIFIER V1 (COMPLETE)	1156-112-018R	1	-	X	-	
	RECTIFIER V1 (COMPLETE)	1156-112-019R	1	-	-	X	
	RECTIFIER CAPACITOR	1158-125-331R	3	X	X	X	
	RECTIFIER RESISTOR	1158-112-015R	1	X	X	X	
	TEMPERATURE SENSOR	1115-769-012R	1	X	X	X	
15	PC BOARD US-70	0918-432-009R	1	X	X	X	
16	CHAIN	0652-410-003R	1	X	X	X	
17	MAINS CABLE	R-5041-106-2R	1	X	X	-	
	MAINS CABLE	R-5041-106-1R	1	-	-	X	
18	GAS HOSE	1361-410-005R	1	X	X	X	
19	PIN SOCKED	C-2986-001-2R	1	X	X	X	

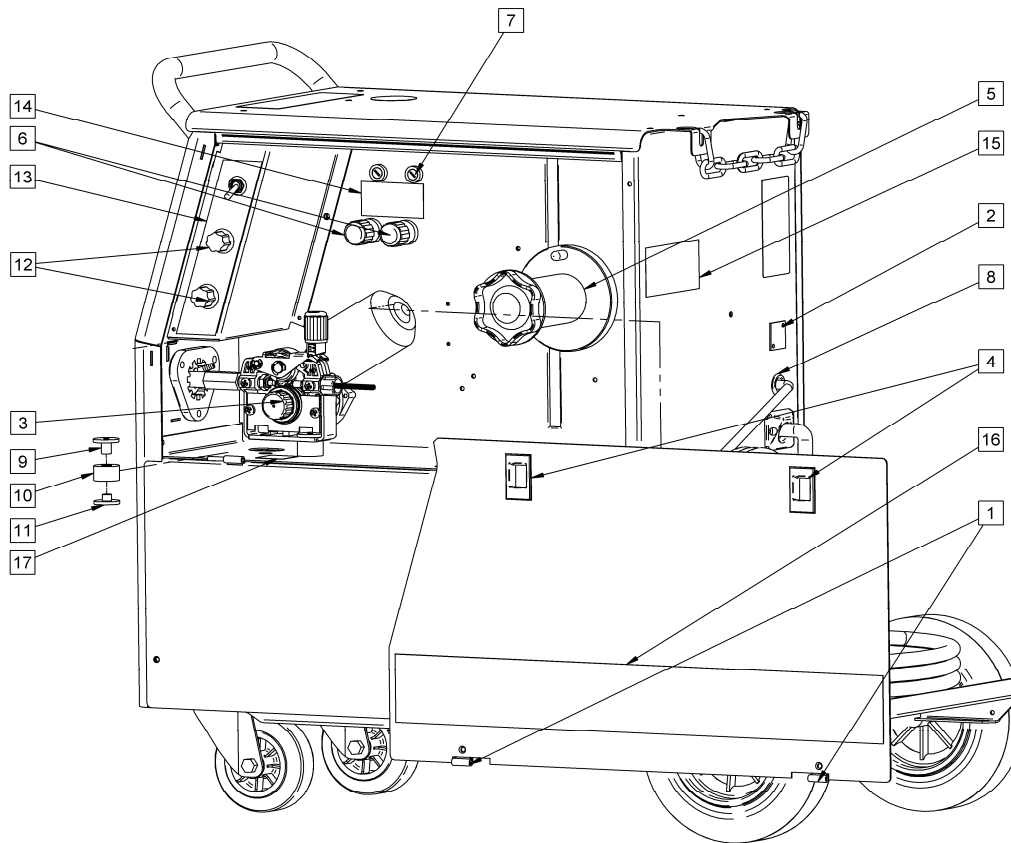
20	EURO CONNECTOR	R-8040-042-1R	1	X	X	X	
	WIRE GUIDE TUBE	R-2010-006-1R	1	X	X	X	
21	CONTACTOR K1	1115-212-211R	1	X	-	-	
	CONTACTOR K1	1115-212-223R	1	-	X	X	
22	SOLENOID VALVE K2	0972-423-004R	1	X	X	X	
23	TERMINAL BLOCK X4	1361-599-328R	1	X	X	X	
24	SWITCH S4	1158-650-021R	1	X	X	X	
25	POTENTIOMETERS R1,R2,R3	1158-113-304R	3	X	X	X	
26	MAIN SWITCH S1	1115-270-019R	1	X	X	X	
27	LAMP H1	0917-421-024R	1	X	X	X	
28	KNOB Ø38	9ET10491R	1	X	X	X	
29	WASHER	1362-211-003R	1	X	X	X	
30	EURO SOCKET COVER	1361-599-708R	1	X	X	X	
31	POWER RESISTOR R4	1158-112-014R	1	X	X	X	
32	CABLE BUSHING/ STRAIN RELIEF	1361-599-399R	1	X	X	-	
	CABLE BUSHING/ STRAIN RELIEF	1361-599-665R	1	-	-	X	
33	CLAMP	1361-599-398R	1	X	X	-	
	CLAMP	1361-599-633R	1	-	-	X	
34	RUBBER CABLE BUSH	1373-111-002R	1	X	X	X	
35	RUBBER CABLE BUSH	1373-111-331R	2	X	X	X	
36	WHEEL	1029-660-007R	2	X	X	X	
37	TURNING WHEEL	1029-660-004R	2	X	X	X	
38	VOLTAGE SWITCH K3	1115-260-006R	1	X	X	X	
39	FRONT LOWER LABEL	2719-107-155R	1	X	-	-	
	FRONT LOWER LABEL	2719-107-074R	1	-	X	-	
	FRONT LOWER LABEL	2719-107-095R	1	-	-	X	
40	FRONT UPPER LABEL	2719-107-154R	1	X	-	-	
	FRONT UPPER LABEL	2719-107-543R	1	-	X	X	
41	WARNING LABEL	2719-107-728R	1	X	X	X	
42	LABEL (SCHEMATIC)	2719-107-052R	1	X	-	-	
	LABEL (SCHEMATIC)	2719-107-203R	1	-	X	X	
43	LEFT SIDE LABEL	2719-107-533R	1	X	-	-	
	LEFT SIDE LABEL	2719-107-535R	1	-	X	-	
	LEFT SIDE LABEL	2719-107-537R	1	-	-	X	
44	FAN M1	0873-100-031R	1	X	X	X	

### Not Illustrated Parts

Item	Description	Part Number	QTY	1	2	3	4
	PCB HARNESS	R-5041-102-1R	1	X	X	-	
	PCB HARNESS	R-5041-102-2R	1	-	-	X	
	MACHINE HARNESS	R-5041-103-1R	1	X	-	-	
	MACHINE HARNESS	R-5041-103-2R	1	-	X	X	
	GROUND CABLE WITH WORK CLAMP -3m	K14010-1	1	X	X	X	


**Figure C**
**Figure C: Machine Assembly (Wire feed chamber)**

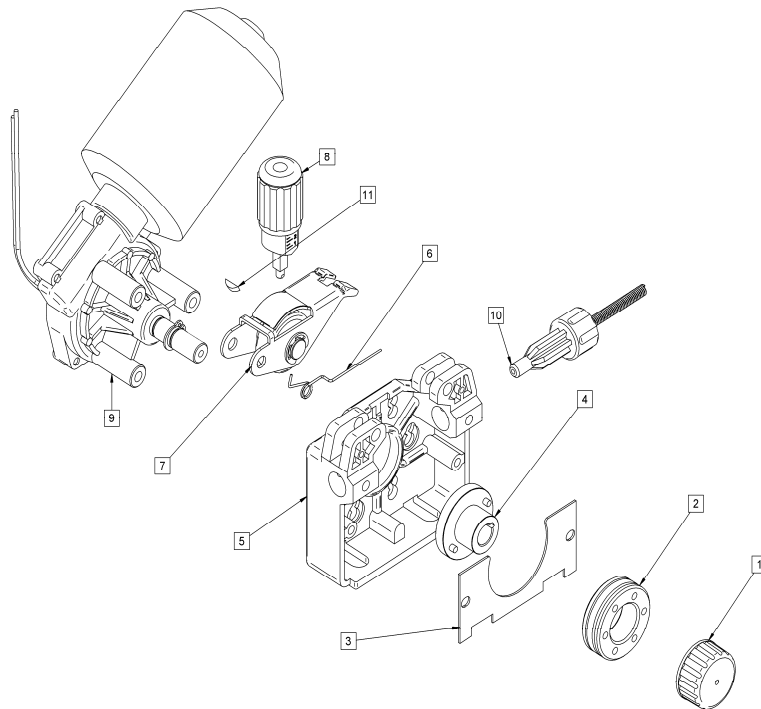
Item	Description	Part Number	QTY	1	2	3
1	LABEL	2719-107-563R	1	X	X	
2	RIGHT SIDE PANEL LABEL	2719-107-532R	1	X	X	
3	BRAKE	0744-000-192R	1	X	X	
4	WIRE DRIVE MOTOR ASS.	0744-000-160R	1	X	X	
5	KNOB $\Phi 25$	9ET13639-3R	2	X	X	
6	LOCKER	0654-610-004R	1	X	X	
7	TERMINAL NUT	D-2846-026-1R	2	X	X	
8	WARNING LABEL	2719-107-732R	1	X	X	
9	BUSHING	1361-599-564R	2	X	X	
10	BUSHING	1361-599-565R	2	X	X	
11	BUSHING	1361-599-720R	2	X	X	
12	EURO CONNECTOR	0646-233-056R	1	-	X	
13	PLASTIC NUT	B11035-1	1	X	X	



**Figure D**

**Figure D: Machine Assembly (Wire feed chamber)**

Item	Description	Part Number	QTY	1	2	3	4
1	HINGE	D-3574-007-1/33R	2	X	X	X	
2	HOLE PLUG	1361-599-058R	1	X	X	X	
3	WIRE DRIVE MOTOR ASS.	0744-000-160R	1	X	X	X	
4	LOCKER	0654-610-004R	1	X	X	X	
5	BRAKE	0744-000-192R	1	X	X	X	
6	TERMINAL NUT	D-2846-026-1R	2	X	X	X	
7	FUSE SOCKET	1158-632-009R	2	X	X	X	
	FUSE F1 1A	1158-660-022R	1	X	X	X	
	FUSE F2 4A	1158-660-037R	1	X	X	X	
8	RUBBER CABLE BUSH	1373-111-002R	1	X	X	X	
9	BUSHING	1361-599-564R	2	X	X	X	
10	BUSHING	1361-599-565R	2	X	X	X	
11	BUSHING	1361-599-720R	2	X	X	X	
12	KNOB $\Phi 25$	9ET13639-3R	2	X	X	X	
13	LABEL	2719-107-561R	1	X	X	X	
14	LABEL	2719-107-562R	1	X	X	X	
15	LABEL	R-7040-228-3R	1	X	X	X	
16	RIGHT SIDE PANEL LABEL	2719-107-534R	1	X	-	-	
	RIGHT SIDE PANEL LABEL	2719-107-536R	1	-	X	-	
	RIGHT SIDE PANEL LABEL	2719-107-538R	1	-	-	X	
17	WARNING LABEL	2719-107-732R	1	X	X	X	
18	PLASTIC NUT	B11035-1	1	X	X	X	



**Figure E: Feeding Unit Assembly**

**Figure E: Feeding Unit Assembly**

Item	Description	Part Number	QTY	1	2
1	FIXING CAP	0744-000-216R	1	X	
2	LOOK AT "ACCESSORIES"		1	X	
3	COVER	0744-000-218R	1	X	
4	ADAPTER RING (COMPLETE)	0744-000-227R	1	X	
5	FEED PLATE	0744-000-219R	1	X	
6	SPRING FOR PRESSURE ARM	0744-000-220R	1	X	
7	PRESURE ARM (COMPLETE)	0744-000-221R	1	X	
8	FIXING ARM (COMPLETE)	0744-000-223R	1	X	
9	D.C. MOTOR	0744-000-229R	1	X	
10	INLET GUIDE (COMPLETE)	0744-000-224R	1	X	
11	WOODRUF KEY	0646-231-102R	1	X	