

PARTS LIST FOR

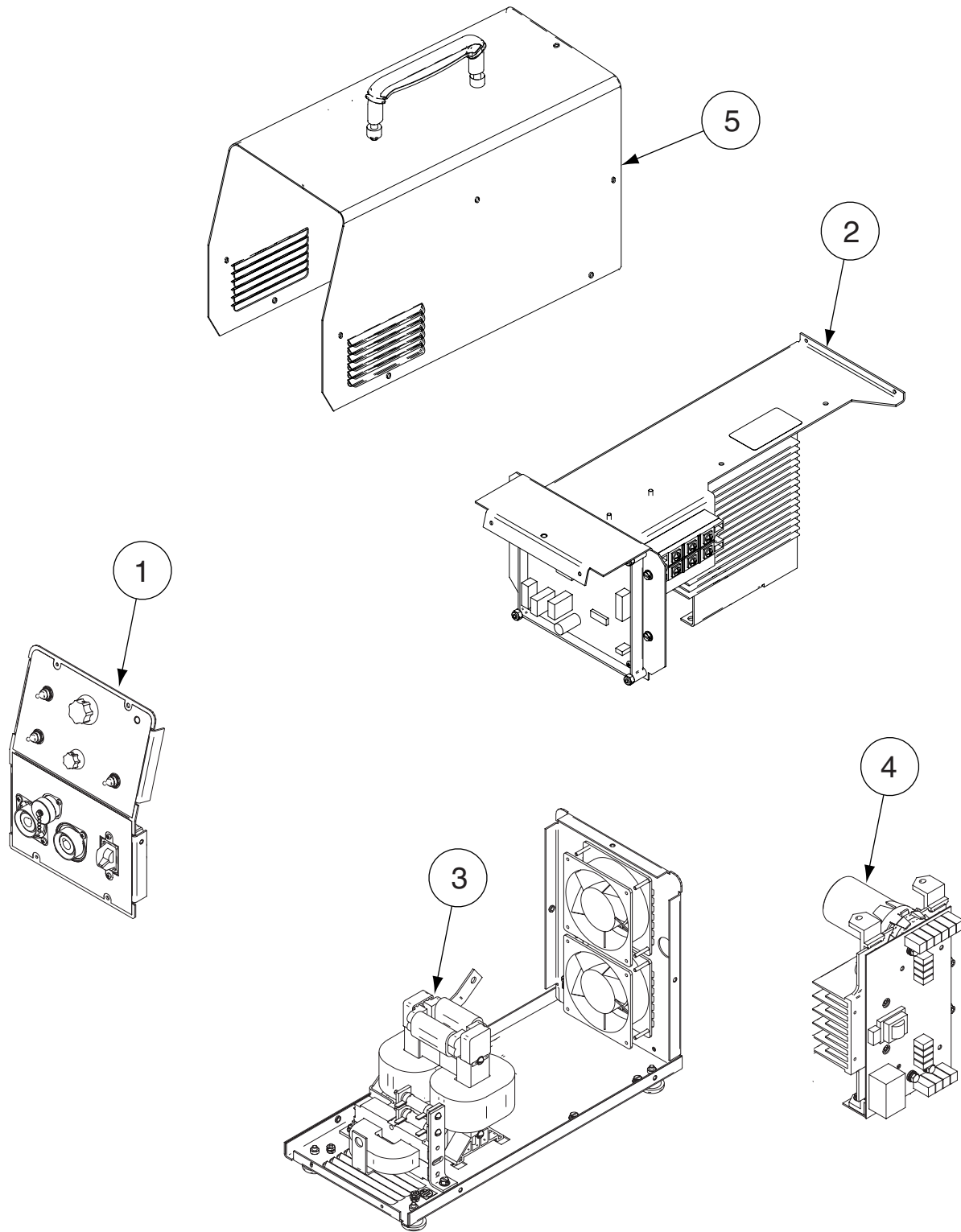
Red-D-Arc ES 275i

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RED-D-ARC ES 275i

Red-D-Arc

ILLUSTRATION OF SUB-ASSEMBLIES



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Red-D-Arc ES 275i

For Code: 10994, 11166, 11223 & 11266

Do Not use this Parts List for a machine if its code number is not listed. Contact the Service Department for any code numbers not listed.

Use the Illustration of Sub-Assemblies page and the table below to determine which sub assembly page and column the desired part is located on for your particular code machine.

Sub Assembly Item No.		1	2	3	4	5		5	
SUB ASSEMBLY PAGE NAME		Miscellaneous Items	Case Front Assembly	Center Assembly	Center Assembly	Base Assembly & Case Back Assembly	Switch Board Heatsink Assembly	Switch Board Heatsink Assembly	Wraparound Assembly
PAGE NO.		P477-B.1	P477-C	P477-D	P477-D.2	P477-E	P477-F	P477-F.2	P477-G
CODE NO.									
10994		1	1	1	•	1	1	•	1
11166		1	2	2	•	1	1	•	2
11223		1	2	2	•	1	•	1	2
11266		1	2	•	1	1	•	1	3

Illustration of Sub Assemblies

MISCELLANEOUS ITEMS
(THESE ITEMS ARE NOT ILLUSTRATED)

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Use only the parts marked "x" in the column under the heading number called for in the model index page.

DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
Input Lead Assembly	S18573-13	1	X								
Cord Grip Connector	S19999	1	X								
Conduit Lock Nut	T14370-3	1	X								

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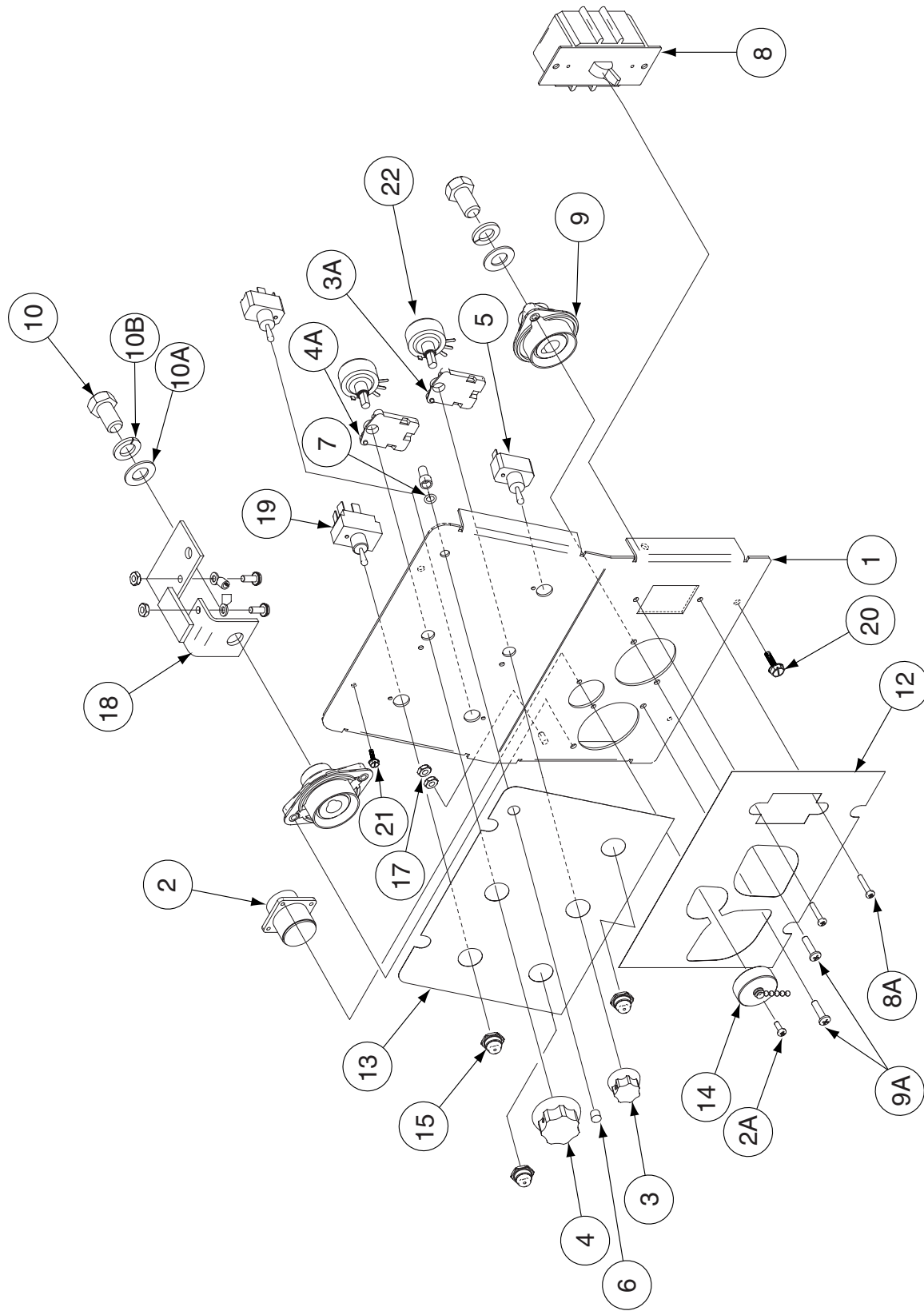
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Case Front Assembly



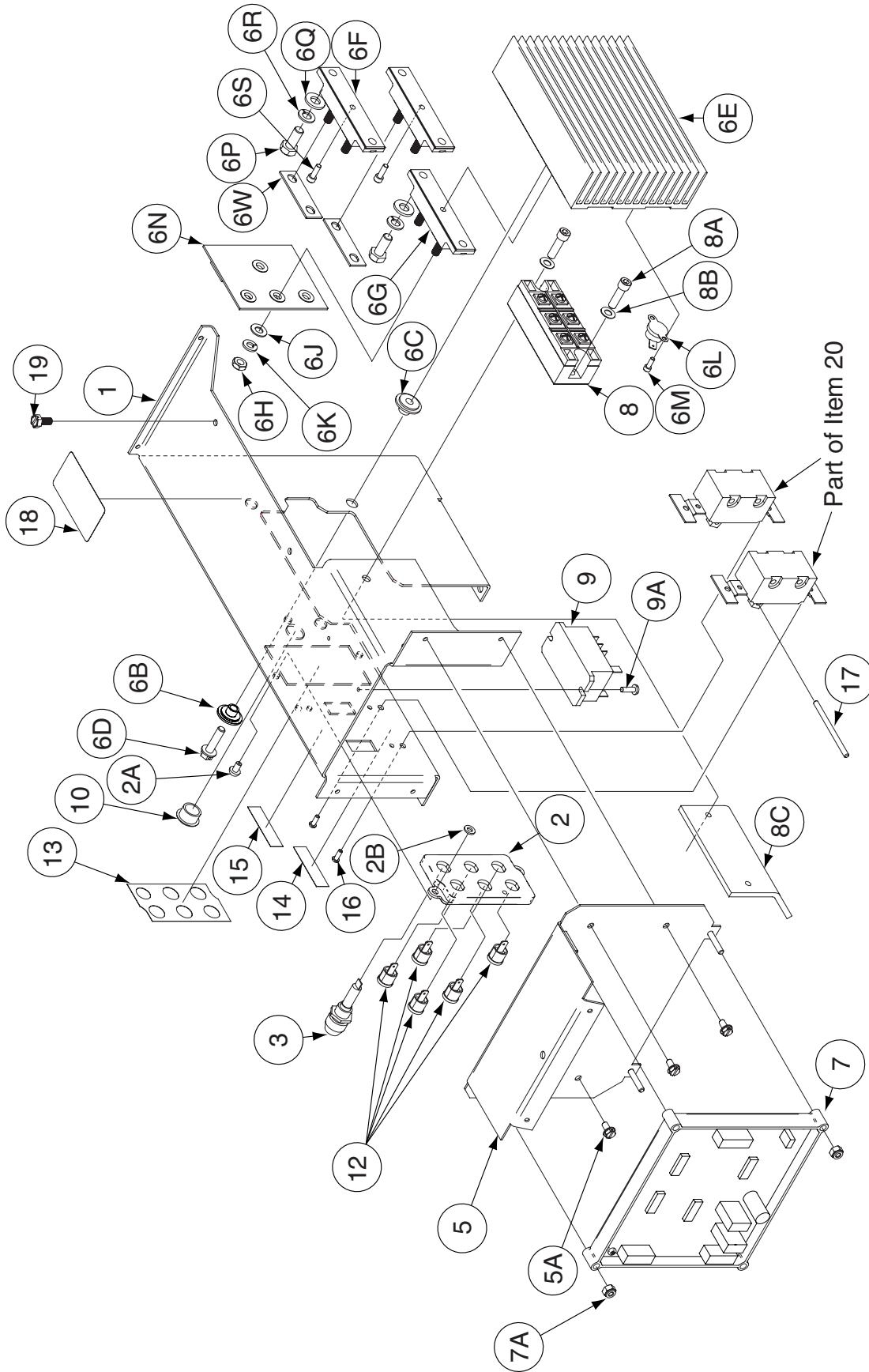
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ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1	Case Front	L11983-1	1	X	X							
2	Amphenol Wiring Harness	L11911-1	1	X	X							
2A	Self Tapping Screw	S8025-96	2	X	X							
3	Knob	T13639-3	1	X	X							
3A	Potentiometer Spacer	S18280	1	X	X							
4	Knob	T10491	1	X	X							
4A	Potentiometer Spacer	S18280	1	X	X							
5	Toggle Switch, SPST	T10800-4	2	X	X							
6	Led Lens, Clear	S23093-1	2	X	X							#
7	Retaining "O" Ring	S23094-1	2	X	X							#
8	Line Switch	S20030	1	X	X							
8A	Self Tapping Screw	S8025-96	2	X	X							
9	Output Terminal	M13896-9	2	X	X							
9A	Thread Forming Screw	S9225-63	4	X	X							
10	1/2-13 x .875 HHCS	CF000344	2	X	X							
10A	Plain Washer	S9262-1	2	X	X							
10B	Lock Washer	E106A-15	2	X	X							
11	Noise Suppressor Assembly (Not Shown)	S20938	1	X	X							
12	Nameplate (Lower) (G4364-1)	G4364	1	X	•							
12	Nameplate (Lower) (G4738-1)	G4738	1	•	X							#
13	Nameplate (Upper) (G4364-2)	G4364	1	X	•							
13	Nameplate (Upper) (G4738-2)	G4738	1	•	X							#
14	Cable Connector Cap	S17062-6	1	X	X							
15	Sealing Boot	S22061-4	3	X	X							
17	#10-24 HN	CF000010	2	X	X							
18	Shunt & Lead Assembly	S21170-5	1	X	X							
19	Toggle Switch, DPST	T10800-47	1	X	X							
20	Thread Forming Screw	S8025-91	2	X	X							
21	#10-24 x .50 HHCS	CF000371	2	X	X							
22	Control Panel Harness	L11998	1	X	•							#
22	Control Panel Harness	L11998-1	1	•	X							#
23	5/16-18 x 1.00 HHCS (Not Shown)	CF000062	1	X	X							
23A	Plain Washer (Not Shown)	S9262-30	2	X	X							
23B	Lock Washer (Not Shown)	E106A-14	1	X	X							
23C	5/16-18 HN (Not Shown)	CF000029	1	X	X							

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Center Assembly (For Codes 11223 & below)



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01-14-2005

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ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1	Center Panel	G4343	1	X	X							
2	Reconnect Panel	M19656	1	X	X							
2A	Rivet	T12584-7	2	X	X							
2B	Plain Washer	S9262-3	2	X	X							
3	Fuse Holder	S10433-1	1	X	X							
4	Fuse (Not Shown)	T10728-30	2	X	X							
5	Control Box	L11982	1	X	X							
5A	Self Tapping Screw	S8025-92	4	X	X							
6	Output Rectifier Assembly, (Includes 6B-6W)	L11974	1	X	X							
6B	Insulator	T11267-A	3	X	X							
6C	Insulator	T11267-B	3	X	X							
6D	Thread Forming Screw	S9225-17	3	X	X							
6E	Output Rectifier Heatsink	L11971	1	X	X							
6F	Diode Module Assembly	S25520-2	2	X	X							
6G	Diode Module Assembly	S25520-1	1	X	X							
6H	1/4-28 HJN	CF000060	6	X	X							
6J	Plain Washer	S9262-23	6	X	X							
6K	Lock Washer	E106A-2	6	X	X							
6L	Thermostat	T13359-12	1	X	X							
6M	Socket Head Cap Screw	T9447-61	2	X	X							
6N	Snubber PC Board Assembly	M19532-[]	1	X	X							
6P	1/4-20 x .625 HHCS	CF000013	6	X	X							
6Q	Plain Washer	S9262-23	6	X	X							
6R	Spring Washer	T12735-4	6	X	X							
6S	Socket Head Cap Screw	T9447-91	3	X	X							
6T	Plain Washer (Not Shown)	S9262-30	1	X	X							
6U	Lock Washer (Not Shown)	E106A-14	1	X	X							
6V	5/16-18 x .75 HHCS (Not Shown)	CF000040	1	X	X							
6W	Lead, Flat Copper	T14190-1	2	X	X							
7	Control PC Board Assembly	G4372-[]	1	X	X							
7A	#10-24 HLN-E1817/1-Nylon Insert	T9187-13	3	X	X							
8	Diode Bridge	M15454-8	1	X	X							
8A	Socket Head Cap Screw	T9447-10	2	X	X							
8B	Pressure Washer	T12735-4	2	X	X							
8C	Input Diode Heatsink	M20155	1	X	X							
9	DC Relay	S15122-12	1	X	X							
9A	Self Tapping Screw	S8025-98	2	X	X							
10	Bushing	T12380-3	1	X	X							
11	M.O.V. Assembly (Not Shown)	S18491-1	1	X	X							
12	Receptacle	T14530-1	5	X	X							
13	Decal (Reconnect) (G4364-3)	G4364	1	X	•							
13	Decal (Reconnect) (G4738-3)	G4738	1	•	X							

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ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
14	Decal (Low Voltage) (G4364-6)	G4364	1	X	•							
14	Decal (Low Voltage) (G4738-6)	G4738	1	•	X							
15	Decal (High Voltage) (G4364-7)	G4364	1	X	•							
15	Decal (High Voltage) (G4738-7)	G4738	1	•	X							
16	#6-32 x .375 PPNHS	CF000337	4	X	X							
17	Switch Pin	S20322	1	X	X							
18	Warning Decal	S18469	1	X	X							
19	Thread Forming Screw	S9225-8	4	X	X							
20	Primary Harness (Not Shown)	G4377	1	X	X							

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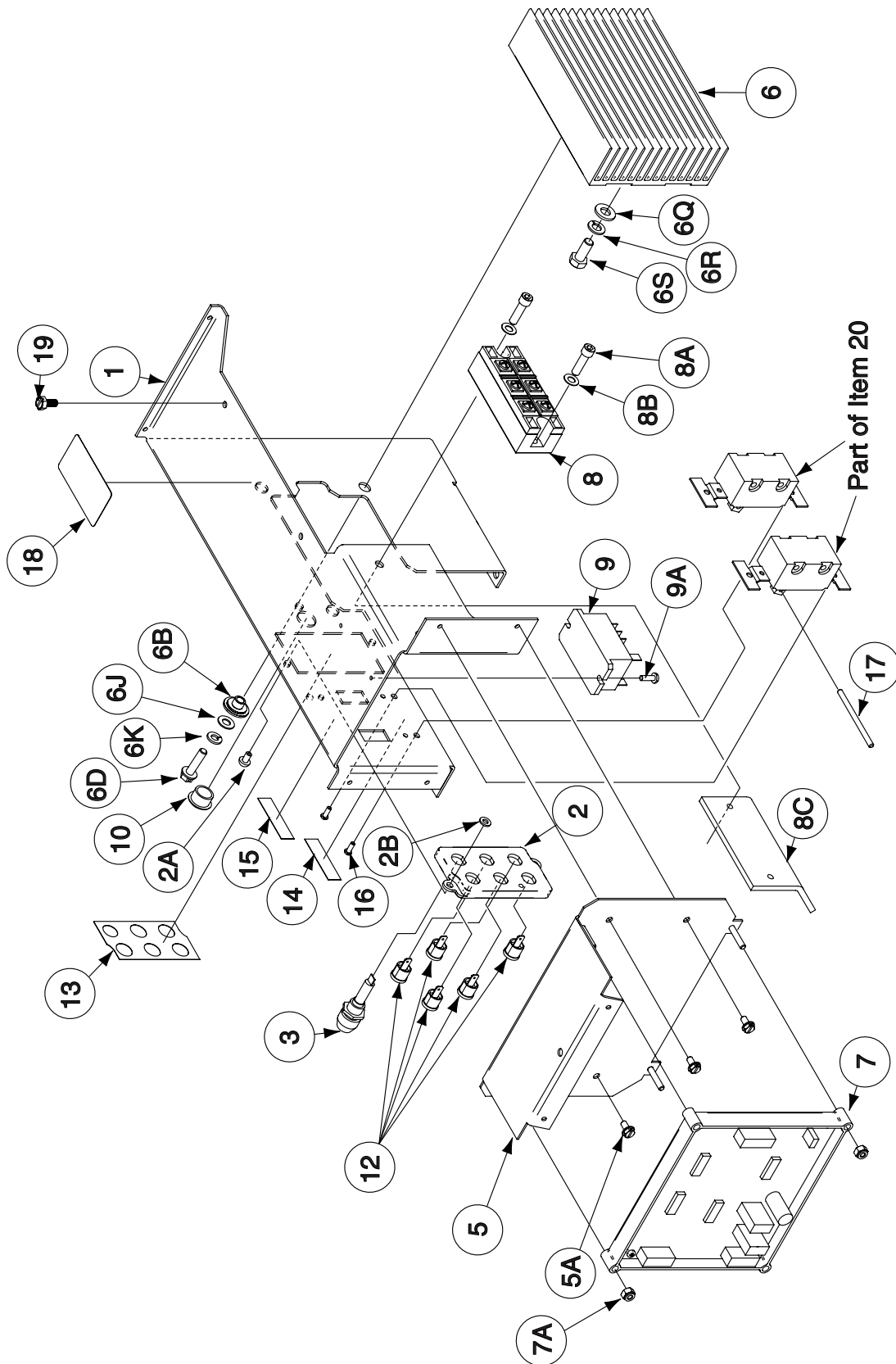
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Center Assembly (For Codes 11266 & Above)



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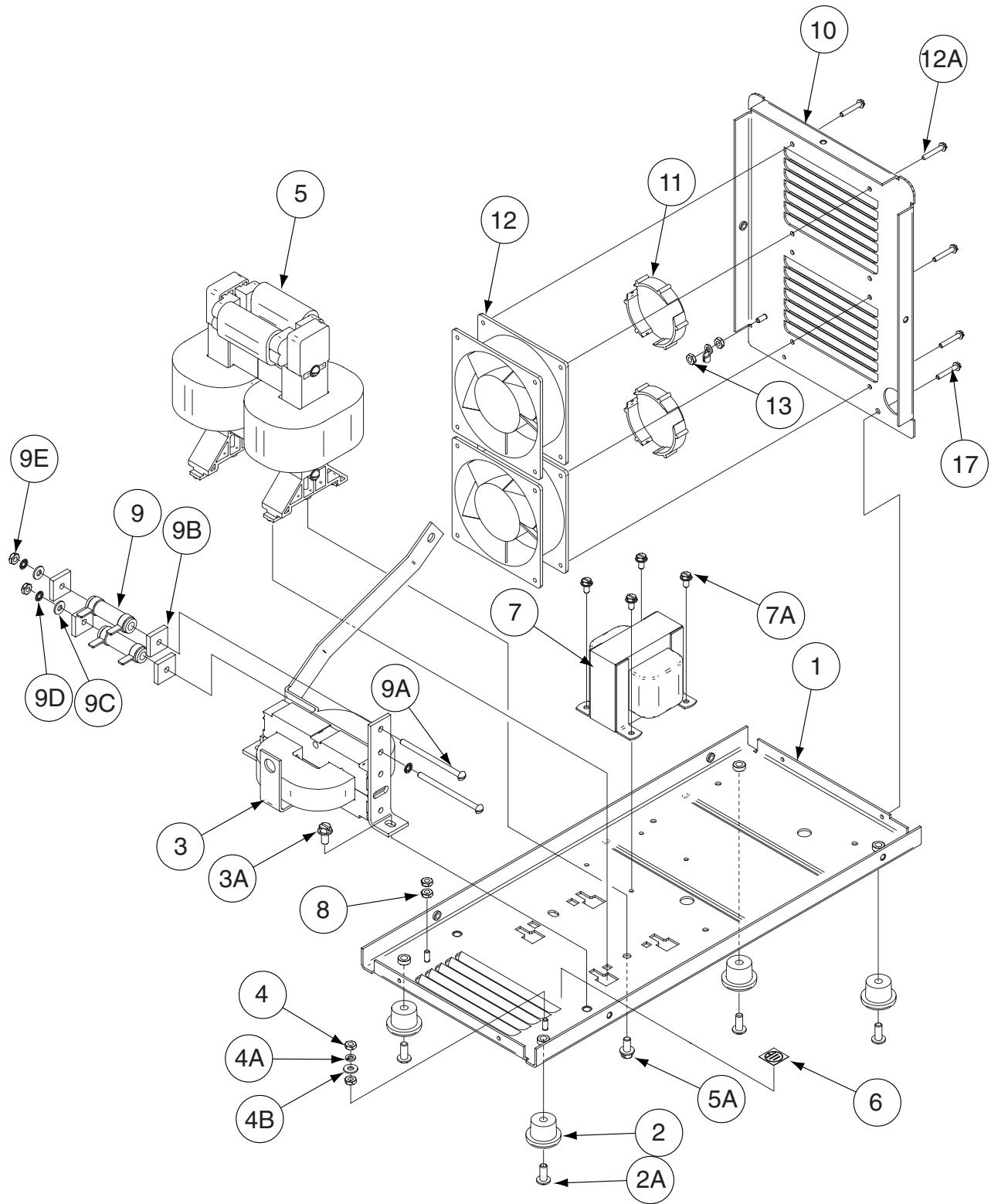
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ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1	Center Panel	G4343	1	X								
2	Reconnect Panel	M19656	1	X								
2A	Rivet	T12584-7	2	X								
2B	Plain Washer	S9262-3	2	X								
3	Fuse Holder	S10433-1	1	X								
4	Fuse (Not Shown)	T10728-30	2	X								
5	Control Box	L11982	1	X								
5A	Self Tapping Screw	S8025-92	4	X								
6	Output Rectifier Potted PC Board Assembly,	M20523-[]	1	X								
6B	Insulator	T11267-A	3	X								
6D	1/4-20 x 1.50 HHCS	CF000141	3	X								
6J	Plain Washer	S9262-98	3	X								
6K	Lock Washer	E106A-2	3	X								
6Q	Plain Washer	S9262-23	4	X								
6R	Lock Washer	E106A-2	4	X								
6S	1/4-20 x .500 HHCS	CF000012	4	X								
7	Control PC Board Assembly	G4372-[]	1	X								
7A	#10-24 HLN-E1817/1-Nylon Insert	T9187-13	3	X								
8	Diode Bridge	M15454-8	1	X								
8A	Socket Head Cap Screw	T9447-10	2	X								
8B	Pressure Washer	T12735-4	2	X								
8C	Input Diode Heatsink	M20155	1	X								
9	DC Relay	S15122-12	1	X								
9A	Self Tapping Screw	S8025-98	2	X								
10	Bushing	T12380-3	1	X								
11	M.O.V. Assembly (Not Shown)	S18491-1	1	X								
12	Receptacle	T14530-1	5	X								
13	Decal (Reconnect) (G4738-3)	G4738	1	X								
14	Decal (Low Voltage) (G4738-6)	G4738	1	X								
15	Decal (High Voltage) (G4738-7)	G4738	1	X								

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Base Assembly & Case Back Assembly



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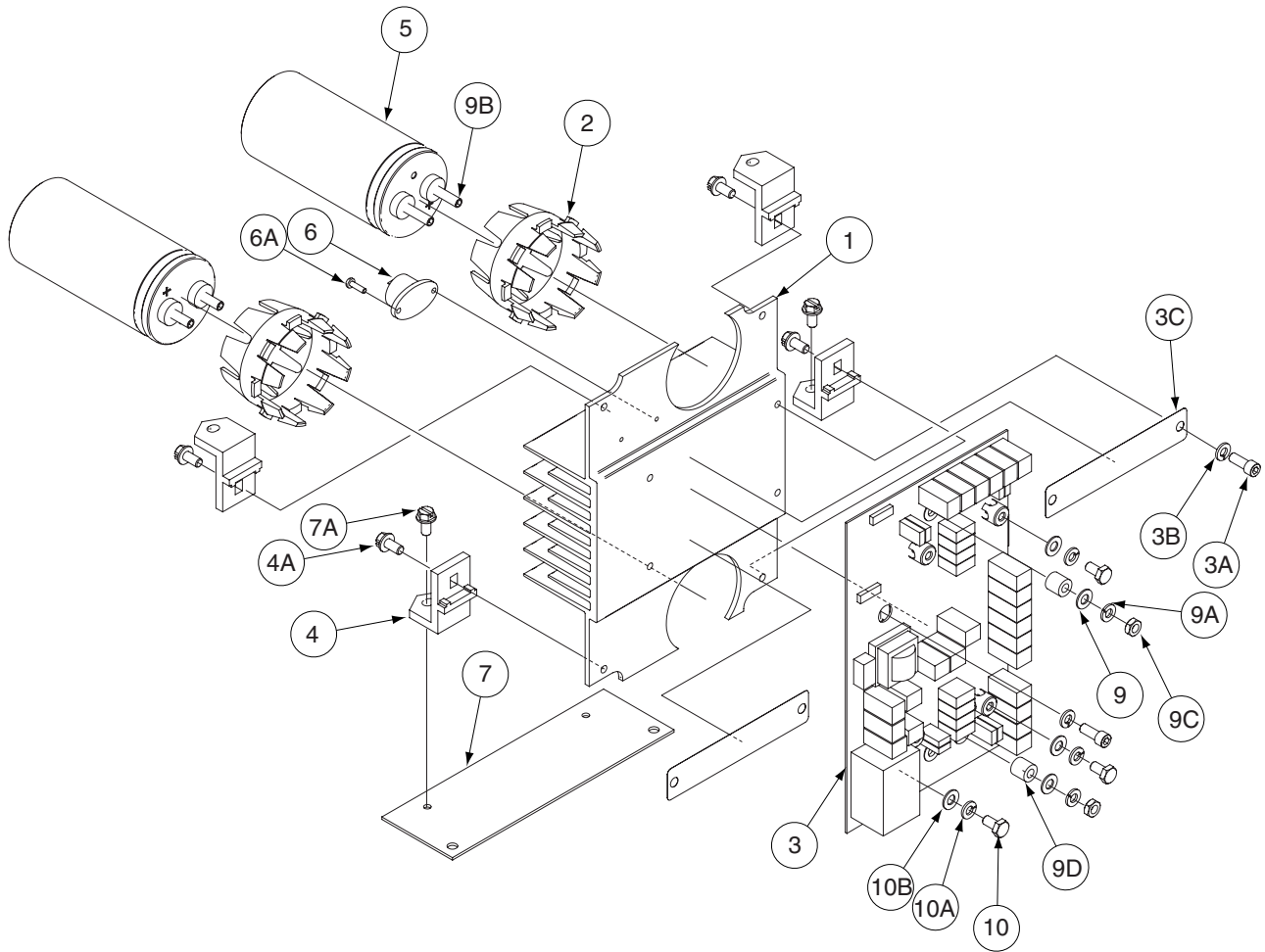
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ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1	Base	G4360-1	1	X								
2	Mounting Foot	S25589	4	X								
2A	Thread Forming Screw	S9225-8	4	X								
3	Choke Assembly	L11959	1	X								
3A	Thread Forming Screw	S9225-8	2	X								
4	#10-24HN	CF000010	2	X								
4A	Lock Washer	E106A-1	1	X								
4B	Plain Washer	S9262-27	1	X								
5	Main Transformer	G4304-1	1	X								
5A	Thread Forming Screw	S9225-8	2	X								
6	Decal (Ground Connection) (G4364-4)	G4345	1	X								
7	Transformer & Terminal Assembly	S25578	1	X								
7A	Self Tapping Screw	S8025-92	4	X								
8	#10-24 HN	CF000010	2	X								
9	Resistor	S10404-12	2	X								
9A	#10-24 x 3.00 RHS	CF000009	2	X								
9B	Insulating Washer	T4479-A	4	X								
9C	Plain Washer	S9262-27	2	X								
9D	Lock Washer	T9695-1	4	X								
9E	#10-24 HN	CF000010	2	X								
10	Case Back	L11984-1	1	X								
11	Dust Cover	S21320	2	X								
12	Fan (Tube Axial)	S18977-3	2	X								
12A	Thread Forming Screw	S9225-52	8	X								
13	#10-24 HN	CF000010	2	X								
15	Rating Plate (Not Shown) (S25567-1A)	S25567-1	1	X								
16	Serial Number Plate (Not Shown) (S25567-1B)	S25567-1	1	X								
17	Thread Forming Screw	S8025-91	4	X								
18	Switch Board Wiring Harness (Not Shown)	L11910	1	X								

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Switch Board Heat Sink Assembly (For Codes 11166 & Below)



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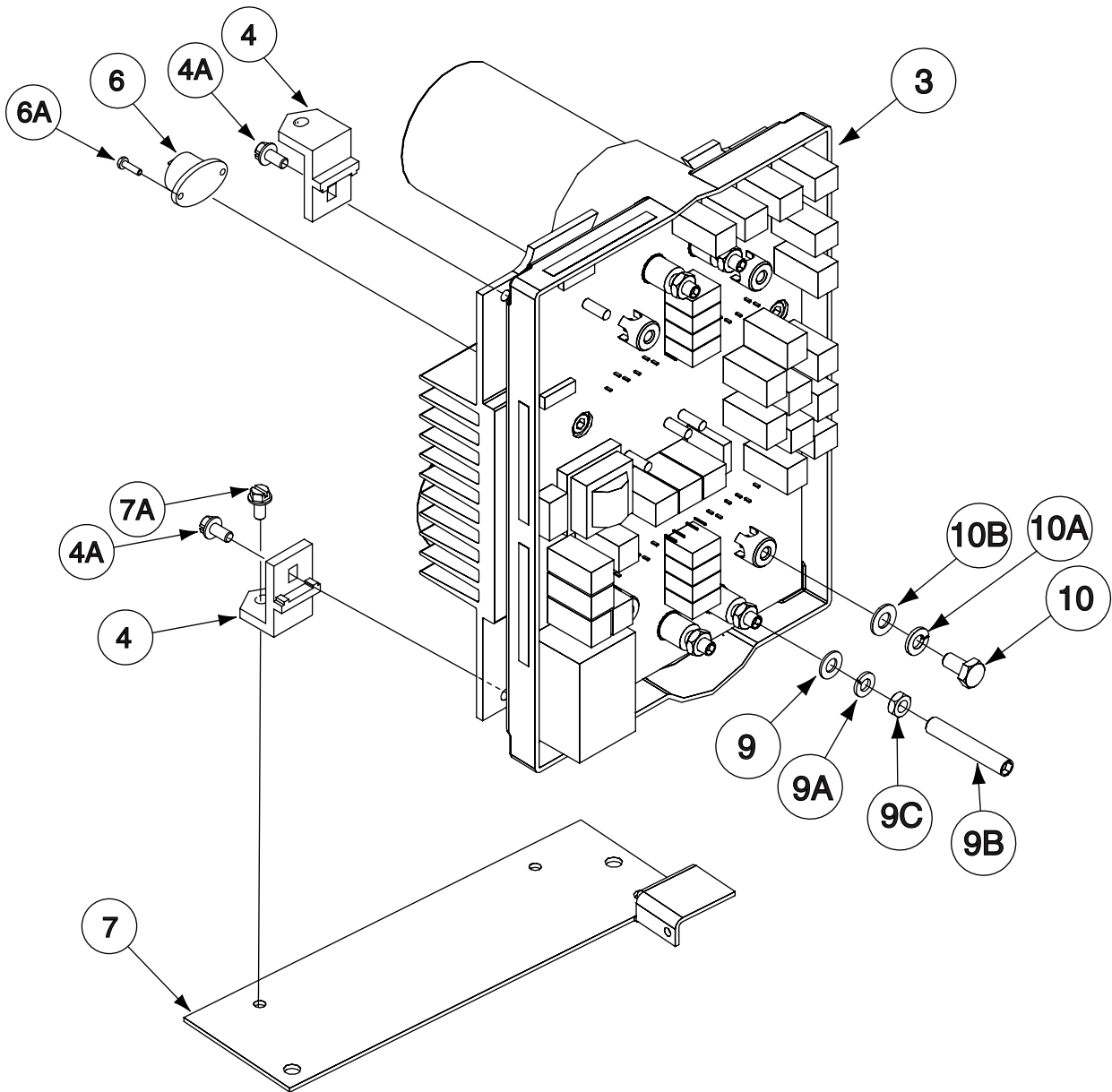
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ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1	Switch Board Heatsink	L11970	1	X								
2	Capacitor Bracket	M19144	2	X								
3	Switch PC Board Assembly	G4385-[]	1	X								
3A	Socket Head Cap Screw	T9447-9	4	X								
3B	Lock Washer	E106A-2	4	X								
3C	Thermal Interface Pad	S25347-2	2	X								
4	Heatsink Holder	S22168	4	X								
4A	Thread Forming Screw	S9225-8	4	X								
5	Capacitor	S13490-169	2	X								
6	Thermostat & Holder Assembly	S24360	1	X								
6A	Self Tapping Screw	S8025-62	2	X								
7	Switch Board Bracket	M20146	1	X								
7A	Thread Forming Screw	S9225-8	2	X								
8	Twisted Lead Assembly (not Shown)	S19222-31	1	X								
9	Plain Washer	S9262-23	4	X								
9A	Lock Washer	E106A-2	4	X								
9B	Set Screw	S11604-52	4	X								
9C	1/4-20 HJN	CF000060	4	X								
9D	Copper Spacer	S23730	4	X								
10	1/4-20 x .50 HHCS	CF000012	5	X								
10A	Lock Washer	E106A-2	5	X								
10B	Plain Washer	S9262-23	5	X								

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Switch Board Heat Sink Assembly (For Codes 11223 & Above)



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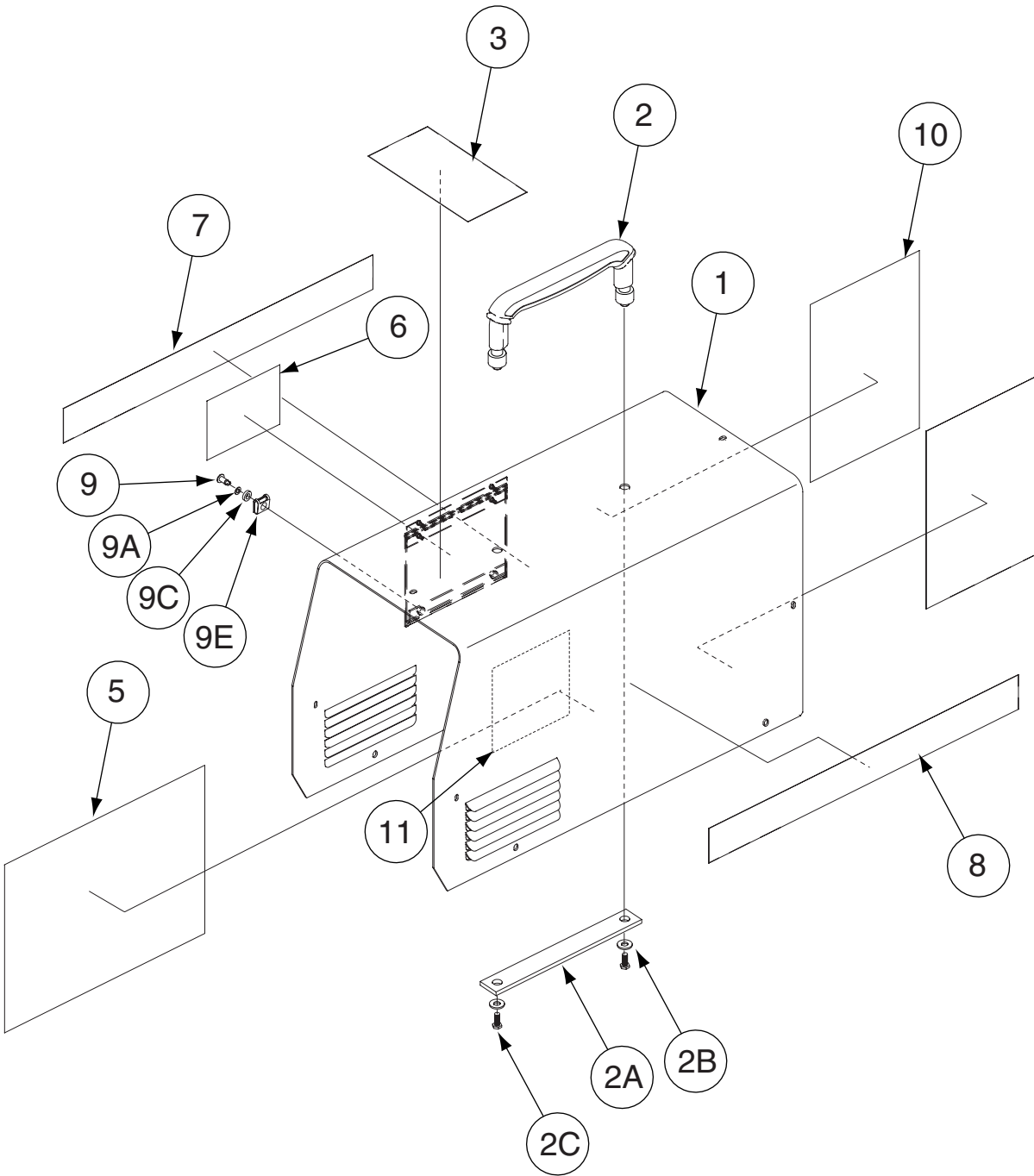
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ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
3	Switch PC Board Potted Assembly	G4385-[]	1	X								
4	Heatsink Holder	S22168	4	X								
4A	Thread Forming Screw	S9225-8	4	X								
6	Thermostat & Holder Assembly	S24360	1	X								
6A	Self Tapping Screw	S8025-62	2	X								
7	Switch Board Bracket	M20146	1	X								
7A	Thread Forming Screw	S9225-8	2	X								
8	Twisted Lead Assembly (not Shown)	S19222-31	1	X								
9	Plain Washer	S9262-23	4	X								
9A	Lock Washer	E106A-2	4	X								
9B	Set Screw	S11604-52	4	X								
9C	1/4-20 HJN	CF000060	4	X								
10	1/4-20 x .50 HHCS	CF000012	5	X								
10A	Lock Washer	E106A-2	5	X								
10B	Plain Washer	S9262-23	5	X								

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Wraparound Assembly



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ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1	Wraparound & Door Assembly	L11987-1	1	X	X	X						
2	Handle Assembly	S18170	1	X	X	X						
2A	Handle Support	S25633	1	X	X	X						
2B	Plain Washer	S9262-98	2	X	X	X						
2C	1/4-20 x .375 HHCS	CF000170	2	X	X	X						
3	Warning Decal	M16196	1	X	X	X						
4	Reconnect Instructions (Not Shown)	S25572	1	X	X	X						
5	Wiring Diagram	G4365-2	1	X	•	•						
5	Wiring Diagram	G4365-4	1	•	X	•						
5	Wiring Diagram	G4365-5	1	•	•	X						
6	Warning Decal	S20900	1	X	X	X						#
7	Side Decal (G4364-8)	G4364	1	X	•	•						#
7	Side Decal (G4738-8)	G4738	1	•	X	X						#
8	Side Decal (G4364-8)	G4364	1	X	•	•						#
8	Side Decal (G4738-8)	G4738	1	•	X	X						#
9	Stud	S24815-1	2	X	X	X						
9A	Sealing Washer	S24816-1	2	X	X	X						
9B	Ejector Spring (Not Shown)	S24817-1	2	X	X	X						
9C	Nylon Wear Washer	S24818-1	2	X	X	X						
9D	Retainer (Not Shown)	S24819-1	2	X	X	X						
9E	Receptacle	S24820-1	2	X	X	X						
10	E2521/1-.010-6.00-9.00	CI001262	2	X	X	X						
11	E2521/1-.010-4.25-4.25	CI001056	1	X	X	X						
12	#10-24 x .50 HHCS (Not Shown)	S24739-2	10	X	X	X						

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