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ZONE	LTR.	DCO	REVISIONS	DATE	BY	APPR.

NOTES:

1. UPPER DIMENSIONS ARE IN MILIMETERS, LOWER DIMENSIONS ARE IN INCHES.

PARTIAL SPECIFICATIONS:

- 1. MAXIMUM TUBE DIAMETER 0.75" (19 MM), MINIMUM 0.375" (9.5 MM).
- 2. WELD LINE FOR FLARED TUBE SHOWN WHEN CLAMPED ON NON-FLARED PORTION, AND SPRING-LOADED FEET ARE NOT USED. FEET WILL ADD 0.200" (5MM) TO SHOWN WELD LINE POSITION.
- 3. ELECTRODE: 2% CER OR 1.5% LA TUNGSTEN 1/16 DIA (1.6MM).
- 4. ELECTRODE BACK STOP: 0.625" (16 MM) FROM TUBE CENTER.
- 5. WATER COOLED ROTOR.
- 6. DRIVE MOTOR : 28 VDC WITH TACHOMETER AND TORQUE LIMITING CLUTCH.
- 7. MAX ROTATION SPEED 9.9 RPM.
- 8. CONSULT FACTORY FOR OTHER OPTIONS AND SPECIFICATIONS.

CLAMP LATCH LEVER

WELD LINE

.500 MAX FLARE LENGTH

[26.9] 1.059 ABSOLUTE MIN

[60.0] 2.35 MAX

CLAMP INSERTS

[24.6] .968

[30.9] R1.218 TO CLAMP PLATE CORNER

COVER GAS FRONT-CHANGEABLE

GAS COVER CLEARANCE [6.4] .250

[20.3] .800 MOUNTING CLEARANCE

[30.0] 1.183 MIN FOR Ø.75 TUBE

[57.2] 2.250

[260.1] 10.240

[86.9] 3.42

[20.3] .800

[40.6] 1.600

BORESCOPE BASED VIEWER

ILLUMINATION SWITCH

TRANSPARENT LIMIT SWITCH COVER

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THIRD ANGLE PROJECTION	FOR APPLIED STANDARDS SEE DOD-STD-100	ARC MACHINES, INC.	
APPROVALS	DATE	DESCRIPTION	
DRAWN: SO	1/9/08	RETURN BEND WELD HEAD	
CHECKED: LM	1/9/08	OUTLINE DRAWING	
APPR:		SIZE	MODEL NO. DWG. NO.
		D	85-750 40850005
CAD FILE:		SCALE: 1:1	DO NOT SCALE DRAWING SHEET 1 OF 1

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