

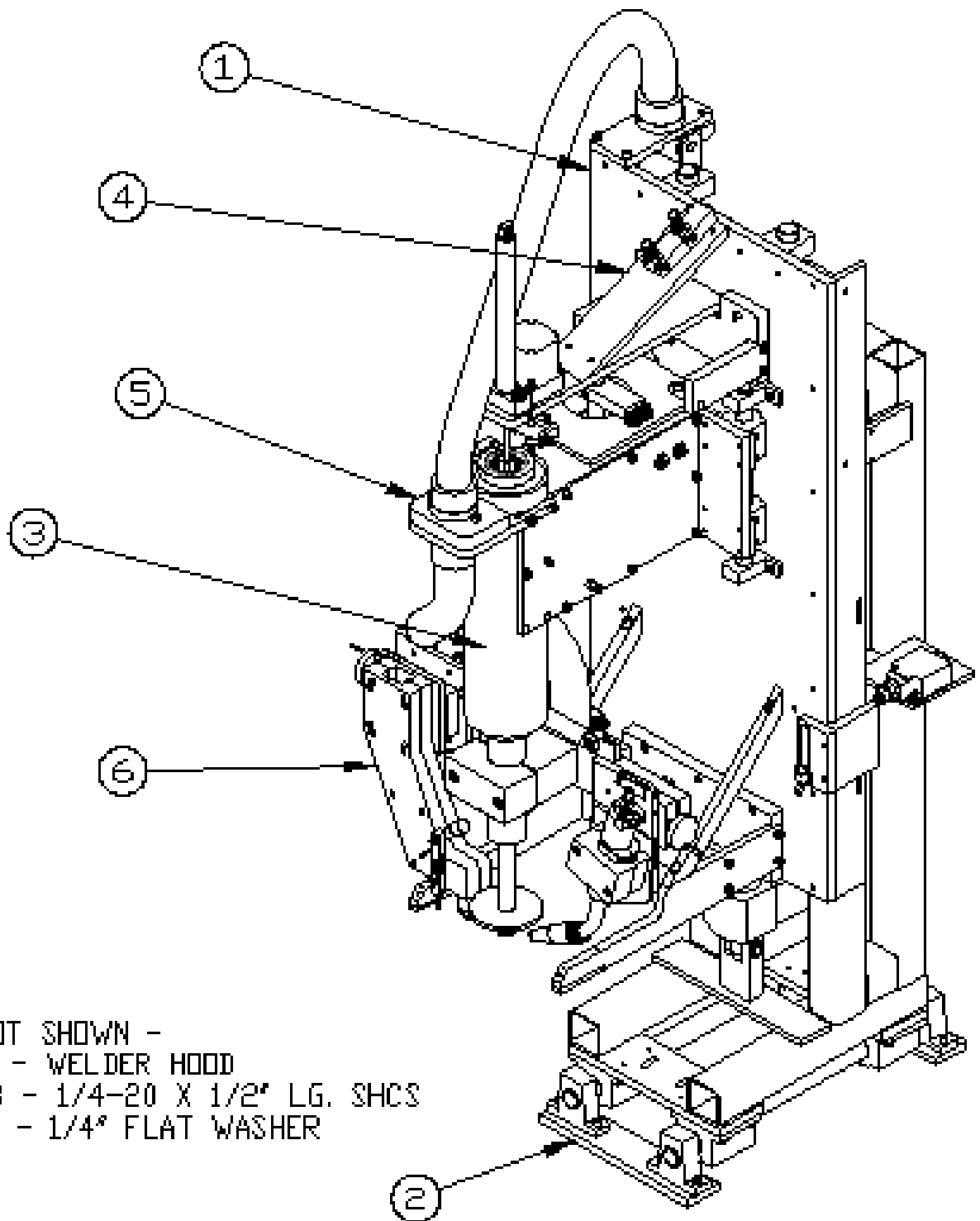
LINE WELDER ASSEMBLY

North Alabama Pipe Corporation

LINEWELDER ASSEMBLY PARTS LIST


PART NUMBER	QTY	DESCRIPTION
20-LWA-01	1	BACK PLATE & STAND ASSEMBLY
20-LWA-02	1	LINEWELDER CENTER SYSTEM ASSEMBLY
20-LWA-03	1	ELECTRICAL BOX
20-LWA-04	1	LINEWELDER APC ASSEMBLY
20-LWA-05	1	OPERATOR PUSH BUTTON BOX
20-LWA-06	1	ALLIGATOR ASSEMBLY
20-LWA-07	1	LINEWELDER FRAME ASSEMBLY
20-LWA-08	1	ROLLER LOCATION ASSEMBLY
20-LWA-09	1	BACK PLATE GROUND CABLE AND AIR FILTER ASSEMBLY
20-LWA-10	1	JUNCTION BOX ASSEMBLY
20-LWA-11	1	POWER UNIT ASSEMBLY
20-LWA-12	1	WELD WIRE CONDUIT & LINER ASSEMBLY
20-LWA-13	1	LINE WELDER HOME SWITCH ASSEMBLY
EPP-0196	158'	SMALL TRACK
EPP-0197	1 SET	TRACK BRACKET
BLK-626	1	APC COVER
FAS-E17	4	#10-24 X 5/8" LG. SHCS
FAS-E30	4	#10 FLAT WASHER
FAS-F23	8	1/4-20 X 1/2" LG. SHCS
FAS-F25	4	1/4-20 X 1" LG. SHCS
FAS-F38	12	Ø1/4" FLAT WASHER
FAS-G4	4	5/16-18 X 1" LG. HHCS
FAS-G21	4	Ø5/16" FLAT WASHER
FAS-H1	4	3/8-16 X 1" LG. HHCS
FAS-H22	4	Ø3/8" FLAT WASHER

20-LWA BOM



ITEMS NOT SHOWN -
BLK-625 - WELDER HOOD
FAS-F23 - 1/4-20 X 1/2" LG. SHCS
FAS-F38 - 1/4" FLAT WASHER

LINE WELDER BACK PLATE & STAND ASSEMBLY

 North Alabama Pipe Corporation

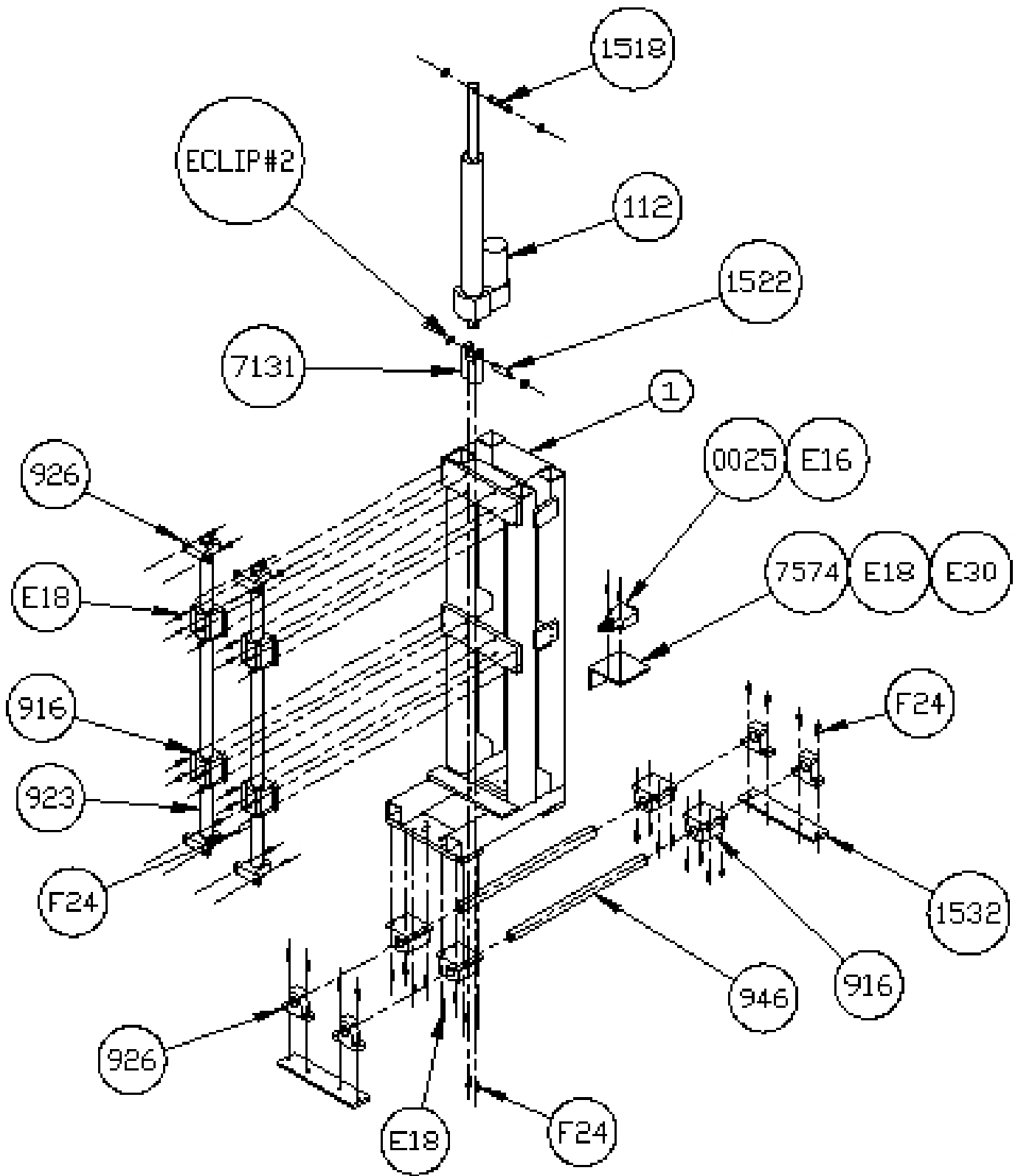
20-LWA-01

LINE WELDER BACK PLATE & STAND PARTS LIST


ITEM	PART NUMBER	QUANTITY	DESCRIPTION
1	20-LWA-0101	1	LINE WELDER BACK PLATE ASSEMBLY
2	20-LWA-0102	1	LINE WELDER BACK STAND ASSEMBLY
3	20-LWA-0103	1	ROTATION SYSTEM ASSEMBLY
4	20-LWA-0104	1	RISE & FALL UPPER ASSEMBLY
5	20-LWA-0105	1	RISE & FALL LOWER ASSEMBLY
6	20-LWA-0106	1	LINE WELDER ARM ASSEMBLY
	BLK-625	1	WELDER HOOD
	FAS-F23	4	1/4-20 X 1/2" LG. SHCS
	FAS-F38	4	1/4" FLAT WASHER

LINE WELDER BACK PLATE ASSEMBLY PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
SWT-0024	1	FROG PROX SWITCH
EPP-0189	1	FLEX HOSE CONNECTOR
EPP-0191	1	FLEX HOSE (BLACK)
EPP-0193	55'	LARGE FLEX TRACK
EPP-0194	1	LARGE TRACK BRACKET SET
WMP-1067	1	BACK PLATE
WMP-1070	2	ARM
WMP-1105	1	FLEX HOSE MOUNT
WMP-1513	2	ARM BRACE
WMP-1514	2	ARM PAD
WMP-1516	1	LEFT STIFFENER ANGLE
WMP-1517	1	RIGHT STIFFENER ANGLE
WMP-1519	1	UPPER ACTUATOR MOUNT
WMP-1520	1	SWITCH MOUNT
LWP-7132	1	ARM PLATE
LWP-7133	1	ARM MOUNT PLATE
LWP-7571	1	BACKPLATE HEIGHT ADJUSTMENT A
LWP-7572	1	BACKPLATE HEIGHT ADJUSTMENT B
LWP-7573	1	WINGNUT
FAS-B1	2	#4-40 X 1/2' LG. R.H.M.S.
FAS-E5	2	#10-32 X 1' LG. S.H.C.S.
FAS-E7	4	#10-24 X 5/8' LG. F.H.C.S.
FAS-F23	4	1/4-20 X 1/2" LG. S.H.C.S.
FAS-F24	2	1/4-20 X 3/4" LG. S.H.C.S.
FAS-F25	37	1/4-20 X 1" LG. S.H.C.S.
FAS-F26	2	1/4-20 X 1-1/4" LG. S.H.C.S.
FAS-H22	1	Ø3/8" FLAT WASHER



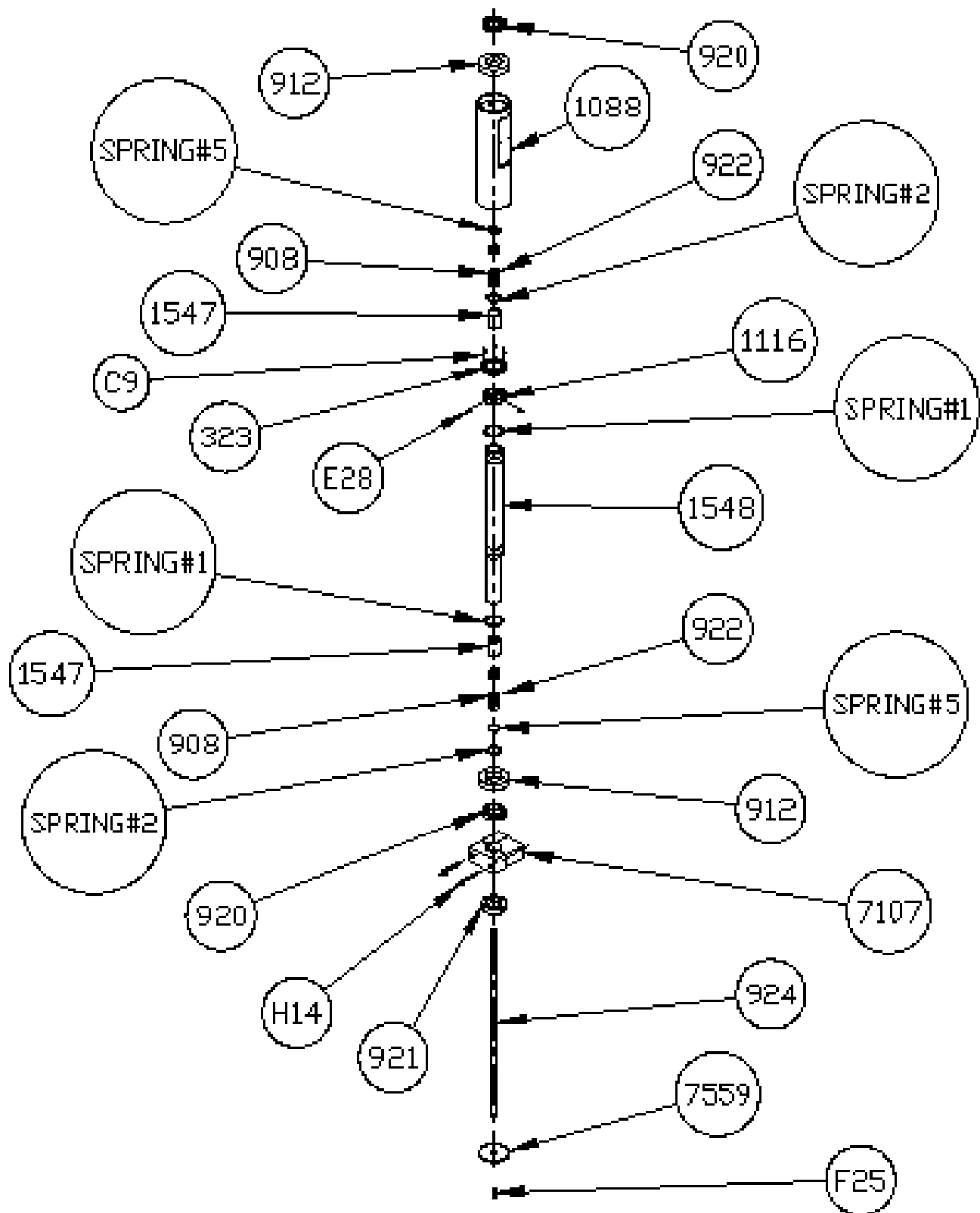
LINE WELDER BACK STAND ASSEMBLY

 North Alabama Pipe Corporation


20-LWA-0102

LINE WELDER BACK STAND ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QUANTITY	DESCRIPTION
1	20-LWA-010201	1	BACK STAND WELDMENT
	SWT-0025	1	LIMIT SWITCH
	MTR-112	1	LINEAR ACTUATOR
	BRG-916	4	PILLOW BLOCK BEARING
	BRG-923	2	Ø1" SHAFT X 36" LG.
	BRG-926	4	SHAFT SUPPORT
	BRG-946	2	Ø1" SHAFT X 18" LG.
	WMP-1518	1	UPPER ACTUATOR PIN
	WMP-1522	1	LOWER ACTUATOR PIN
	WMP-1532	2	BACK STAND MOUNTING PLATE
	LWP-7131	1	LOWER ACTUATOR MOUNT
	LWP-7574	1	BACKPLATE HEIGHT LIMIT SWITCH MOUNT
	FAS-ECLIP #2	4	1/2" EXTERNAL ROTOR CLIP
	FAS-E16	2	#10-24 X 1/2" LG. S.H.C.S.
	FAS-E18	34	#10-24 X 3/4" LG. S.H.C.S.
	FAS-E30	2	#10 FLAT WASHER
	FAS-F24	18	1/4-20 X 3/4" LG. S.H.C.S.



LINE WELDER
 ROTATION SYSTEM ASSEMBLY

 North Alabama Pipe Corporation

20-LWA-0103

LINE WELDER ROTATION SYSTEM ASSEMBLY PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
PLY-323	1	ROTATION SPROCKET INCLUDES WMP-1116 & BLK-655
BRG-908	2	INSERT
BRG-912	2	BEARING 6210
BRG-920	2	BEARING NUT
BRG-921	1	SHAFT COLLAR
BRG-922	4	O'RING
BRG-924	1	Ø3/4 THOMSON ROD X 26-7/8' LG.
WMP-1088	1	ARM SHAFT HOUSING
WMP-1116	REF.	SEE PLY-323 ABOVE
WMP-1547	2	INSERT HOUSING
WMP-1548	1	ARM SHAFT
LWP-7107	1	ARM MOUNT
LWP-7559	1	OUTLET PLUNGER
FAS-C9	4	#6-32 X 1/2' LG. S.H.C.S.
FAS-E27	2	#10-24 X 1/4' LG. S.H.S.S.
FAS-F25	1	1/4-20 X 1' LG. S.H.C.S.
FAS-H14	2	3/8-16 X 2-1/2' LG. S.H.C.S.
FAS-RPIN #2	1	Ø1/8' X 1' ROLL PIN
FAS-SPRING #1	2	SNAP RING #1
FAS-SPRING #2	2	SNAP RING #2
FAS-SPRING #5	2	SNAP RING #5

RISE & FALL UPPER ASSEMBLY PARTS LIST

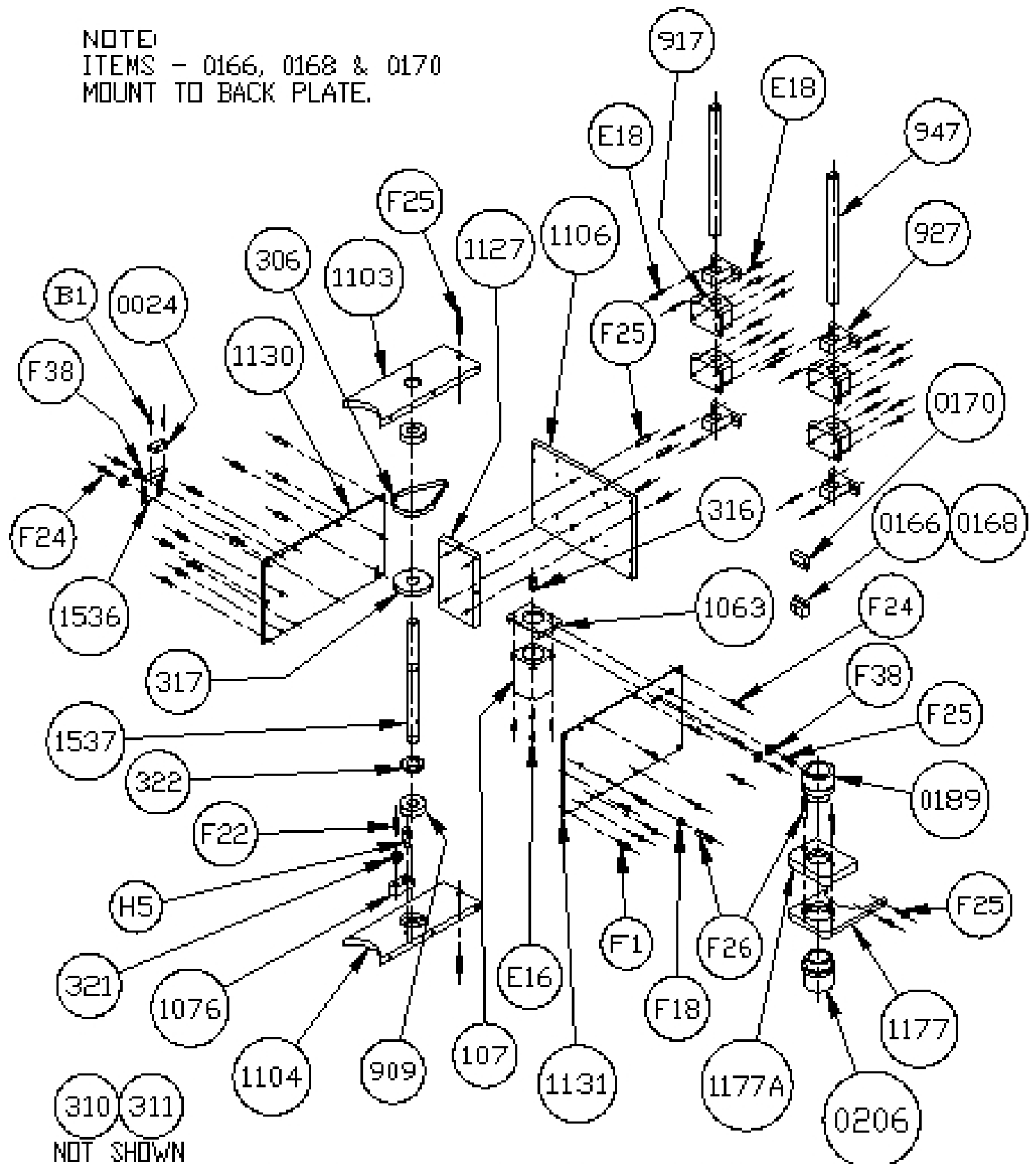
PART NUMBER	QUANTITY	DESCRIPTION
SWT-0024	1	FROG PROX SWITCH
EPP-0167	1	3 PIN MALE N/LOCK
EPP-0168	2	4 PIN MALE N/LOCK
EPP-0169	1	11 PIN FEMALE N/LOCK
MTR-104	1	STEPPER MOTOR
AIR-411	1	AIR CYLINDER 3/4 X 6
AIR-412	2	FLOW CONTROL VALVE
AIR-415	2	PUSHLOK CONNECTOR 1/8 X 1/8 MALE
AIR-417	2	PUSHLOK ELBOW 1/4 X 1/8 MALE
AIR-419	2	MUFFLER
AIR-423	1	PUSHLOK TEE 1/8
AIR-428	2	AIR VALVE 120VAC/60 HZ
AIR-436	2	AIR VALVE 24VDC
AIR-459	1	AIR CYLINDER PROXIMITY SWITCH
BRG-936	2	V WHEEL
BRG-940	1	BRASS LEAD NUT
WMP-1061	1	CYLINDER SUPPORT PLATE
WMP-1077	1	WOBBLE PLATE SUPPORT
WMP-1098	1	WOBBLE PLATE
WMP-1126	2	WOBBLE PLATE ARMS
WMP-1132	1	WOBBLE PLATE UNION MOUNT
WMP-1534	1	CYLINDER SUPPORT BRACE
WMP-1535	1	WOBBLE PLATE SWITCH MOUNT
WMP-1538	2	WOBBLE PLATE HINGE
WMP-1540	1	PLUNGER CYLINDER MOUNT
WMP-1541	2	WOBBLE PLATE MOTOR MOUNT
WMP-1542	1	UNION JOINT
WMP-1544	1	ACME SCREW 1/4-20 X 3-1/2' LG.
WMP-1546	1	ROTATE ARM
WMP-1573	1	ACME NUT MOUNT
FAS-B1	2	#4-40 X 1/2' LG. R.H.M.S.
FAS-B2	4	#4-40 X 1' LG. S.H.C.S.
FAS-E16	2	#10-24 X 1/2' LG. S.H.C.S.
FAS-E18	2	#10-24 X 3/4' LG. S.H.C.S.
FAS-E20	4	#10-24 X 1-1/2' LG. S.H.C.S.
FAS-E30	4	#10 FLAT WASHER
FAS-F17	2	1/4-20 X 1/2' LG. S.H.S.S.
FAS-F23	4	1/4-20 X 1/2' LG. S.H.C.S.
FAS-F25	4	1/4-20 X 1' LG. S.H.C.S.
FAS-F26	6	1/4-20 X 1-1/4' LG. S.H.C.S.
FAS-F29	2	1/4-20 NYLOCK NUT
FAS-F38	2	Ø1/4' FLAT WASHER
FAS-F45	2	Ø1/4 X 1/4' LG. SHOULDER SCREW
FAS-SHIM#6	2	SHIM #6 Ø.173 X Ø.250 X .015

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*

* - VALVE USED DEPENDS ON CONTROL VOLTAGE

20-LWA-0104 BOM

NOTE:
 ITEMS - 0166, 0168 & 0170
 MOUNT TO BACK PLATE.



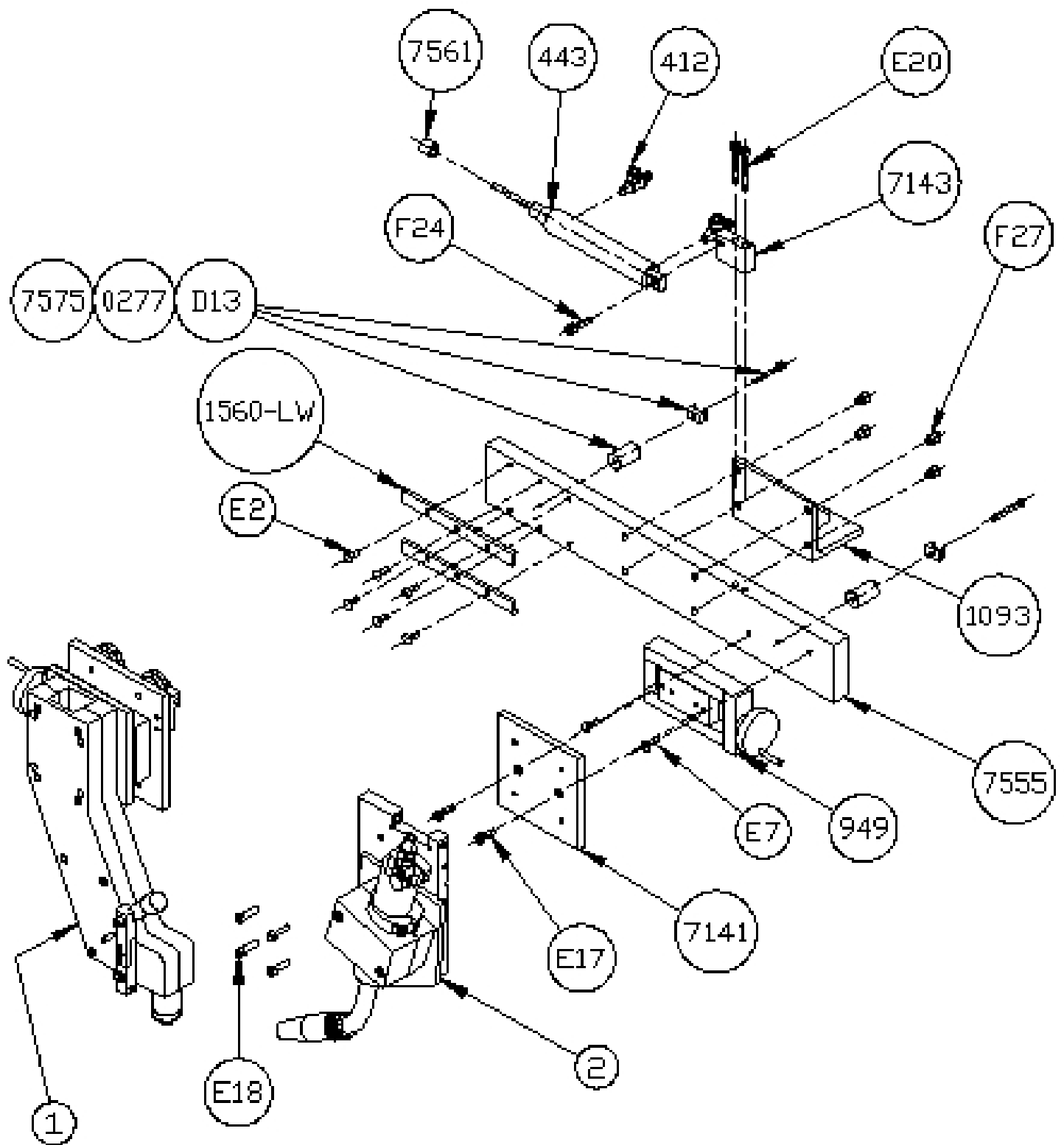
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RISE & FALL LOWER ASSEMBLY


RISE & FALL LOWER ASSEMBLY PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
SWT-0024	1	FROG PROX SWITCH
EPP-0166	1	2 PIN MALE N/LOCK
EPP-0168	1	4 PIN MALE N/LOCK
EPP-0170	1	6 PIN FEMALE N/LOCK
MTR-107	1	STEPPER MOTOR
EPP-0189	1	UPPER CONDUIT HUB
EPP-0206	1	LOWER CONDUIT HUB
PLY-306	1	ROTATION BELT
PLY-310	1	#25 CHAIN
PLY-311	1	#25 MASTERLINK
PLY-316	1	ROTATION DRIVE PULLEY
PLY-317	1	ROTATION PULLEY
PLY-321	1	IDLER SPROCKET 1/4 PITCH, 18 TEETH
PLY-322	1	ROTATION SPROCKET
BRG-909	2	BEARING 6204
BRG-917	4	PILLOW BLOCK
BRG-927	4	SUPPORT BLOCK
BRG-947	2	3/4" QUICK SHAFT X 11" LG.
WMP-1063	1	MOTOR MOUNT
WMP-1076	1	IDLER MOUNT BLOCK
WMP-1103	1	TOP BEARING PLATE
WMP-1104	1	BOTTOM BEARING PLATE
WMP-1106	1	BOX MOUNT PLATE
WMP-1127	1	BACK PLATE
WMP-1130	1	LEFT SIDE PLATE
WMP-1131	1	RIGHT SIDE PLATE
WMP-1177A	1	UPPER CONDUIT MOUNT
WMP-1177	1	LOWER CONDUIT MOUNT
WMP-1536	1	ROTATION SWITCH MOUNT
WMP-1537	1	ROTATION SHAFT
FAS-B1	2	#4-40 X 1/2" LG. R.H.M.S.
FAS-E16	4	#10-24 X 1/2" LG. S.H.C.S.
FAS-E18	24	#10-24 X 3/4" LG. S.H.C.S.
FAS-F1	4	1/4-20 X 5/8" LG. B.H.C.S.
FAS-F18	1	1/4-20 HEX. NUT
FAS-F22	1	Ø1/4 X 3/4" LG. SHOULDER SCREW
FAS-F24	20	1/4-20 X 3/4" LG. S.H.C.S.
FAS-F25	9	1/4-20 X 1" LG. S.H.C.S.
FAS-F26	3	1/4-20 X 1-1/4" LG. S.H.C.S.
FAS-F38	4	Ø1/4" FLAT WASHER
FAS-H5	1	Ø3/8 X 3/4" LG. SHOULDER SCREW

20-LWA-0105 BOM



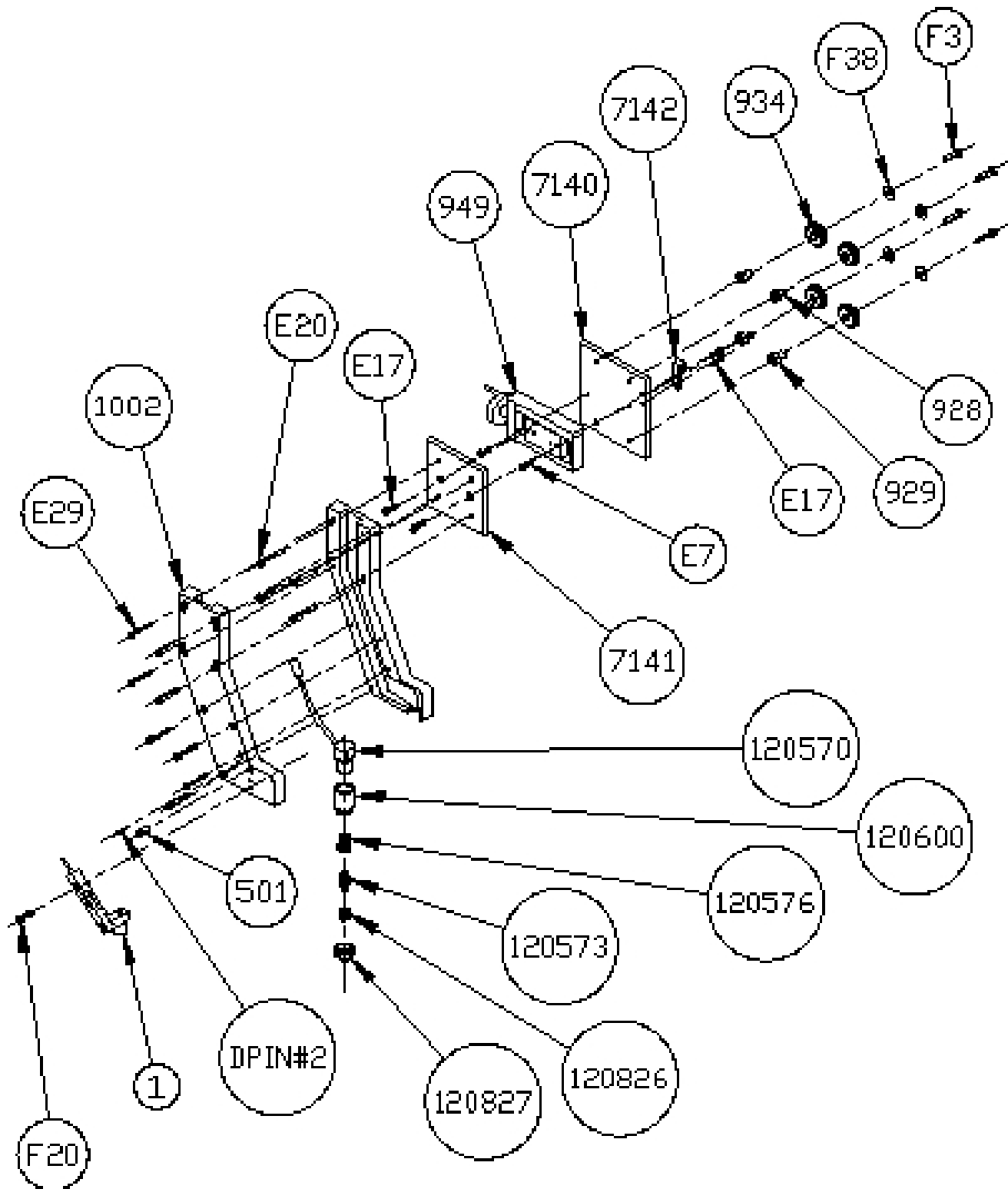
LINE WELDER ARM ASSEMBLY

 North Alabama Pipe Corporation


20-LWA-0106

LINE WELDER ARM PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-LWA-010601	1	LINE WELDER ARM ASSEMBLY (PLASMA SIDE)
2	20-LWA-010602	1	LINE WELDER ARM ASSEMBLY (WELD SIDE)
	AIR-412	2	FLOW CONTROL
	AIR-443	1	AIR CYLINDER
	BRG-949	1	SLIDE
	EPP-0277	2	TIE WRAP MOUNTING BRACKET
	WMP-1093	1	FLEX CONNECTOR MOUNT
	LMP-1560-LW	2	T-2 TRACK
	LWP-7141	1	TORCH PLATE
	LWP-7143	1	CYLINDER MOUNT BLOCK
	LWP-7555	1	ARM PLATE
	LWP-7561	1	5/16 ID X 1/2 OD X 1/2" LG NYLON
	LWP-7575	2	WIRE STANDOFF
	FAS-D13	2	#8-32 X 1-1/2" LG. SHCS
	FAS-E2	6	#10-24 X 5/8" LG. BHSCS
	FAS-E7	2	#10-24 X 5/8" LG. FHSCS
	FAS-E17	2	#10-24 X 5/8" LG. SHCS
	FAS-E18	4	#10-24 X 3/4" LG. SHCS
	FAS-E20	2	#10-24 X 1-1/2" LG. SHCS
	FAS-F24	1	1/4-20 X 3/4" LG. SHCS
	FAS-F27	4	1/4-20 X 1-1/2" LG. SHCS



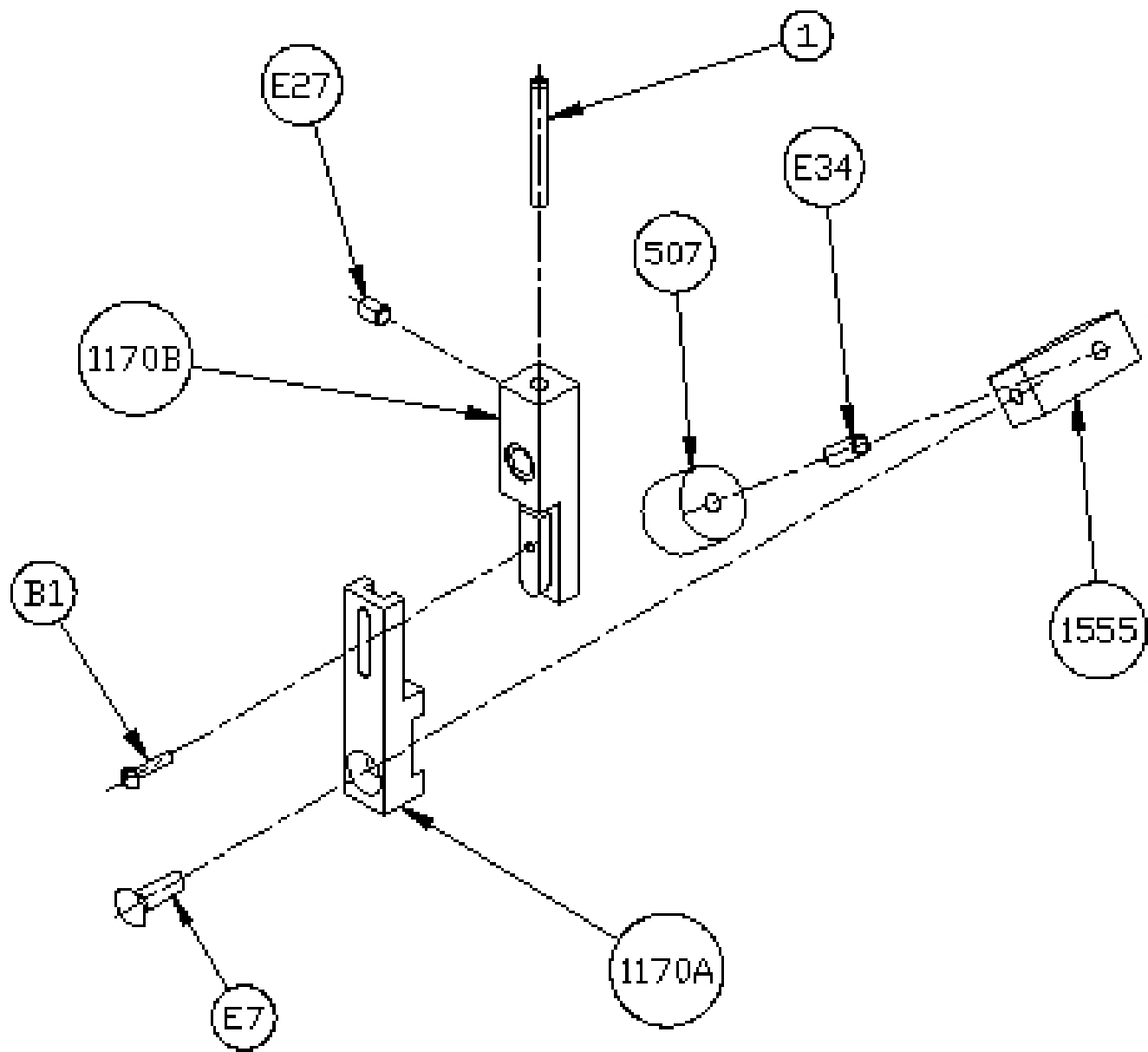
LINE WELDER ARM ASSEMBLY (PLASMA SIDE)

 North Alabama Pipe Corporation
20-LWA-010601

LINE WELDER ARM ASSEMBLY (PLASMA SIDE) PARTS LIST

ITEM	PART NUMBER	QUANTITY	DESCRIPTION
1	20-WAS-COUPON ASY	1	COUPON COLLECTOR ASSEMBLY
	MSC-501	1	BALL DETENT
	BRG-928	2	V WHEEL BUSHING
	BRG-929	2	ECCENTRIC V WHEEL BUSHING
	BRG-934	4	V WHEEL
	BRG-949	1	SLIDE
	WMP-1002	1	PLASMA TORCH HOUSING
	LWP-7140	1	MOUNT PLATE
	LWP-7141	1	PLASMA TORCH PLATE
	LWP-7142	1	CYLINDER BRACKET
	TCH-120570	1	TORCH BODY
	TCH-120600	1	SHIELD CAP
	TCH-120576	1	SWIRL RING
	TCH-120573	1	ELECTRODE
	TCH-120826	1	NOZZLE
	TCH-120827	1	SHIELD
	FAS-E7	2	#10-24 X 5/8" LG. F.H.C.S.
	FAS-E17	4	#10-24 X 5/8" LG. SHCS
	FAS-E20	4	#10-24 X 1-1/2" LG. S.H.C.S.
	FAS-E29	8	#10-24 X 1-1/4" LG. S.H.C.S.
	FAS-F3	4	1/4-20 X 1" LG. B.H.C.S.
	FAS-F20	1	Ø1/4 X 1/2" LG. SHOULDER BOLT
	FAS-F38	4	Ø1/4" FLAT WASHER
	FAS-DPIN #2	1	Ø1/8" X 1" LG. DOWEL PIN

20-LWA-010601 BOM



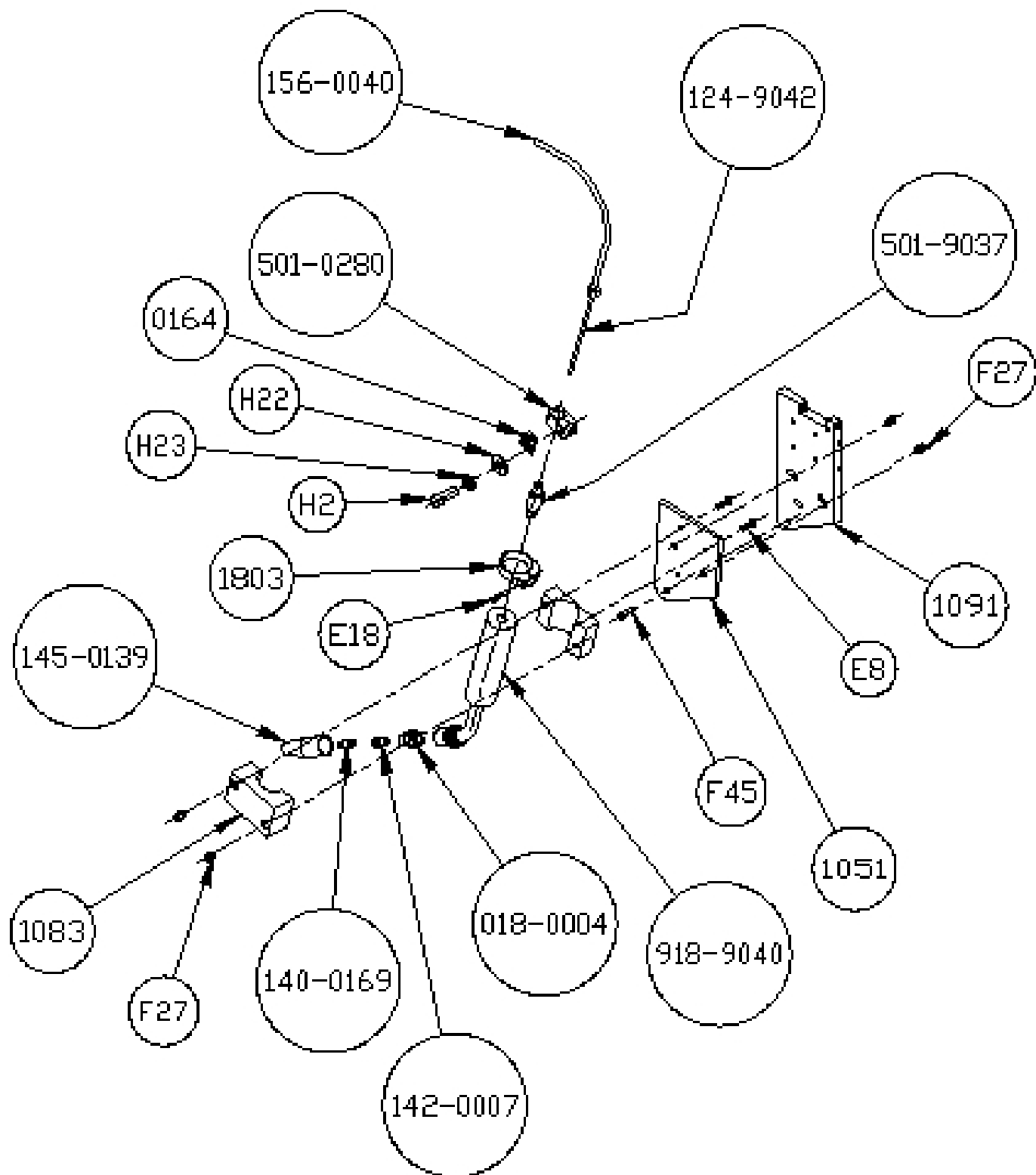
COUPON COLLECTOR ASSEMBLY

 North Alabama Pipe Corporation
20-WAS-COUPON ASY

COUPON COLLECTOR ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1		1	SECTION OF LINER #TCH-124-9042 X 1-1/2' LG.
	MSC-507	1	MAGNET
	WMP-1170A	1	COUPON COLLECTION LOWER ARM
	WMP-1170B	1	COUPON COLLECTION UPPER ARM
	WMP-1555	1	MAGNET MOUNT
	FAS-B1	1	#4-40 X 1/2' LG. RSLMS
	FAS-E7	1	#10-24 X 5/8' LG. FHMS
	FAS-E27	1	#10-24 X 1/4' LG. SHSS
	FAS-E34	1	#10-32 X 1/2' LG. SHSS

20-WAS-COUPON ASY BOM

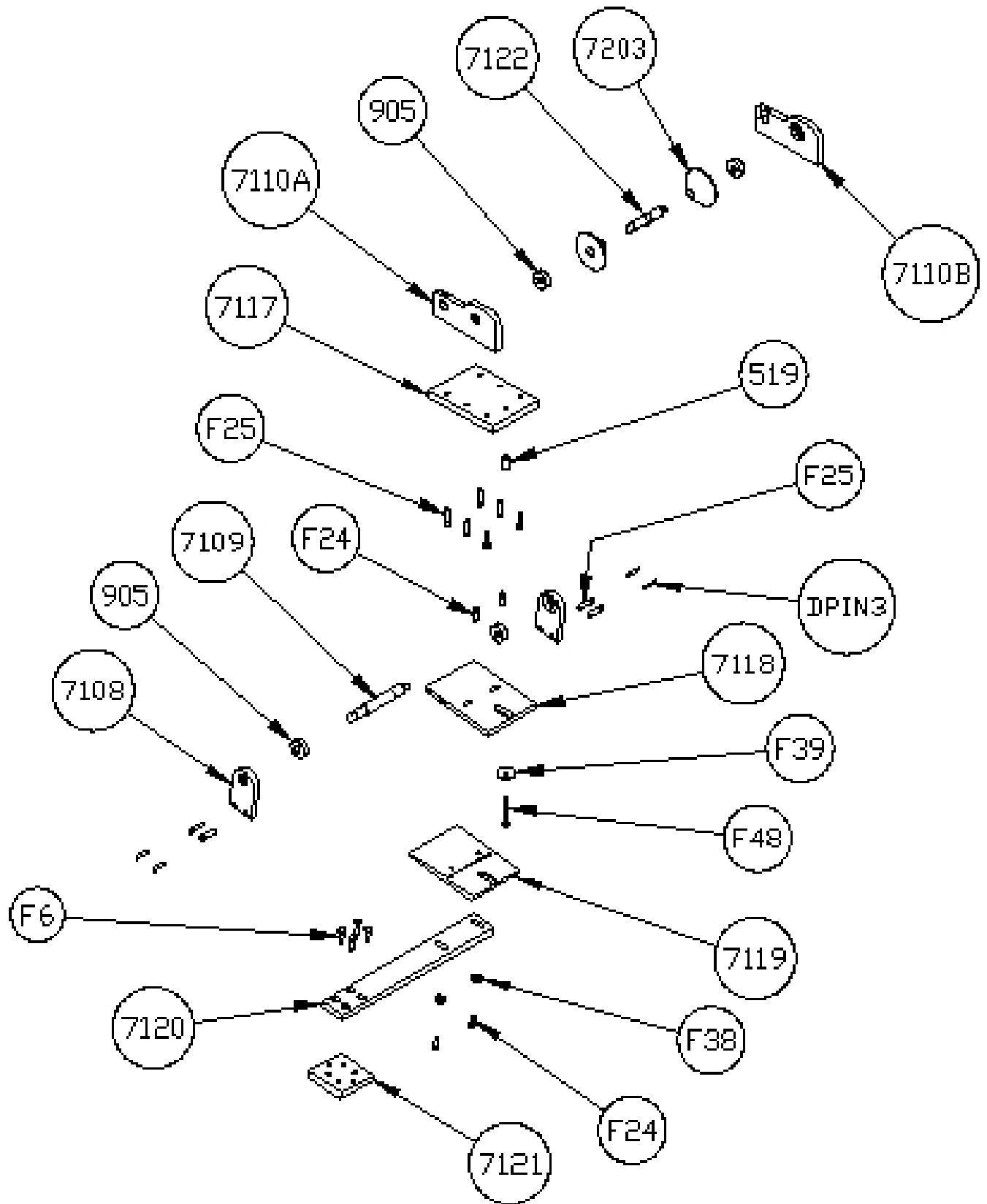


LINE WELDER ARM ASSEMBLY (WELD SIDE)


 North Alabama Pipe Corporation
20-LWA-010602

LINE WELDER ARM ASSEMBLY (WELD SIDE) PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
EPP-0164	1	CABLE LUG
WMP-1051	1	WELD TORCH MOUNT PLATE
WMP-1083	1	TORCH CLAMP BLOCK
WMP-1091	1	WELD TORCH PLATE
WMP-1803	1	TORCH ADJUSTMENT COLLAR
TCH-018-0004	1	DIFFUSER
TCH-124-9042	1	17 FT. LINER .035-.045
TCH-140-0169	1	CONTACT TIP
TCH-142-0007	1	TIP HOLDER
TCH-145-0139	1	NOZZLE
TCH-156-0040	1	10 FT. CONDUIT
TCH-501-0280	1	POWER CABLE CLAMP
TCH-501-9037	1	ADAPTOR PLUG
TCH-918-9040	1	WELD TORCH
FAS-E8	2	#10-24 X 3/4' LG. F.H.C.S.
FAS-E18	1	#10-24 X 3/4' LG. S.H.C.S.
FAS-F27	4	1/4-20 X 1-1/2' LG. S.H.C.S.
FAS-F45	1	Ø1/4' X 1/4' LG. S.H.S.B.
FAS-H2	1	3/8-16 X 1-1/4' LG. H.H.C.S.
FAS-H2E	1	Ø3/8' FLAT WASHER
FAS-H23	1	Ø3/8' LOCK WASHER

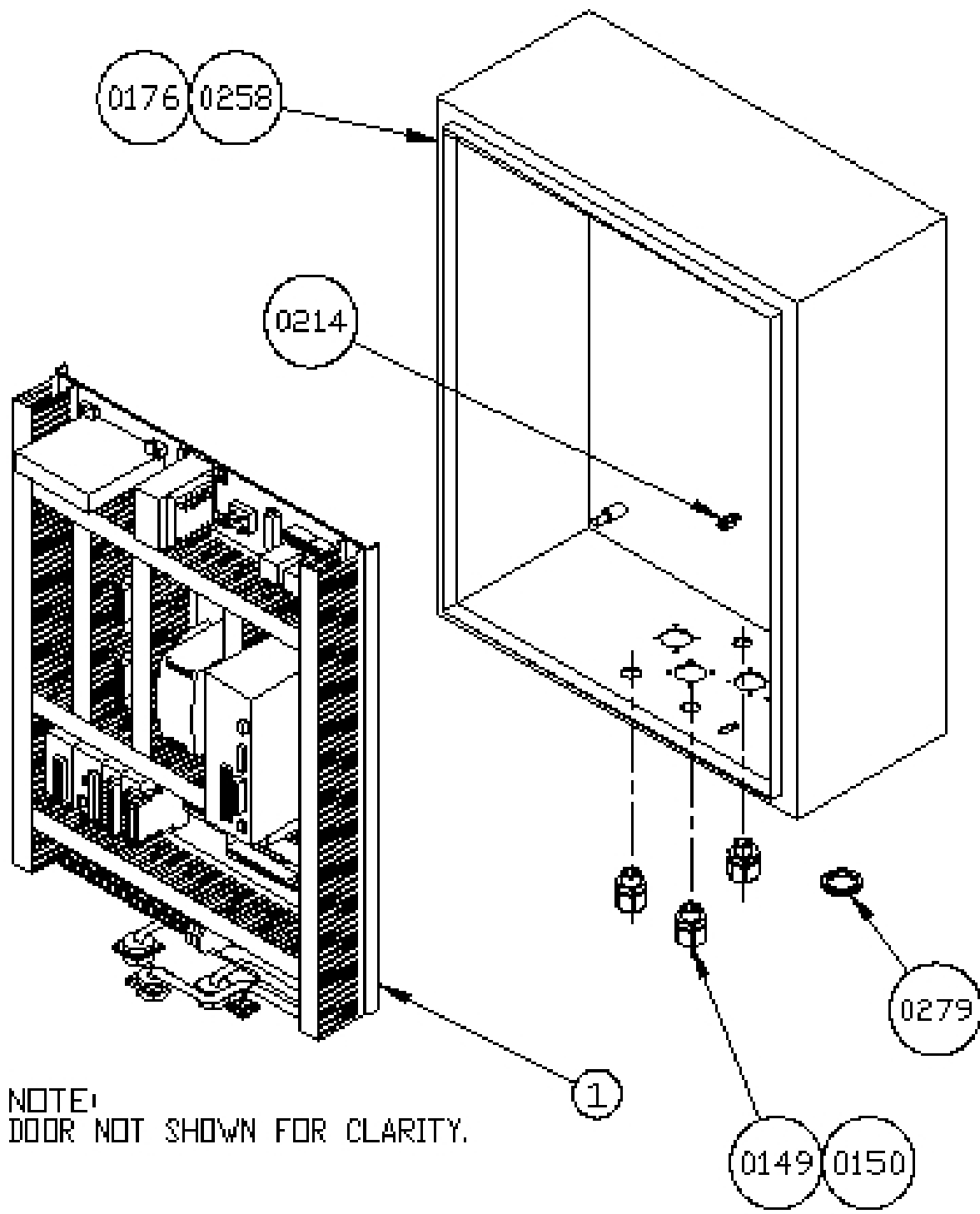


LINEWELDER CENTER SYSTEM ASSEMBLY

 North Alabama Pipe Corporation
20-LWA-02


LINEWELDER CENTER SYSTEM ASSEMBLY PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
MSC-519	1	COMPRESSION SPRING
BRG-905	4	BEARING
LWP-7108	2	PIVOT PLATE
LWP-7109	1	PIVOT SHAFT
LWP-7110A	1	ROLLER SIDE PLATE
LWP-7110B	1	ROLLER SIDE PLATE
LWP-7117	1	ROLLER MOUNT PLATE
LWP-7118	1	PIVOT PLATE MOUNT
LWP-7119	1	BOTTOM PLATE
LWP-7120	1	CENTER SYSTEM MOUNT ARM
LWP-7121	1	MOUNT PLATE
LWP-7122	1	ROLLER SHAFT
LWP-7203	2	ROLLER
FAS-F6	4	1/4-20 X 1" LG. FHSCS
FAS-F24	4	1/4-20 X 3/4" LG. SHCS
FAS-F25	10	1/4-20 X 1" LG. SHCS
FAS-F38	2	Ø1/4" FLAT WASHER
FAS-F39	1	Ø1/4" FENDER WASHER
FAS-F48	1	1/4-20 X 2" LG. SHCS
FAS-DPIN #3	4	Ø3/16" X 1" LG. DOWEL PIN



NOTE:
DOOR NOT SHOWN FOR CLARITY.

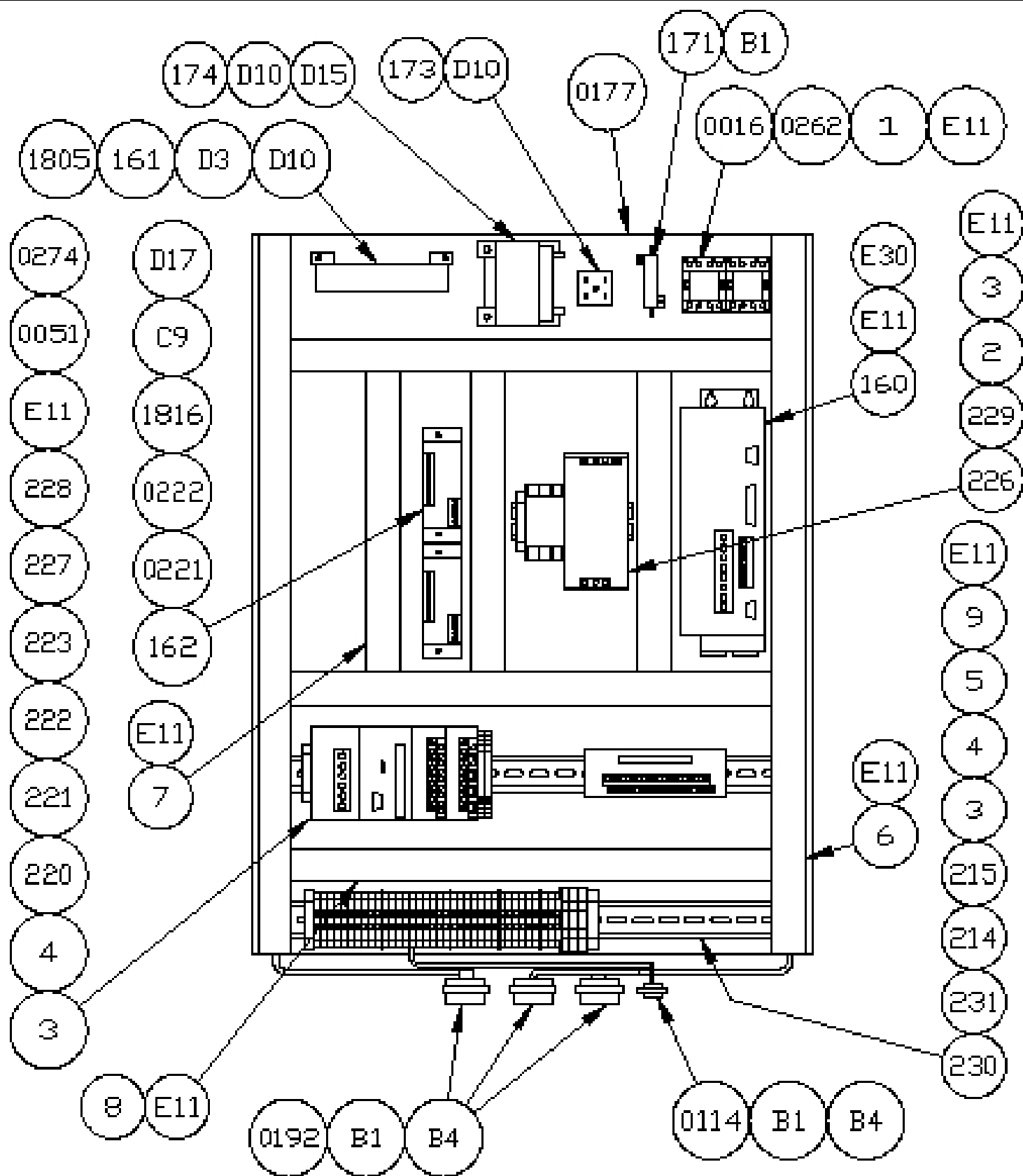
LINE WELDER CONTROL CABINET

 North Alabama Pipe Corporation

20-LWA-03

LINE WELDER CONTROL CABINET PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-LWA-0301	1	LINE WELDER CONTROL CABINET BACK PLATE
	EPP-0149	15Ft.	1/2" PVC TUBING
	EPP-0150	2	1/2" PVC STRAIGHT FITTING
	EPP-0176	1	30X24X10 BRAIN BOX
	EPP-0214	1	MINI GENDER CHANGER #30-9531
	EPP-0258	1	ELECTRICAL HAZZARD LABEL
	EPP-0279	4-3/4"	PANDUIT GROMMET EDGING #GEE99F-C



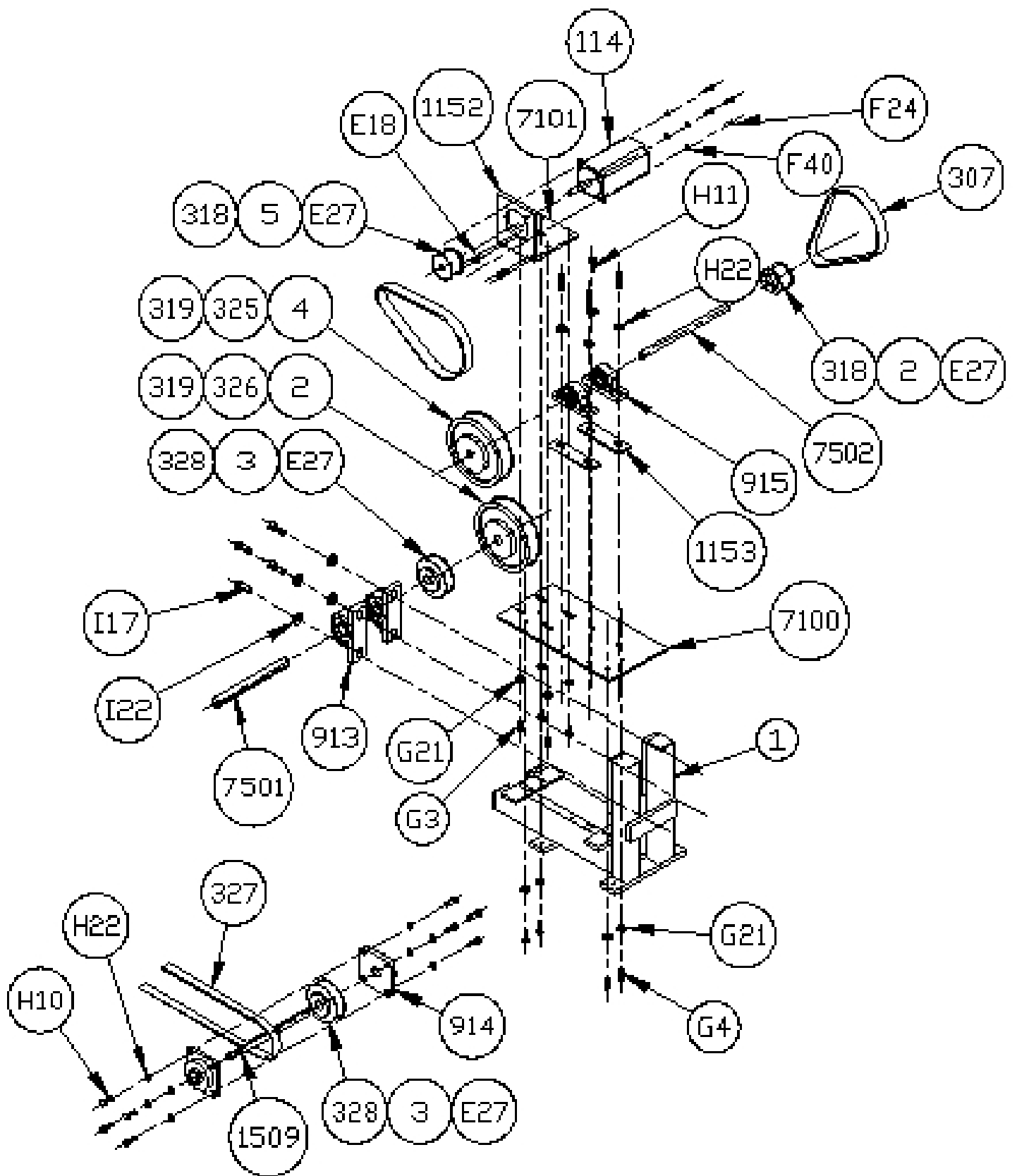
LINE WELDER CONTROL CABINET
BACK PLATE ASSEMBLY

North Alabama Pipe Corporation


20-LWA-0301

LINE WELDER CONTROL CABINET BACK PLATE PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	PLC-210	1	DIN RAIL X 3-1/4" LG.
2	PLC-210	1	DIN RAIL 4-1/2" LG.
3		4	TERMINAL BLOCK END CAP
4	PLC-210	2	DIN RAIL X 18" LG.
5		1	GROUND TERMINAL BLOCK
6		2	WIRE WAY X 27" LG.
7		3	WIRE WAY X 11-1/4" LG.
8		1	WIRE WAY X 18" LG.
9		1	TERMINAL BLOCK LABELS
	DRV-160	1	KOLLMORGAN DRIVE SERVO STAR DCD #CR06550
	DRV-162	2	CYBERPAK CY-41 STEPPER DRIVE
	DRV-171	1	BRAKING RESISTOR OHMITE 850F1R0 #296-1125
	DRV-173	1	BRIDGE RECTIFIER #266-0044
	DRV-174	1	TRANSFORMER #836-1886
	EPP-0114	1	9 PIN AMP RECPT #512-1107
	EPP-0177	1	30 X 24 BACK PLATE SAGINAM 30P24
	EPP-0192	1	BOX LINKAGE CABLES (PIG-TAILS ONLY)
	EPP-0218	1	4 COOLING FAN DC #592-0970
	EPP-0221	2	STEPPER DRIVE CONNECTOR 5 PIN #502-0449
	EPP-0222	2	STEPPER DRIVE CONNECTOR 10 PIN #502-6116
	EPP-0262	4	DIODE #568-0273
	EPP-0274	2	PLC RELAY 24VDC SPDT MO
	PLC-214	3	FUSE BLOCK WEIDMULLER
	PLC-215	1	FUSE BLOCK END PLATE
	PLC-220	1	POWER SUPPLY CJIWPA202
	PLC-221	1	CPU CJ1MCPU22
	PLC-222	2	INPUT MODULE CJ1WID211
	PLC-223	1	INPUT MODULE CJ1WOC211
	PLC-226	1	POWER SUPPLY 24VDC 10 AMP PULS CS10.241
	PLC-227	1	PLC BREAK-OUT BOARD OMRON XW2B40G4
	PLC-228	1	PLC BREAK-OUT BOARD CABLE OMRON XW2Z-100K
	PLC-229	1	POWER SUPPLY 5VDC 1.5 AMP OMRON S82K-00705
	PLC-230	35	TERMINAL BLOCKS PHOENIX 3004362
	PLC-231	5	TERMINAL BLOCK END CAPS PHOENIX 3003020
	SWT-0016	2	8 PIN RELAY BASE PF083A-E
	SWT-0051	2	RELAY
	WMP-1805	2	FAN MOUNT
	WMP-1816	2	CYBERPAK MOUNT PLATE
	FAS-B1	18	#4-40 X 1/2" LG. RSLMS
	FAS-B4	16	#4-40 HEX NUT
	FAS-C9	4	#6-32 X 1/2" LG. SHCS
	FAS-D3	2	#8-32 X 3/8" LG. RSLMS
	FAS-D10	7	#8-32 X 3/4" LG. SHCS
	FAS-D15	4	#8-32 HEX NUT
	FAS-D17	8	#8032 X 3/8" LG. FHMS
	FAS-E11	32	#10-24 X 1/2" LG. RSLMS
	FAS-E30	4	#10 FLAT WASHER



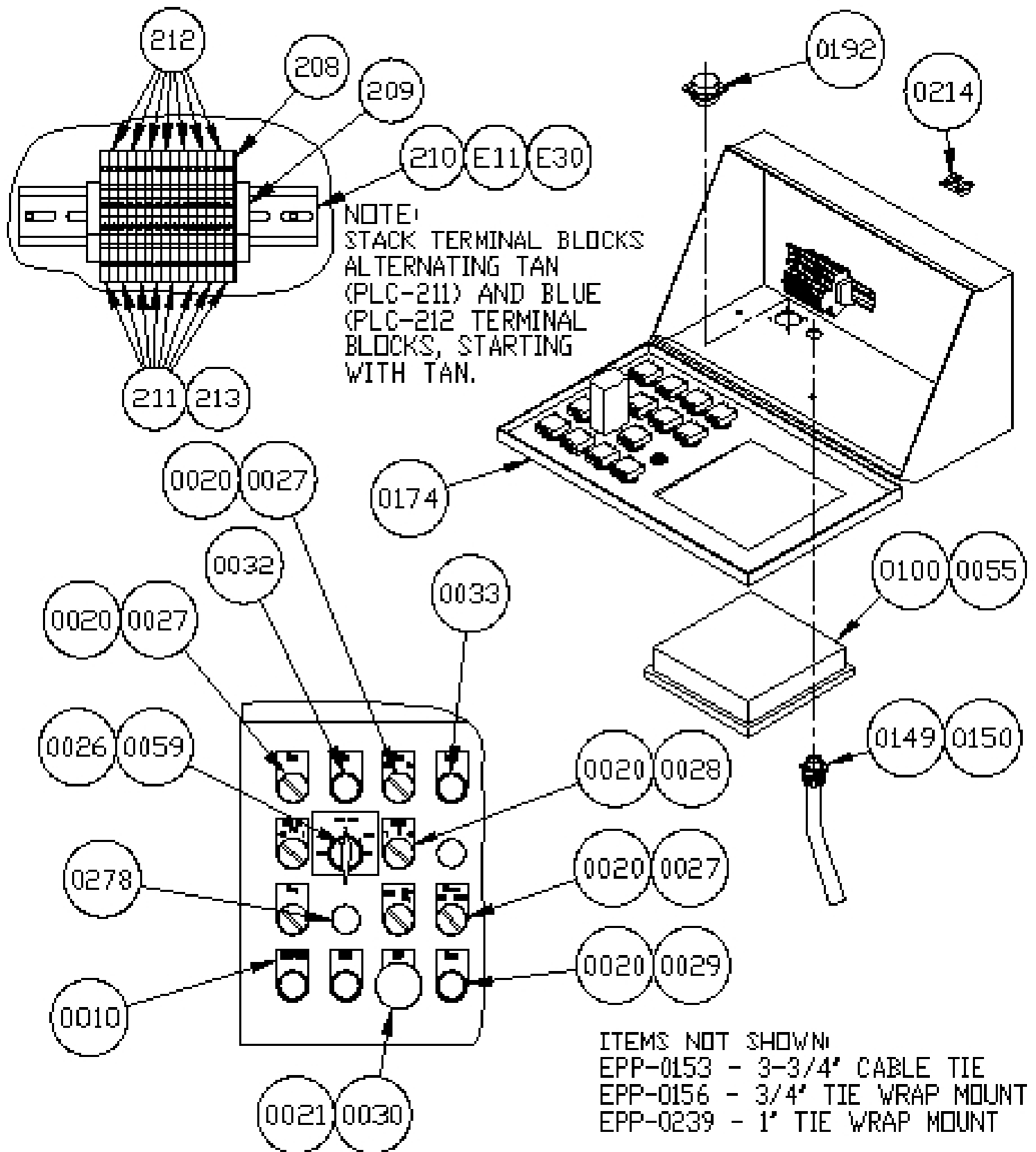
LINEWELDER APC ASSEMBLY

 North Alabama Pipe Corporation


20-LWA-04

LINEWELDER APC ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-LWA-0401	1	APC-FRAME WELDMENT
	MTR-114	1	SERVO MOTOR
	PLY-307	2	BELT 800 8M 30
	PLY-318	2	PULLEY P24 8M 30
	PLY-319	2	TAPER LOCK PULLEY P72 8M 30
	PLY-325	1	Ø3/4" TAPER LOCK SK 3/4
	PLY-326	1	Ø1" TAPER LOCK SK 1
	PLY-327	54 FT.	DRIVE BELT 25T10C
	PLY-328	2	PULLEY 40T10/32
	BRG-913	2	PILLOW BLOCK BEARING MP16
	BRG-914	2	FLANGE BEARING MSF 16
	BRG-915	2	PILLOW BLOCK BEARING NP12
	WMP-1509	1	Ø1" SHAFT X 9" LG.
	WMP-1152	1	MOTOR MOUNT PLATE
	WMP-1153	2	BEARING PLATE
	WMP-1808	1	1/4" X 2" LG. KEY STOCK
	WMP-1809	1	5mm X 2" LG. KEY STOCK
	WMP-1810	2	3/16" X 2" LG. KEY STOCK
	WMP-1811	2	1/4" X 1-1/2" LG. KEY STOCK
	LWP-7100	1	MAIN MOUNTING PLATE
	LWP-7101	1	MOTOR ADJUSTMENT PLATE
	LWP-7501	1	Ø1" SHAFT X 10" LG.
	LWP-7502	1	Ø3/4" SHAFT X 12" LG.
	FAS-E18	4	#10-24 X 3/4" LG. SHCS
	FAS-E27	6	#10-24 X 1/4" LG. SHSS
	FAS-F24	4	1/4-20 X 3/4" LG. SHCS
	FAS-F40	4	Ø1/4" LOCK WASHER
	FAS-G3	4	5/16-18 X 3/4" LG. HHCS
	FAS-G4	4	5/16-18 X 1" LG. HHCS
	FAS-G21	8	Ø5/16" FLAT WASHER
	FAS-H10	8	3/8-16 X 1" LG. SHCS
	FAS-H11	4	3/8-16 X 1-1/4" LG. SHCS
	FAS-H22	12	Ø3/8 FLAT WASHER
	FAS-I17	4	1/2-13 X 1-1/4" LG. SHCS
	FAS-I22	4	Ø1/2" FLAT WASHER



LINE WELDER PUSH BUTTON BOX ASSEMBLY

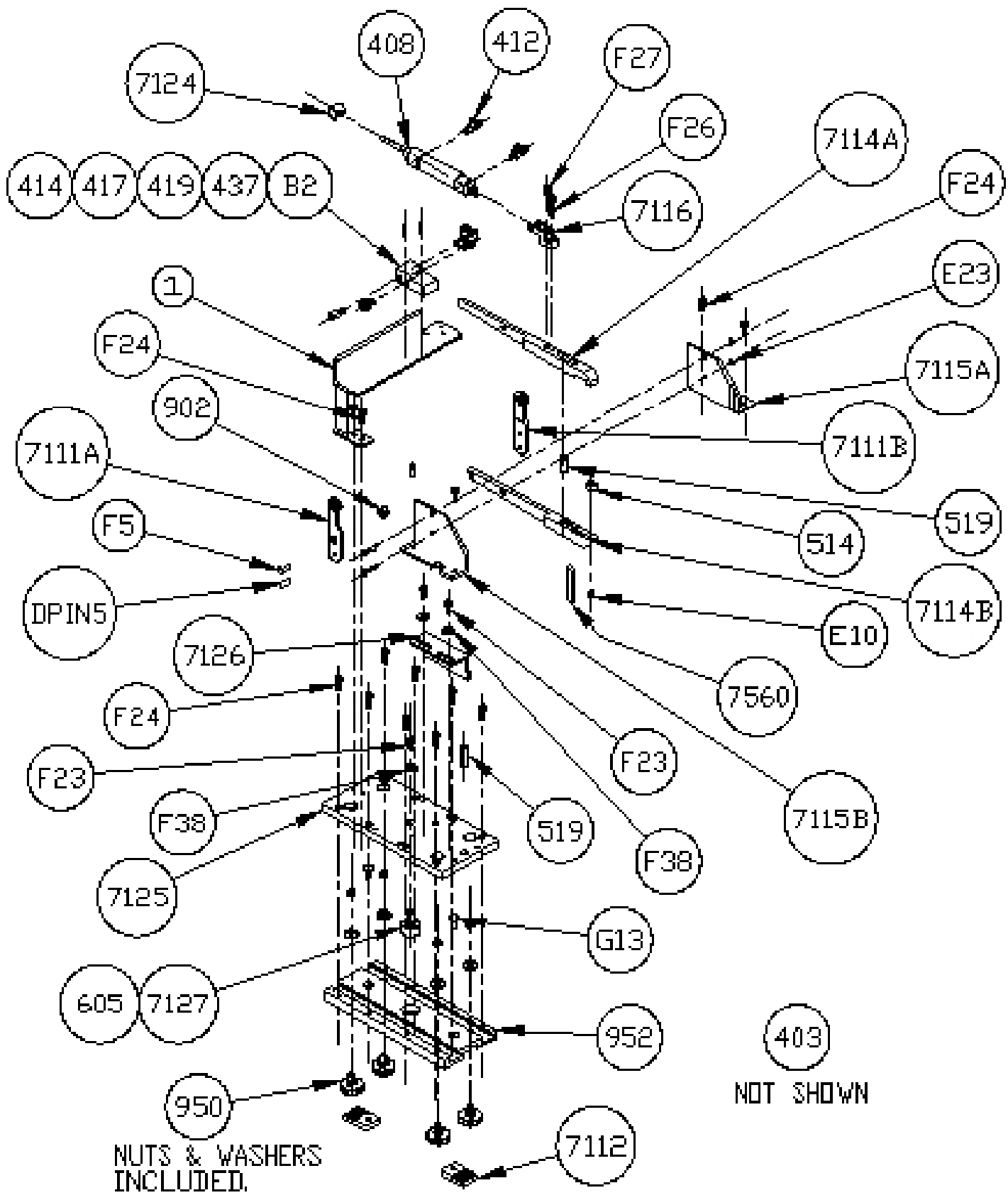
 North Alabama Pipe Corporation

20-LWA-05

LINE WELDER PUSH BUTTON BOX PARTS LIST


PART NUMBER	QUANTITY	DESCRIPTION
EPP-0100	1	EASON PANEL
EPP-0149	4 Ft.	1/2" PVC CONDUIT
EPP-0150	1	1/2" PVC STRAIGHT FITTING
EPP-0153	34	3-3/4" LG. WIRE TIE
EPP-0156	2	3-3/4" LG. TIE WRAP MOUNT
EPP-0239	7	1" TIE WRAP MOUNT
EPP-0174	1	EASON SWITCH BOX
EPP-0192	REF.	BOX LINK CABLE SET
EPP-0214	2	MINI GENDER CHANGER #30-9531
PLC-208	1	SIDE PLATE
PLC-209	2	ENDS
PLC-210	5-3/4" LG	DIN RAIL
PLC-211	8	TAN TERMINAL BLOCK
PLC-212	7	BLUE TERMINAL BLOCK
PLC-213	1	TERMINAL BLOCK LABEL NUMBERS
SWT-0010	1 SET	CONTROL BOX LABELS
SWT-0020	13	CONTACT BLOCK 1 N.O.
SWT-0021	1	CONTACT BLOCK 1 N.C.
SWT-0026	1	MULTI-POSITION SWITCH
SWT-0027	6	2 POSITION SWITCH
SWT-0028	2	3 POSITION SWITCH
SWT-0029	3	BLK PUSH BUTTON SWITCH
SWT-0030	1	RED PUSH BUTTON SWITCH
SWT-0032	1	PILOT LIGHT GREEN
SWT-0033	1	PILOT LIGHT RED
SWT-0055	1 SET	EASON PUSH BUTTON LABELS
SWT-0059	1	LINE WELDER PIPE SIZE LEGEND PLATE
FAS-E11	2	#10-24 X 1/2" LG. RHMS
FAS-E30	2	#10 FLAT WASHER

20-LWA-05 BOM



NUTS & WASHERS INCLUDED.

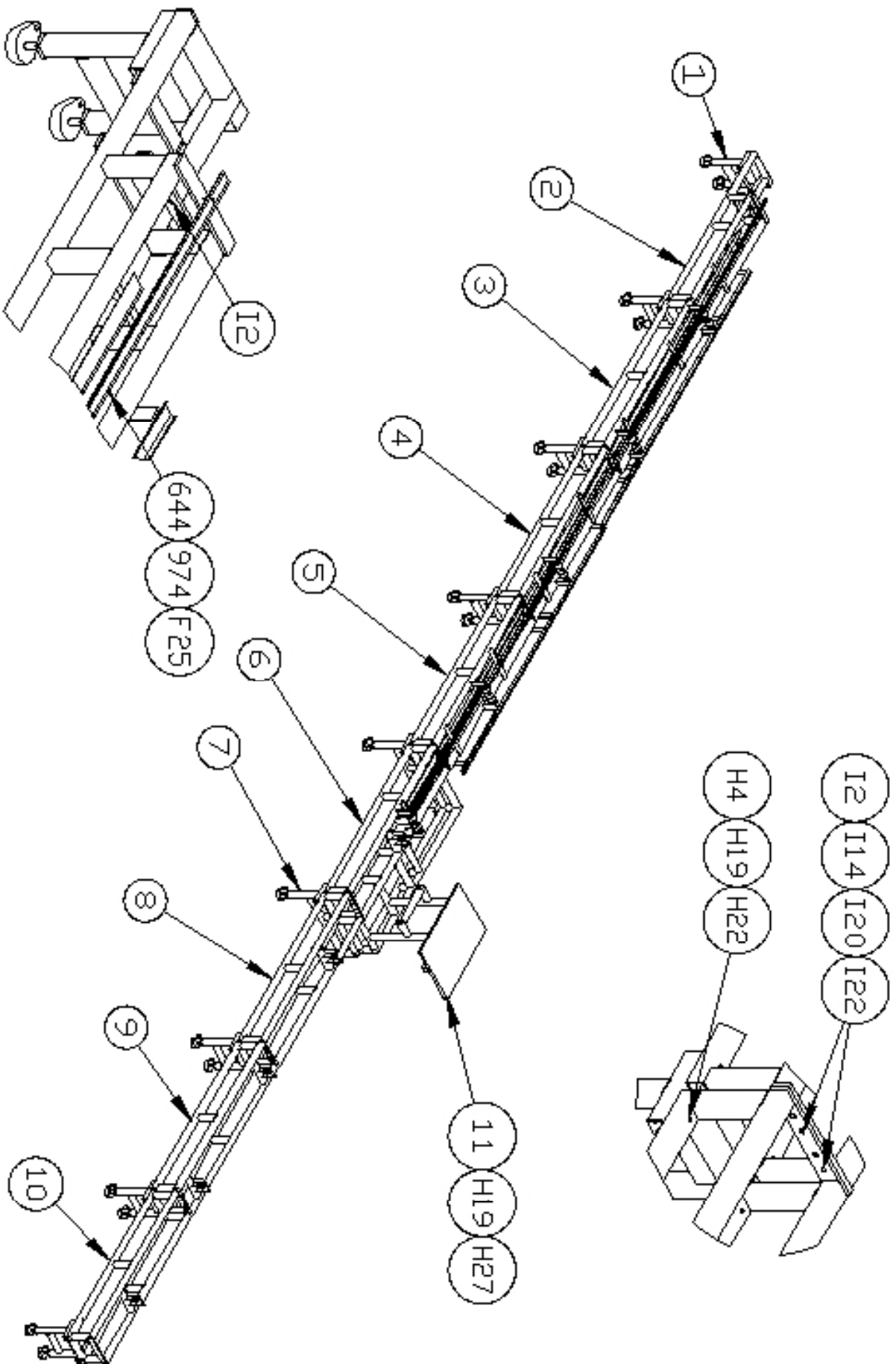
ALLIGATOR ASSEMBLY

 North Alabama Pipe Corporation

ALLIGATOR ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-LWA-0601	1	WIRE TROLLEY WELDMENT
	AIR-403	18'	Ø1/4" AIR LINE
	AIR-408	1	2" STROKE AIR CYLINDER
	AIR-412	2	FLOW CONTROL VALVE
	AIR-414	1	1/4T X 1/8P MALE CONNECTOR
	AIR-417	2	1/4T X 1/8P ELBOW
	AIR-419	1	1/8 MUFFLER
	AIR-437	1	AIR VALVE
	MSC-514	1	GRIPPER PAD
	MSC-519	2	COMPRESSION SPRING
	MSC-605	1	PLUNGER COMPRESSION SPRING LEE #LC-055J-3MW
	BRG-902	1	KP4A BEARING
	BRG-950	4	"V" WHEEL
	BRG-952	1	BEARING PLATE
	LWP-7111A	1	LEFT ARM
	LWP-7111B	1	RIGHT ARM
	LWP-7112	2	BELT CLIP
	LWP-7114A	1	UPPER PIPE GRIPPER ARM
	LWP-7114B	1	LOWER PIPE GRIPPER ARM
	LWP-7115A	1	RIGHT MOUNT ANGLE
	LWP-7115B	1	LEFT MOUNT ANGLE
	LWP-7116	1	AIR CYLINDER MOUNT
	LWP-7124	1	ROD COUPLER
	LWP-7125	1	MOUNT PLATE
	LWP-7126	1	SWITCH ACTUATOR
	LWP-7127	1	GROUND PLUNGER
	LWP-7560	1	1/4" X 1/2" X 2.50 LG. A2 TOOL STEEL
	FAS-B2	2	#4-40 X 1" LG. RHMS
	FAS-E10	1	#10-24 X 1/4" LG. SHCS
	FAS-E23	4	#10-24 HEX NUT
	FAS-F5	1	1/4-20 X 3/4" LG. FHSCS
	FAS-F22	2	Ø1/4 X 3/4" LG. SHSB
	FAS-F23	3	1/4-20 X 1/2" LG. SHCS
	FAS-F24	12	1/4-20 X 3/4" LG. SHCS
	FAS-F26	1	1/4-20 X 1-1/4" LG. SHCS
	FAS-F27	1	1/4-20 X 1-1/2" LG. SHCS
	FAS-F38	3	Ø1/4" FLAT WASHER
	FAS-G13	2	5/16-18 X 3/4" LG. FHCS
	FAS-DPIN #5	1	Ø1/4" X 3/4" LG. DOWEL PIN

20-LWA-06 BOM

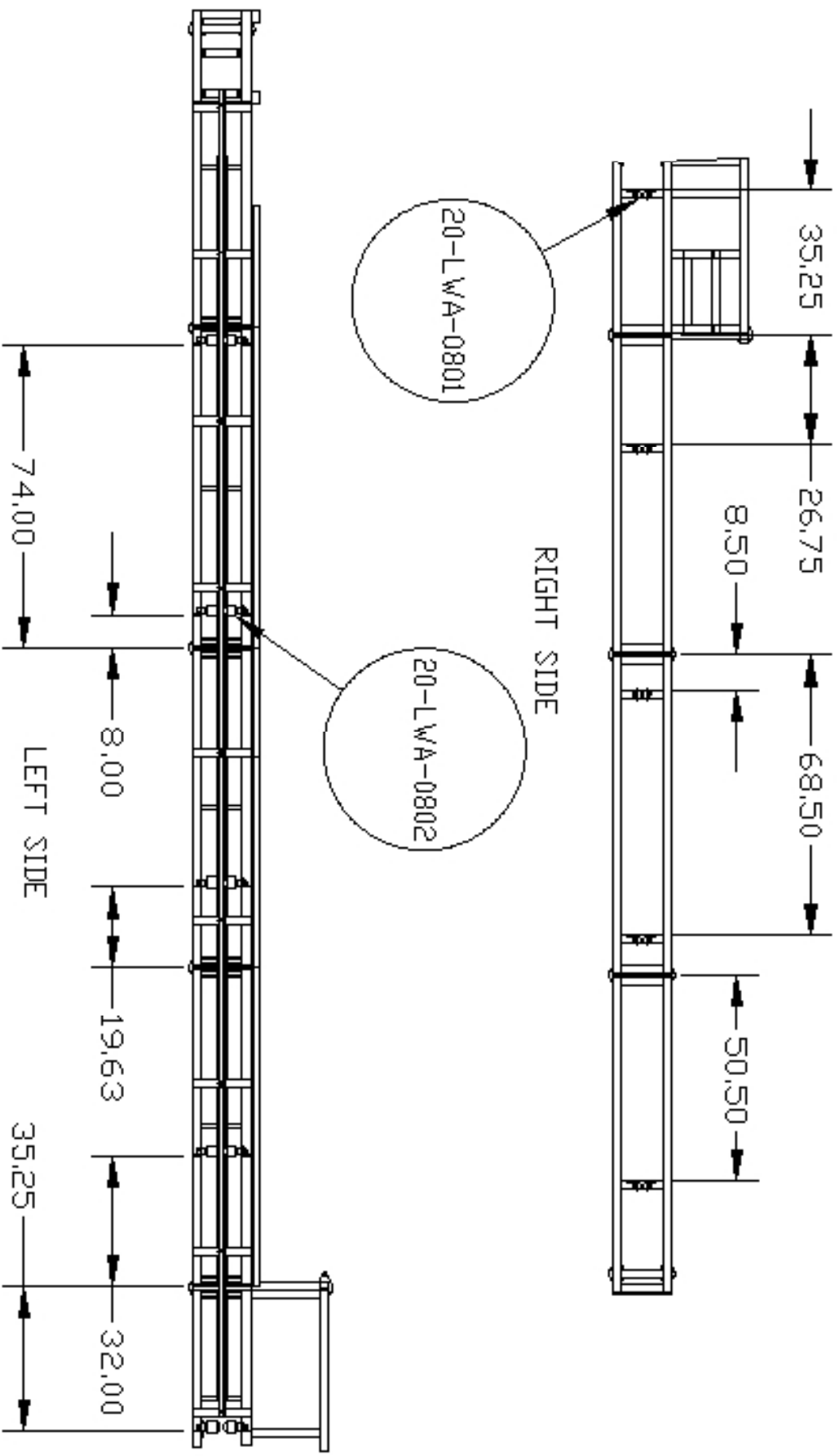


LINEWELDER FRAME ASSEMBLY


North Alabama Pipe Corporation

LINEWELDER FRAME ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-LWA-0701	7	FRAME SUPPORT LEG WELDMENT
2	20-LWA-0702	1	END FRAME APC WELDMENT
3	20-LWA-0703	1	BASIC FRAME #3 WELDMENT
4	20-LWA-0704	1	BASIC FRAME #2 WELDMENT
5	20-LWA-0705	1	BASIC FRAME #1 WELDMENT
6	20-LWA-0706	1	MIDSECTION WELDMENT
7	20-LWA-0707	1LH/1RH	MID FRAME SUPPORT LEG
8	20-LWA-0708	1	BASIC FRAME RH 1 WELDMENT
9	20-LWA-0709	1	BASIC FRAME RH 2 WELDMENT
10	20-LWA-0710	1	BASIC END FRAME WELDMENT
11	20-LWA-0711	1	MIDSECTION TOP SHELF
	BLK-644	10	8mm X 2" LG. KEYSTOCK
	BRG-974	4	HEPCO TRACK
	FAS-F25	12	1/4-20 X 1" LG. SHCS
	FAS-H4	38	3/8-16 X 5" LG. HHCS
	FAS-H19	40	3/8-16 HEX NUT
	FAS-H22	76	Ø3/8" FLAT WASHER
	FAS-H27	2	3/8-16 X 3" LG. SHCS
	FAS-I2	16	1/2-13 X 1-3/4" LG. HHCS
	FAS-I14	14	1/2-13 HEX NUT
	FAS-I20	14	Ø1/2" X 1" LG. DOWEL PIN
	FAS-I22	28	Ø1/2" FLAT WASHER

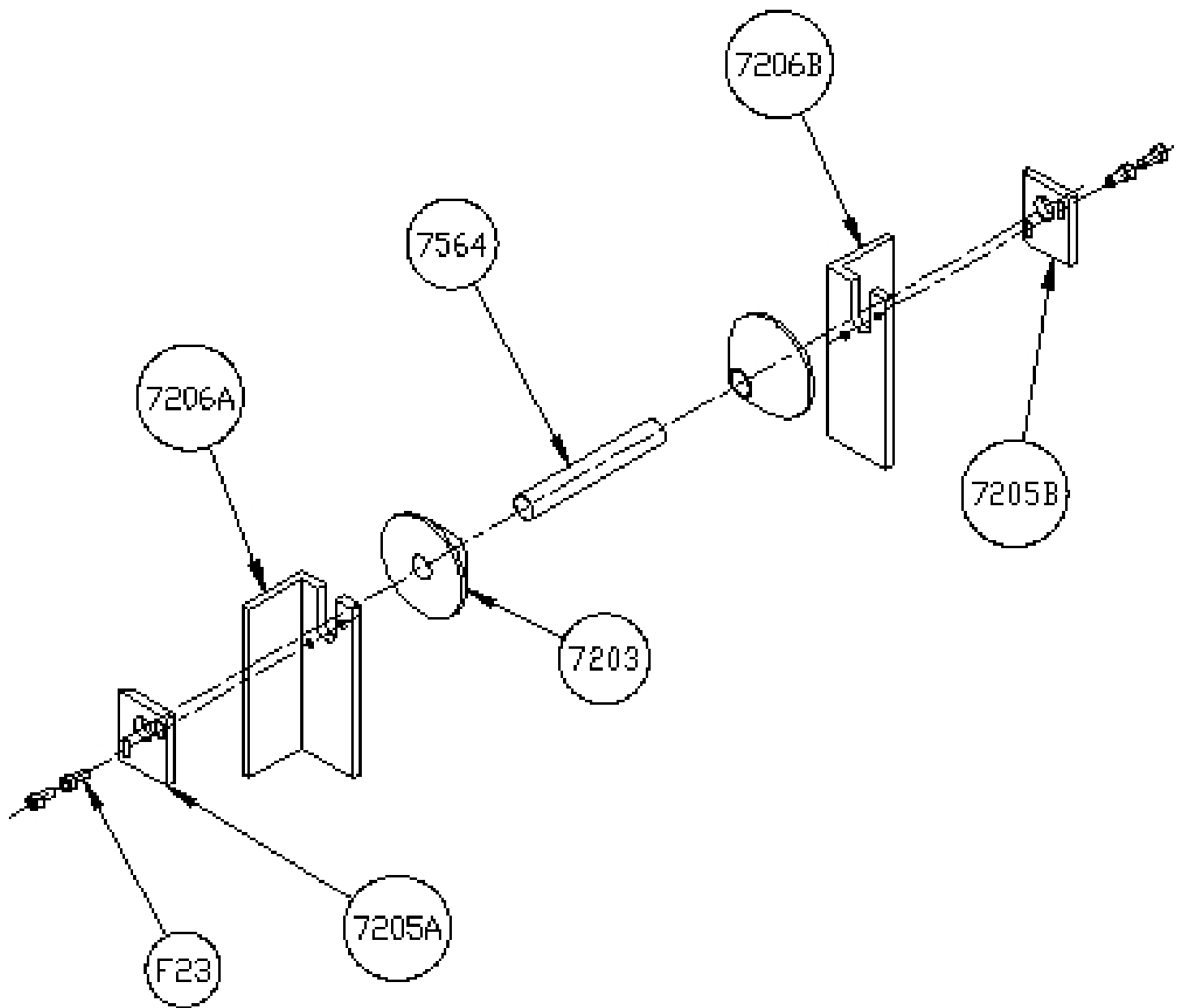


ROLLER LOCATION ASSEMBLY

 North Alakama Pipe Corporation

ROLLER LOCATION ASSEMBLY PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
20-LWA-0801	5	ROLLER ASSEMBLY
20-LWA-0802	5	DUAL ROLLER ASSEMBLY

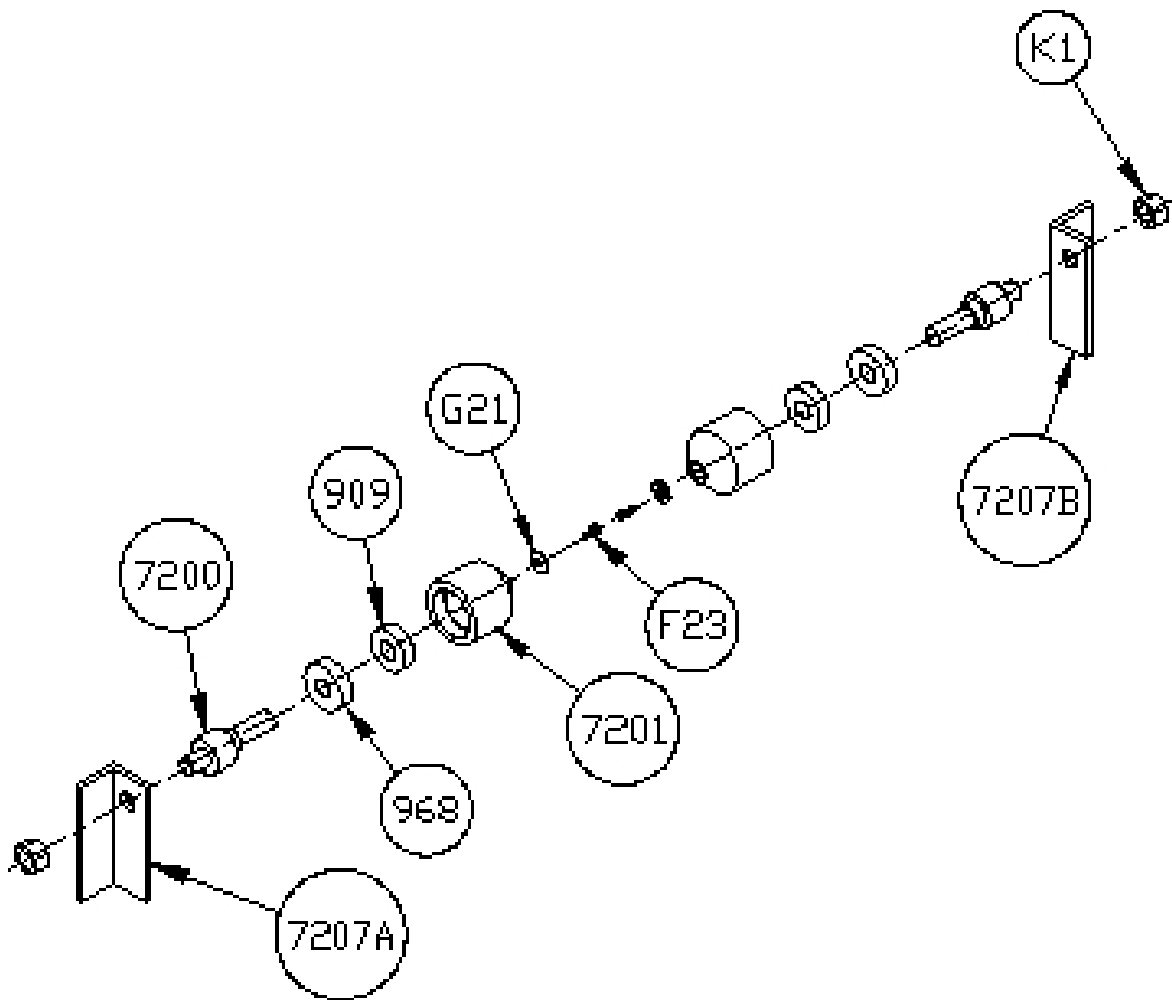


NOTE:
5 SETS REQ'D PER
LINE WELDER

ROLLER ASSEMBLY


ROLLER ASSEMBLY PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
LWP-7203	2	ROLLER
LWP-7205A	1	LEFT LOCK PLATE
LWP-7205B	1	RIGHT LOCK PLATE
LWP-7206A	1	LEFT MOUNT ANGLE
LWP-7206B	1	RIGHT MOUNT ANGLE
LWP-7564	1	Ø.625 X 4.50 LG CRS
FAS-F23	4	1/4-20 X 1/2" LG. SHCS



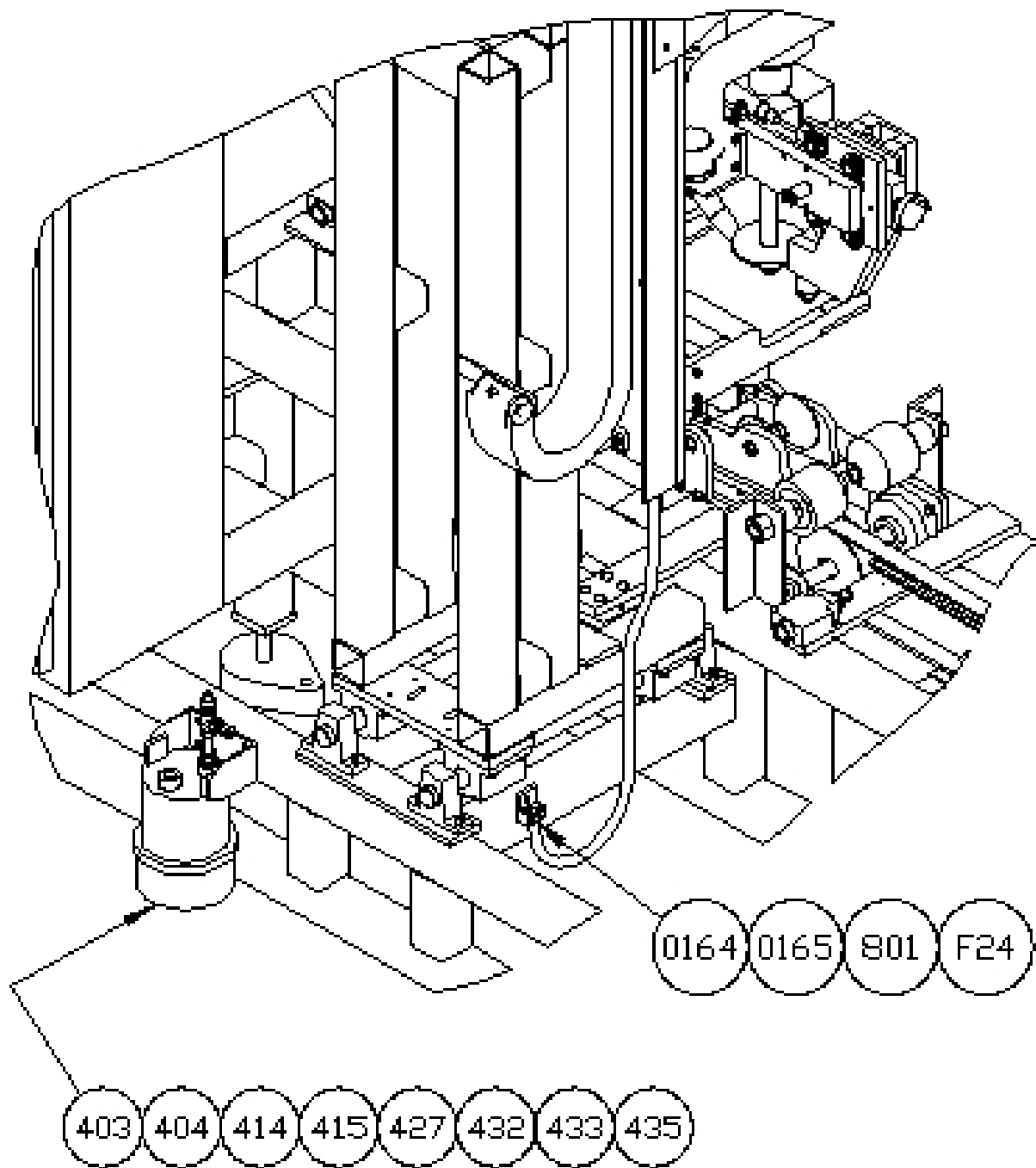
NOTE:
5 SETS REQ'D PER
LINE WELDER

DUAL ROLLER ASSEMBLY


 North Alabama Pipe Corporation
20-LWA-0802

DUAL ROLLER PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
BRG-909	2	#6204 2RS BEARING
BRG-968	2	#6304 2RS BEARING
LWP-7200	2	SHAFT
LWP-7201	2	ROLLER
LWP-7207A	1	LEFT MOUNT ANGLE
LWP-7207B	1	RIGHT MOUNT ANGLE
FAS-F23	2	1/4-20 X 1/2" LG. SHCS
FAS-G21	1	ø5/16 FLAT WASHER
FAS-K1	2	3/4-10 HEX NUT



BACK PLATE GROUNDING CABLE AND AIR FILTER ASSEMBLY

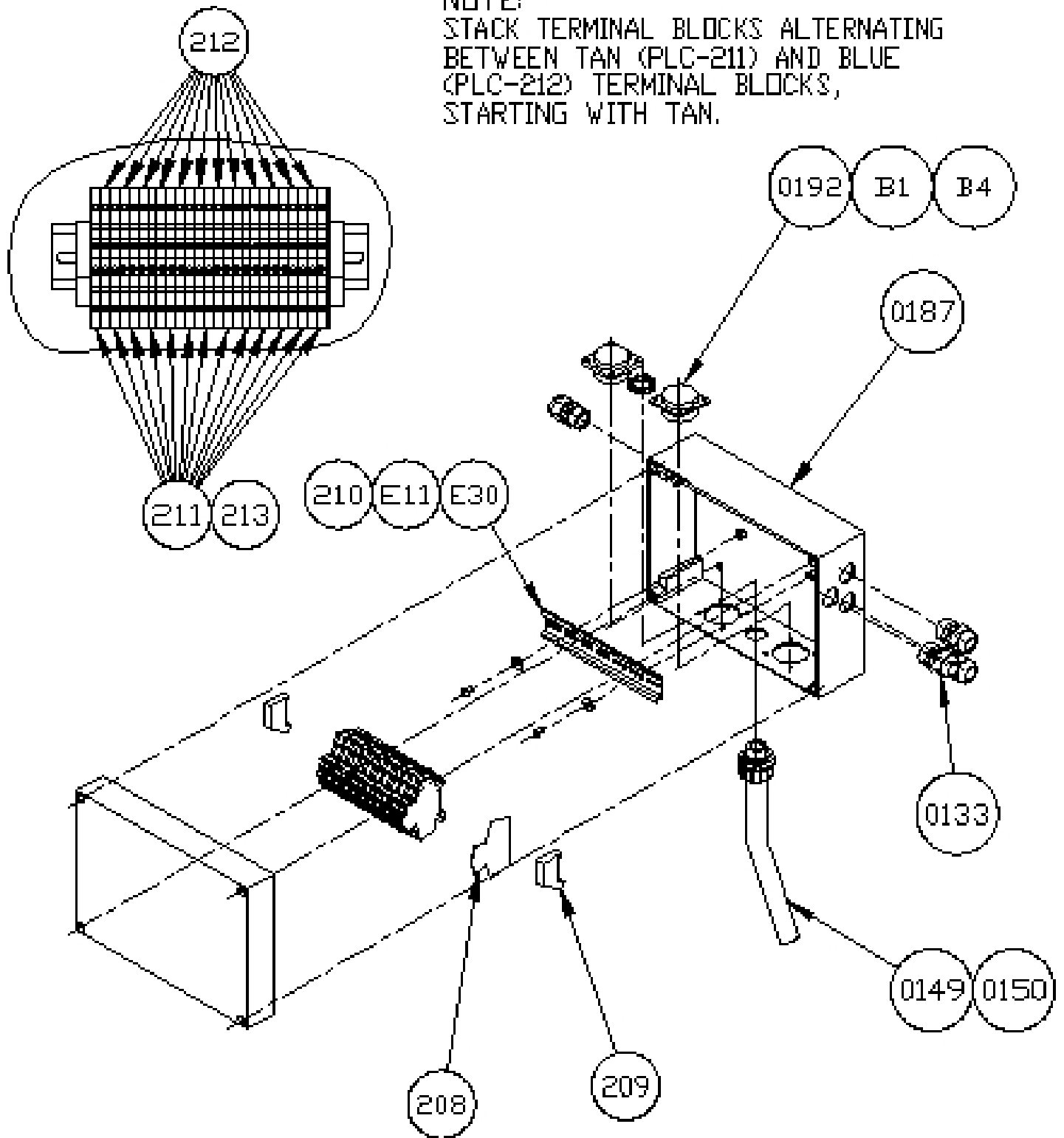
 North Alabama Pipe Corporation

20-LWA-09


BACK PLATE GROUNDING CABLE AND AIR FILTER

PART NUMBER	QUANTITY	DESCRIPTION
AIR-403	50 FT.	Ø1/4" AIR LINE
AIR-404	35FT.	Ø1/8" AIR LINE
AIR-414	1	1/8 P X 1/4" T ADAPTER
AIR-415	1	1/8 P X 1/8 T ADAPTER
AIR-427	1	M-26 AIR FILTER
AIR-432	1	1/8" NIPPLE
AIR-433	1	1/4 X 1/8 NPT REDUCER
AIR-435	1	1/8 NPT TEE
EPP-0164	1	CABLE LUG
EPP-0165	1	DOUBLE CABLE LUG
WIR-801	3 FT.	#2 WELD CABLE BLACK
FAS-F24	1	1/4-20 X 3/4" LG. SHCS

NOTE:
STACK TERMINAL BLOCKS ALTERNATING
BETWEEN TAN (PLC-211) AND BLUE
(PLC-212) TERMINAL BLOCKS,
STARTING WITH TAN.



LINE WELDER JUNCTION BOX ASSEMBLY

 North Alabama Pipe Corporation

20-LWA-10

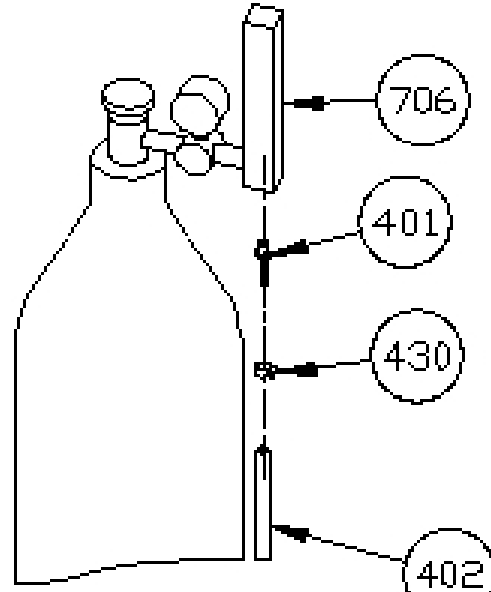
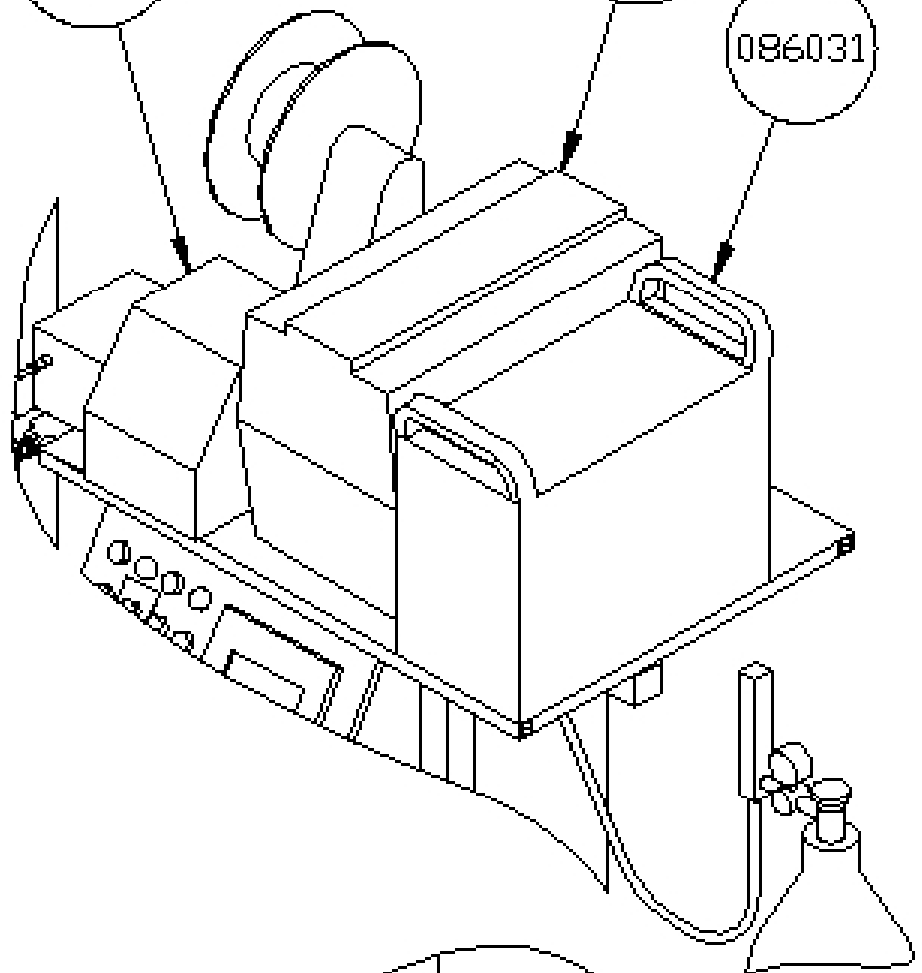
LINE WELDER JUNCTION BOX ASSEMBLY PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
PLC-208	1	SIDE PLATE
PLC-209	2	ENDS
PLC-210	6-3/4"	DIN RAIL
PLC-211	13	TAN TERMINAL BLOCK
PLC-212	12	BLUE TERMINAL BLOCK
PLC-213	1	TERMINAL BLOCK LABEL NUMBERS
EPP-0133	4	LARGE STRAIN RELIEF
EPP-0149	4 Ft.	1/2" PVC CONDUIT
EPP-0150	1	1/2" PVC STRAIGHT FITTING
EPP-0187	1	BOX
EPP-0192	REF.	BOX LINK CABLE SET
FAS-E11	2	#10-24 X 3/8" LG. RHMS
FAS-E30	2	#10 FLAT WASHER

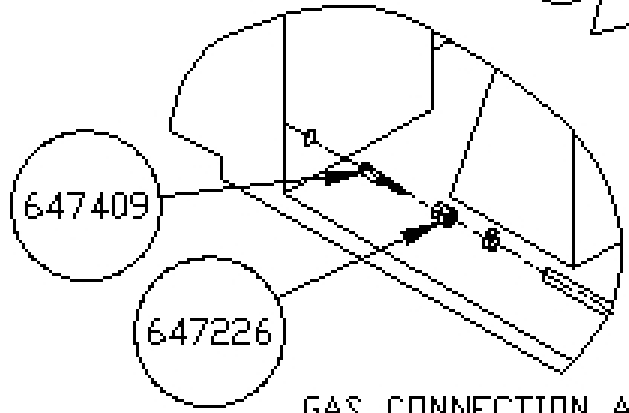
195-059 141-580 151-026 515-039

903-471

086031




GAS BOTTLE PROVIDED BY CUSTOMER



GAS CONNECTION AT REAR OF WIRE FEEDER

WIRE FEEDER, WELDER POWER & PLASMA UNIT ASSEMBLY

 North Alabama Pipe Corporation

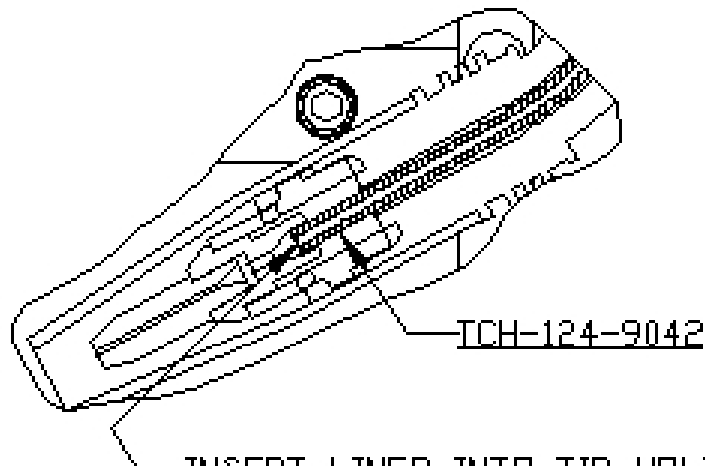
20-LWA-11

WIRE FEEDER, WELDER POWER & PLASMA UNIT PARTS LIST

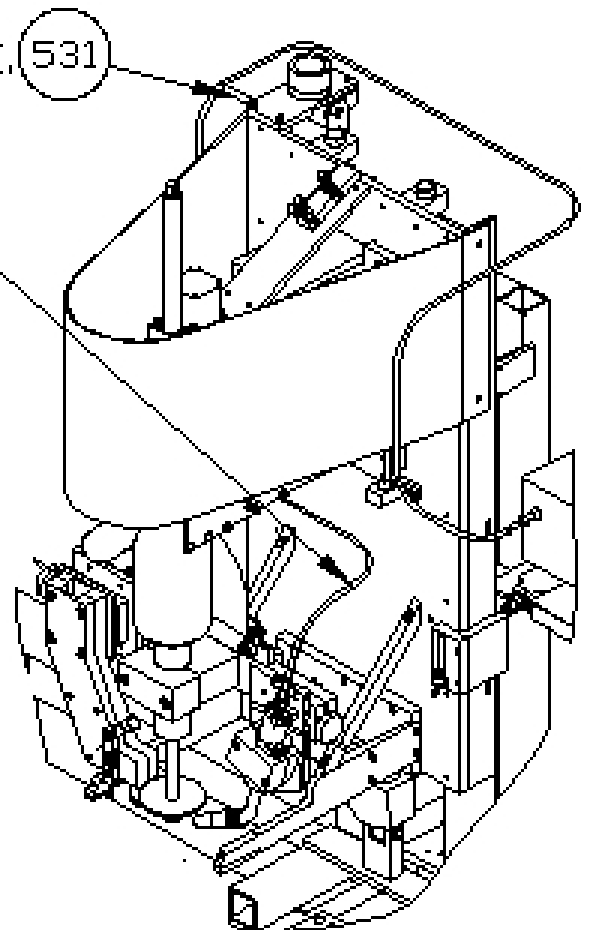
PART NUMBER	QUANTITY	DESCRIPTION
AIR-401	1	1/4" BARB X 1/4" NPT HOSE BARB
AIR-402	7 Ft	1/4" RED HOSE
AIR-430	2	9/16" HOSE CLAMP
TCH-086031	1	FMX 600 HAND 208/240
TCH-706	1	REGULATOR
WPP-141-580	1	WIRE STRAIGHTENER
WPP-151-026	1	DRIVE KIT WITH ROLLERS
WPP-195-059	1	S-74DX WIRE FEED
WPP-515-039	1	WIRE GUIDE
WPP-903-471	1	XMT-304 POWER UNIT
WPP-647226	1	AW-14A INERT GAS NUT
WPP-647409	1	AW-17 INERT GAS NIPPLE

ATTACH SPRING AS SHOWN TO HOLD LINER CONDUIT IN PLACE. (531)

ROUTE LINER CONDUIT AROUND AND BEHIND WELD ARM ASSEMBLY AS SHOWN. LINER CONDUIT SHOULD NOT KINK OR BIND AS WELD HEAD ROTATES.



INSERT LINER INTO TIP HOLDER, DO NOT ALLOW IT TO BOTTOM OUT IN HOLDER. LINER SHOULD BE LOOSE AND NOT BIND AS WELD ARM IS ROTATED.



WIRE FEEDER UNIT

LOCATE, DRILL & TAP FOR #10-24 SHSS AT ASSEMBLY TO HOLD LINER INSERT IN POSITION. DO NOT OVERTIGHTEN.

TCH-156-0040


TCH-501-9155

(E27)

TCH-501-9705

LINER INSERT APPROX. 4.02 LG. SEAL WITH HEAT SHRINK TUBING.

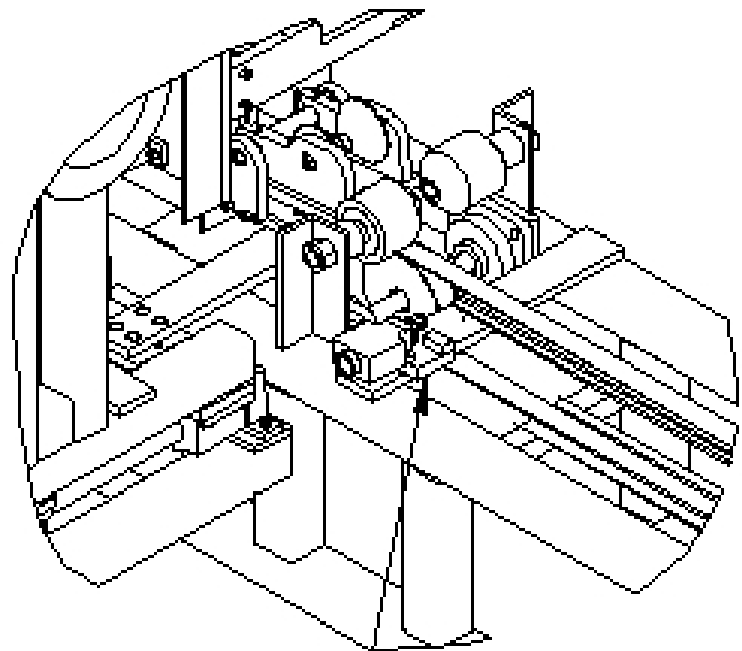
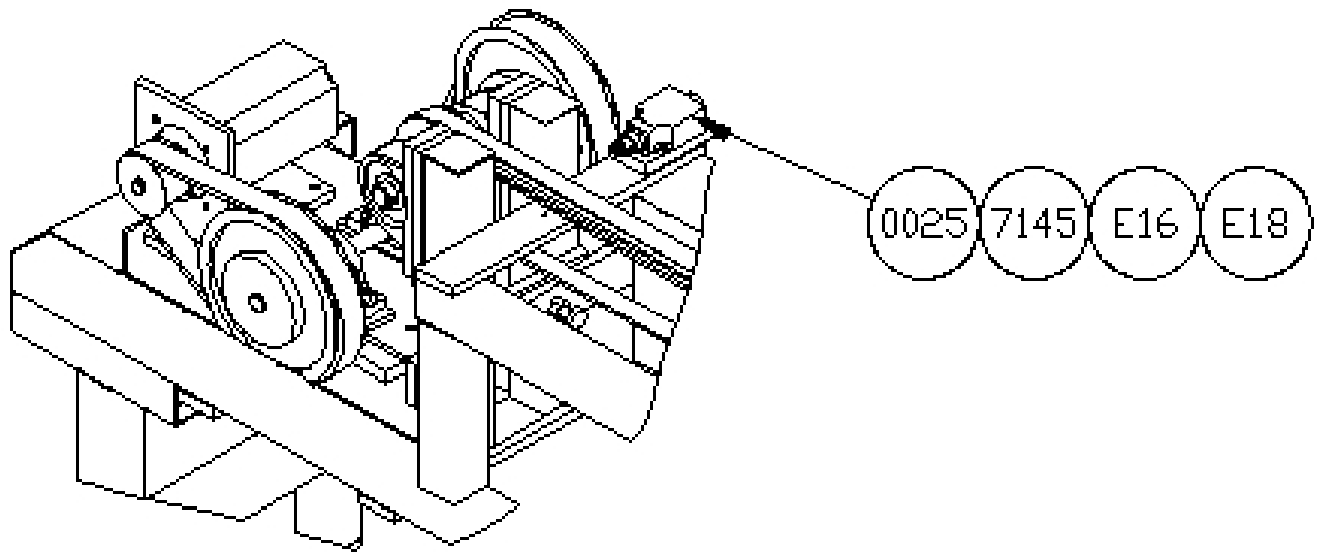
LINEWELDER WELD WIRE CONDUIT AND LINER

 North Alabama Pipe Corporation

20-LWA-12

LINEWELDER WELD CONDUIT AND LINER PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
MSC-531	1	EXTENSION SPRING
TCH-124-9042	1	LINER
TCH-156-0040	1	10' CONDUIT
TCH-501-9705	1	ADAPTER PLUG
TCH-501-9155	1	BLOCK ADAPTER
FAS-E27	1	#10-24 X 1/4" LG. SHSS



LINE WELDER HOME SWITCH ASSEMBLY
North Alabama Pipe Corporation

20-LWA-13

LINE WELDER HOME SWITCH ASSEMBLY PARTS LIST

PART NUMBER	QUANTITY	DESCRIPTION
SWT-0024	1	FROG SWITCH
SWT-0025	2	LIMIT SWITCH
LWP-7145	1	END TRAVEL SWITCH MOUNT
LWP-7570	1	HOME SWITCH MOUNT
FAS-B1	4	#4-40 X 1/2" RSLMS
FAS-E16	4	#10-24 X 1/2" LG. SHCS
FAS-E18	4	#10-24 X 3/4" LG. SHCS