



## Pro-XMv2



## Pro-XMv2 Parts ID Manual

Order Number: XM-82999

Revision: A  
DOC-0018

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**Scope of Manual:**

This manual contains diagrams and related parts lists to identify potential service/spare parts for your DEMTECH Services, Inc. Pro-XMv2 Extrusion Welder.

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**Manual Number: 603-PARTS ID MANUAL/PRO-XMv2, Revision: A**

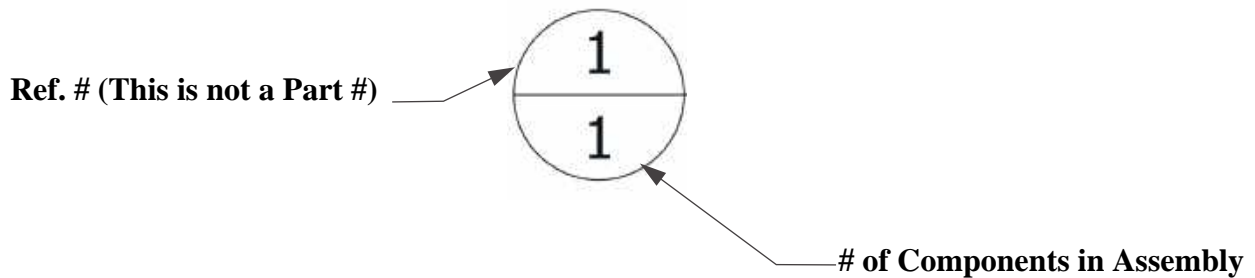
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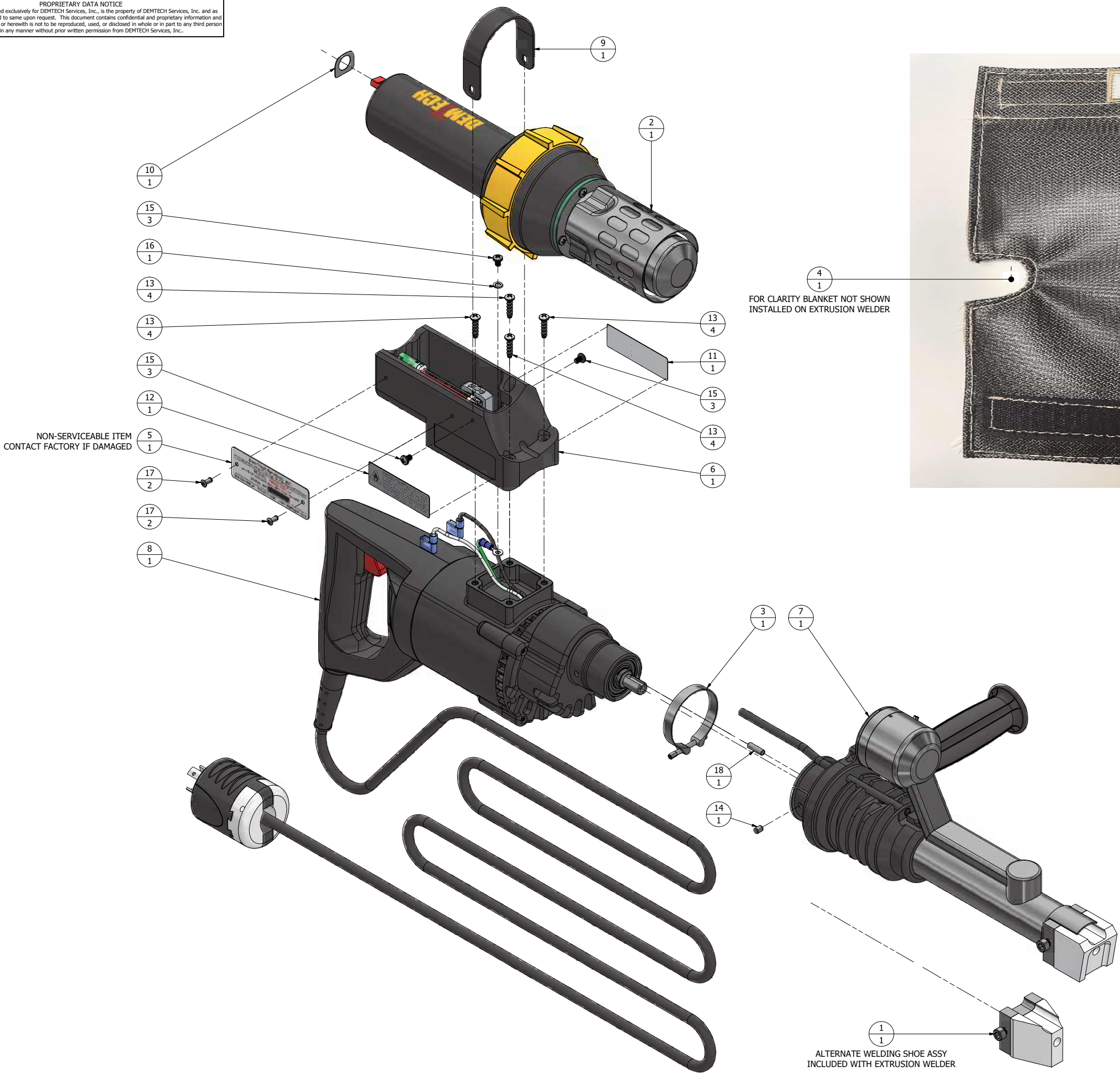
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## 1 Ordering Instructions

Refer to the diagrams and related parts lists on the following pages to identify replacement parts for the Pro-XMv2 Extrusion Welder. To locate a part, find it visually on the exploded assembly diagram and note its Reference Number. Next refer to the assemblies parts list to identify the corresponding Part Number using the Reference Number. When ordering parts, be sure to specify the Part Number not the Reference Number. '**Hardware**' refers to non-stock items, these parts are still available for order, please provide the part description to order NS-Hardware items.



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PARTS LIST			
ITEM	ORDER NO	DESCRIPTION	QTY
1	TS-14118	[TS-605-0500/A] ASSY, SHOE, CORNER, INSIDE, FOR 12mm (1/2") SHEET THICKNESS	1
2	XM-71460	[605-PREHEAT/2200/A] PREHEATER, 220V, 2200W	1
3	XM-71512	[605-040] CLAMP, BARREL	1
4	XM-71513	[605-043] INSULATION BLANKET, PRO-XMv2, XMPv2	1
5	XM-71624	[603-399/XMv2] SERIAL PLATE, PRO-XMv2	1
6	XM-82992	[603-015/A] ASSY, MOTOR WIRING HOUSING, PRO-XMv2	1
7	XM-82996	[603-BARREL/A] ASSY, BARREL/MANIFOLD/SCREW, PRO-XM, PRO-XMv2	1
8	XM-82997	[603-DRILL/A] ASSY, DRILL MOTOR COMPLETE, PRO-XMv2	1
9	XM-83018	[603-015B] BRACKET, PREHEATER, PRO-XMv2	1
10	XM-83095	[603-326] OVERLAY, PREHEAT CONTROL, PRO-XMv2	1
11	XM-83098	[603-015SL] LABEL, PREHEATER SETTING, PRO-XMv2	1
12	XM-83099	[603-015WL] WARNING LABEL, PRO-XMv2	1
13	HARDWARE	SCREW, #10 X 3/4" LONG, PAN HEAD PHILLIPS, HIGH-LOW, ZINC PLATED STEEL	4
14	HARDWARE	PIN, DOWEL, 3/16" OD X 1/4" LONG, 18-8 STAINLESS STEEL	1
15	HARDWARE	SCREW, M4 X 0.7 X 5mm LONG, PAN HEAD PHILLIPS, 18-8 STAINLESS STEEL	3
16	HARDWARE	WASHER, M4 REGULAR SPLIT LOCK, 18-8 STAINLESS STEEL	1
17	HARDWARE	RIVET, 1/8" BLIND, DOME STYLE, STAINLESS STEEL	2
18	HARDWARE	PIN, DOWEL, 3/16" OD X 5/8" LONG, HARDENED, 416 STAINLESS STEEL	1

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TITLE  
[603-0100/A] PRO-XMv2 EXTRUSION WELDER

SIZE  
D

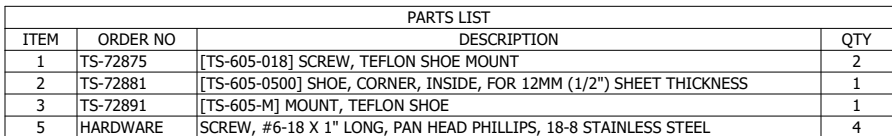
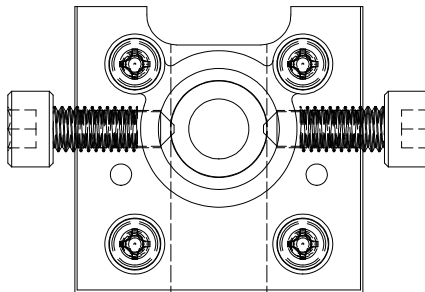
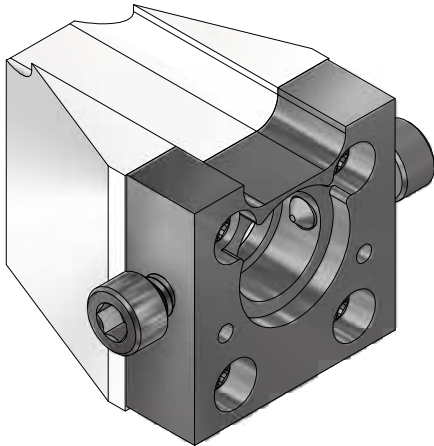
DWG NO  
XM-82999

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SCALE  
3:4

SHEET 4 OF 4



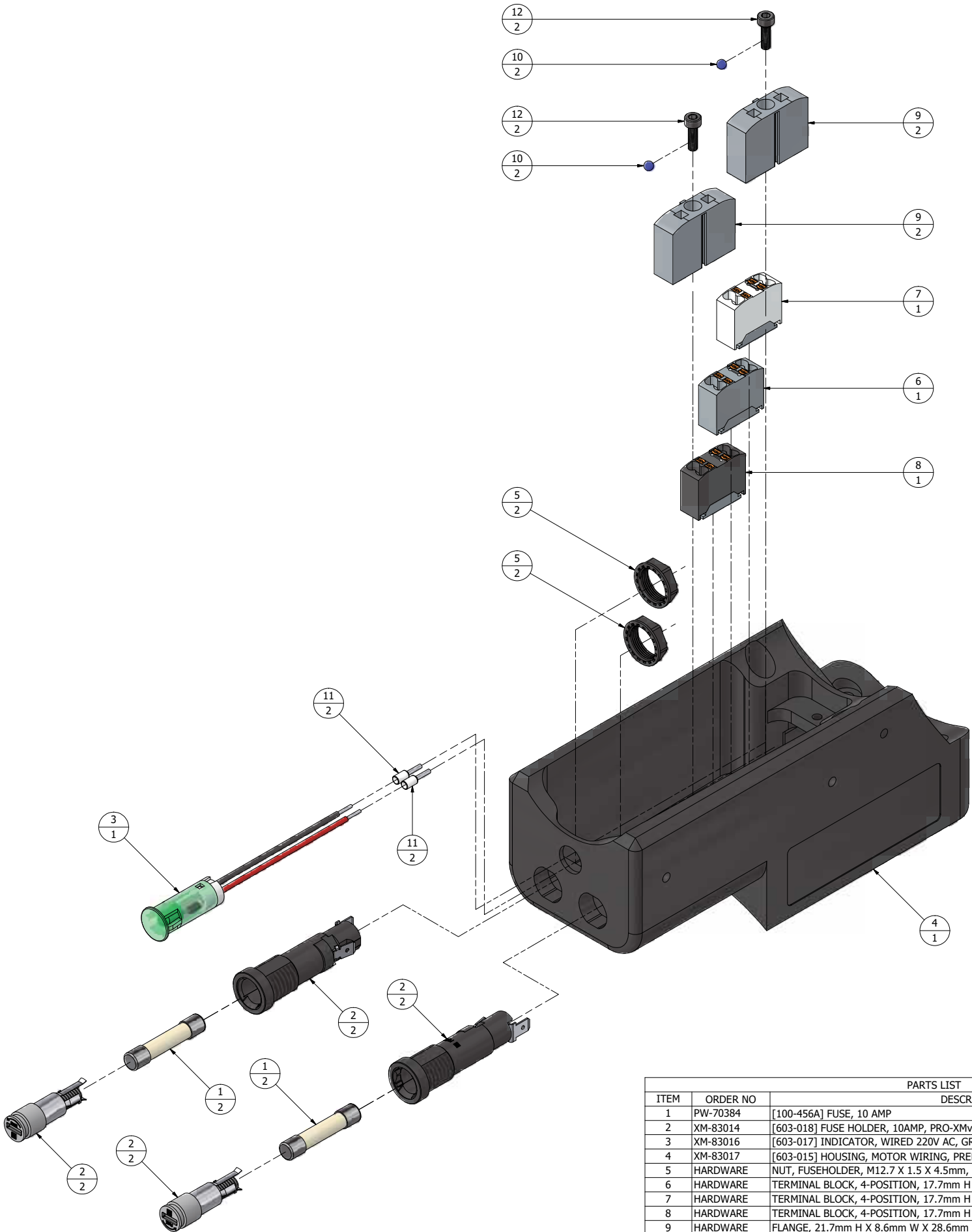


2. DURING INSTALLATION TORQUE ALL PAN HEAD SELF-TAPPING SCREWS TO 10±1 IN-LB.

1. ○ SYMBOL DESIGNATES ITEM/QUANTITY BALLOON. UPPER DIGIT IS ITEM NUMBER, LOWER DIGIT IS QUANTITY REQUIRED PER ASSEMBLY.

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TITLE  
[603-015/A] ASSY, MOTOR WIRING  
HOUSING, PRO-XMv2

SIZE  
D

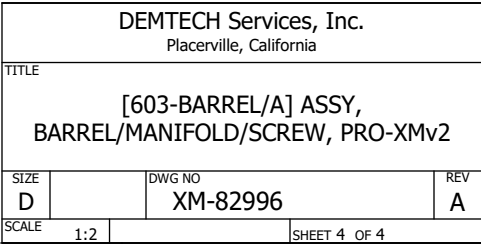
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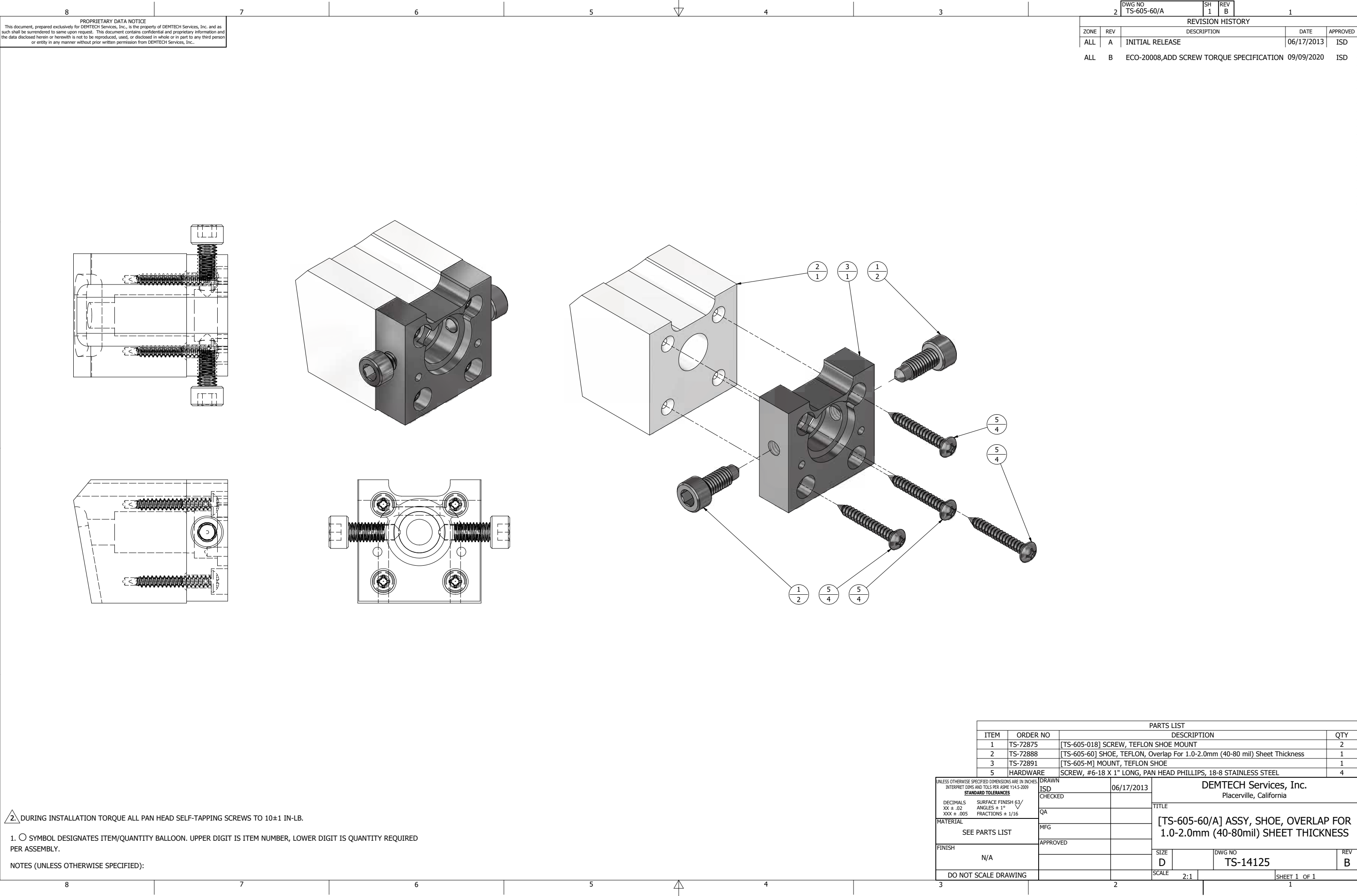
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**A**



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2		DWG NO TS-605-60/A	SH 1	REV B	1	
REVISION HISTORY						
ZONE	REV	DESCRIPTION			DATE	APPROVED
ALL	A	INITIAL RELEASE			06/17/2013	ISD
ALL	B	ECO-20008,ADD SCREW TORQUE SPECIFICATION			09/09/2020	ISD

PARTS LIST			
ITEM	ORDER NO	DESCRIPTION	QTY
1	TS-72875	[TS-605-018] SCREW, TEFLON SHOE MOUNT	2
2	TS-72888	[TS-605-60] SHOE, TEFLON, Overlap For 1.0-2.0mm (40-80 mil) Sheet Thickness	1
3	TS-72891	[TS-605-M] MOUNT, TEFLON SHOE	1
5	HARDWARE	SCREW, #6-18 X 1" LONG, PAN HEAD PHILLIPS, 18-8 STAINLESS STEEL	4

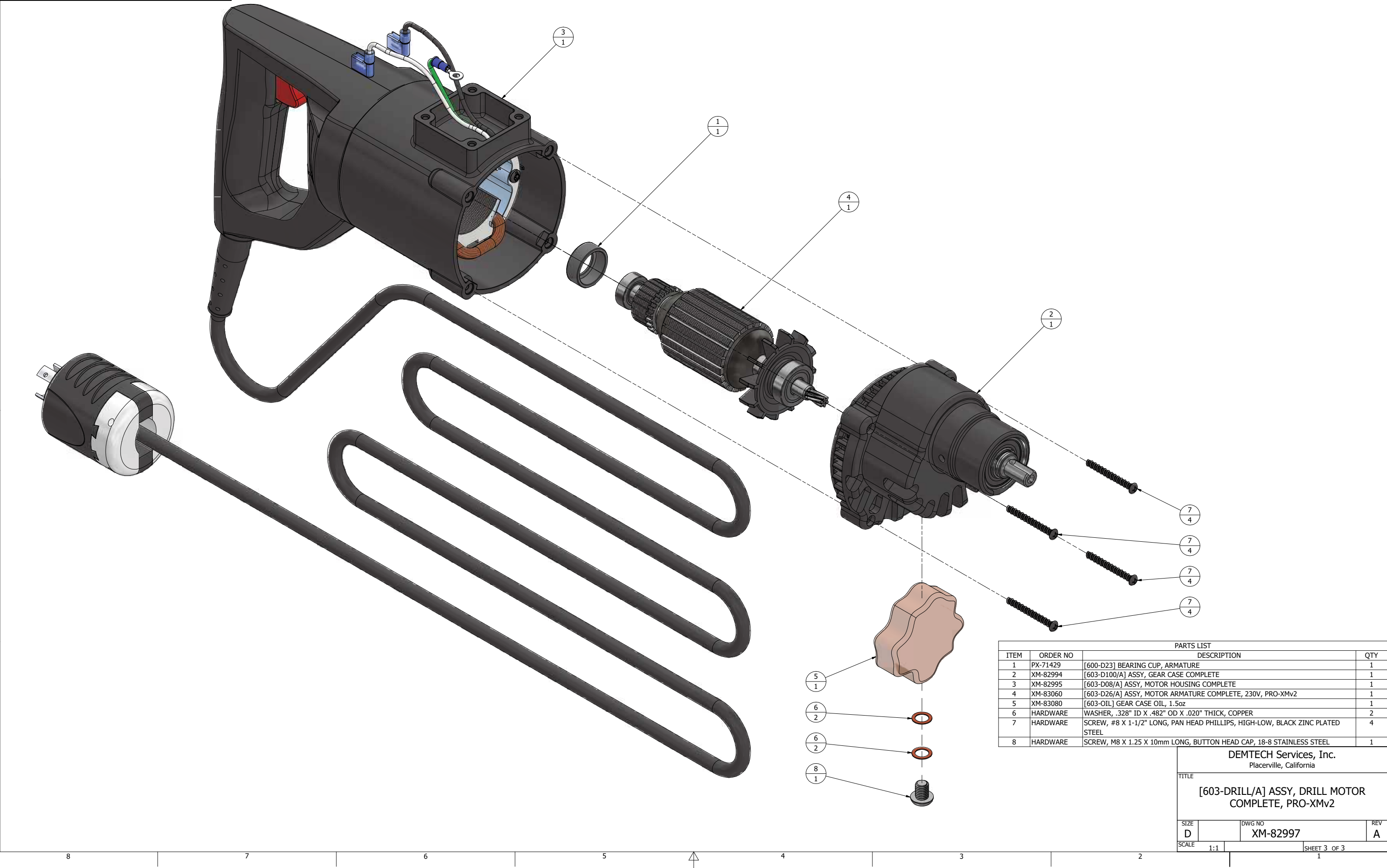
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES INTERPRET DIMS AND TOLS PER ASME Y14.5-2009		DRAWN ISD	06/17/2013	DEMTECH Services, Inc. Placerville, California	
STANDARD TOLERANCES		CHECKED		TITLE	
DECIMALS .XX ± .02		QA		[TS-605-60/A] ASSY, SHOE, OVERLAP FOR 1.0-2.0mm (40-80mil) SHEET THICKNESS	
ANGLES ± 1°		MFG			
FRACTIONS ± 1/16		APPROVED		SIZE D	DWG NO TS-14125
MATERIAL SEE PARTS LIST				REV B	
FINISH N/A				SCALE 2:1	SHEET 1 OF 1
DO NOT SCALE DRAWING					

2. DURING INSTALLATION TORQUE ALL PAN HEAD SELF-TAPPING SCREWS TO 10±1 IN-LB.

1. ○ SYMBOL DESIGNATES ITEM/QUANTITY BALLOON. UPPER DIGIT IS ITEM NUMBER, LOWER DIGIT IS QUANTITY REQUIRED PER ASSEMBLY.

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PARTS LIST			
ITEM	ORDER NO	DESCRIPTION	QTY
1	PX-71429	[600-D23] BEARING CUP, ARMATURE	1
2	XM-82994	[603-D100/A] ASSY, GEAR CASE COMPLETE	1
3	XM-82995	[603-D08/A] ASSY, MOTOR HOUSING COMPLETE	1
4	XM-83060	[603-D26/A] ASSY, MOTOR ARMATURE COMPLETE, 230V, PRO-XMv2	1
5	XM-83080	[603-OIL] GEAR CASE OIL, 1.5oz	1
6	HARDWARE	WASHER, .328" ID X .482" OD X .020" THICK, COPPER	2
7	HARDWARE	SCREW, #8 X 1-1/2" LONG, PAN HEAD PHILLIPS, HIGH-LOW, BLACK ZINC PLATED STEEL	4
8	HARDWARE	SCREW, M8 X 1.25 X 10mm LONG, BUTTON HEAD CAP, 18-8 STAINLESS STEEL	1

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TITLE  
[603-DRILL/A] ASSY, DRILL MOTOR COMPLETE, PRO-XMv2

SIZE  
D

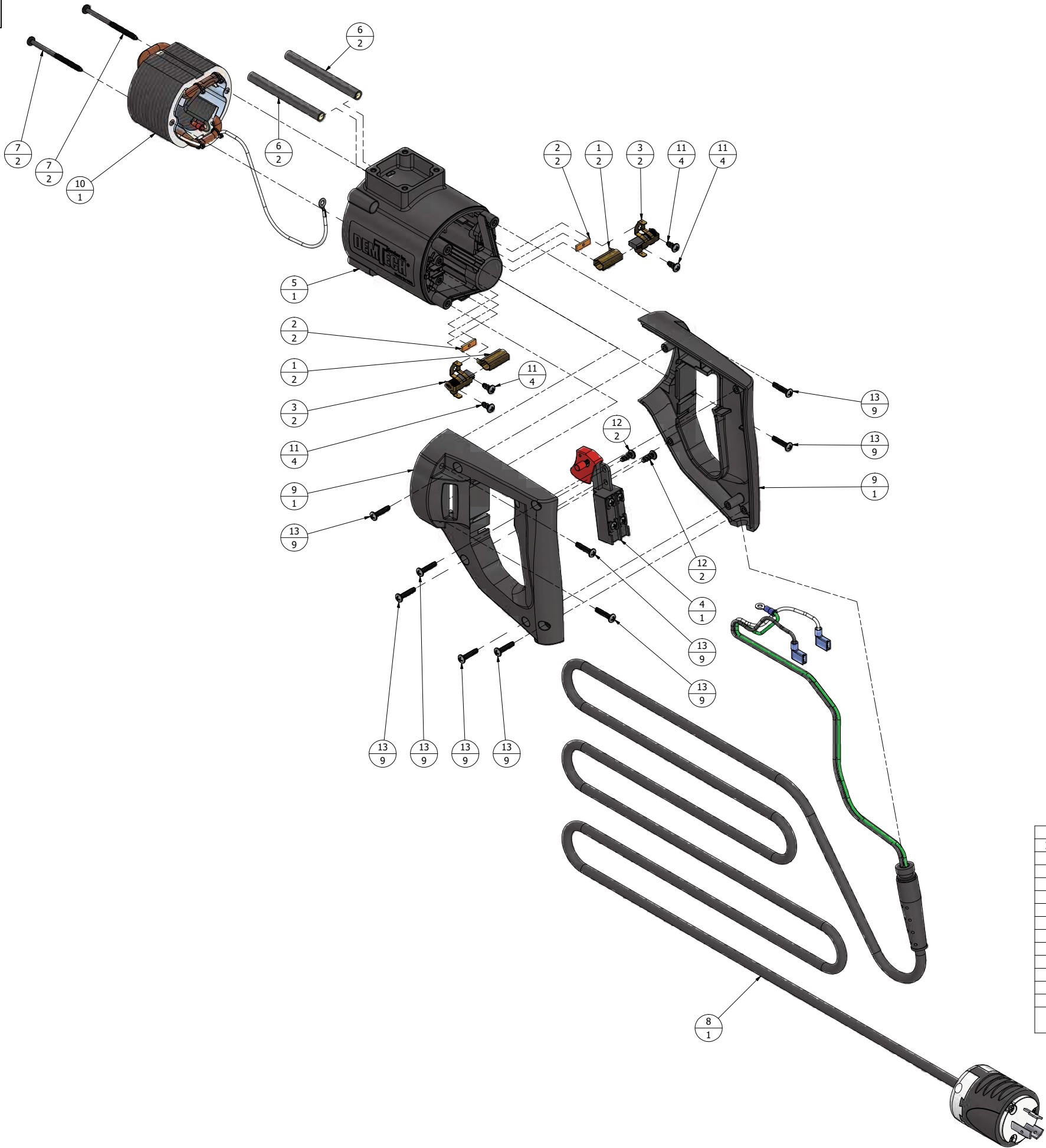
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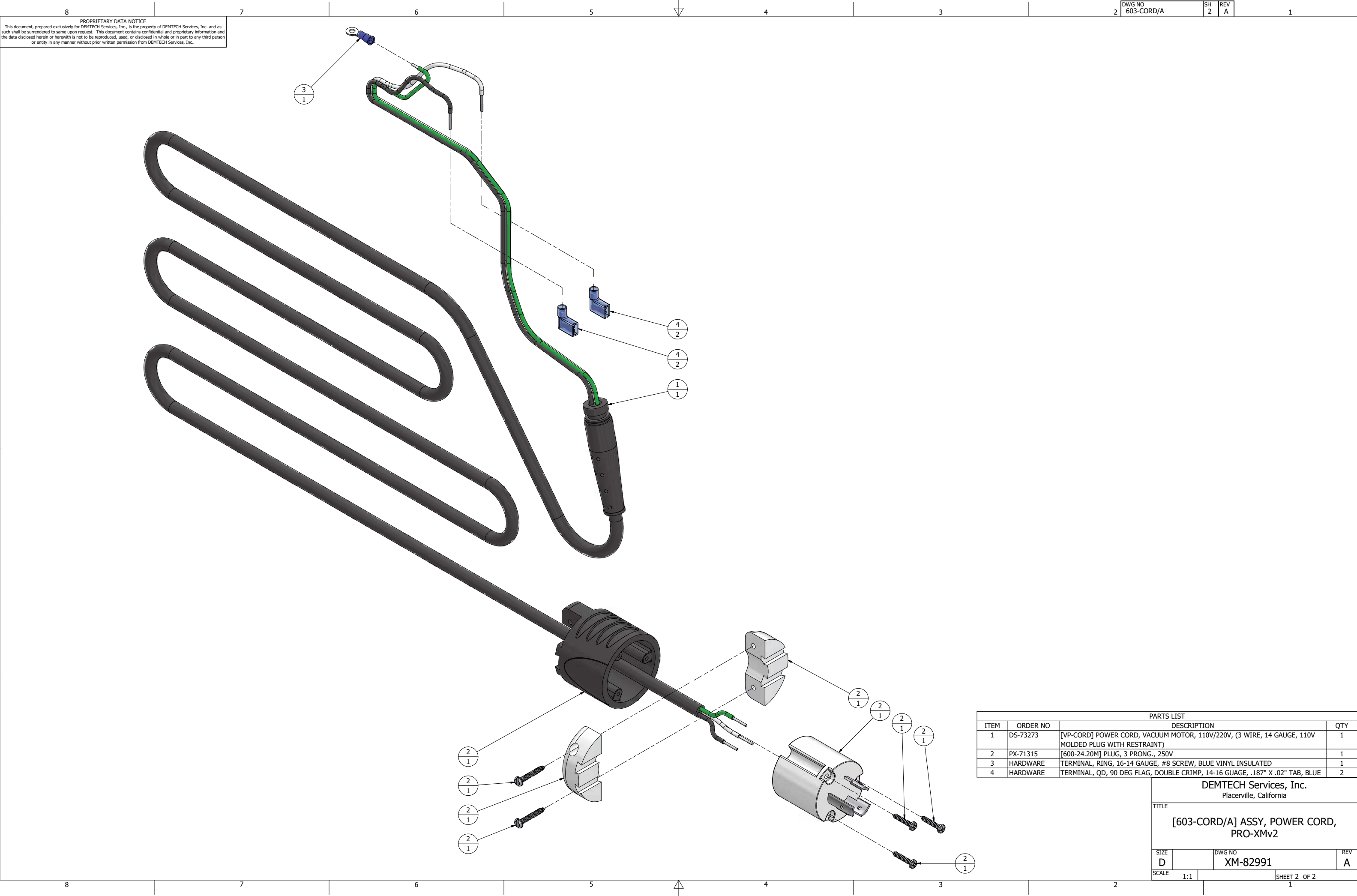
PARTS LIST			
ITEM	ORDER NO	DESCRIPTION	QTY
1	PX-71405	[600-D03] BRUSH HOLDER	2
2	PX-71406	[600-D04] BRUSH INSULATOR	2
3	PX-71407	[600-D05] BRUSH, SOLD INDIVIDUALLY	2
4	PX-71409	[600-D07] TRIGGER SWITCH	1
5	PX-71411	[600-D08] HOUSING, MOTOR	1
6	PX-71428	[600-D22/S] SLEEVING, FIELD WINDING WIRES	2
7	PX-71431	[600-D24.1EX] SCREW, FIELD COIL, GEAR CASE TO HOUSING	2
8	XM-82991	[603-CORD/A] ASSY, POWER CORD, PRO-XMv2	1
9	XM-83037	[603-D06] D-HANDLE, DRILL MOTOR	1
10	XM-83055	[603-D22] FIELD COIL, 230V, PRO-XMv2	1
11	HARDWARE	SCREW, #10 X 3/8" LONG, PAN HEAD PHILLIPS, HIGH-LOW, ZINC PLATED STEEL	4
12	HARDWARE	SCREW, #10 X 1/2" LONG, PAN HEAD PHILLIPS, HIGH-LOW, ZINC PLATED STEEL	2
13	HARDWARE	SCREW, 8-16 X 3/4" LONG, THREAD-FORMING, PAN HEAD PHILLIPS, 18-8 STAINLESS STEEL	9

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TITLE  
[603-D08/A] ASSY, MOTOR HOUSING  
COMPLETE

SIZE D	DWG NO XM-82995	REV A
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SCALE 1:2	SHEET 3 OF 3
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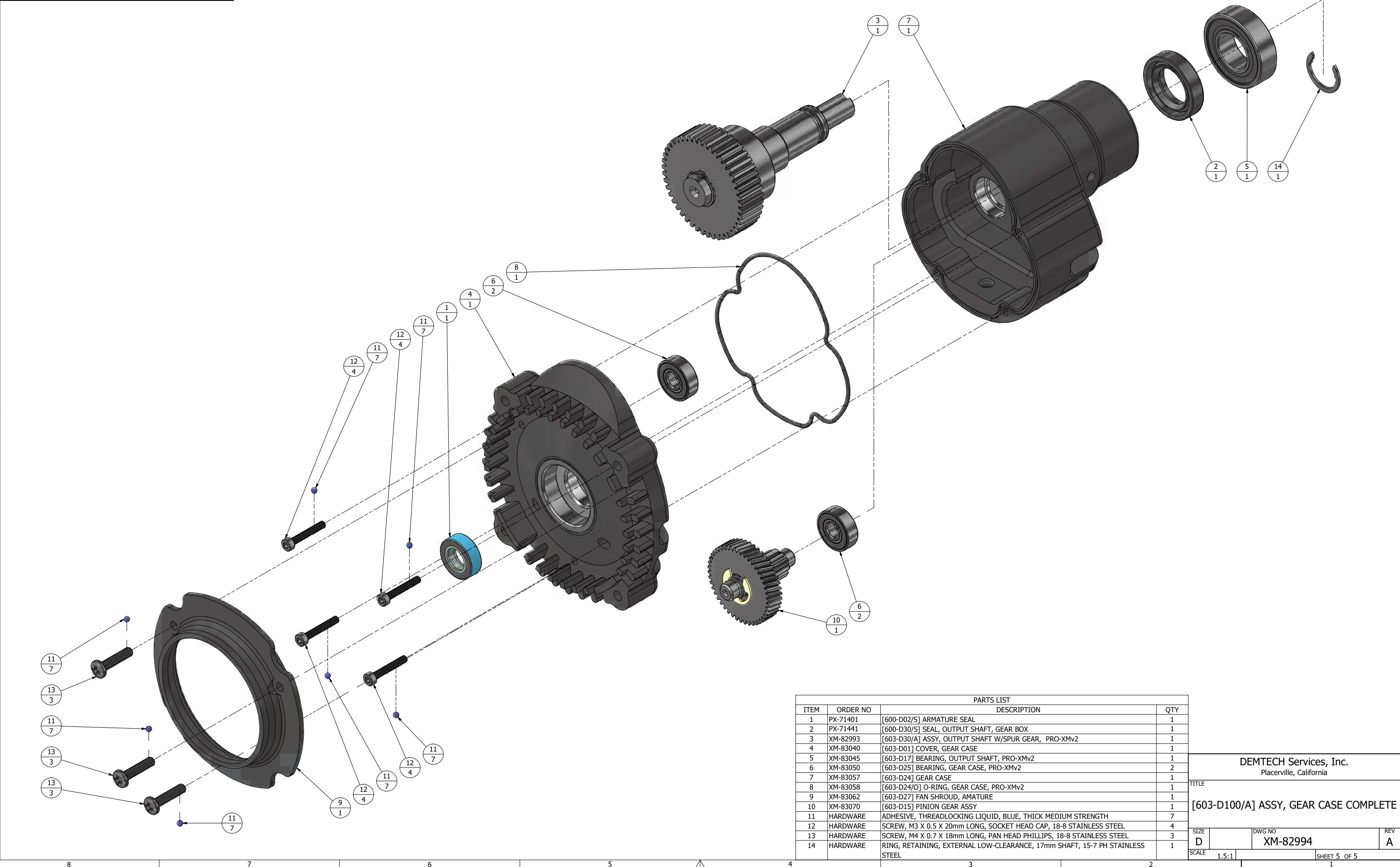
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PARTS LIST			
ITEM	ORDER NO	DESCRIPTION	QTY
1	DS-73273	[VP-CORD] POWER CORD, VACUUM MOTOR, 110V/220V, (3 WIRE, 14 GAUGE, 110V MOLDED PLUG WITH RESTRAINT)	1
2	PX-71315	[600-24.20M] PLUG, 3 PRONG., 250V	1
3	HARDWARE	TERMINAL, RING, 16-14 GAUGE, #8 SCREW, BLUE VINYL INSULATED	1
4	HARDWARE	TERMINAL, QD, 90 DEG FLAG, DOUBLE CRIMP, 14-16 GUAGE, .187" X .02" TAB, BLUE	2

DEMTECH Services, Inc. Placerville, California			
TITLE [603-CORD/A] ASSY, POWER CORD, PRO-XMv2			
SIZE D	DWG NO XM-82991		REV A
SCALE 1:1	SHEET 2 OF 2		



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PARTS LIST			
ITEM	ORDER NO	DESCRIPTION	QTY
1	PX-71401	[600-D02/S] ARMATURE SEAL	1
2	PX-71441	[600-D30/S] SEAL, OUTPUT SHAFT, GEAR BOX	1
3	XM-82993	[603-D30/A] ASSY, OUTPUT SHAFT W/SPUR GEAR, PRO-XMv2	1
4	XM-83040	[603-D01] COVER, GEAR CASE	1
5	XM-83045	[603-D17] BEARING, OUTPUT SHAFT, PRO-XMv2	1
6	XM-83050	[603-D25] BEARING, GEAR CASE, PRO-XMv2	2
7	XM-83057	[603-D24] GEAR CASE	1
8	XM-83058	[603-D24/O] O-RING, GEAR CASE, PRO-XMv2	1
9	XM-83062	[603-D27] FAN SHROUD, AMATURE	1
10	XM-83070	[603-D15] PINION GEAR ASSY	1
11	HARDWARE	ADHESIVE, THREADLOCKING LIQUID, BLUE, THICK MEDIUM STRENGTH	7
12	HARDWARE	SCREW, M3 X 0.5 X 20mm LONG, SOCKET HEAD CAP, 18-8 STAINLESS STEEL	4
13	HARDWARE	SCREW, M4 X 0.7 X 18mm LONG, PAN HEAD PHILLIPS, 18-8 STAINLESS STEEL	3
14	HARDWARE	RING, RETAINING, EXTERNAL LOW-CLEARANCE, 17mm SHAFT, 15-7 PH STAINLESS STEEL	1

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TITLE  
[603-D100/A] ASSY, GEAR CASE COMPLETE

SIZE  
D

DWG NO  
XM-82994

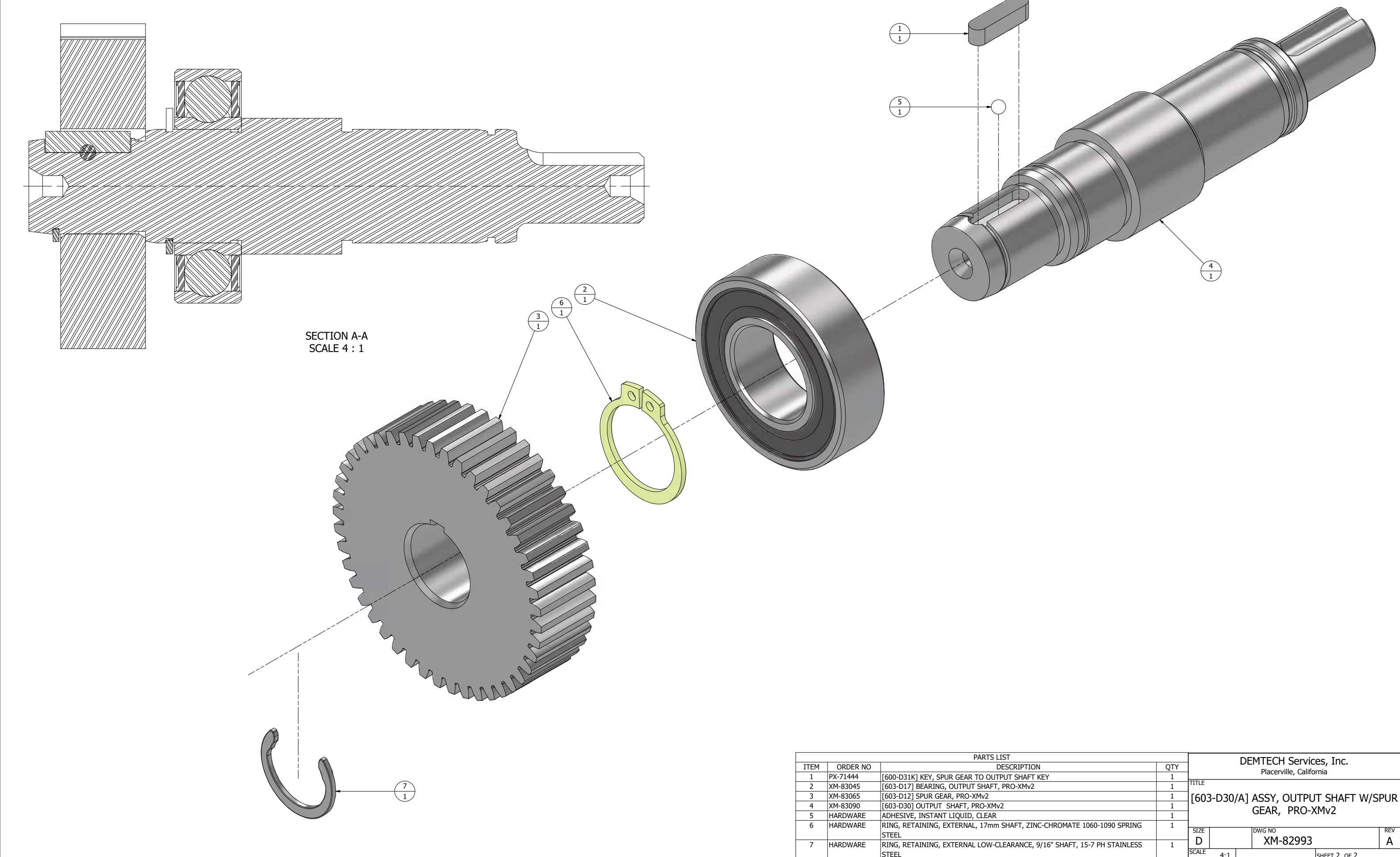
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SHEET 5 OF 5



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PARTS LIST				DEMTECH Services, Inc. Placerville, California		
ITEM	ORDER NO	DESCRIPTION	QTY	TITLE		
1	PX-71444	[600-D31K] KEY, SPUR GEAR TO OUTPUT SHAFT KEY	1	[603-D30/A] ASSY, OUTPUT SHAFT W/SPUR GEAR, PRO-XMv2		
2	XM-83045	[603-D17] BEARING, OUTPUT SHAFT, PRO-XMv2	1			
3	XM-83065	[603-D12] SPUR GEAR, PRO-XMv2	1			
4	XM-83090	[603-D30] OUTPUT SHAFT, PRO-XMv2	1			
5	HARDWARE	ADHESIVE, INSTANT LIQUID, CLEAR	1	SIZE D	DWG NO XM-82993	REV A
6	HARDWARE	RING, RETAINING, EXTERNAL, 17mm SHAFT, ZINC-CHROMATE 1060-1090 SPRING STEEL	1	SCALE 4:1 SHEET 2 OF 2		
7	HARDWARE	RING, RETAINING, EXTERNAL LOW-CLEARANCE, 9/16" SHAFT, 15-7 PH STAINLESS STEEL	1			