



## Pro-XMv2



## Pro-XMv2 Parts ID Manual

Inventory ID: XM-82999

Revision: C  
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: **PARTS ID MANUAL/PRO-XMv2, Revision: C**

DEMTECH Services, Inc.  
6414 Capitol Avenue Diamond Springs, CA 95619 U.S.A.  
Telephone: (530) 621-3200  
Toll Free: (888) 324-9353

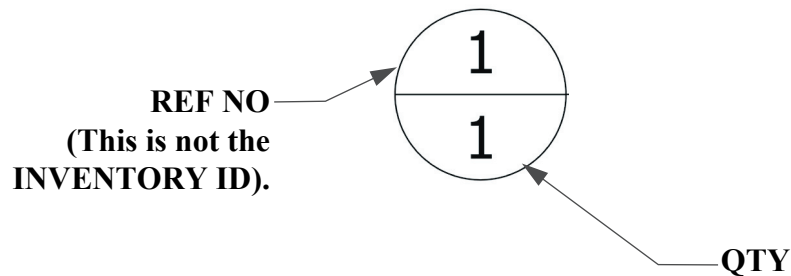
Web Site: [www.demtech.com](http://www.demtech.com)

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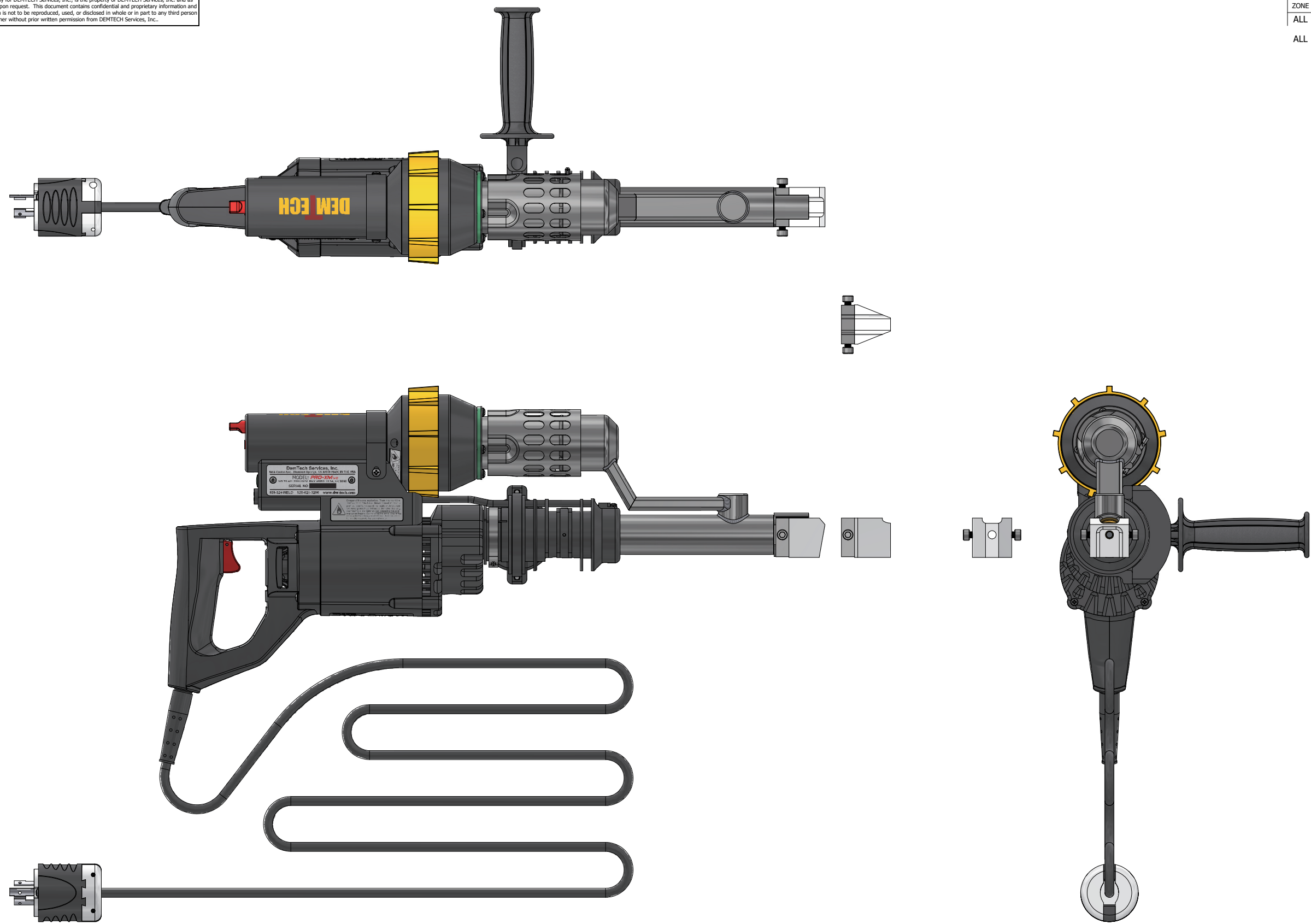
## 1 Ordering Instructions

Use the exploded assembly diagrams and related parts lists on the following pages to identify replacement parts for the Pro-XMv2 Extrusion Welder. For a specific assembly diagram identify a part by finding it visually on the diagram and note its Reference Number (REF NO). Next refer to the parts list to identify its corresponding INVENTORY ID. When ordering parts, be sure to specify the INVENTORY ID not the REF NO. "HARDWARE" refers to non-stock components, these parts are also available for order by providing the complete part description.



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| 2                |     | DWG NO<br>603-0100/A  | SH<br>1    | REV<br>B | 1 |
|------------------|-----|---|------------|----------|---|
| REVISION HISTORY |     |   |            |          |   |
| ZONE             | REV | DESCRIPTION   | DATE       | APPROVED |   |
| ALL              | A   | ECO-25009, INITIAL RELEASE TO PRODUCTION                    | 06/05/2025 | ISD      |   |
| ALL              | B   | ECO-25017, ADDED MANIFOLD, SHIELD NOZZLE & TEFLON SHOE ASSY | 08/12/2025 | ISD      |   |



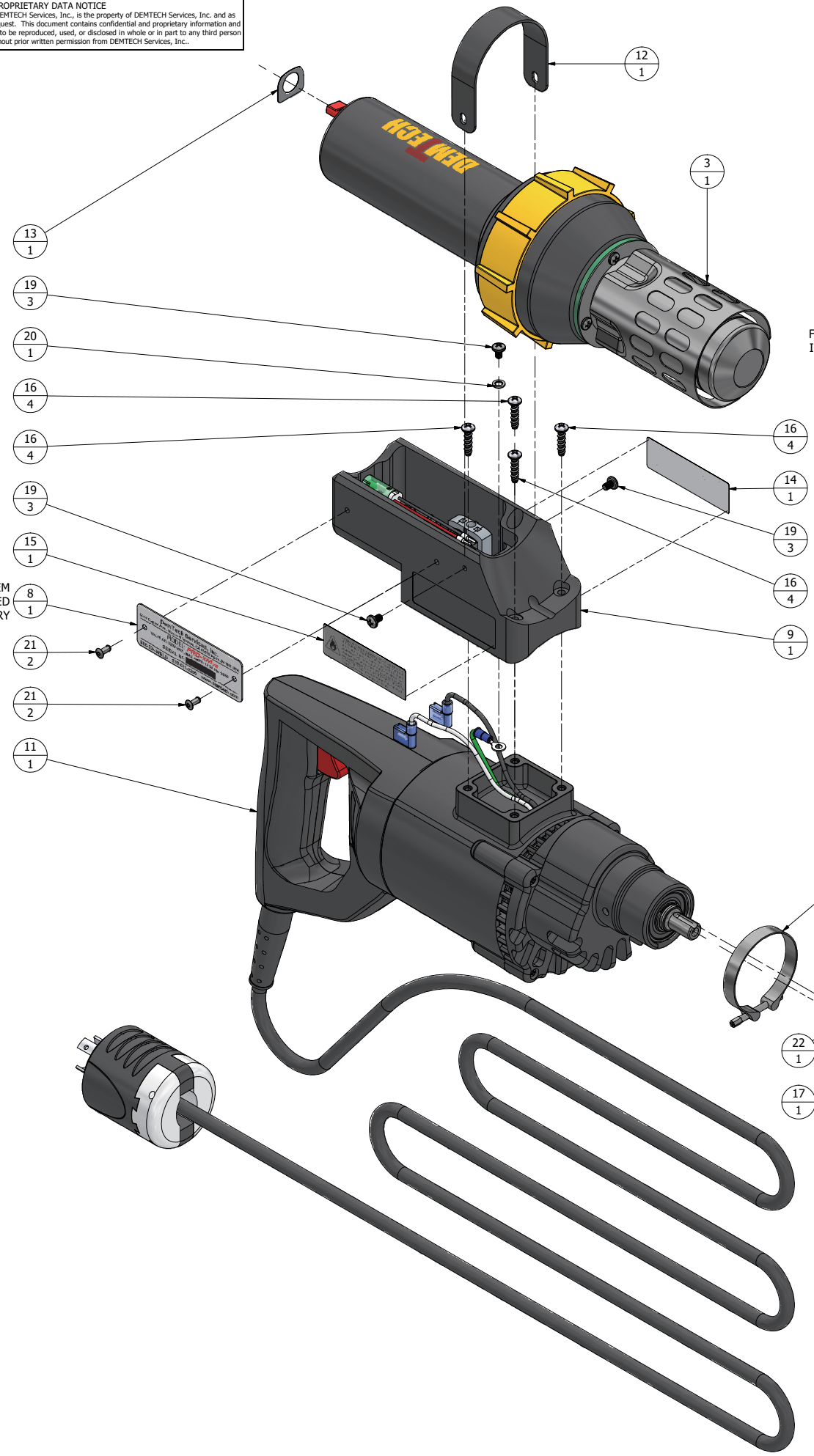
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1. THE BALLOON SYMBOL,  $\Theta$ , CONTAINS THE REFERENCE NUMBER (REF NO) AND QUANTITY (QTY) OF A SPECIFIED COMPONENT IN THIS ASSY. THE UPPER DIGIT IS THE REF NO AND THE LOWER DIGIT IS THE QTY REQUIRED FOR THIS ASSY.

NOTES (UNLESS OTHERWISE SPECIFIED):

|  |                          |              |            |   |          |
|--|--------------------------|--------------|------------|---|----------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009 |                          | DRAWN<br>ISD | 06/05/2025 | DEMTECH Services, Inc.<br>Placerville, California |          |
| STANDARD TOLERANCES  |                          | CHECKED      |            | TITLE   |          |
| DECIMALS   | SURFACE FINISH 63/       | QA           |            | [603-0100/A] PRO-XMv2 EXTRUSION WELDER            |          |
| XX ± .02   | ANGLES ± 1°              | MFG          |            | SIZE  | D        |
| XXX ± .005   | FRACTIONS ± 1/16         | APPROVED     |            | DWG NO  | XM-82999 |
| MATERIAL   | SEE NOTES AND PARTS LIST |              |            | REV   | B        |
| FINISH   | N/A                      |              |            | SCALE   | 1:2      |
| DO NOT SCALE DRAWING   |                          |              |            | SHEET 1 OF 4                                      |          |

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| PARTS LIST |              |   |     |
|------------|--------------|---|-----|
| REF NO     | INVENTORY ID | DESCRIPTION   | QTY |
| 1          | TS-14118     | [TS-605-0500/A] ASSY, SHOE, CORNER, INSIDE, FOR 12MM (1/2") SHEET THICKNESS         | 1   |
| 2          | TS-14125     | [TS-605-60/A] ASSY, TEFLON SHOE, Overlap, For 1.0-2.0mm (40-80 mil) Sheet Thickness | 1   |
| 3          | XM-71460     | [605-PREHEAT/2200/A] PREHEATER, 220V, 2200W   | 1   |
| 4          | XM-71482     | [605-012] PREHEAT MANIFOLD  | 1   |
| 5          | XM-71492     | [605-016] SHIELD, NOZZLE AIR  | 1   |
| 6          | XM-71512     | [605-040] CLAMP, BARREL   | 2   |
| 7          | XM-71513     | [605-043] INSULATION BLANKET, PRO-XMv2, XMPv2                                       | 1   |
| 8          | XM-71624     | [603-399/XMv2] SERIAL PLATE, PRO-XMv2   | 1   |
| 9          | XM-82992     | [603-015/A] ASSY, MOTOR WIRING HOUSING, PRO-XMv2                                    | 1   |
| 10         | XM-82996     | [603-BARREL/A] ASSY, BARREL/SCREW, PRO-XMv2   | 1   |
| 11         | XM-82997     | [603-DRILL/A] ASSY, DRILL MOTOR COMPLETE, PRO-XMv2                                  | 1   |
| 12         | XM-83018     | [603-015B] BRACKET, PREHEATER, PRO-XMv2   | 1   |
| 13         | XM-83095     | [603-326] OVERLAY, PREHEAT CONTROL, PRO-XMv2  | 1   |
| 14         | XM-83098     | [603-015SL] LABEL, PREHEATER SETTING, PRO-XMv2                                      | 1   |
| 15         | XM-83099     | [603-015WL] WARNING LABEL, PRO-XMv2   | 1   |
| 16         | HARDWARE     | SCREW, #10 X 3/4" LONG, PAN HEAD PHILLIPS, HIGH-LOW, ZINC PLATED STEEL              | 4   |
| 17         | HARDWARE     | PIN, DOWEL, 3/16" OD X 1/4" LONG, 18-8 STAINLESS STEEL                              | 1   |
| 18         | HARDWARE     | PIN, COILED SPRING, 2.5mm OD X 12mm LONG, STD DUTY, SPRING STEEL                    | 2   |
| 19         | HARDWARE     | SCREW, M4 X 0.7 X 5mm LONG, PAN HEAD PHILLIPS, 18-8 STAINLESS STEEL                 | 3   |
| 20         | HARDWARE     | WASHER, M4 REGULAR SPLIT LOCK, 18-8 STAINLESS STEEL                                 | 1   |
| 21         | HARDWARE     | RIVET, 1/8" BLIND, DOME STYLE, STAINLESS STEEL                                      | 2   |
| 22         | HARDWARE     | PIN, DOWEL, 3/16" OD X 5/8" LONG, HARDENED, 416 STAINLESS STEEL                     | 1   |

1 (1)  
 ALTERNATE WELDING SHOE ASSY INCLUDED WITH EXTRUSION WELDER

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 Placerville, California

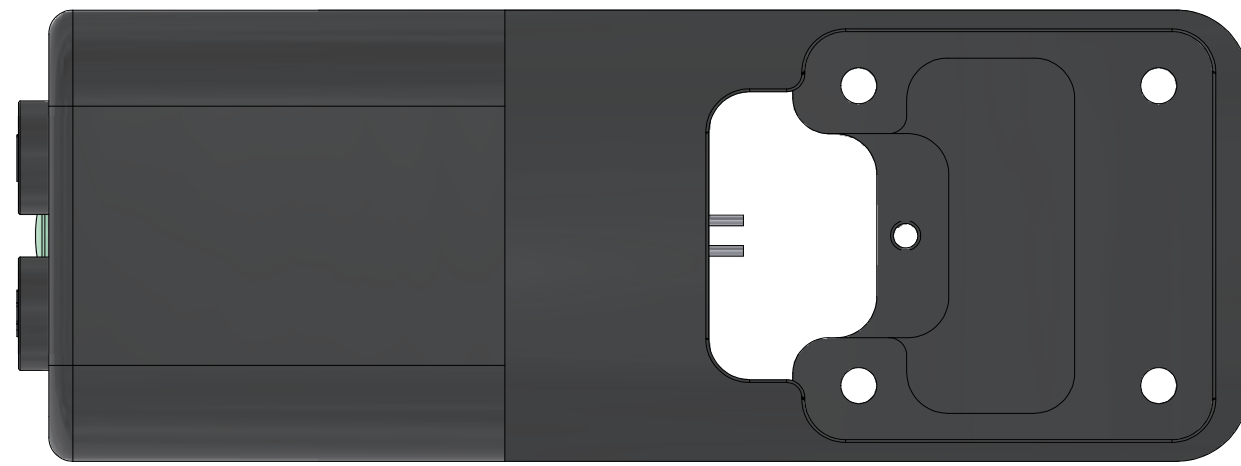
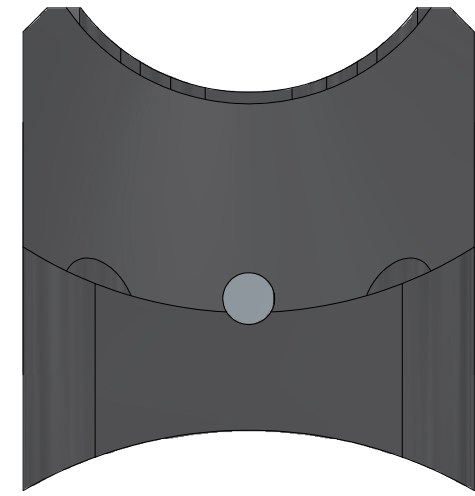
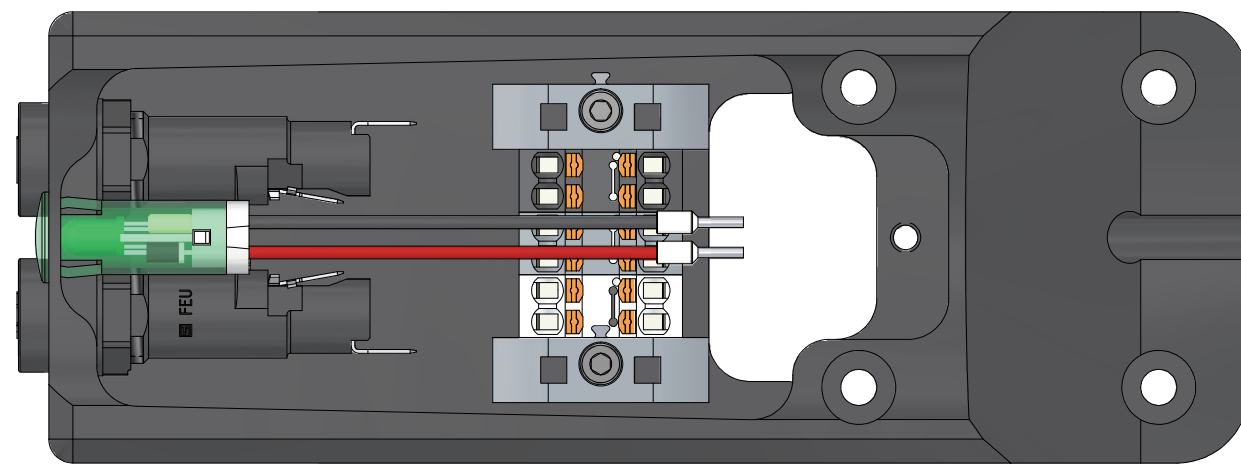
TITLE  
 [603-0100/A] PRO-XMv2 EXTRUSION WELDER

SIZE D DWG NO XM-82999 REV B

SCALE 3:4 SHEET 4 OF 4

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| 2                |     | DWG NO<br>603-015/A                      | SH<br>1 | REV<br>A   | 1        |  |
|------------------|-----|--|---------|------------|----------|--|
| REVISION HISTORY |     |  |         |            |          |  |
| ZONE             | REV | DESCRIPTION                              |         | DATE       | APPROVED |  |
| ALL              | A   | ECO-25009, INITIAL RELEASE TO PRODUCTION |         | 06/05/2025 | ISD      |  |



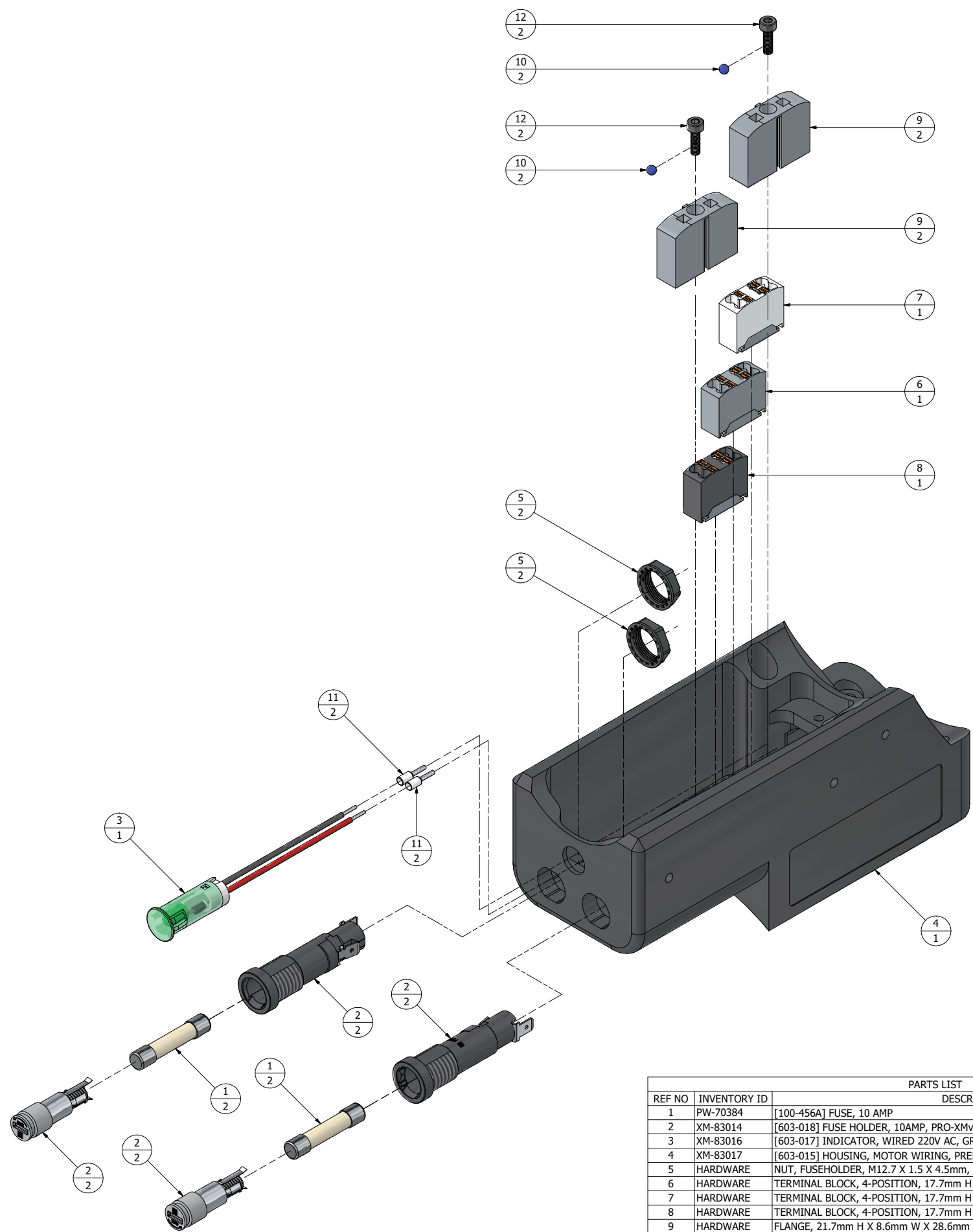
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NOTES (UNLESS OTHERWISE SPECIFIED):

|  |                    |              |            |   |          |
|--|--------------------|--------------|------------|---|----------|
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| STANDARD TOLERANCES  |                    | CHECKED      |            | TITLE   |          |
| DECIMALS   | SURFACE FINISH 63/ | QA           |            | [603-015/A] ASSY, MOTOR WIRING HOUSING, PRO-XMv2  |          |
| XX ± .02   | ANGLES ± 1°        | MFG          |            | SIZE  | DWG NO   |
| XXX ± .005   | FRACTIONS ± 1/16   | APPROVED     |            | D   | XM-82992 |
| MATERIAL   |                    |              |            | SCALE   | REV      |
| SEE NOTES AND PARTS LIST   |                    |              |            | 2:1   | A        |
| FINISH   |                    |              |            | SHEET 1 OF 4                                      |          |
| N/A  |                    |              |            |   |          |
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| PARTS LIST |              |  |     |
|------------|--------------|--|-----|
| REF NO     | INVENTORY ID | DESCRIPTION  | QTY |
| 1          | PW-70384     | [100-456A] FUSE, 10 AMP  | 2   |
| 2          | XM-83014     | [603-018] FUSE HOLDER, 10AMP, PRO-XMv2                                   | 2   |
| 3          | XM-83016     | [603-017] INDICATOR, WIRED 220V AC, GREEN LED                            | 1   |
| 4          | XM-83017     | [603-015] HOUSING, MOTOR WIRING, PREHEATER MOUNT, PRO-XMv2               | 1   |
| 5          | HARDWARE     | NUT, FUSEHOLDER, M12.7 X 1.5 X 4.5mm, HEX, BLACK PLASTIC                 | 2   |
| 6          | HARDWARE     | TERMINAL BLOCK, 4-POSITION, 17.7mm H X 8.3mm W X 21.6mm D, GRAY PLASTIC  | 1   |
| 7          | HARDWARE     | TERMINAL BLOCK, 4-POSITION, 17.7mm H X 8.3mm W X 21.6mm D, WHITE PLASTIC | 1   |
| 8          | HARDWARE     | TERMINAL BLOCK, 4-POSITION, 17.7mm H X 8.3mm W X 21.6mm D, BLACK PLASTIC | 1   |
| 9          | HARDWARE     | FLANGE, 21.7mm H X 8.6mm W X 28.6mm D, SCREW MOUNT, GRAY PLASTIC         | 2   |
| 10         | HARDWARE     | ADHESIVE, THREADLOCKING LIQUID, BLUE, FOR PLASTICS                       | 2   |
| 11         | HARDWARE     | FERRULE, INSULATED, 24-20 AWG, WHITE                                     | 2   |
| 12         | HARDWARE     | SCREW, M3 X 0.5 X 10mm LONG, SOCKET HEAD CAP, 18-8 STAINLESS STEEL       | 2   |

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 Placerville, California

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

SIZE  
**D**

DWG NO  
**XM-82992**

REV  
**A**

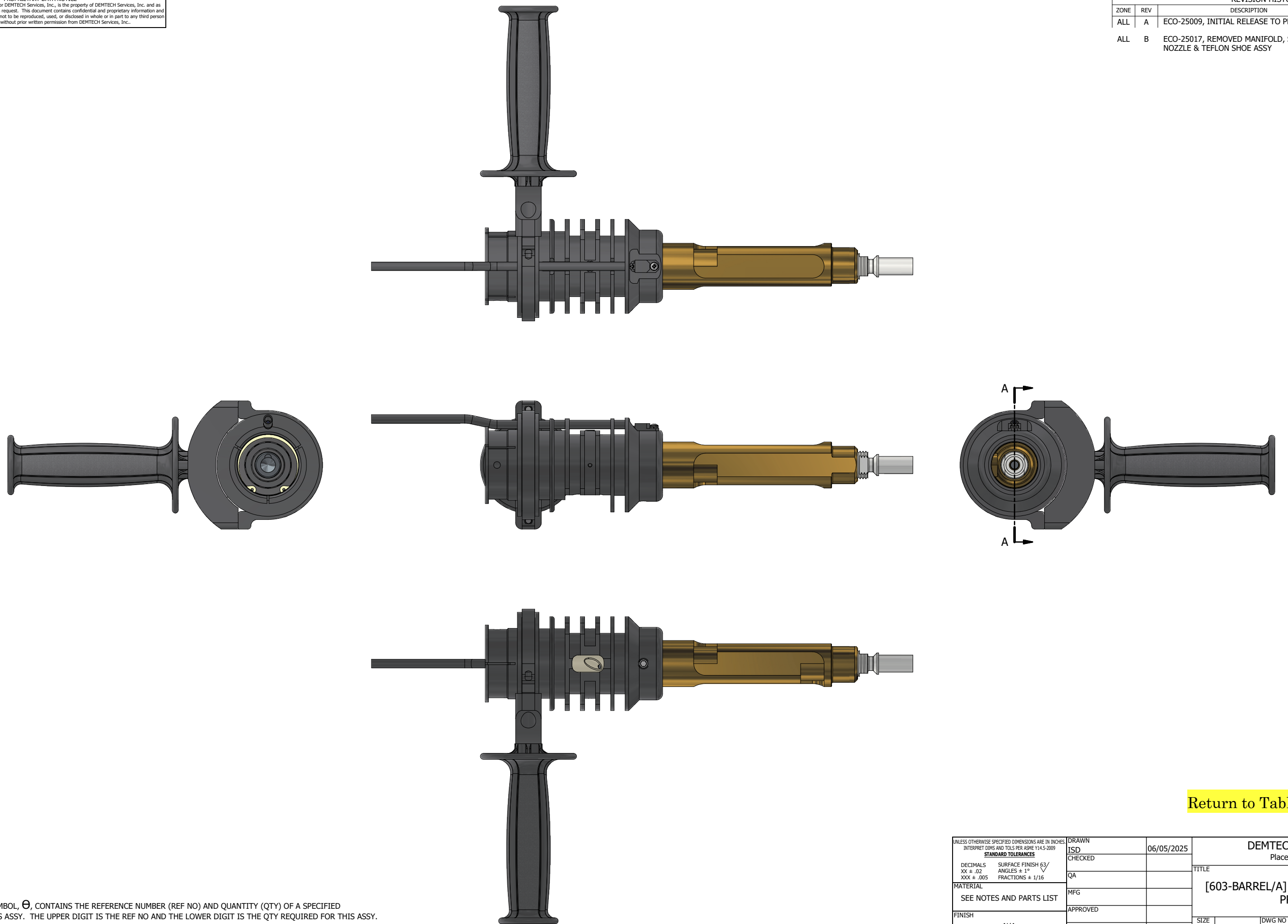
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SHEET 4 OF 4



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| DWG NO           |     | SH  | REV | 1          |          |
|------------------|-----|---|-----|------------|----------|
| 603-BARREL/A     |     | 1   | B   |            |          |
| REVISION HISTORY |     |   |     |            |          |
| ZONE             | REV | DESCRIPTION   |     | DATE       | APPROVED |
| ALL              | A   | ECO-25009, INITIAL RELEASE TO PRODUCTION                      |     | 06/05/2025 | ISD      |
| ALL              | B   | ECO-25017, REMOVED MANIFOLD, SHIELD NOZZLE & TEFLON SHOE ASSY |     | 08/12/2025 | ISD      |

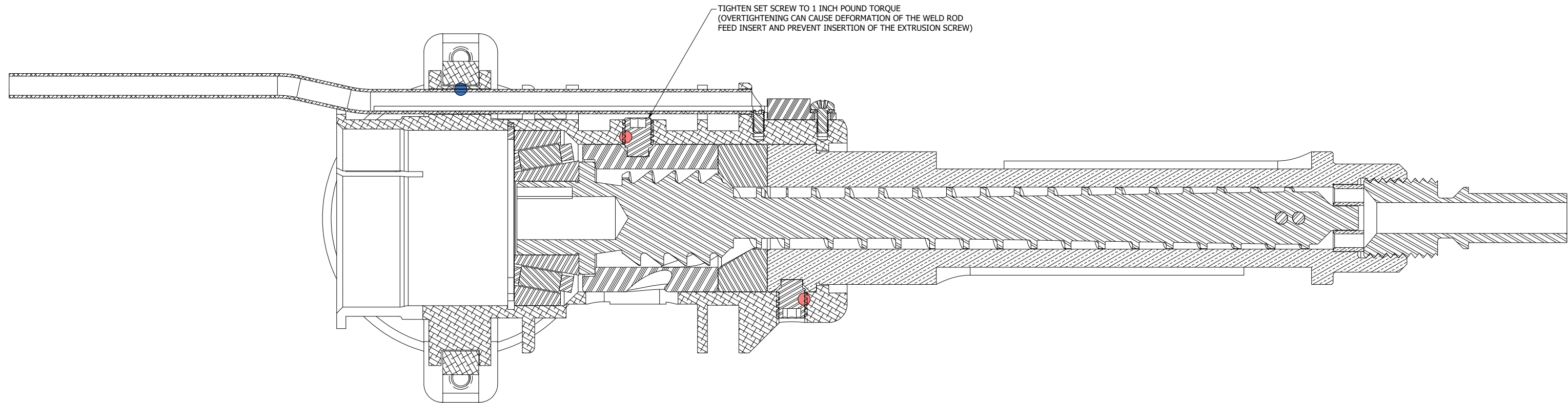


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 NOTES (UNLESS OTHERWISE SPECIFIED):

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|  |                    |              |            |   |          |
|--|--------------------|--------------|------------|---|----------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009 |                    | DRAWN<br>ISD | 06/05/2025 | DEMTECH Services, Inc.<br>Placerville, California |          |
| STANDARD TOLERANCES  |                    | CHECKED      |            | TITLE   |          |
| DECIMALS   | SURFACE FINISH 63/ | QA           |            | [603-BARREL/A] ASSY, BARREL/SCREW,<br>PRO-XMv2    |          |
| XX ± .02   | ANGLES ± 1°        | MFG          |            | SIZE  | DWG NO   |
| XXX ± .005   | FRACTIONS ± 1/16   | APPROVED     |            | D   | XM-82996 |
| MATERIAL   |                    |              |            | SCALE   | REV      |
| SEE NOTES AND PARTS LIST   |                    |              |            | 3:4   | B        |
| FINISH   |                    |              |            | SHEET 1 OF 4                                      |          |
| N/A  |                    |              |            |   |          |
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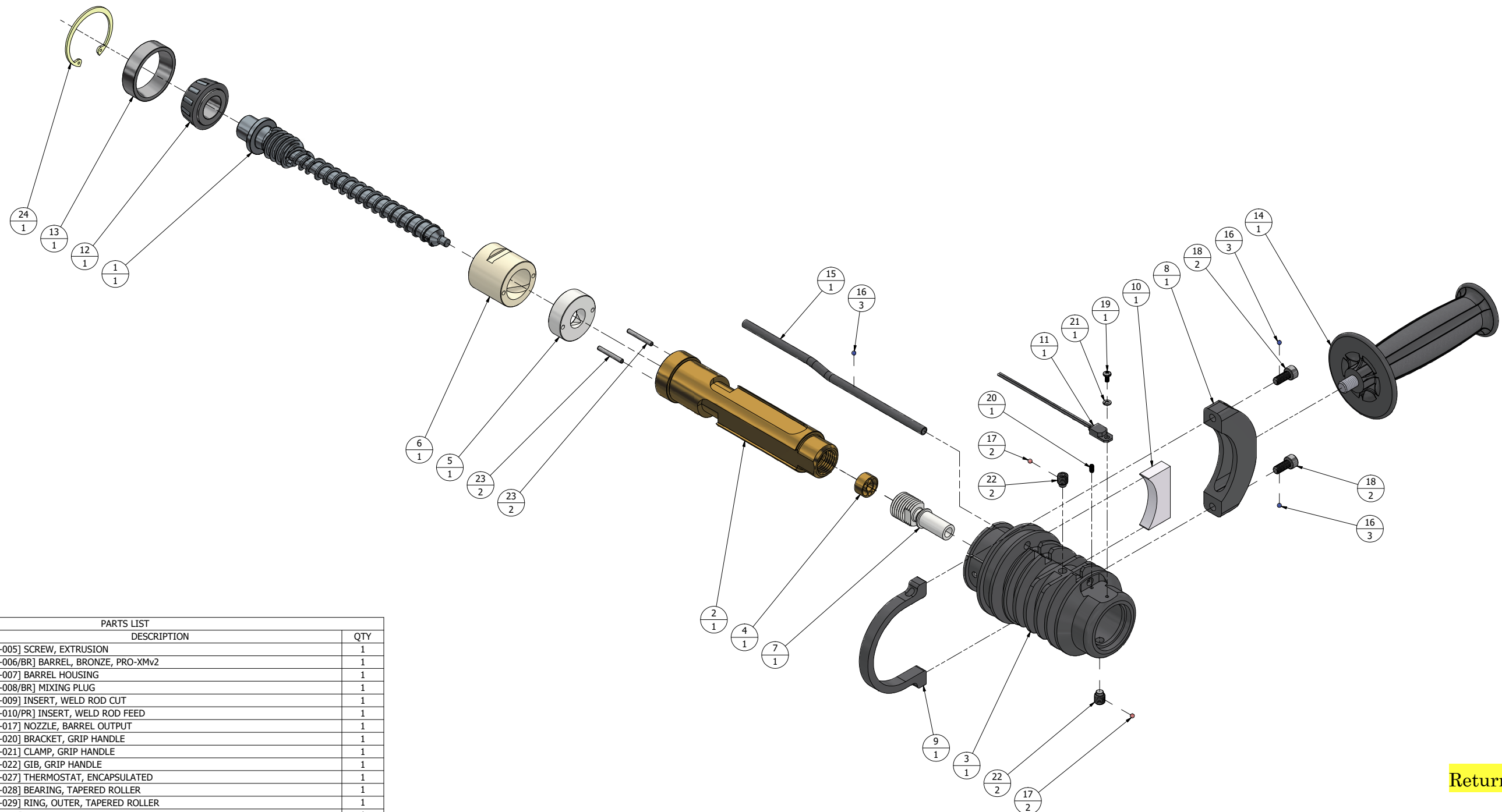


SECTION A-A  
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|   |                    |          |
|---|--------------------|----------|
| DEMTECH Services, Inc.<br>Placerville, California       |                    |          |
| TITLE<br>[603-BARREL/A] ASSY, BARREL/SCREW,<br>PRO-XMv2 |                    |          |
| SIZE<br>D   | DWG NO<br>XM-82996 | REV<br>B |
| SCALE<br>2:1  | SHEET 3 OF 4       |          |

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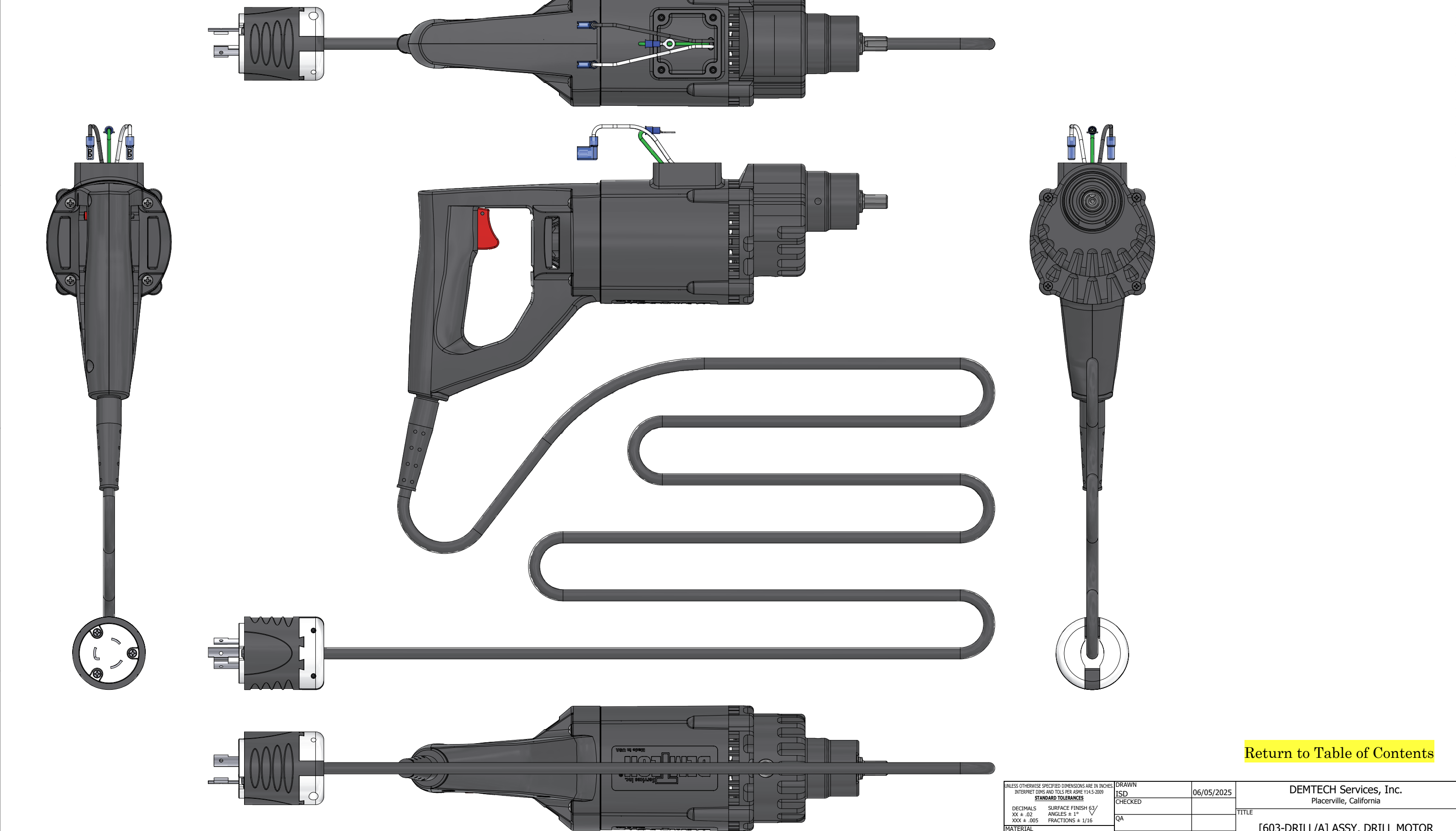
| PARTS LIST |              |  |     |
|------------|--------------|--|-----|
| REF NO     | INVENTORY ID | DESCRIPTION  | QTY |
| 1          | XM-71466     | [605-005] SCREW, EXTRUSION   | 1   |
| 2          | XM-71467     | [605-006/BR] BARREL, BRONZE, PRO-XMv2  | 1   |
| 3          | XM-71470     | [605-007] BARREL HOUSING   | 1   |
| 4          | XM-71472     | [605-008/BR] MIXING PLUG   | 1   |
| 5          | XM-71474     | [605-009] INSERT, WELD ROD CUT   | 1   |
| 6          | XM-71477     | [605-010/PR] INSERT, WELD ROD FEED   | 1   |
| 7          | XM-71494     | [605-017] NOZZLE, BARREL OUTPUT  | 1   |
| 8          | XM-71498     | [605-020] BRACKET, GRIP HANDLE   | 1   |
| 9          | XM-71500     | [605-021] CLAMP, GRIP HANDLE   | 1   |
| 10         | XM-71502     | [605-022] GIB, GRIP HANDLE   | 1   |
| 11         | XM-71507     | [605-027] THERMOSTAT, ENCAPSULATED   | 1   |
| 12         | XM-71508     | [605-028] BEARING, TAPERED ROLLER  | 1   |
| 13         | XM-71509     | [605-029] RING, OUTER, TAPERED ROLLER  | 1   |
| 14         | XM-71585     | [605-D46] HANDLE, DRILL MOTOR  | 1   |
| 15         | XM-83019     | [603-019] TUBE, WIRE CONDUIT, PRO-XMv2   | 1   |
| 16         | HARDWARE     | ADHESIVE, THREADLOCKING LIQUID, BLUE, THICK MEDIUM STRENGTH                              | 3   |
| 17         | HARDWARE     | ADHESIVE, THREADLOCKING LIQUID, RED  | 2   |
| 18         | HARDWARE     | SCREW, M6 X 1 X 14mm LONG, SOCKET HEAD CAP, 18-8 STAINLESS STEEL                         | 2   |
| 19         | HARDWARE     | SCREW, M3 X 0.5 X 6mm LONG, PAN HEAD PHILLIPS, 18-8 STAINLESS STEEL                      | 1   |
| 20         | HARDWARE     | SCREW, SET, M3 X 0.5 X 6mm LONG, ALLEN CUP POINT, 18-8 STAINLESS STEEL                   | 1   |
| 21         | HARDWARE     | WASHER, M3 REGULAR SPLIT LOCK, 18-8 STAINLESS STEEL                                      | 1   |
| 22         | HARDWARE     | SCREW, SET, M8 X 1.25 X 10mm LONG, ALLEN SOCKET EXTENDED DOG POINT, 18-8 STAINLESS STEEL | 2   |
| 23         | HARDWARE     | PIN, DOWEL, 1/8" DIA X 1" LONG, 416 STAINLESSS STEEL                                     | 2   |
| 24         | HARDWARE     | RING, RETAINING, INTERNAL, 1-3/4" HOUSING, ZINC CHROMATE STEEL                           | 1   |

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|   |                           |                 |
|---|---------------------------|-----------------|
| <b>DEMTECH Services, Inc.</b><br>Placerville, California    |                           |                 |
| TITLE<br><b>[603-BARREL/A] ASSY, BARREL/SCREW, PRO-XMv2</b> |                           |                 |
| SIZE<br><b>D</b>  | DWG NO<br><b>XM-82996</b> | REV<br><b>B</b> |
| SCALE<br>1:2  | SHEET 4 OF 4              |                 |

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| 2 DWG NO<br>603-DRILL/A |     | SH<br>1                                  | REV<br>A | 1          |          |
|-------------------------|-----|--|----------|------------|----------|
| REVISION HISTORY        |     |  |          |            |          |
| ZONE                    | REV | DESCRIPTION                              |          | DATE       | APPROVED |
| ALL                     | A   | ECO-25009, INITIAL RELEASE TO PRODUCTION |          | 06/05/2025 | ISD      |



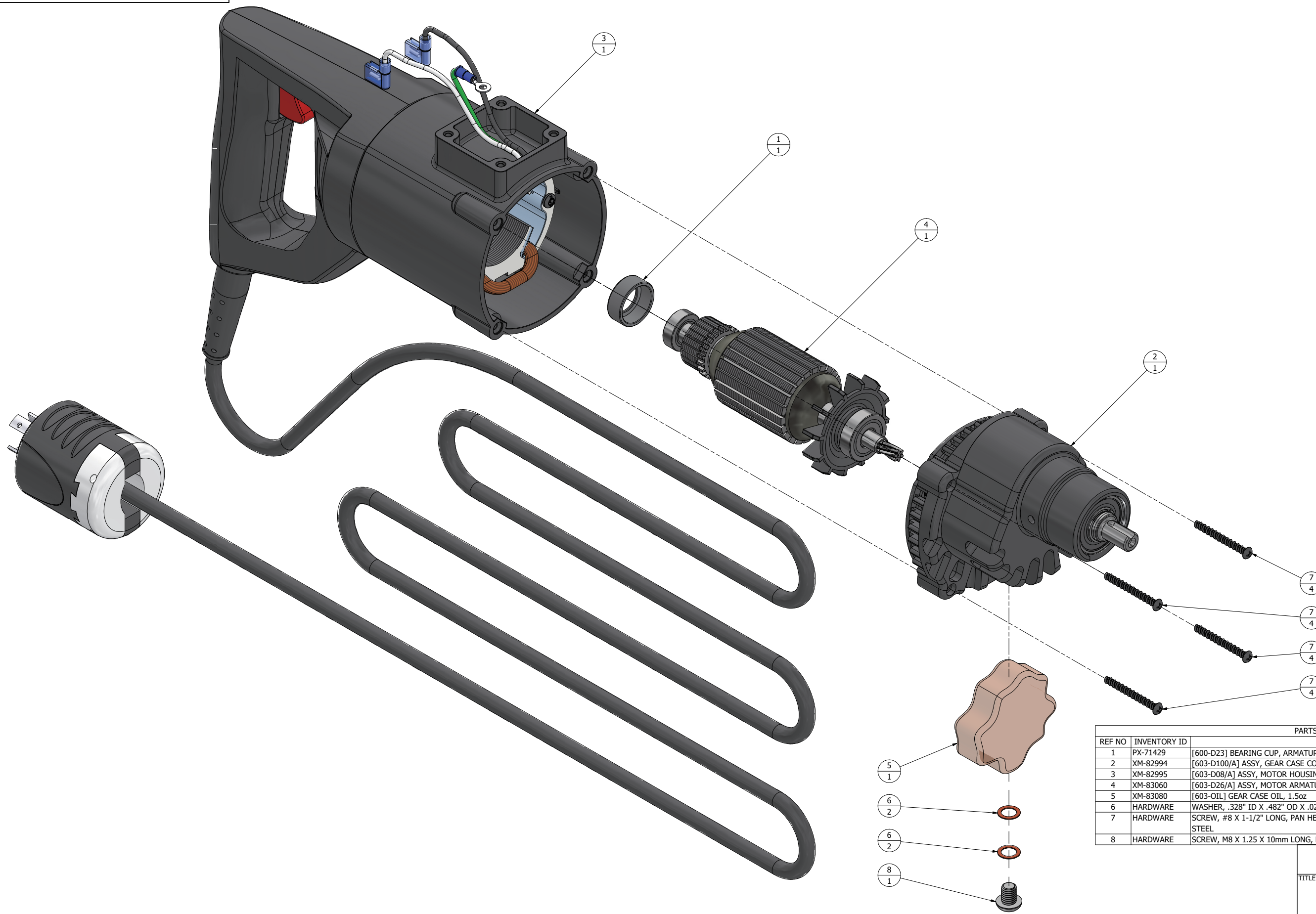
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|   |                                |              |            |   |              |
|---|--------------------------------|--------------|------------|---|--------------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009<br>STANDARD TOLERANCES |                                | DRAWN<br>ISD | 06/05/2025 | DEMTECH Services, Inc.<br>Placerville, California     |              |
| DECIMALS  | SURFACE FINISH 63/<br>XX ± .02 | CHECKED      |            | TITLE   |              |
| ANGLES ± 1°   | FRACTIONS ± 1/16               | QA           |            | [603-DRILL/A] ASSY, DRILL MOTOR<br>COMPLETE, PRO-XMv2 |              |
| MATERIAL  | SEE NOTES AND PARTS LIST       | MFG          |            | SIZE  | DWG NO       |
| FINISH  | N/A                            | APPROVED     |            | D   | XM-82997     |
| DO NOT SCALE DRAWING  |                                |              |            | SCALE   | 3:4          |
|   |                                |              |            |   | REV<br>A     |
|   |                                |              |            |   | SHEET 1 OF 3 |

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| PARTS LIST |              |   |     |
|------------|--------------|---|-----|
| REF NO     | INVENTORY ID | 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   |

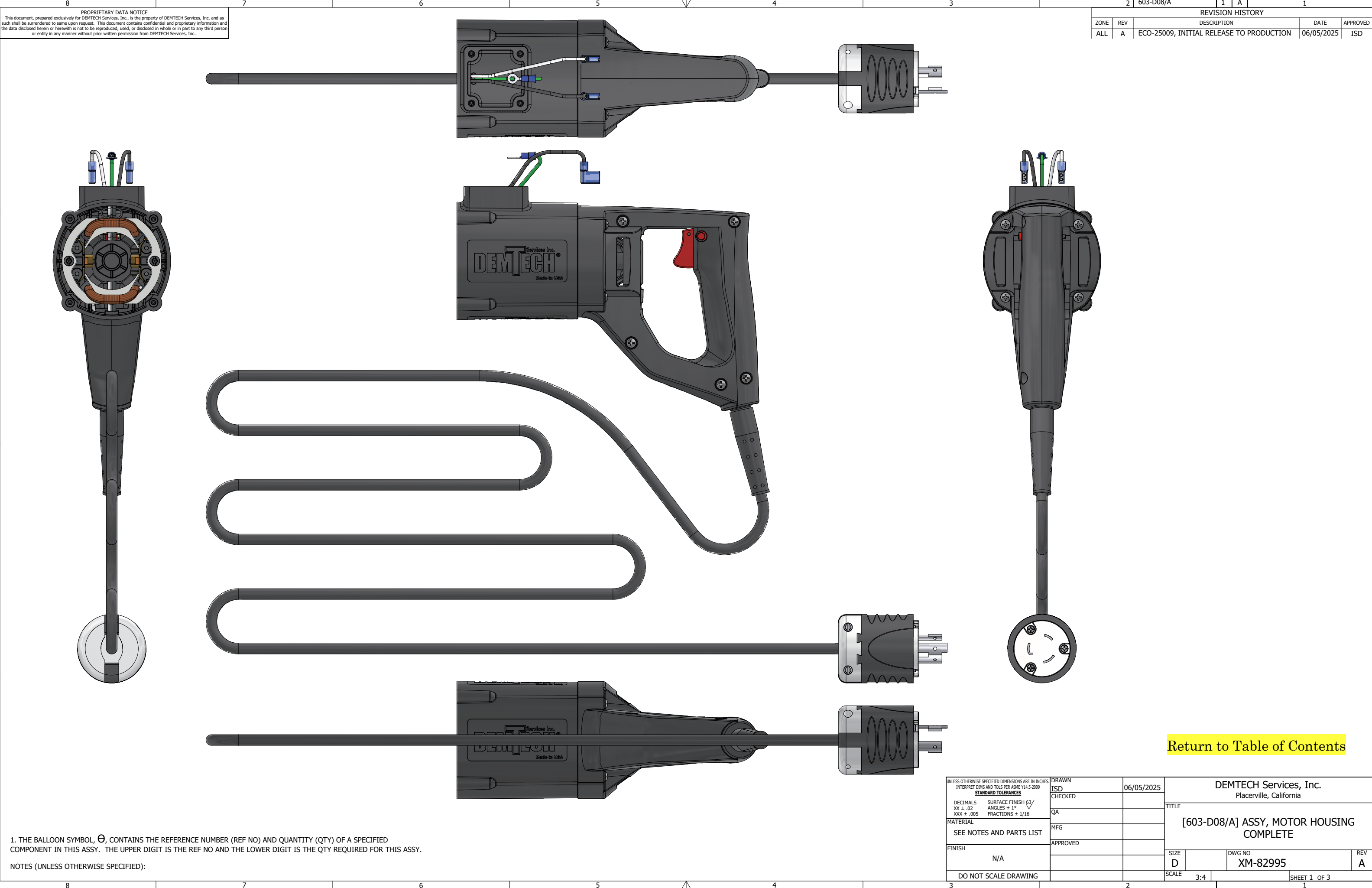
**DEMTECH Services, Inc.**  
Placerville, California

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

|                     |                           |                 |
|---------------------|---------------------------|-----------------|
| <b>SIZE</b><br>D    | <b>DWG NO</b><br>XM-82997 | <b>REV</b><br>A |
| <b>SCALE</b><br>1:1 | <b>SHEET 3 OF 3</b>       |                 |

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| 2 DWG NO<br>603-D08/A |     | SH<br>1                                  | REV<br>A | 1          |          |
|-----------------------|-----|--|----------|------------|----------|
| REVISION HISTORY      |     |  |          |            |          |
| ZONE                  | REV | DESCRIPTION                              |          | DATE       | APPROVED |
| ALL                   | A   | ECO-25009, INITIAL RELEASE TO PRODUCTION |          | 06/05/2025 | ISD      |

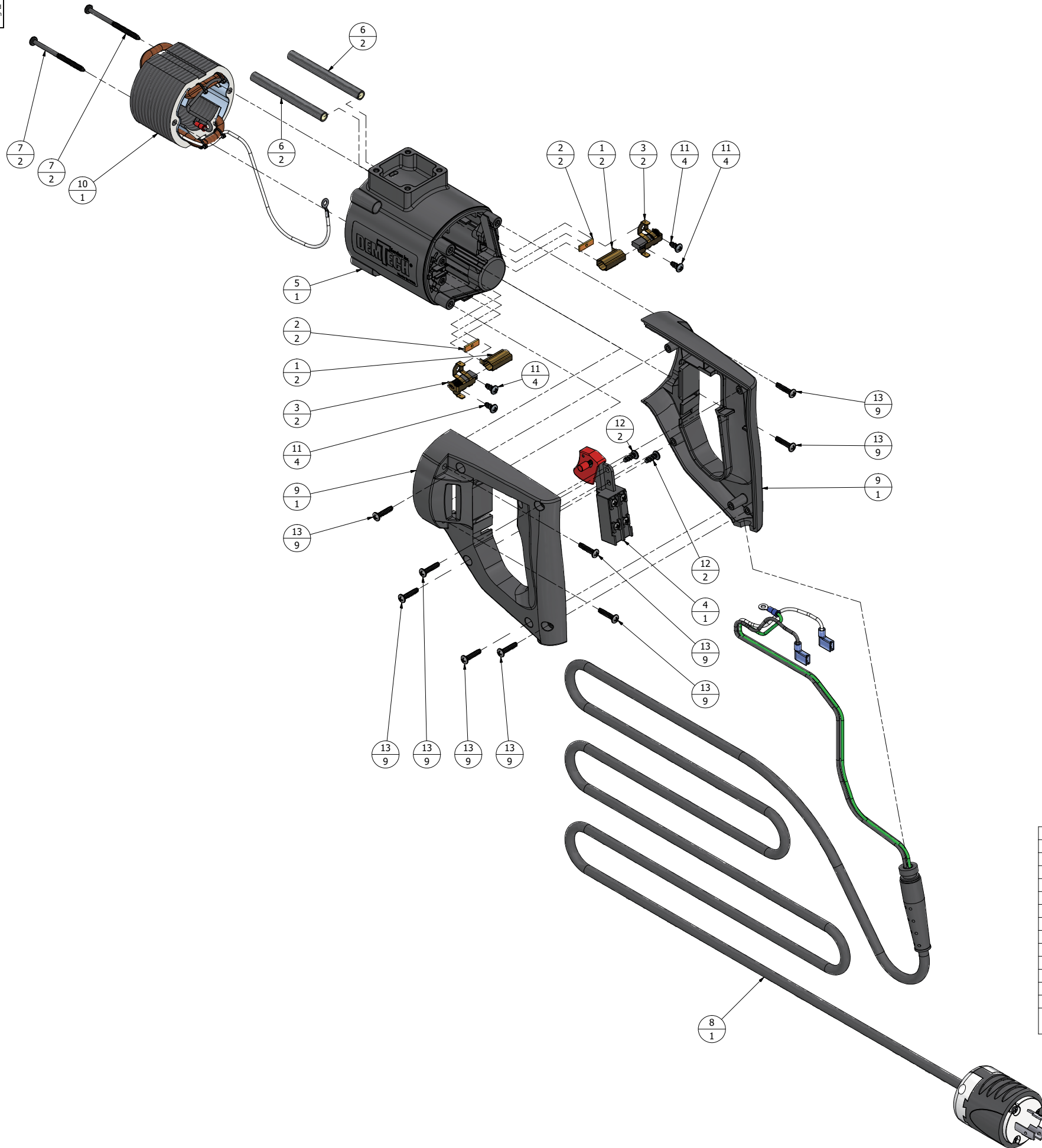


1. THE BALLOON SYMBOL,  $\Theta$ , CONTAINS THE REFERENCE NUMBER (REF NO) AND QUANTITY (QTY) OF A SPECIFIED COMPONENT IN THIS ASSY. THE UPPER DIGIT IS THE REF NO AND THE LOWER DIGIT IS THE QTY REQUIRED FOR THIS ASSY.  
 NOTES (UNLESS OTHERWISE SPECIFIED):

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|   |                                |              |              |   |          |
|---|--------------------------------|--------------|--------------|---|----------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br><small>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009</small><br><b>STANDARD TOLERANCES</b> |                                | DRAWN<br>ISD | 06/05/2025   | DEMTECH Services, Inc.<br>Placerville, California |          |
| DECIMALS  | SURFACE FINISH 63/<br>XX ± .02 | CHECKED      |              | TITLE   |          |
| ANGLES ± 1°   | FRACTIONS ± 1/16               | QA           |              | [603-D08/A] ASSY, MOTOR HOUSING<br>COMPLETE       |          |
| MATERIAL  | SEE NOTES AND PARTS LIST       | MFG          |              | SIZE  | DWG NO   |
| FINISH  | N/A                            | APPROVED     |              | D   | XM-82995 |
| DO NOT SCALE DRAWING  |                                | SCALE        | 3:4          | REV   | A        |
|   |                                |              | SHEET 1 OF 3 |   |          |

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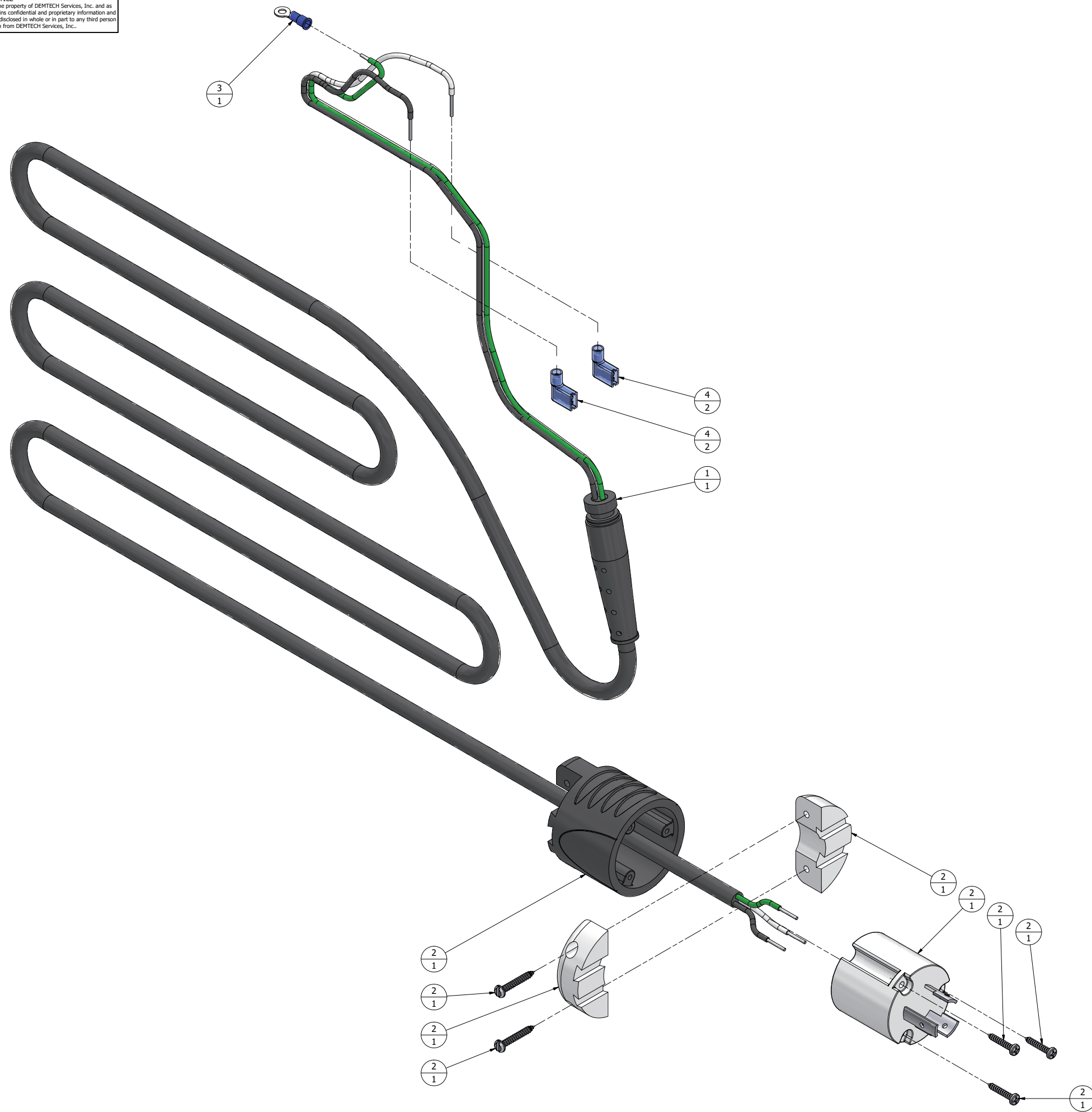
| PARTS LIST |              |  |     |
|------------|--------------|--|-----|
| REF NO     | INVENTORY ID | DESCRIPTION  | QTY |
| 1          | PX-71405     | [600-D03] BRUSH HOLDER   | 2   |
| 2          | PX-71406     | [600-D04] BRUSH INSULATOR  | 2   |
| 3          | PX-71407     | [600-D05] BRUSH, 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   |

**DEMTECH Services, Inc.**  
Placerville, California

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

|                  |                           |                 |
|------------------|---------------------------|-----------------|
| SIZE<br><b>D</b> | DWG NO<br><b>XM-82995</b> | REV<br><b>A</b> |
| SCALE<br>1:2     | SHEET 3 OF 3              |                 |

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| PARTS LIST |              |  |     |
|------------|--------------|--|-----|
| REF NO     | INVENTORY ID | 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 GAUGE, .187" X .02" TAB, BLUE                       | 2   |

**DEMTECH Services, Inc.**  
Placerville, California

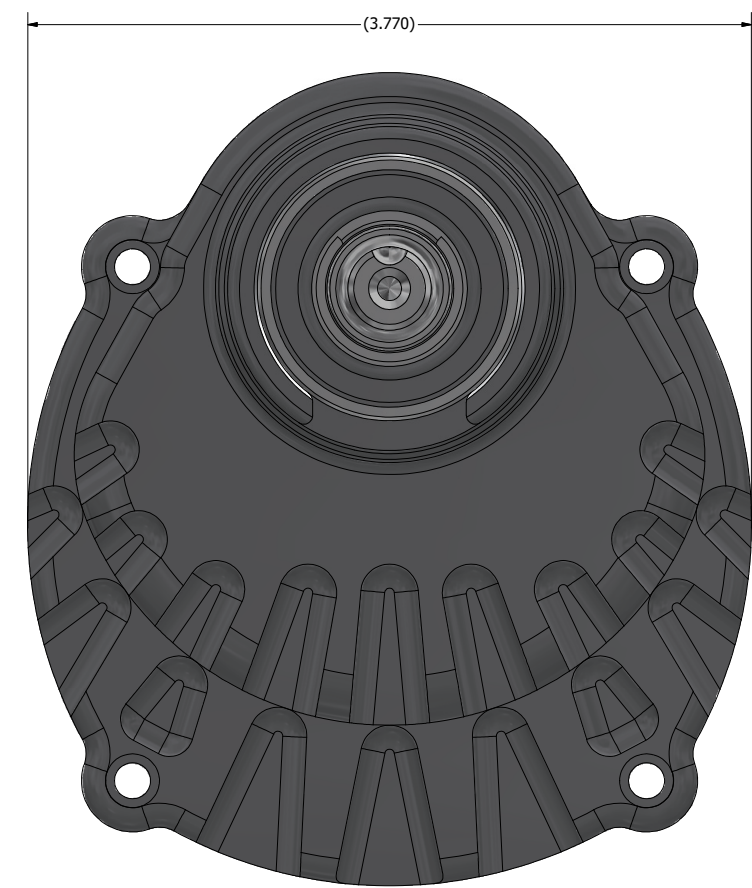
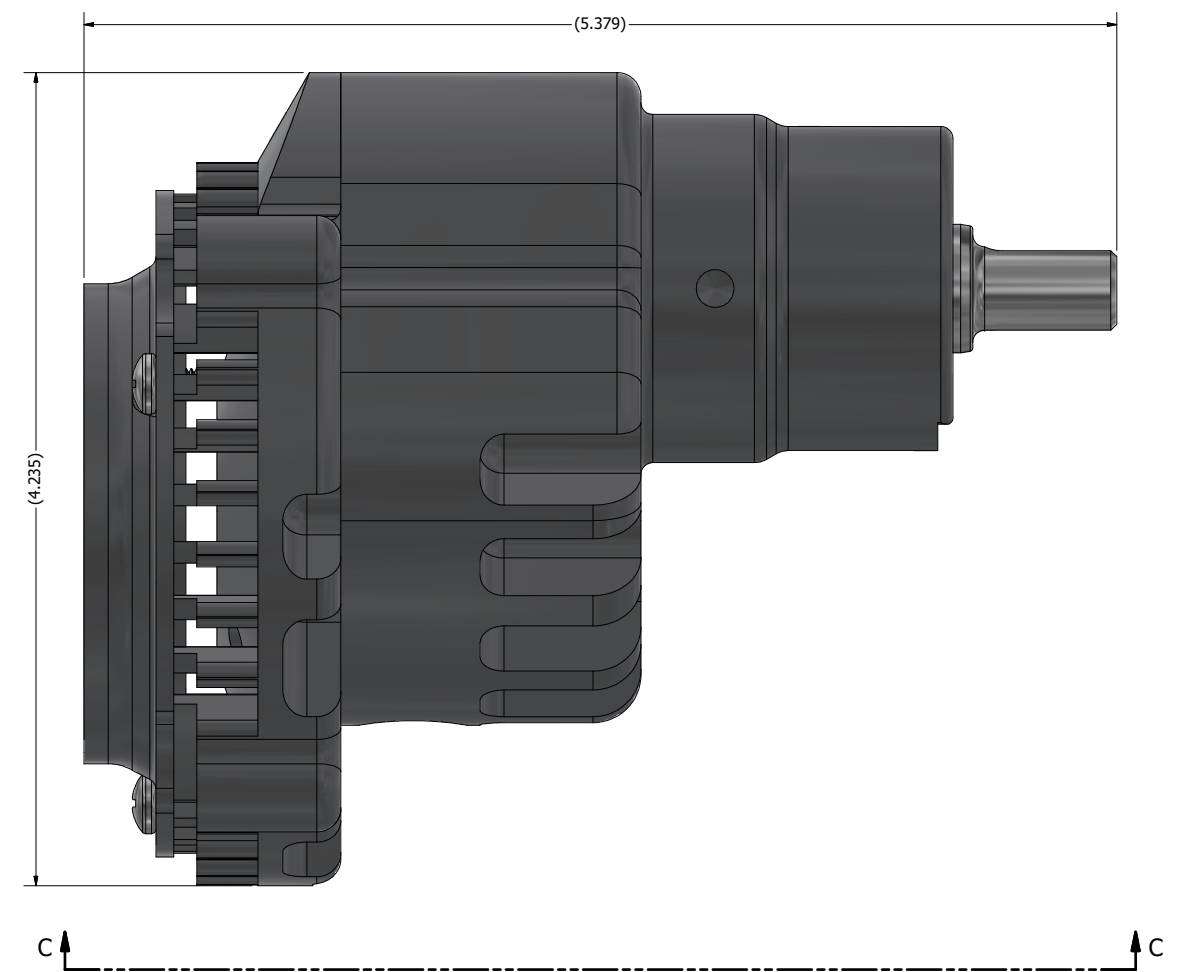
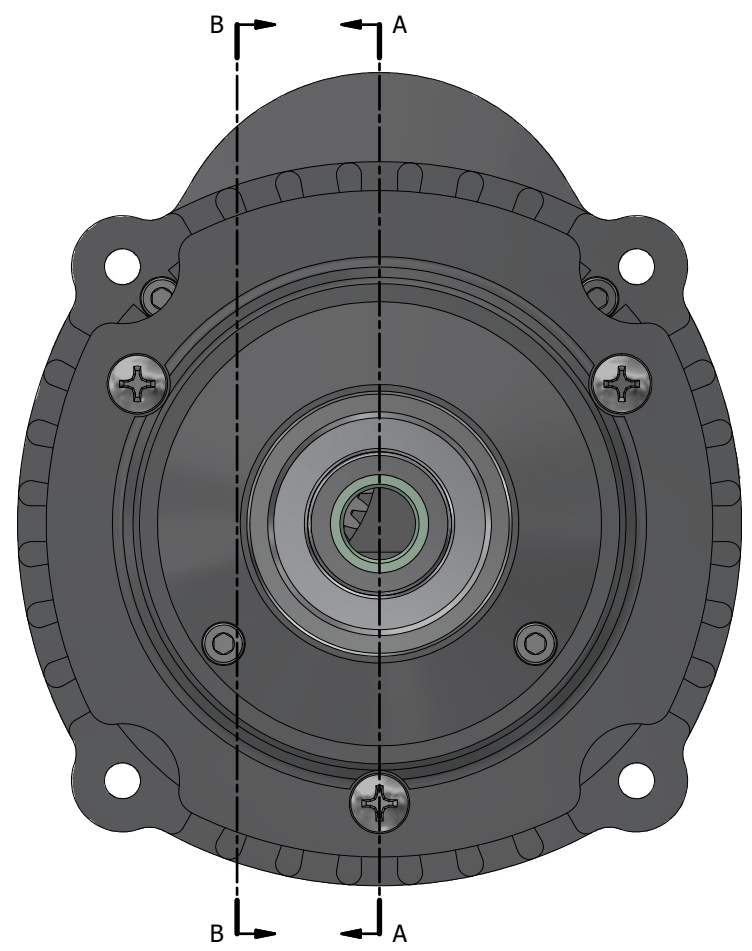
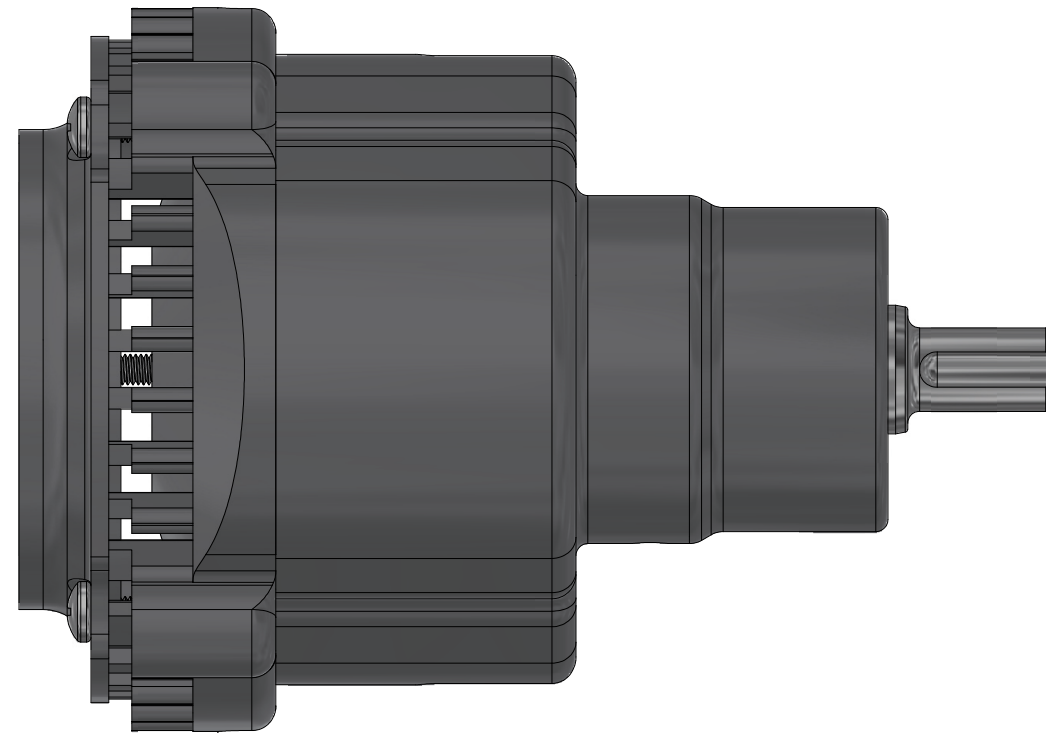
TITLE  
**[603-CORD/A] ASSY, POWER CORD, PRO-XMv2**

|                  |                           |                 |
|------------------|---------------------------|-----------------|
| SIZE<br><b>D</b> | DWG NO<br><b>XM-82991</b> | REV<br><b>A</b> |
| SCALE<br>1:1     | SHEET 2 OF 2              |                 |



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| 2 DWG NO<br>603-D100/A |     | SH<br>1                                  | REV<br>A   | 1        |
|------------------------|-----|--|------------|----------|
| REVISION HISTORY       |     |  |            |          |
| ZONE                   | REV | DESCRIPTION                              | DATE       | APPROVED |
| ALL                    | A   | ECO-25009, INITIAL RELEASE TO PRODUCTION | 06/05/2025 | ISD      |



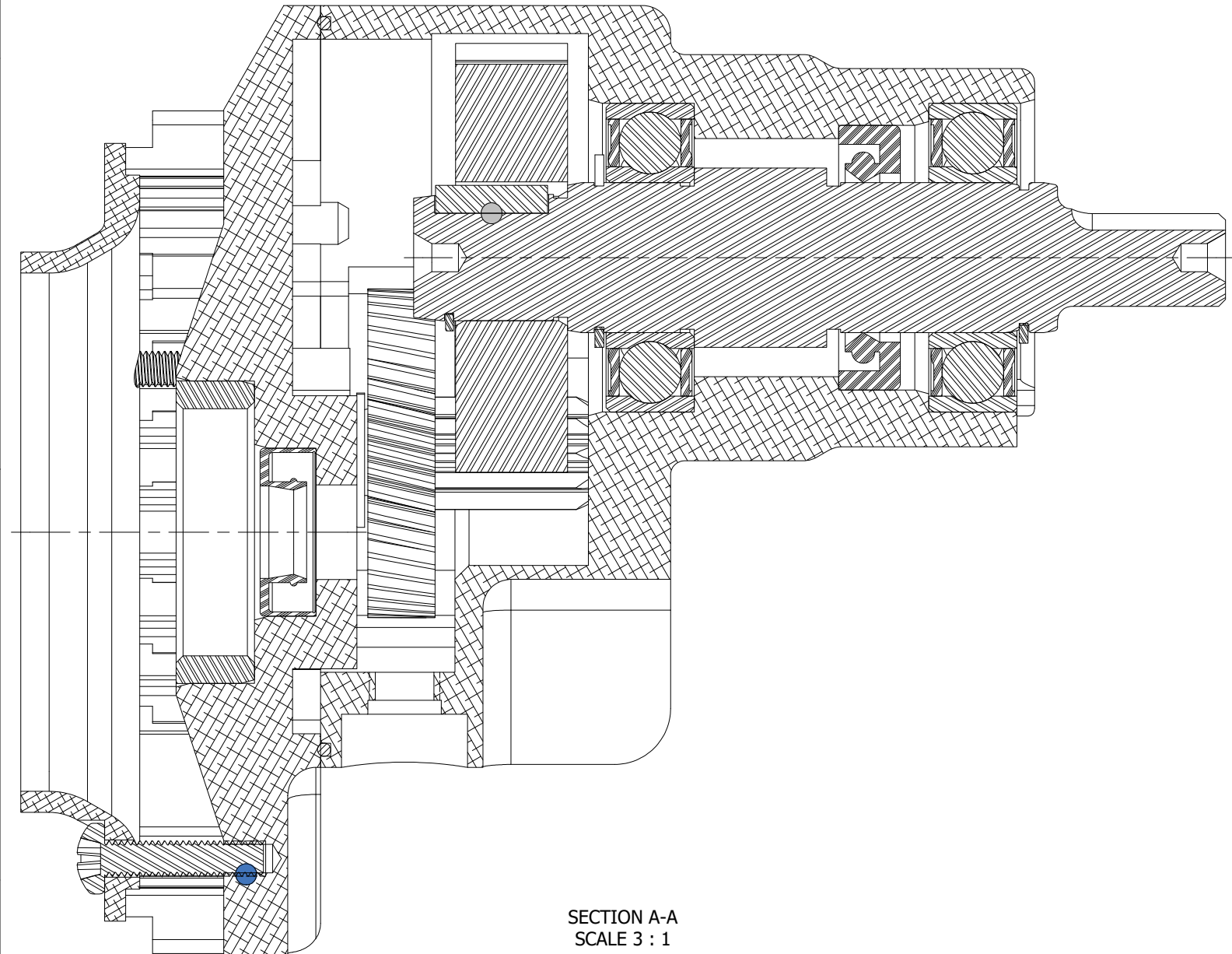
[Return to Table of Contents](#)

1. THE BALLOON SYMBOL,  $\Theta$ , CONTAINS THE REFERENCE NUMBER (REF NO) AND QUANTITY (QTY) OF A SPECIFIED COMPONENT IN THIS ASSY. THE UPPER DIGIT IS THE REF NO AND THE LOWER DIGIT IS THE QTY REQUIRED FOR THIS ASSY.

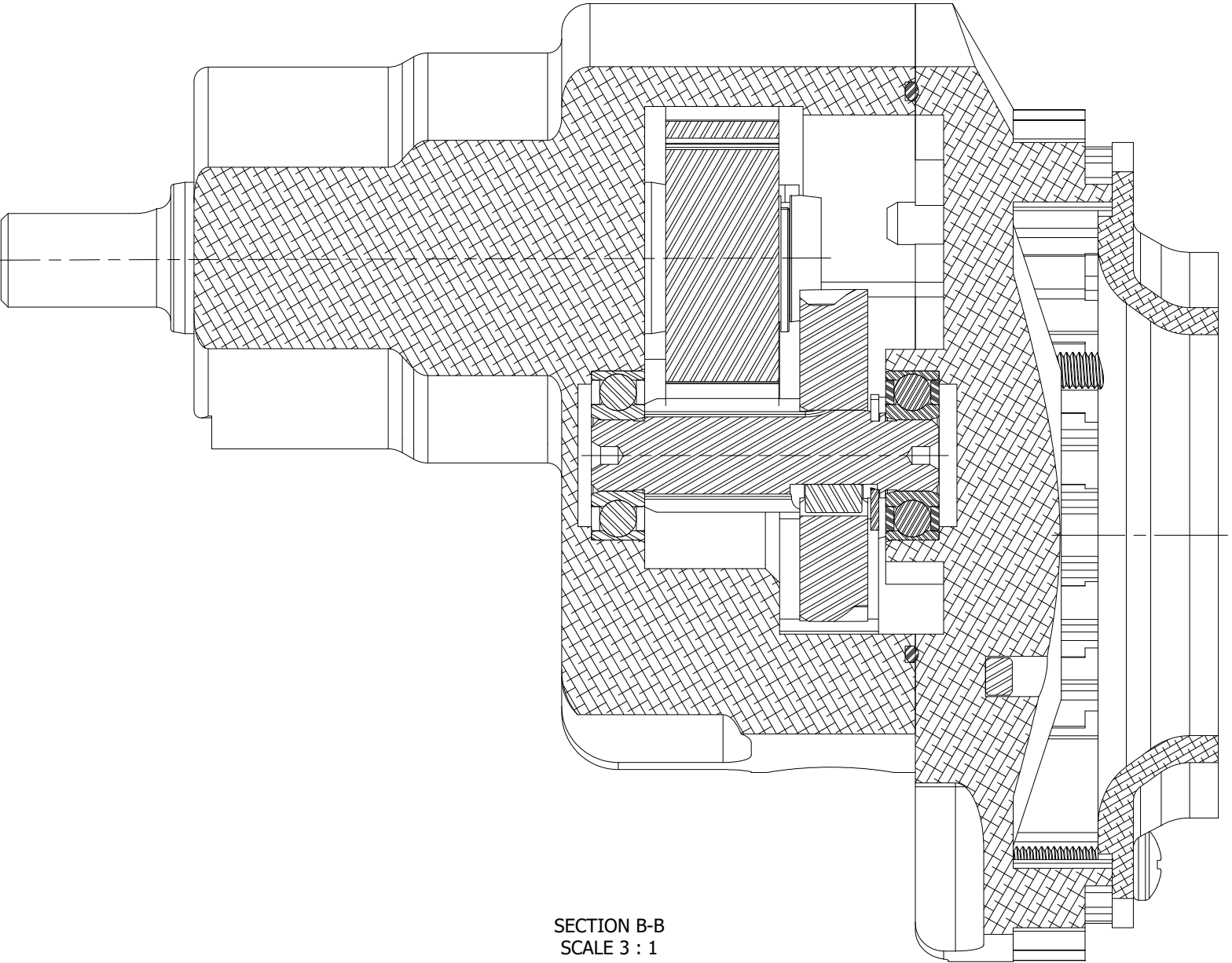
NOTES (UNLESS OTHERWISE SPECIFIED):

|  |                                |              |            |   |          |
|--|--------------------------------|--------------|------------|---|----------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009 |                                | DRAWN<br>ISD | 06/05/2025 | DEMTECH Services, Inc.<br>Placerville, California |          |
| STANDARD TOLERANCES  |                                | CHECKED      |            | TITLE   |          |
| DECIMALS   | SURFACE FINISH 63/<br>XX ± .02 | QA           |            | [603-D100/A] ASSY, GEAR CASE COMPLETE             |          |
| ANGLES ± 1°  |                                | MFG          |            | SIZE  | DWG NO   |
| FRACTIONS ± 1/16   |                                | APPROVED     |            | D   | XM-82994 |
| MATERIAL   | SEE NOTES AND PARTS LIST       |              |            | SCALE   | REV      |
| FINISH   | N/A                            |              |            | 2:1   | A        |
| DO NOT SCALE DRAWING   |                                |              |            | SHEET 1 OF 5                                      |          |

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SECTION A-A  
 SCALE 3 : 1

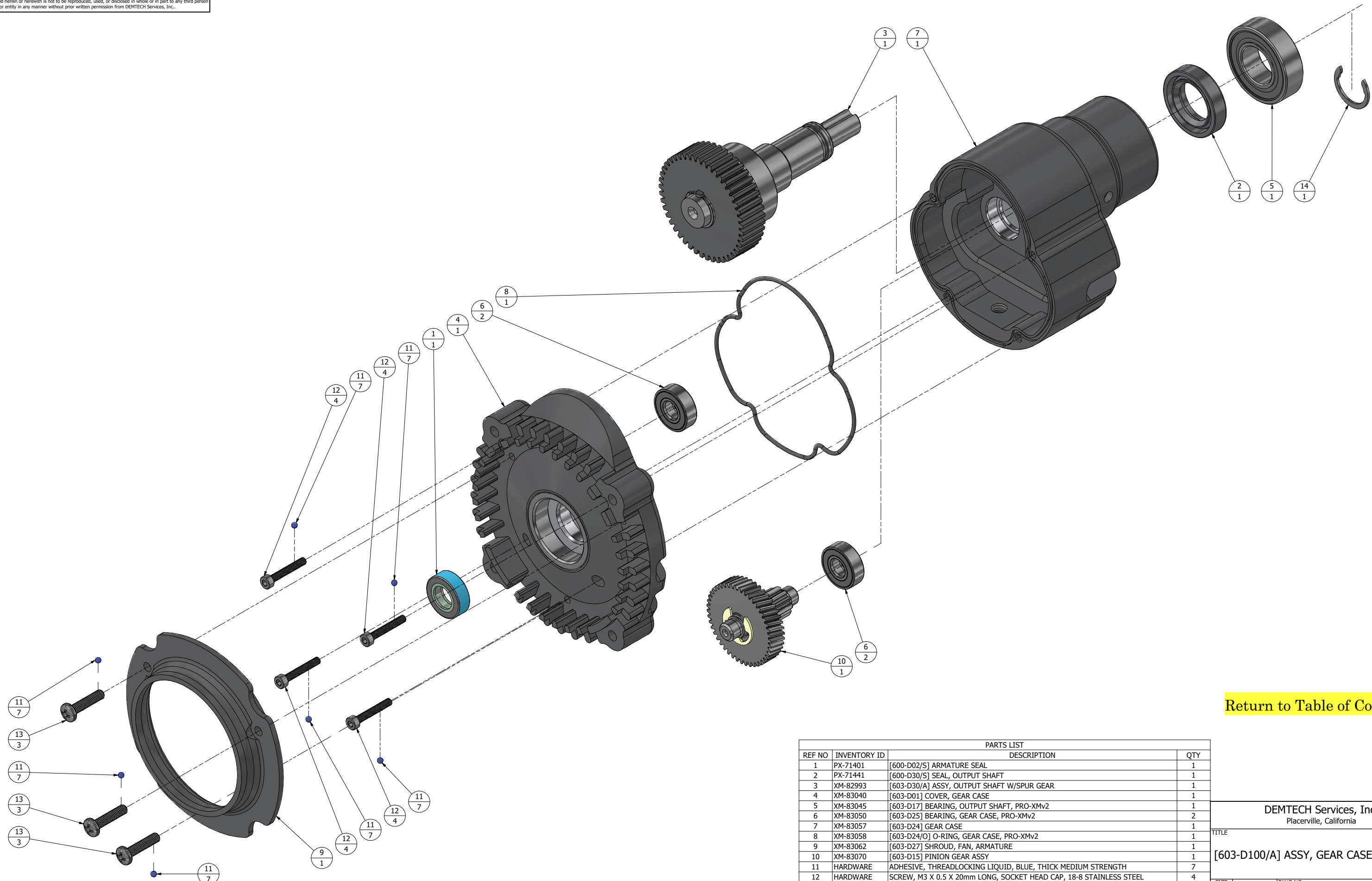


SECTION B-B  
 SCALE 3 : 1

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|   |                    |          |
|---|--------------------|----------|
| DEMTECH Services, Inc.<br>Placerville, California |                    |          |
| TITLE<br>[603-D100/A] ASSY, GEAR CASE COMPLETE    |                    |          |
| SIZE<br>D   | DWG NO<br>XM-82994 | REV<br>A |
| SCALE<br>3:1                                      | SHEET 2 OF 5       |          |

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| PARTS LIST |              |  |     |
|------------|--------------|--|-----|
| REF NO     | INVENTORY ID | DESCRIPTION  | QTY |
| 1          | PX-71401     | [600-D02/S] ARMATURE SEAL  | 1   |
| 2          | PX-71441     | [600-D30/S] SEAL, OUTPUT SHAFT   | 1   |
| 3          | XM-82993     | [603-D30/A] ASSY, OUTPUT SHAFT W/SPUR GEAR                                   | 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] SHROUD, FAN, ARMATURE  | 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   |

DEMTECH Services, Inc.  
 Placerville, California

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

SIZE  
**D**

SCALE  
 1.5:1

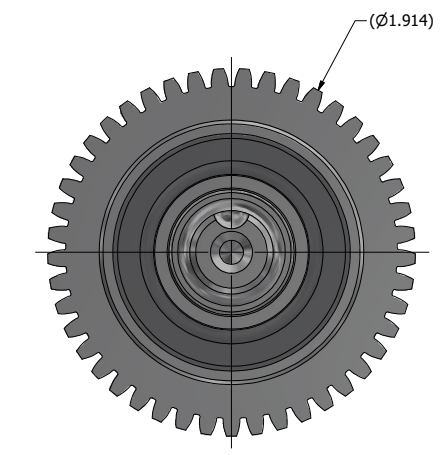
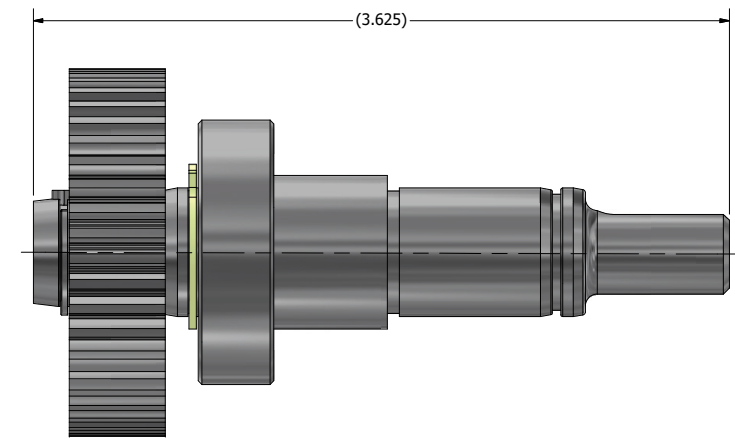
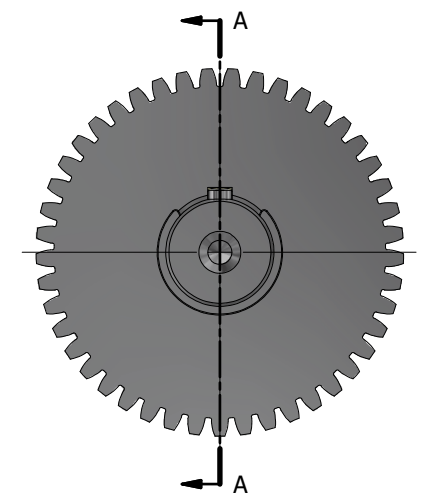
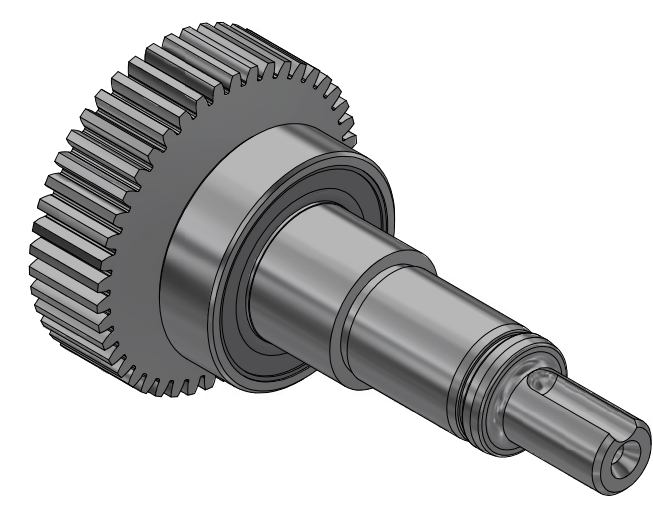
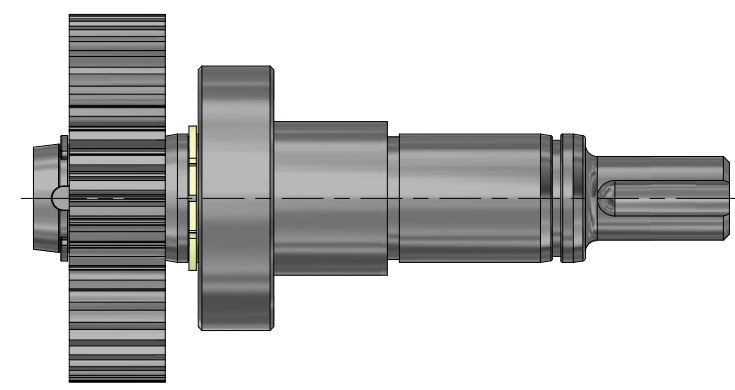
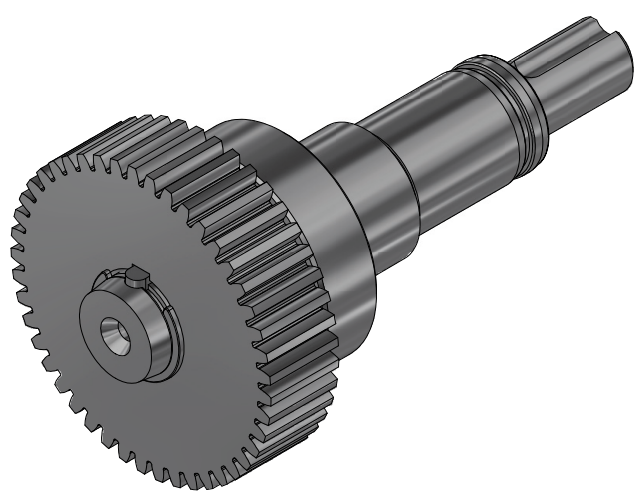
DWG NO  
**XM-82994**

REV  
**A**

SHEET 5 OF 5

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| 2                |     | DWG NO<br>603-D30/A                      | SH<br>1    | REV<br>A | 1 |
|------------------|-----|--|------------|----------|---|
| REVISION HISTORY |     |  |            |          |   |
| ZONE             | REV | DESCRIPTION                              | DATE       | APPROVED |   |
| ALL              | A   | ECO-25009, INITIAL RELEASE TO PRODUCTION | 03/26/2025 | ISD      |   |



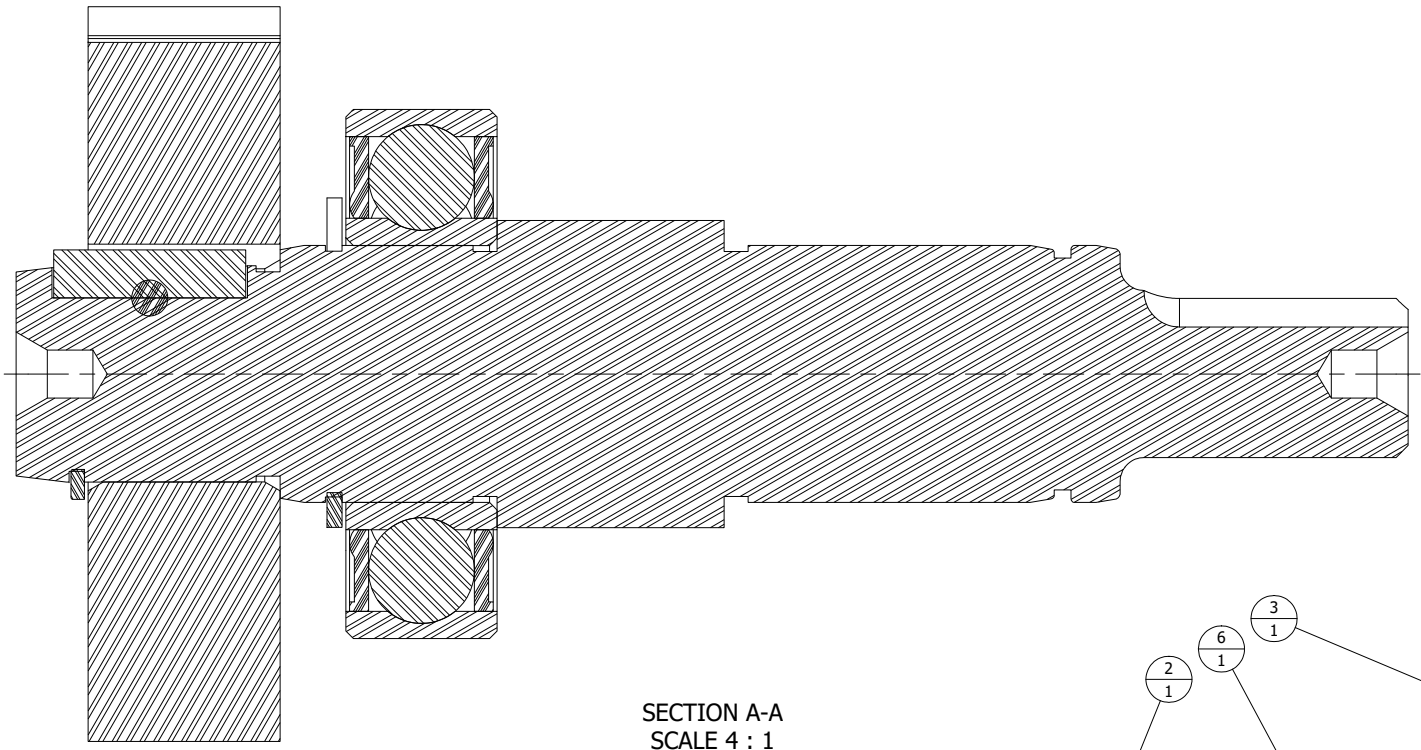
[Return to Table of Contents](#)

1. THE BALLOON SYMBOL,  $\Theta$ , CONTAINS THE REFERENCE NUMBER (REF NO) AND QUANTITY (QTY) OF A SPECIFIED COMPONENT IN THIS ASSY. THE UPPER DIGIT IS THE REF NO AND THE LOWER DIGIT IS THE QTY REQUIRED FOR THIS ASSY.

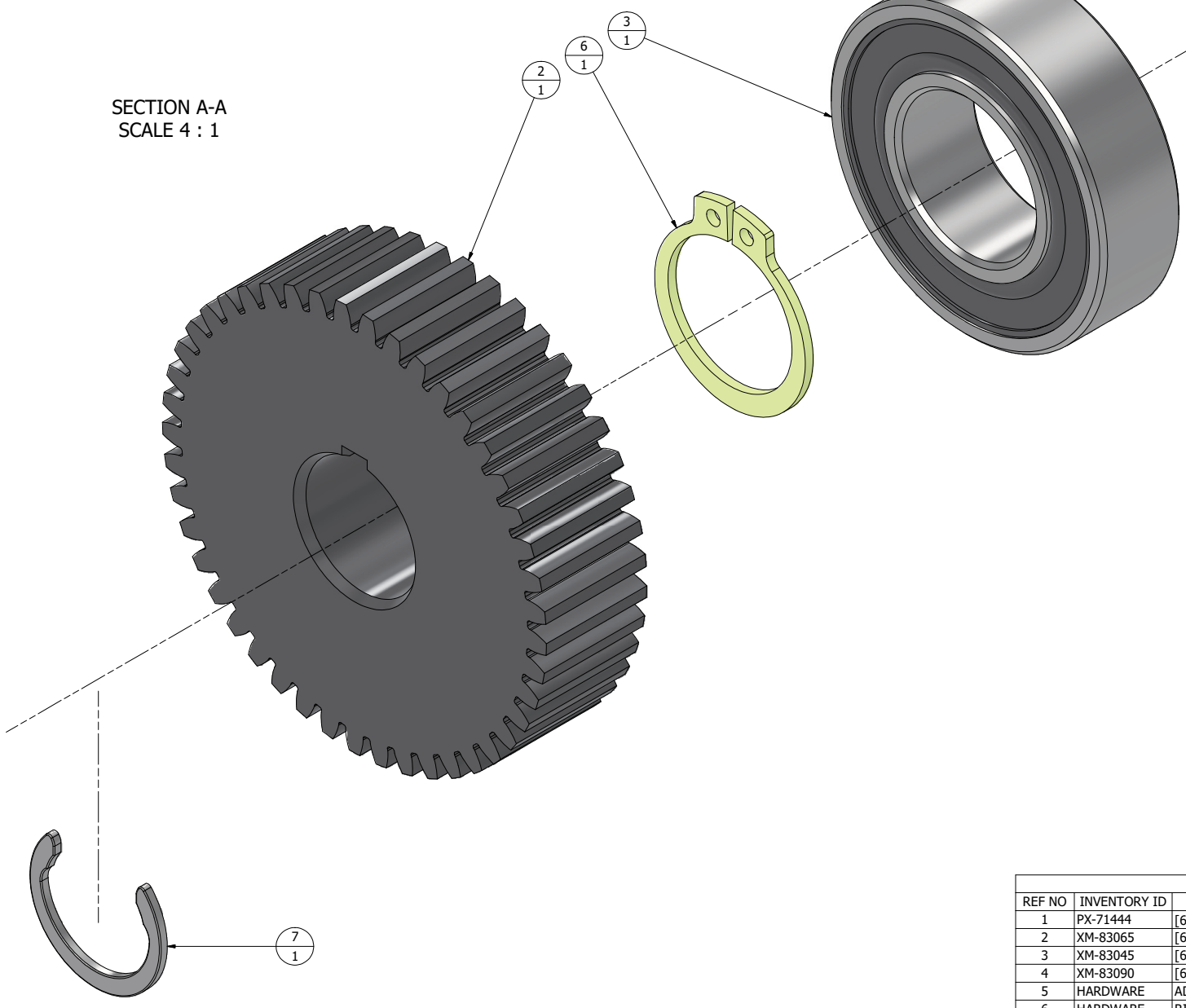
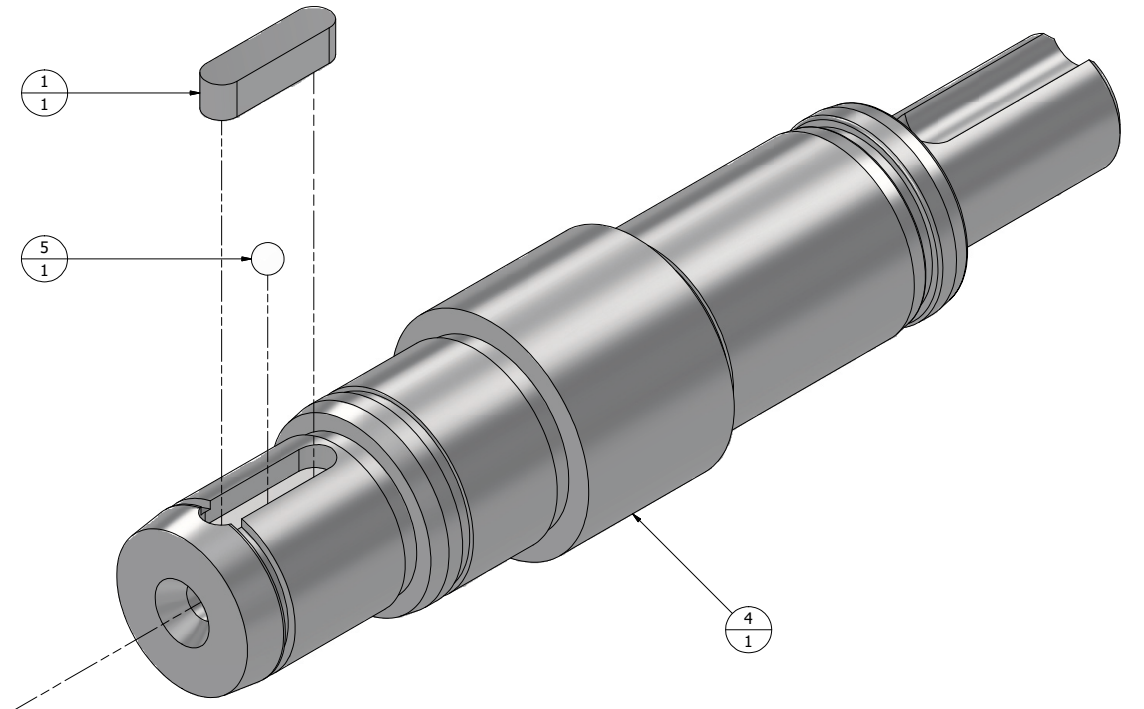
NOTES (UNLESS OTHERWISE SPECIFIED):

|  |                          |              |            |   |          |
|--|--------------------------|--------------|------------|---|----------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009 |                          | DRAWN<br>ISD | 03/26/2025 | DEMTECH Services, Inc.<br>Placerville, California |          |
| STANDARD TOLERANCES  |                          | CHECKED      |            | TITLE   |          |
| DECIMALS   | SURFACE FINISH 63/       | QA           |            | [603-D30/A] ASSY, OUTPUT SHAFT W/SPUR GEAR        |          |
| XX ± .02   | ANGLES ± 1°              | MFG          |            | SIZE  | DWG NO   |
| XXX ± .005   | FRACTIONS ± 1/16         | APPROVED     |            | D   | XM-82993 |
| MATERIAL   | SEE NOTES AND PARTS LIST |              |            | SCALE   | REV      |
| FINISH   | N/A                      |              |            | 2:1   | A        |
| DO NOT SCALE DRAWING   |                          |              |            | SHEET 1 OF 2                                      |          |

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SECTION A-A  
 SCALE 4 : 1



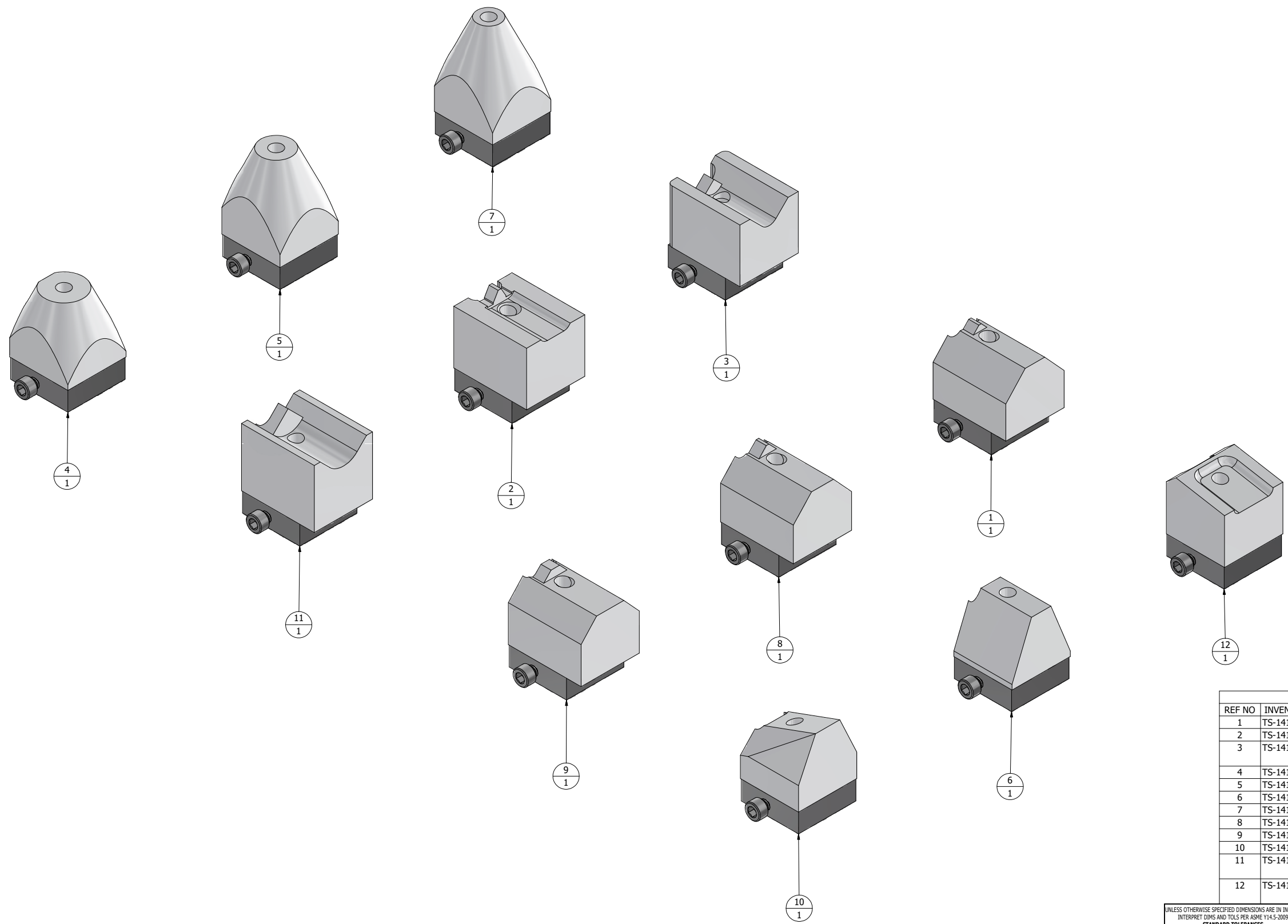
[Return to Table of Contents](#)

| PARTS LIST |              |   |     |
|------------|--------------|---|-----|
| REF NO     | INVENTORY ID | DESCRIPTION   | QTY |
| 1          | PX-71444     | [600-D31K] KEY, LARGE GEAR TO OUTPUT SHAFT                                    | 1   |
| 2          | XM-83065     | [603-D12] SPUR GEAR, PRO-XMv2   | 1   |
| 3          | XM-83045     | [603-D17] BEARING, OUTPUT SHAFT, PRO-XMv2                                     | 1   |
| 4          | XM-83090     | [603-D30] OUTPUT SHAFT, PRO-XMv2  | 1   |
| 5          | HARDWARE     | ADHESIVE, INSTANT LIQUID, CLEAR   | 1   |
| 6          | HARDWARE     | RING, RETAINING, EXTERNAL, 17mm SHAFT, ZINC-CHROMATE 1060-1090 SPRING STEEL   | 1   |
| 7          | HARDWARE     | RING, RETAINING, EXTERNAL LOW-CLEARANCE, 9/16" SHAFT, 15-7 PH STAINLESS STEEL | 1   |

|   |                    |          |
|---|--------------------|----------|
| DEMTECH Services, Inc.<br>Placerville, California   |                    |          |
| TITLE<br>[603-D30/A] ASSY, OUTPUT SHAFT W/SPUR GEAR |                    |          |
| SIZE<br>D   | DWG NO<br>XM-82993 | REV<br>A |
| SCALE<br>4:1  | SHEET 2 OF 2       |          |

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| 2                | DWG NO<br>DOC-0020 | SH<br>1                   | REV<br>A   | 1        |
|------------------|--------------------|---------------------------|------------|----------|
| REVISION HISTORY |                    |                           |            |          |
| ZONE             | REV                | DESCRIPTION               | DATE       | APPROVED |
| ALL              | A                  | DOC-0020, INITIAL RELEASE | 08/06/2025 | FRK      |



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| PARTS LIST |              |   |     |
|------------|--------------|---|-----|
| REF NO     | INVENTORY ID | DESCRIPTION   | QTY |
| 1          | TS-14113     | [TS-605-0174/A] ASSY, SHOE, FILLET, FOR 5-8MM (3/16"- 5/16") SHEET THICKNESS        | 1   |
| 2          | TS-14114     | [TS-605-0184/A] ASSY, SHOE, V-SEAM, FOR 10MM (3/8") SHEET THICKNESS                 | 1   |
| 3          | TS-14115     | [TS-605-0196/A] ASSY, SHOE, CORNER, OUTSIDE, FOR 10MM(3/8") SHEET THICKNESS         | 1   |
| 4          | TS-14116     | [TS-605-0337/A] ASSY, SHOE, CONE, 25MM (1") DIAMETER                                | 1   |
| 5          | TS-14117     | [TS-605-0366/A] ASSY, SHOE, CONE, 20MM (3/4") DIAMETER                              | 1   |
| 6          | TS-14118     | [TS-605-0500/A] ASSY, SHOE, CORNER, INSIDE, FOR 12MM (1/2") SHEET THICKNESS         | 1   |
| 7          | TS-14119     | [TS-605-0600/A] ASSY, SHOE, CONE, 15MM (5/8") DIAMETER                              | 1   |
| 8          | TS-14120     | [TS-605-0829/A] ASSY, SHOE, FILLET FOR 10MM (3/8") SHEET THICKNESS                  | 1   |
| 9          | TS-14121     | [TS-605-0830/A] ASSY, SHOE, FILLET, FOR 12MM (1/2") SHEET THICKNESS                 | 1   |
| 10         | TS-14123     | [TS-605-0837.3/A] ASSY, SHOE, 3 BEAD, 5/8" (15MM), SLANT                            | 1   |
| 11         | TS-14124     | [TS-605-0838/A] ASSY, SHOE, CORNER, OUTSIDE, FOR 12MM (1/2") SHEET THICKNESS        | 1   |
| 12         | TS-14125     | [TS-605-60/A] ASSY, TEFLON SHOE, Overlap, For 1.0-2.0mm (40-80 mil) Sheet Thickness | 1   |

1. THE BALLOON SYMBOL,  $\Theta$ , CONTAINS THE REFERENCE NUMBER (REF NO) AND QUANTITY (QTY) OF A SPECIFIED COMPONENT IN THIS ASSY. THE UPPER DIGIT IS THE REF NO AND THE LOWER DIGIT IS THE QTY REQUIRED FOR THIS ASSY.

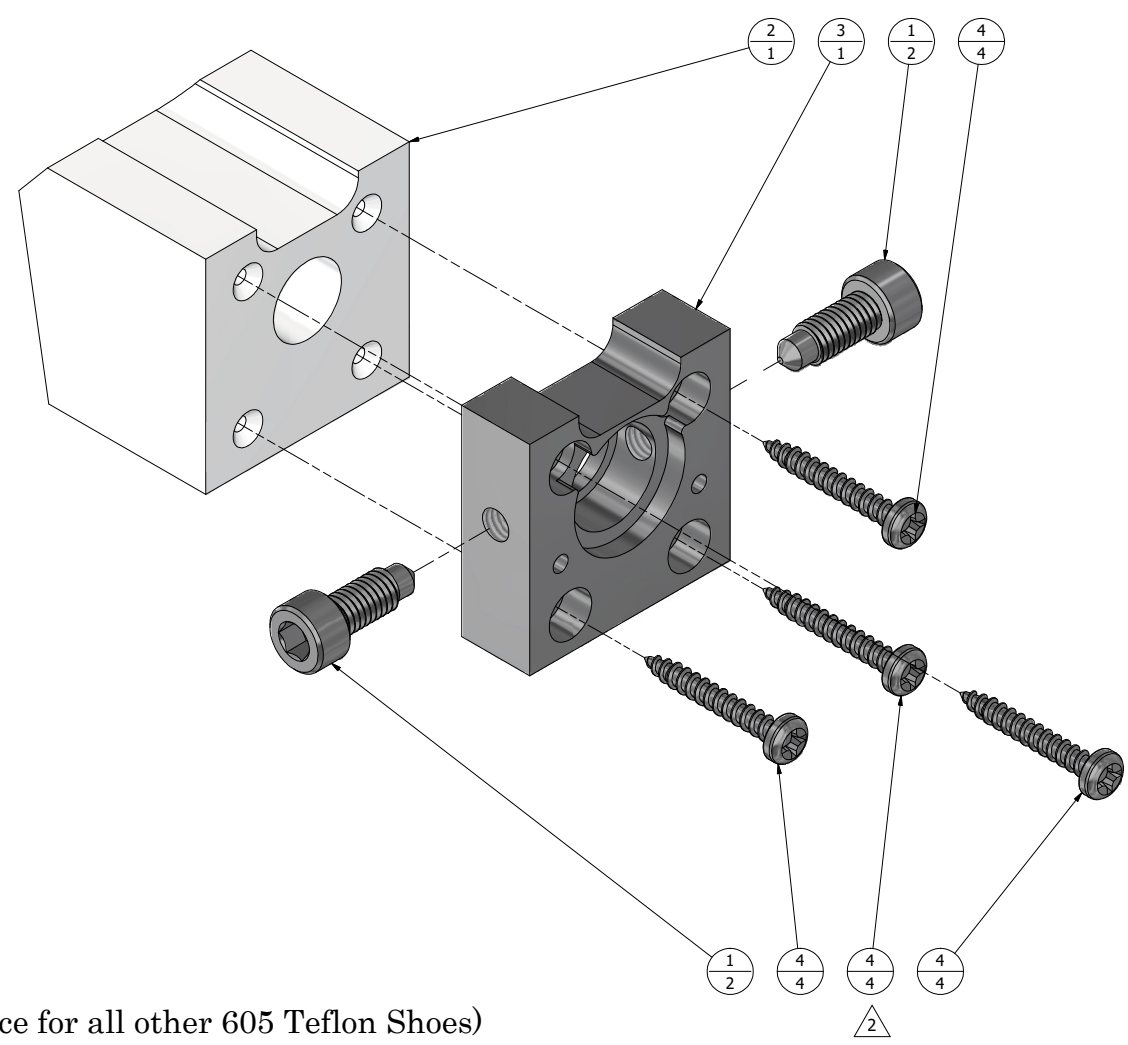
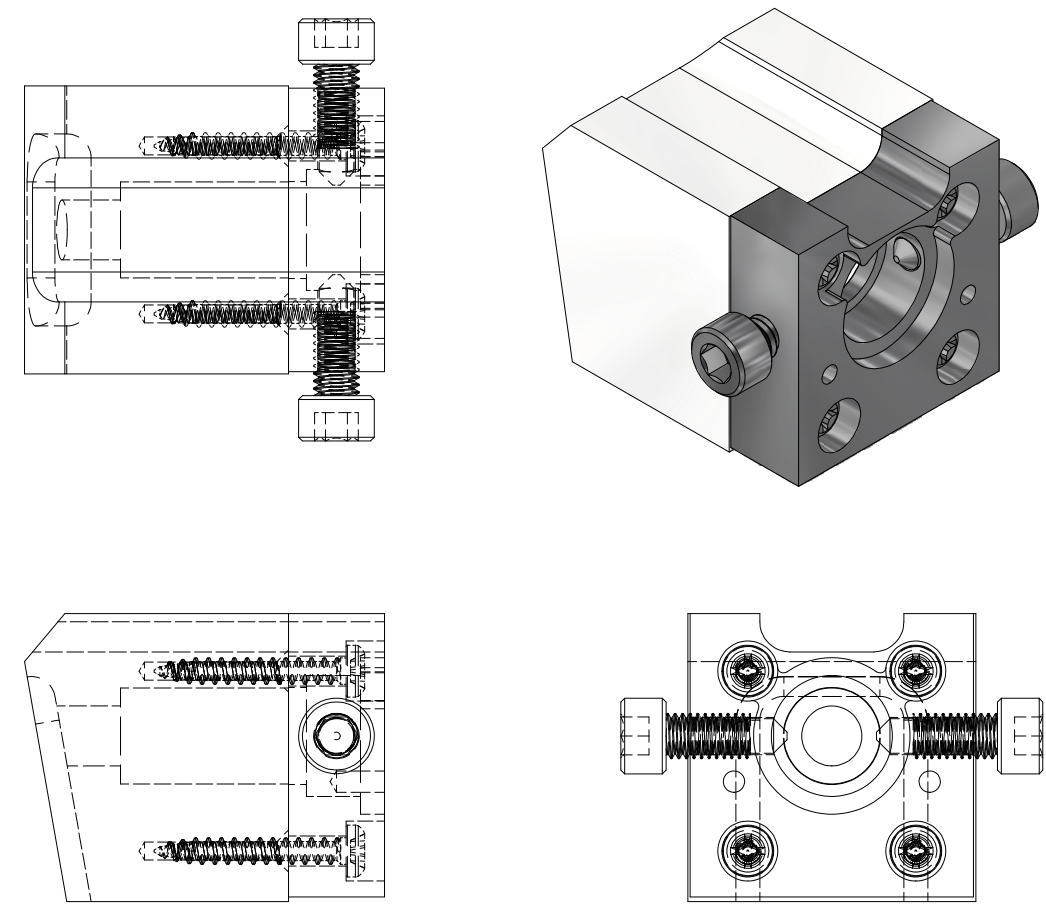
NOTES (UNLESS OTHERWISE SPECIFIED):

|   |  |               |            |   |                    |
|---|--|---------------|------------|---|--------------------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009            |  | DRAWN<br>FRK  | 08/06/2025 | DEMTECH Services, Inc.<br>Placerville, California     |                    |
| STANDARD TOLERANCES<br>DECIMALS .02 SURFACE FINISH 63/<br>XX ± .02 ANGLES ± 1°<br>XXX ± .005 FRACTIONS ± 1/16 |  | CHECKED<br>QA |            | TITLE<br>[TS-605-XXXXX] ASSY'S, OPTIONAL TEFLON SHOES |                    |
| MATERIAL<br>SEE PARTS LIST  |  | MFG           |            | SIZE<br>D   | DWG NO<br>DOC-0020 |
| FINISH<br>N/A   |  | APPROVED      |            | SCALE<br>1:1  | REV<br>A           |
| DO NOT SCALE DRAWING  |  |               |            | SHEET 1 OF 1  |                    |

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| 2                | DWG NO<br>TS-605-60/A | SH<br>1                                  | REV<br>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      |

All Teflon Shoe Assemblies take the same mount and hardware



(Assembly reference for all other 605 Teflon Shoes)

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| PARTS LIST |              |   |     |
|------------|--------------|---|-----|
| REF NO     | INVENTORY ID | 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   |
| 4          | HARDWARE     | SCREW, #6-13 X 1" LONG, PAN HEAD PHILLIPS, 410 STAINLESS STEEL              | 4   |

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

NOTES (UNLESS OTHERWISE SPECIFIED):

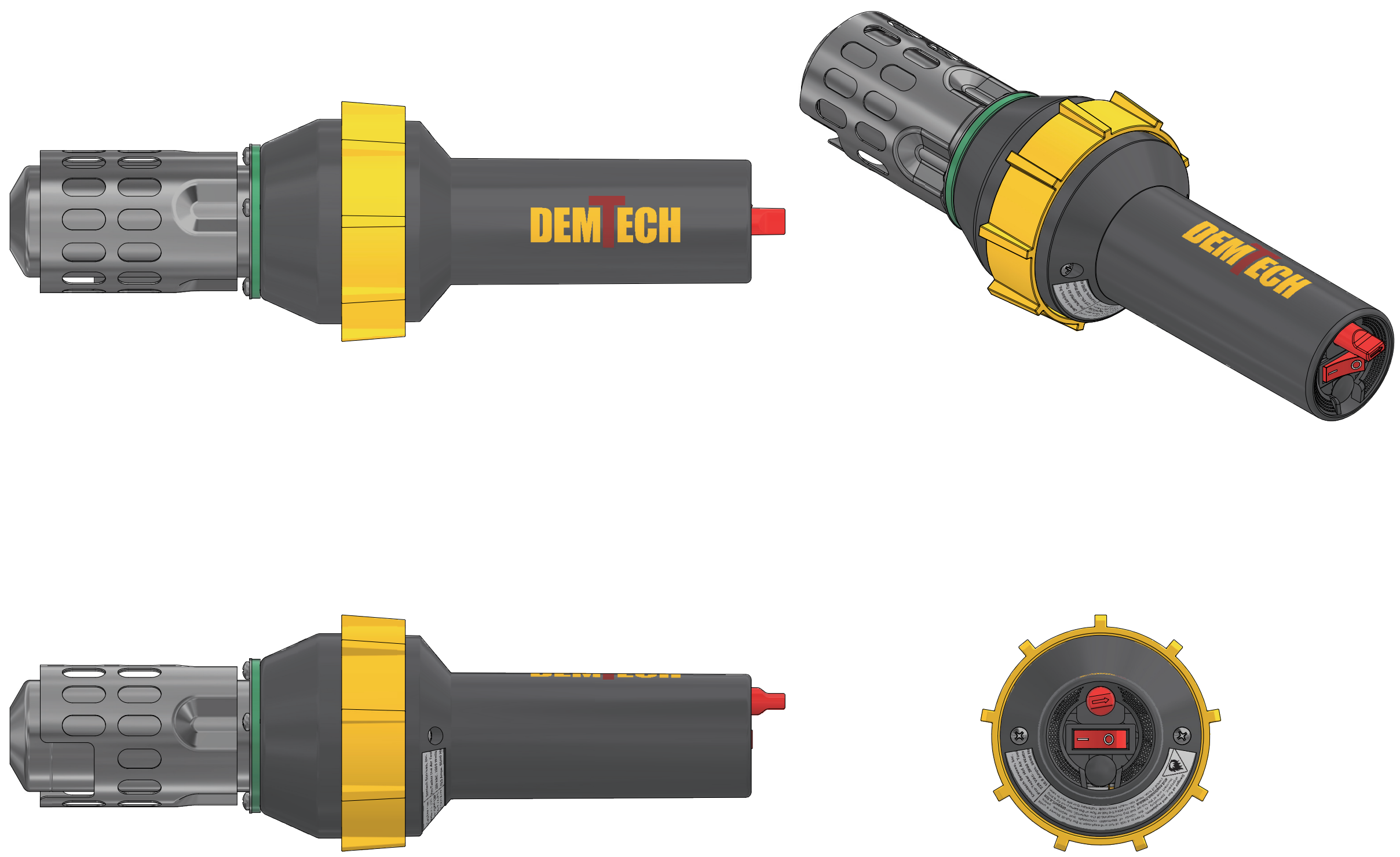
1. THE BALLOON SYMBOL, Θ, CONTAINS THE REFERENCE NUMBER (REF NO) AND QUANTITY (QTY) OF A SPECIFIED COMPONENT IN THIS ASSY. THE UPPER DIGIT IS THE REF NO AND THE LOWER DIGIT IS THE QTY REQUIRED FOR THIS ASSY.

NOTES (UNLESS OTHERWISE SPECIFIED):

|  |                    |              |            |   |          |
|--|--------------------|--------------|------------|---|----------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009 |                    | DRAWN<br>ISD | 06/17/2013 | DEMTECH Services, Inc.<br>Placerville, California   |          |
| STANDARD TOLERANCES  |                    | CHECKED      |            | TITLE   |          |
| DECIMALS   | SURFACE FINISH 63/ | QA           |            | [TS-605-60/A] ASSY, TEFLON SHOE,<br>Overlap, For 1.0-2.0mm (40-80 mil) Sheet<br>Thickness |          |
| XX ± .02   | ANGLES ± 1°        | MFG          |            | SIZE  | DWG NO   |
| XXX ± .005   | FRACTIONS ± 1/16   | APPROVED     |            | D   | TS-14125 |
| MATERIAL   |                    |              |            | REV   | B        |
| SEE PARTS LIST   |                    |              |            | SCALE   | 2:1      |
| FINISH   |                    |              |            | SHEET 1 OF 1  |          |
| N/A  |                    |              |            |   |          |
| DO NOT SCALE DRAWING   |                    |              |            |   |          |

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| DWG NO           |     | SH   | REV        | 1        |  |
|------------------|-----|--|------------|----------|--|
| XM-71460         |     | 1  | B          |          |  |
| REVISION HISTORY |     |  |            |          |  |
| ZONE             | REV | DESCRIPTION  | DATE       | APPROVED |  |
| ALL              | A   | INITIAL RELEASE TO PRODUCTION  | 03/30/2021 | ODM      |  |
| ALL              | B   | ECO-24001, RELEASE DRAWING TO PRODUCTION, REPLACE A-6101772 WITH PRT-75055 | 01/03/2024 | ODM      |  |



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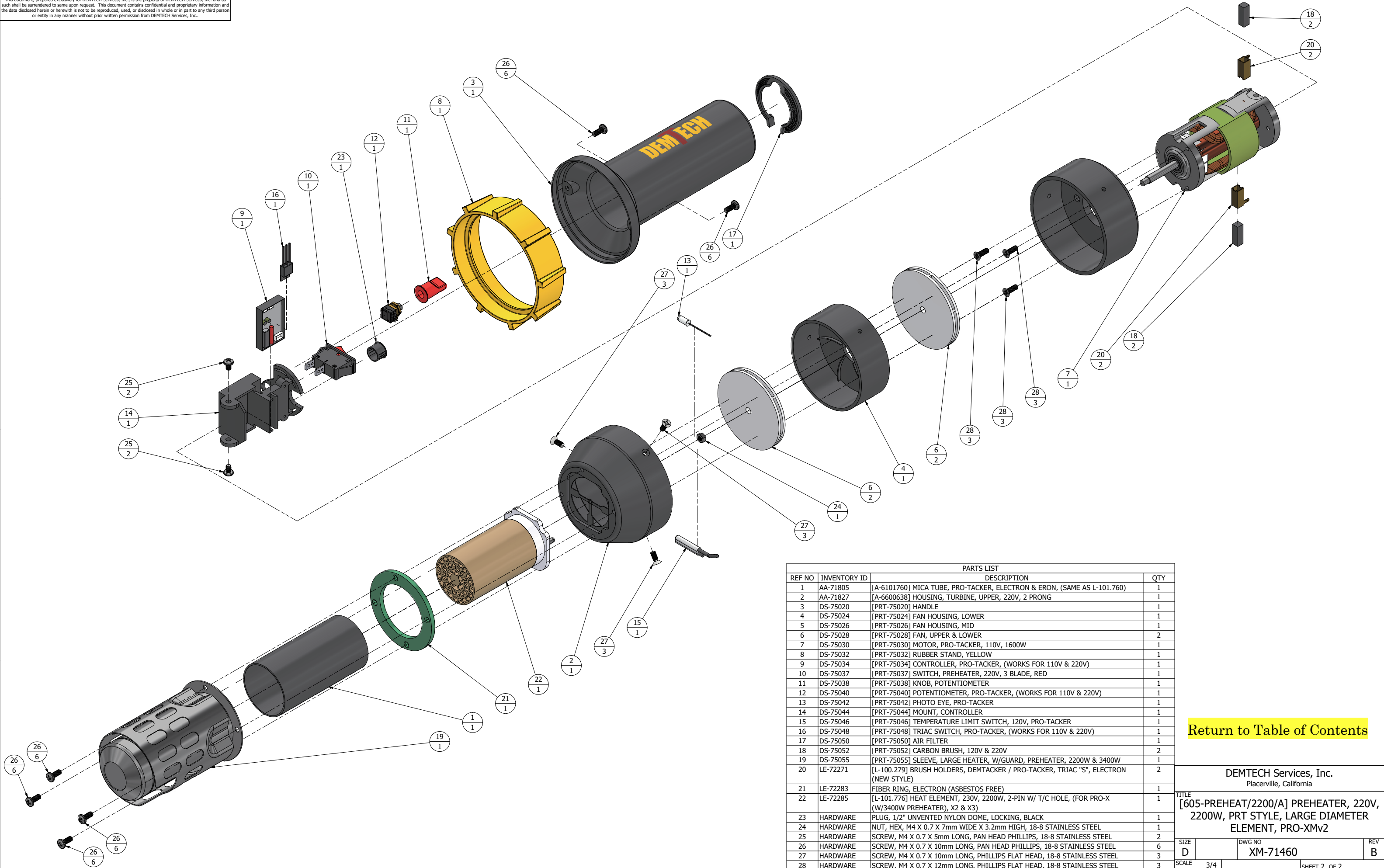
1. THE BALLOON SYMBOL,  $\Theta$ , CONTAINS THE REFERENCE NUMBER (REF NO) AND QUANTITY (QTY) OF A SPECIFIED COMPONENT IN THIS ASSY. THE UPPER DIGIT IS THE REF NO AND THE LOWER DIGIT IS THE QTY REQUIRED FOR THIS ASSY.

NOTES (UNLESS OTHERWISE SPECIFIED):

|  |                                |              |            |  |          |
|--|--------------------------------|--------------|------------|--|----------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>INTERPRET DIMS AND TOLS PER ASME Y14.5-2009 |                                | DRAWN<br>ODM | 03/30/2021 | DEMTECH Services, Inc.<br>Placerville, California  |          |
| STANDARD TOLERANCES  |                                | CHECKED      |            | TITLE  |          |
| DECIMALS   | SURFACE FINISH 63/<br>XX ± .02 | QA           |            | [605-PREHEAT/2200/A] PREHEATER, 220V,<br>2200W, PRT STYLE, LARGE DIAMETER<br>ELEMENT, PRO-XMv2 |          |
| ANGLES ± 1°  | FRACTIONS ± 1/16               | MFG          |            | SIZE   | DWG NO   |
| MATERIAL   | SEE PARTS LIST                 | APPROVED     |            | D  | XM-71460 |
| FINISH   | N/A                            |              |            | SCALE  | REV      |
| DO NOT SCALE DRAWING   |                                |              |            | 1:1  | B        |
|  |                                |              | 2          | SHEET 1 OF 2   |          |



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| PARTS LIST |              |  |     |
|------------|--------------|--|-----|
| REF NO     | INVENTORY ID | DESCRIPTION  | QTY |
| 1          | AA-71805     | [A-6101760] MICA TUBE, PRO-TACKER, ELECTRON & ERON, (SAME AS L-101.760)                            | 1   |
| 2          | AA-71827     | [A-6600638] HOUSING, TURBINE, UPPER, 220V, 2 PRONG   | 1   |
| 3          | DS-75020     | [PRT-75020] HANDLE   | 1   |
| 4          | DS-75024     | [PRT-75024] FAN HOUSING, LOWER   | 1   |
| 5          | DS-75026     | [PRT-75026] FAN HOUSING, MID   | 1   |
| 6          | DS-75028     | [PRT-75028] FAN, UPPER & LOWER   | 2   |
| 7          | DS-75030     | [PRT-75030] MOTOR, PRO-TACKER, 110V, 1600W   | 1   |
| 8          | DS-75032     | [PRT-75032] RUBBER STAND, YELLOW   | 1   |
| 9          | DS-75034     | [PRT-75034] CONTROLLER, PRO-TACKER, (WORKS FOR 110V & 220V)  | 1   |
| 10         | DS-75037     | [PRT-75037] SWITCH, PREHEATER, 220V, 3 BLADE, RED  | 1   |
| 11         | DS-75038     | [PRT-75038] KNOB, POTENTIOMETER  | 1   |
| 12         | DS-75040     | [PRT-75040] POTENTIOMETER, PRO-TACKER, (WORKS FOR 110V & 220V)                                     | 1   |
| 13         | DS-75042     | [PRT-75042] PHOTO EYE, PRO-TACKER  | 1   |
| 14         | DS-75044     | [PRT-75044] MOUNT, CONTROLLER  | 1   |
| 15         | DS-75046     | [PRT-75046] TEMPERATURE LIMIT SWITCH, 120V, PRO-TACKER   | 1   |
| 16         | DS-75048     | [PRT-75048] TRIAC SWITCH, PRO-TACKER, (WORKS FOR 110V & 220V)                                      | 1   |
| 17         | DS-75050     | [PRT-75050] AIR FILTER   | 1   |
| 18         | DS-75052     | [PRT-75052] CARBON BRUSH, 120V & 220V  | 2   |
| 19         | DS-75055     | [PRT-75055] SLEEVE, LARGE HEATER, W/GUARD, PREHEATER, 2200W & 3400W                                | 1   |
| 20         | LE-72271     | [L-100.279] BRUSH HOLDERS, DEMENTACKER / PRO-TACKER, TRIAC "S", ELECTRON (NEW STYLE)               | 2   |
| 21         | LE-72283     | FIBER RING, ELECTRON (ASBESTOS FREE)   | 1   |
| 22         | LE-72285     | [L-101.776] HEAT ELEMENT, 230V, 2200W, 2-PIN W/ T/C HOLE, (FOR PRO-X (W/3400W PREHEATER), X2 & X3) | 1   |
| 23         | HARDWARE     | PLUG, 1/2" UNVENTED NYLON DOME, LOCKING, BLACK   | 1   |
| 24         | HARDWARE     | NUT, HEX, M4 X 0.7 X 7mm WIDE X 3.2mm HIGH, 18-8 STAINLESS STEEL                                   | 1   |
| 25         | HARDWARE     | SCREW, M4 X 0.7 X 5mm LONG, PAN HEAD PHILLIPS, 18-8 STAINLESS STEEL                                | 2   |
| 26         | HARDWARE     | SCREW, M4 X 0.7 X 10mm LONG, PAN HEAD PHILLIPS, 18-8 STAINLESS STEEL                               | 6   |
| 27         | HARDWARE     | SCREW, M4 X 0.7 X 10mm LONG, PHILLIPS FLAT HEAD, 18-8 STAINLESS STEEL                              | 3   |
| 28         | HARDWARE     | SCREW, M4 X 0.7 X 12mm LONG, PHILLIPS FLAT HEAD, 18-8 STAINLESS STEEL                              | 3   |

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DEMTECH Services, Inc.  
 Placerville, California

TITLE  
**[605-PREHEAT/2200/A] PREHEATER, 220V, 2200W, PRT STYLE, LARGE DIAMETER ELEMENT, PRO-XMv2**

SIZE D DWG NO XM-71460 REV B

SCALE 3/4 SHEET 2 OF 2