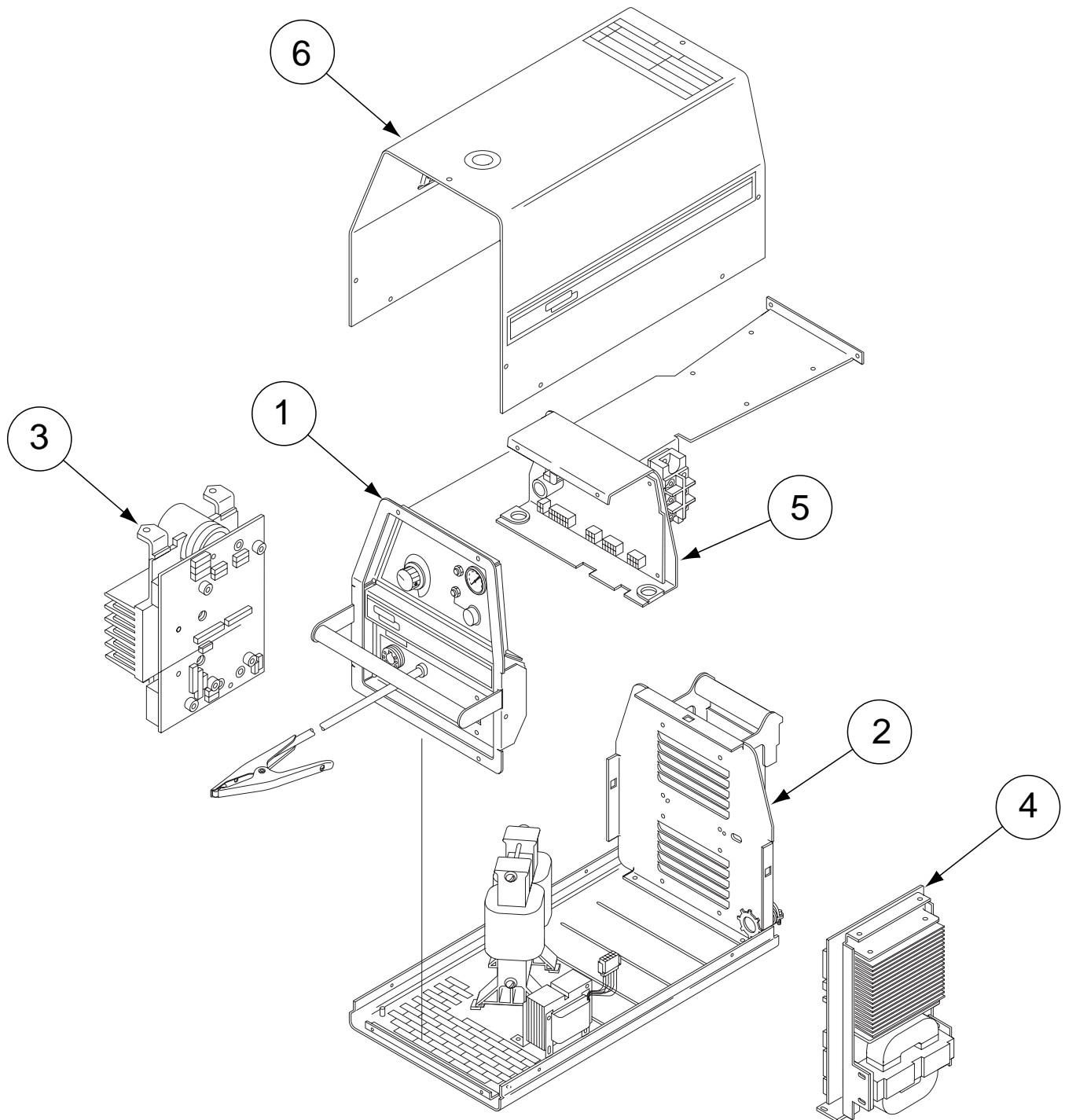


# PARTS LIST FOR VIPER

VIPER



# ILLUSTRATION OF SUB-ASSEMBLIES



# VIPER

## For Codes: 10597 to 10635

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	6	
SUB ASSEMBLY PAGE NAME →	Optional Equipment	Miscellaneous Items	Case Front Assembly	Base & Case Back	Power Board Heat Sink Assembly	Output Board Heatsink Assembly	Center Panel Assembly	Wraparound Assembly	HF-Less Plasma Torch
PAGE NO. →	P336-B.1	P336-B.2	P336-C	P336-D	P336-E	P336-F	P336-G	P336-H	P210-K
CODE NO. ↓									
10597 (208/230/460/1/3/50/60) (Domestic)		1	1	1	1	1	1	1	1
10635 (460/575/3/50/60) (Canadian)		1	1	1	2	1	2	2	1



# OPTIONAL EQUIPMENT LISTING

Miscellaneous Options Available for your machine are listed below:

# Indicates a change this printing.

DESCRIPTION .....	PART NUMBER
HF-Less Plasma Cutting Torch 25' .....	Order K1571-1
HF-Less Plasma Cutting Torch 50' .....	Order K1571-2
Undercarriage .....	Order K1600-2
Combination Circle Kit .....	Order K1625-1
Adapter Bushing 38 mm .....	Order K1626-1
Suction Pivot .....	Order K1628-1

#



# Indicates a change this printing.

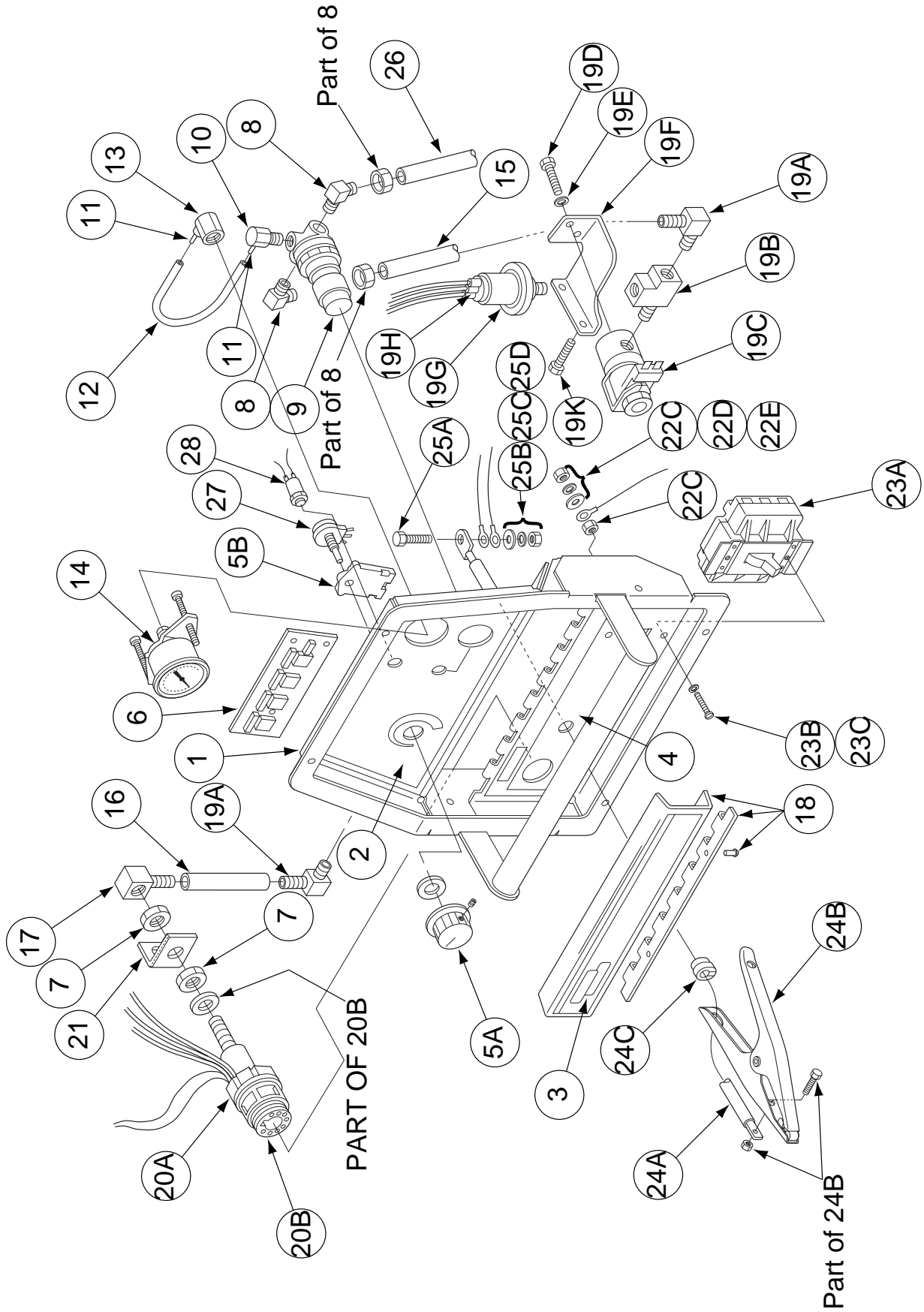
Use only the parts marked "x" in the column under the heading number called for in the model index page.

\* Recommended Spare Part

DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
Plug & Lead Assembly (P2-P40)	S18250-520	1	X								
Plug & Lead Assembly (P3-P20-P32-P33)	S18250-522	1	X								
Plug & Lead Assembly (P5-P10)	S18250-523	1	X								
Plug & Lead Assembly (P4)	S18250-524	1	X								
Plug & Lead Assembly (P1-P21-P30)	S18250-525	1	X								
Primary Harness	L10988	1	X								



# Case Front Assembly



# Indicates a change this printing.

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

Recommended Spare Parts are Highlighted in Bold

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
	Case Front Assembly, Includes: (Item 1 thru 22E)	L10944-1	1	X								
1	Case Front Welded Assembly	M19171-1	1	X								
2	Nameplate	L10996-1	1	X								
3	Nameplate	L10996-2	1	X								
4	Nameplate	L10996-3	1	X								
5A	Knob	T10491	1	X								
5B	Control Pot Spacer	S18280	1	X								
<b>6</b>	<b>Display P.C. Board</b>	<b>L10721-[ ]</b>	<b>1</b>	<b>X</b>								
7	Hex Nut, Brass	S22990-2B	1	X								
8	90° Male Hose Elbow	S18451-2	2	X								
<b>9</b>	<b>Pressure Regulator</b>	<b>S22184</b>	<b>1</b>	<b>X</b>								
10	Elbow	S22155	1	X								
11	Adapter	T14557-21	2	X								
12	Flex Tube	T10642-221	1	X								
13	Pipe Cap	S22154	1	X								
<b>14</b>	<b>Pressure Gauge</b>	<b>S11395-4</b>	<b>1</b>	<b>X</b>								
15	Flex Tube	T10642-220	1	X								
16	Flex Tube	T10642-221	1	X								
17	Hose Nipple	S23941	1	X								
18	Case Front Door	M19172-1	1	X								
	Rivet	T12584-4	4	X								
	<b>Spring</b>	<b>S24049-A</b>	<b>1</b>	<b>X</b>								
	Decal	S24060	1	X								
	Mounting Bracket	S24049-B	1	X								
<b>19</b>	<b>Solenoid Assembly, Includes: (Item 19A thru 19K)</b>	<b>S18667-7</b>	<b>1</b>	<b>X</b>								
19A	Male Elbow	T13442	2	X								
19B	Street Tee	T14130	1	X								
19C	<b>Solenoid Valve</b>	<b>S18667-7</b>	<b>1</b>	<b>X</b>								
19D	#10-32 Round Head Screw	CF000113	2	X								
19E	Lock Washer	T9695-1	2	X								
19F	Solenoid Bracket	S23864	1	X								
19G	Pressure Switch	S18638-2	1	X								
19H	Plug Housing	S18249-4	1	X								
19J	Filter Screen (Not Shown)	S20829	1	X								
19K	Self Tapping Screw	S8025-70	2	X								
20A	Bulkhead Nut	S22990-2A	1	X								
20B	Plug & Lead Assembly	S18250-521	1	X								
21	Rectifier Bracket Arm	T11655-6	1	X								
22A	Thread Forming Screw	S9225-17	1	X								
22B	Lock Washer	T9695-17	1	X								
22C	Hex Nut	CF000017	2	X								
22D	Plain Washer	S9262-98	2	X								
22E	Lock Washer	E106A-2	1	X								
<b>23A</b>	<b>Line Switch (Code 10597)</b>	<b>S20030-1</b>	<b>1</b>	<b>X</b>								
<b>23A</b>	<b>Line Switch (Code 10635)</b>	<b>S20030</b>	<b>1</b>	<b>X</b>								
23B	#6-32 x .50 Round Head Screw	CF000338	2	X								
23C	Lock Washer	T9695-1	2	X								
23D	Plain Washer (Not Shown)	S9262-3	2	X								
24A	Work Lead	S11609-24	1	X								
<b>24B</b>	<b>Ground Clamp</b>	<b>M12033</b>	<b>1</b>	<b>X</b>								

#



# Indicates a change this printing.

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

**Recommended Spare Parts are Highlighted in Bold**

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
24C	Split Strain Relief	T9274-2	1	X								
25A	1/4-20 x .750 Hex Head Cap Screw	CF000014	1	X								
25B	Plain Washer	S9262-98	1	X								
25C	Lock Washer	E106A-2	1	X								
25D	1/4-20 Hex Nut	CF000017	1	X								
26	Flex Tube	T10642-219	1	X								
<b>27</b>	<b>Potentiometer</b>	<b>T10812-112T</b>	<b>1</b>	<b>X</b>								
28	Push Button	T15089	2	X								

#

Note: When ordering new printed circuit boards indicate the dash number [ ] of the "Old" board that is to be replaced. This will aid Lincoln in supplying the correct and latest board along with any necessary jumpers or adapters. The dash number brackets [ ] have purposely been left blank so as to eliminate errors, confusion and updates.





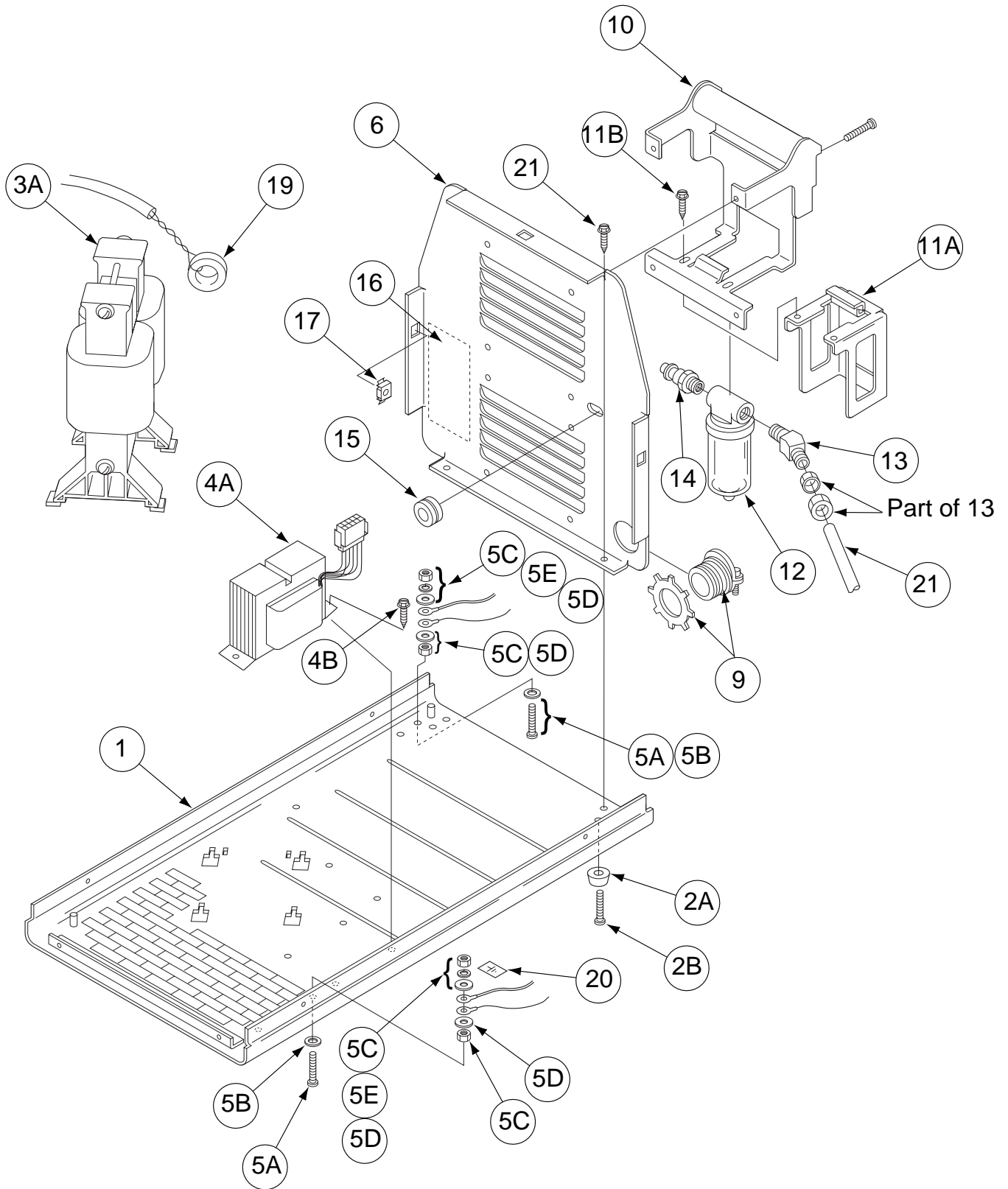
# NOTES

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VIPER



# Base & Case Back



# Indicates a change this printing.

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

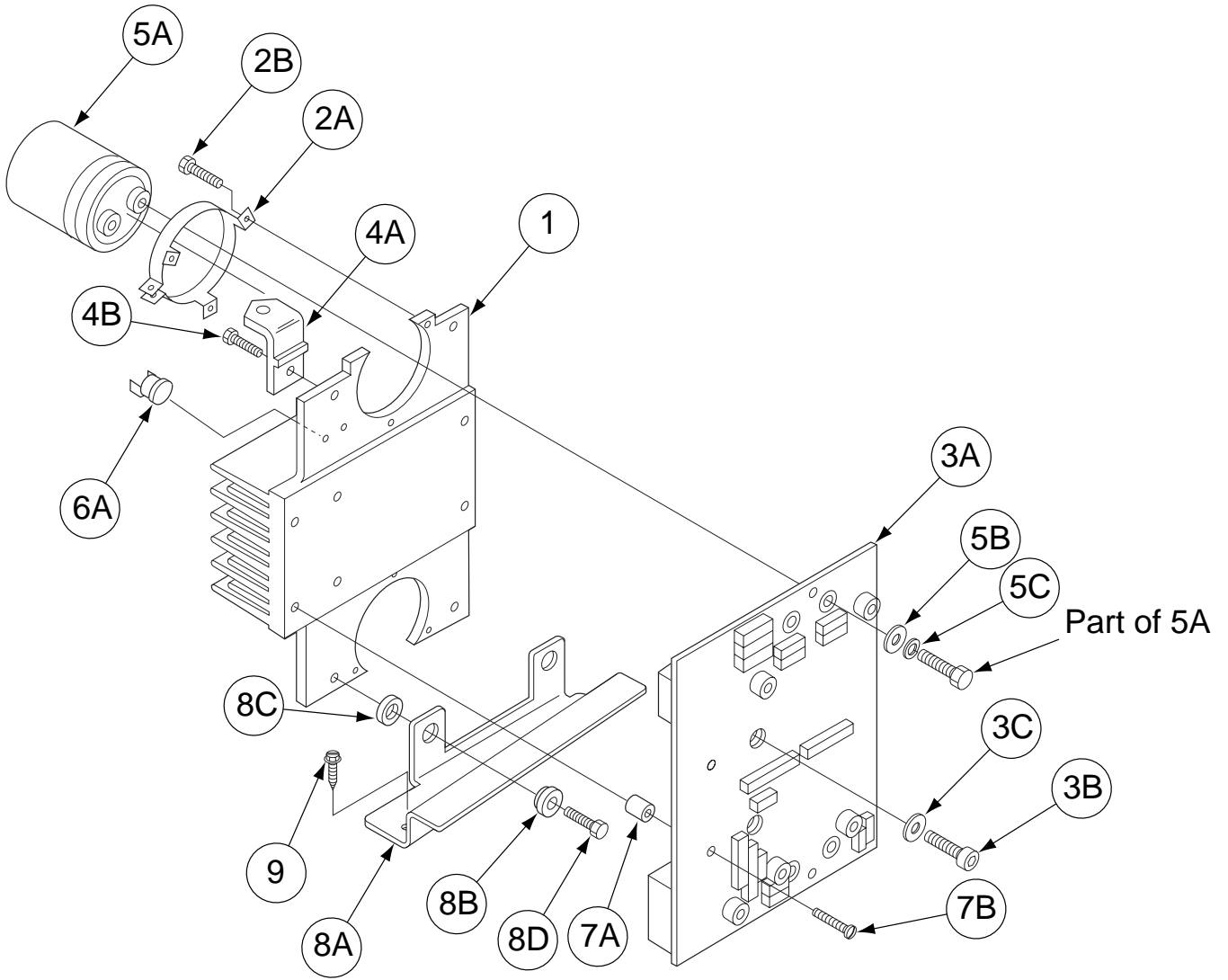
**Recommended Spare Parts are Highlighted in Bold**

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
1	Case Bottom Riveted Assembly	M18862-1	1	X								
2A	Foot	T14882-4	4	X								
2B	Thread Forming Screw	S9225-36	4	X								
<b>3A</b>	<b>Main Transformer Assembly</b>	<b>G3191</b>	<b>1</b>	<b>X</b>								
3B	Thread Forming Screw (Not Shown)	S9225-8	2	X								
<b>4A</b>	<b>Auxiliary Transformer Assembly</b>	<b>M16085-16</b>	<b>1</b>	<b>X</b>								
4B	Self Tapping Screw	S8025-70	4	X								
5A	Thread Forming Screw	S9225-17	1	X								
5B	Lock Washer	T9695-17	1	X								
5C	Hex Nut	CF000017	2	X								
5D	Plain Washer	S9262-98	2	X								
5E	Lock Washer	E106A-2	1	X								
	Case Back Assembly, Includes: (Item 6 thru 18)	M18804-1	1	X								
6	Case Back	L10162-1	1	X								
7	Dust Cover (Not Shown)	S21320	2	X								
<b>8A</b>	<b>Fan (Tubeaxial) (Not Shown)</b>	<b>S18977-3</b>	<b>2</b>	<b>X</b>								
8B	Self Tapping Screw (Not Shown)	S8025-98	8	X								
9	Box Connector	T9639-3	1	X								
10	Filter Bracket Assembly	M18808-1	1	X								
11A	Filter Guard	M18810-1	1	X								
11B	Self Tapping Screw	S8025-92	2	X								
<b>12</b>	<b>Air Filter, Includes:</b>	<b>S22183</b>	<b>1</b>	<b>X</b>								
	<b>Filter Element</b>	<b>S22183-A</b>	<b>1</b>	<b>X</b>								
13	Elbow, 45°	S23007	1	X								
14	Pneumatic Nipple	S23044	1	X								
15	Grommet	S10255-5	1	X								
16	Decal	T13086-86	1	X								
17	Nut Retainer	T10097-2	4	X								
18	Plug Button (Not Shown)	T10397-10	1	X								
<b>19</b>	<b>Current Transformer</b>	<b>S18444-4</b>	<b>1</b>	<b>X</b>								
20	Decal (Ground Connection)	T13260-4	1	X								
21	Flex Tube	T10642-222	1	X								
22	Rear Nameplate, (Not Shown) (Code 10597)	S23949	1	X								
22	Rear Nameplate, (Not Shown) (Code 10635)	S24326	1	X								

#



# Power Board Heat Sink Assembly



# Indicates a change this printing.

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

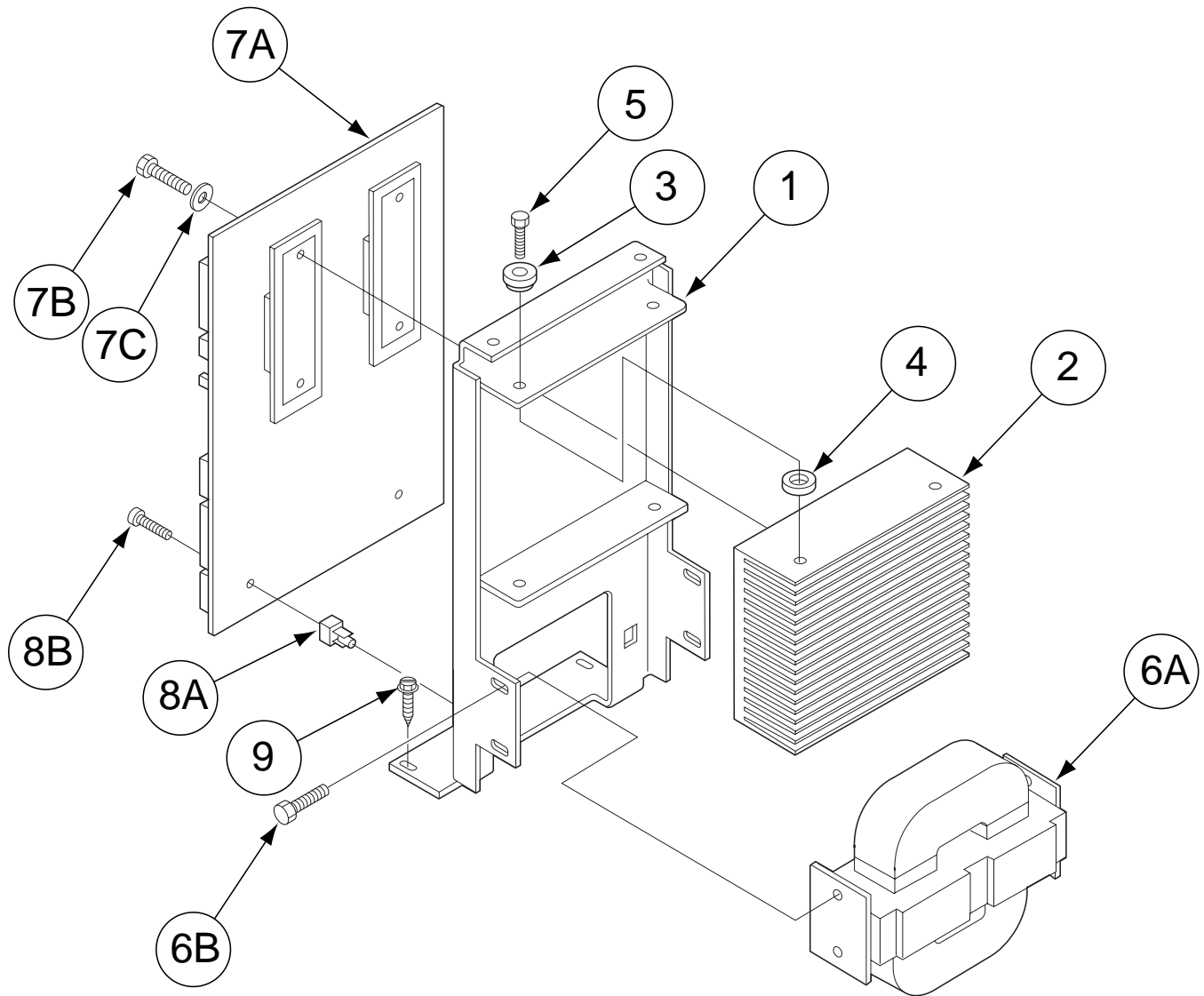
**Recommended Spare Parts are Highlighted in Bold**

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
	<b>Power Board Heatsink Assembly, Includes: Power Board Heatsink Assembly, Includes: (Item 1 thru 8D)</b>	<b>M18740 M18740</b>	<b>1 1</b>	<b>X • • X</b>								
<b>1</b>	<b>Power Board Heatsink</b>	<b>L10585</b>	<b>1</b>	<b>X X</b>								
2A	Capacitor Bracket	S18434-3	1	X X								
2B	Self Tapping Screw	S8025-76	6	X X								
2C	#10-24 x .75 Round Head Screw (Not Shown)	CF000072	2	X X								
2D	#10-24 Square Nut (Not Shown)	CF000154	2	X X								
<b>3A</b>	<b>Power Board</b>	<b>G3172-[ ]</b>	<b>1</b>	<b>X •</b>								
<b>3A</b>	<b>Power Board</b>	<b>G3508-[ ]</b>	<b>1</b>	<b>• X</b>								
3B	Socket Head Cap Screw	T9447-9	4	X X								
3C	Lock Washer	E106A-2	4	X X								
4A	Heatsink Holder	S22168	2	X X								
4B	Thread Forming Screw	S9225-8	2	X X								
<b>5A</b>	<b>Capacitor</b>	<b>S13490-160</b>	<b>2</b>	<b>X •</b>								
<b>5A</b>	<b>Capacitor</b>	<b>S13490-167</b>	<b>2</b>	<b>• X</b>								
5B	Plain Washer	S9262-23	8	X X								
5C	Lock Washer	E106A-2	4	X X								
<b>6A</b>	<b>Thermostat</b>	<b>T13359-13</b>	<b>1</b>	<b>X X</b>								
6B	Cell Insulation (Not Shown)	S14499-85	1	X X								
7A	Insulated Tubing	T7028-52	2	X X								
7B	#10-24 x .75 Round Head Screw	CF000072	2	X X								
8A	Power Board Bracket	M18863	1	X X								
8B	Insulator	T11267-A	2	X X								
8C	Insulator	T11267-B	2	X X								
8D	Thread Forming Screw	S9225-45	2	X X								
9	Thread Forming Screw	S9225-8	2	X X								

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# Output Board Heatsink Assembly



# Indicates a change this printing.

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

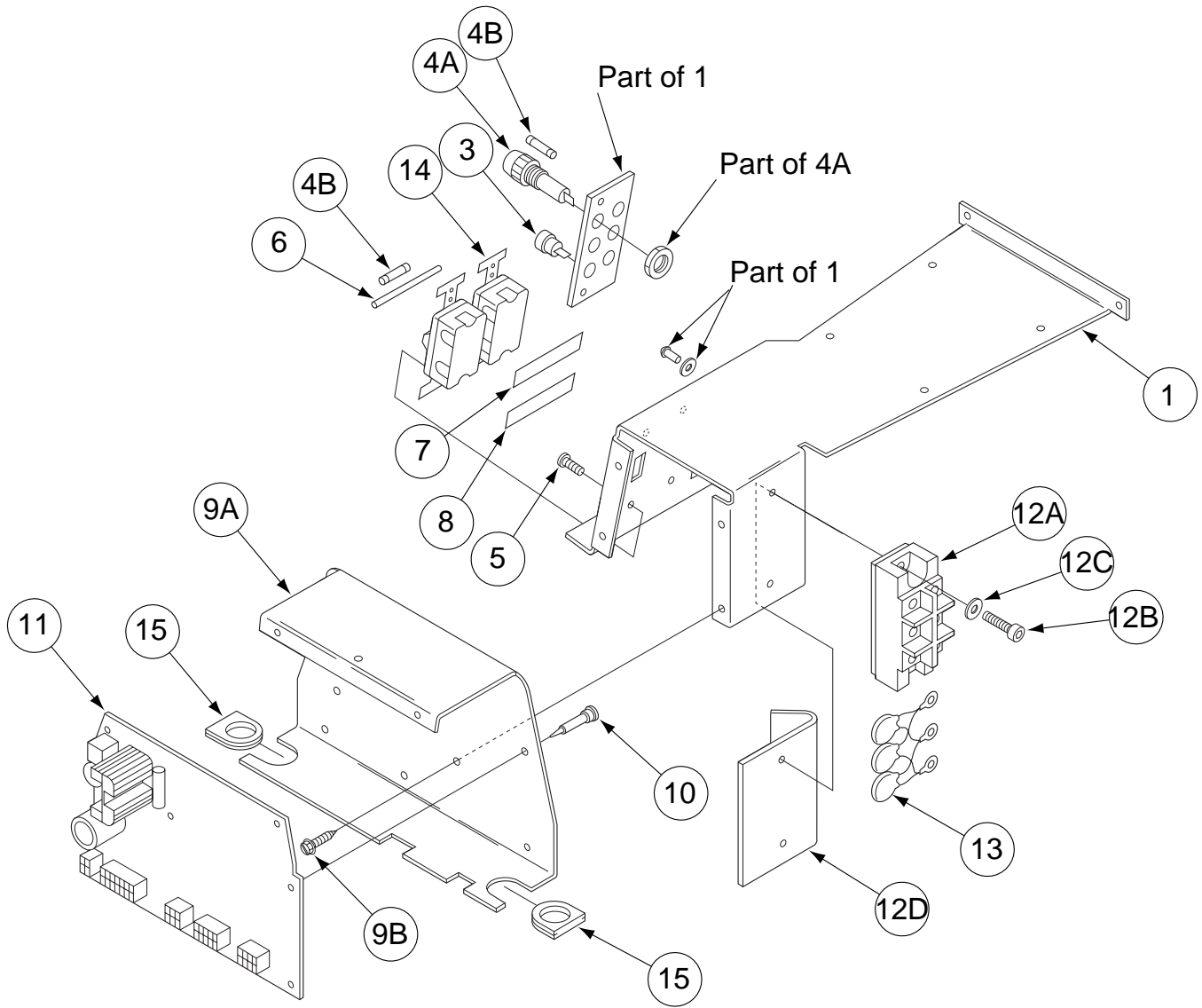
Recommended Spare Parts are Highlighted in Bold

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
	<b>Output Board Heatsink Assembly, Includes: (Item 1 thru 8B)</b>	<b>M18787</b>	<b>1</b>	<b>X</b>								
1	Output Bracket	M18311	1	X								
2	<b>Output Board Heatsink</b>	<b>M18786</b>	<b>1</b>	<b>X</b>								
3	Insulator	T11267-A	4	X								
4	Insulator	T11267-B	4	X								
5	Thread forming Screw	S9225-45	4	X								
6A	<b>Choke Assembly</b>	<b>L9157</b>	<b>1</b>	<b>X</b>								
6B	Thread Forming Screw	S9225-8	4	X								
7A	<b>Output PC Board Assembly</b>	<b>G3326-[ ]</b>	<b>1</b>	<b>X</b>								
7B	Socket Head Cap Screw	T9447-9	4	X								
7C	Lock Washer	E106A-2	4	X								
8A	PC Board Standoff	S14020-3	2	X								
8B	Self Tapping Screw	S8025-71	2	X								
9	Thread Forming Screw	S9225-8	2	X								

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# Center Panel Assembly





# Indicates a change this printing.

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

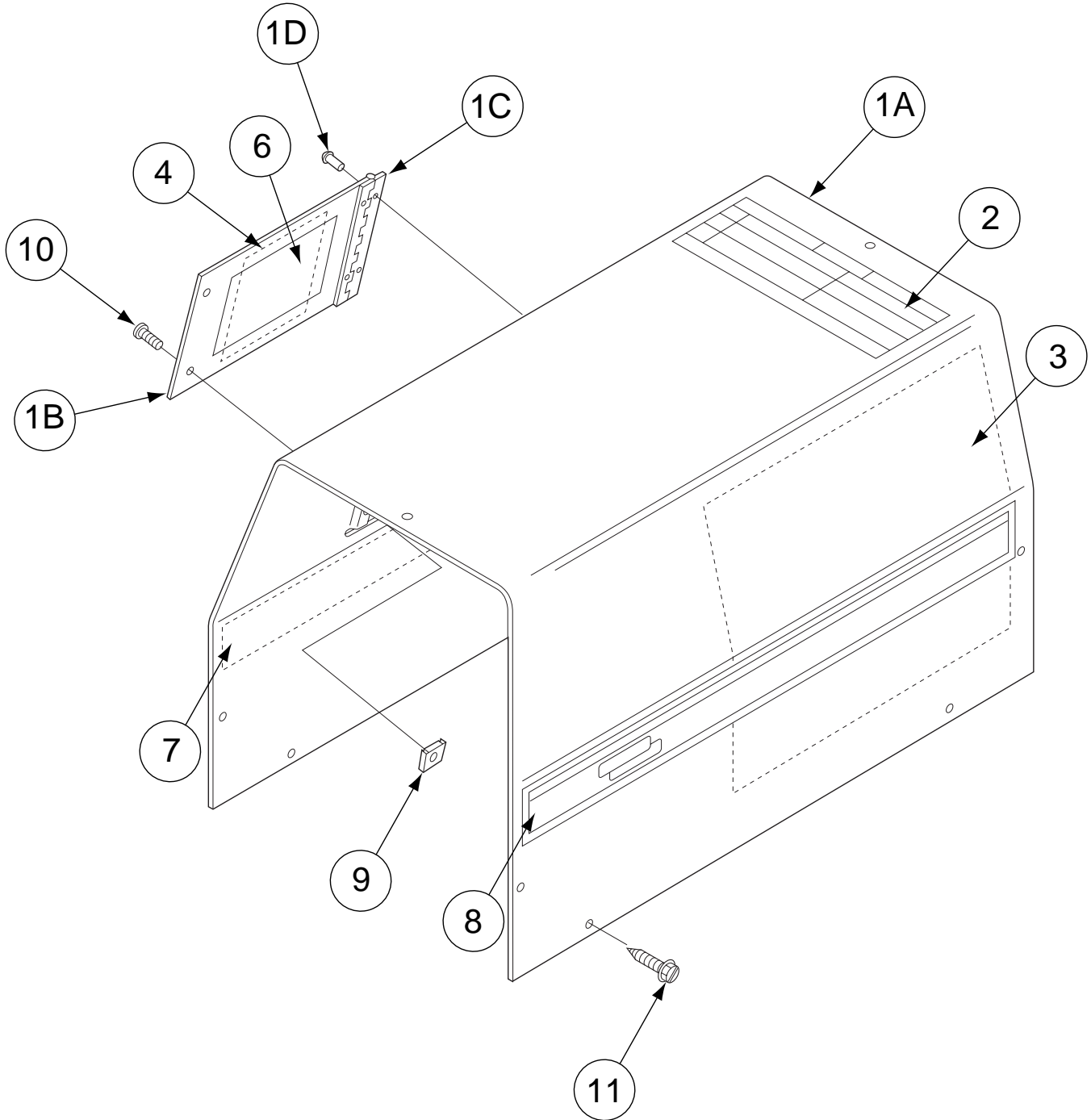
**Recommended Spare Parts are Highlighted in Bold**

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
	<b>Center Panel Assembly, Includes: (Item 1 thru 9B, Center Panel Assembly, Includes: (Item 1 thru 9B, 12A thru 13)</b>	<b>M19238</b> <b>M19079</b>	<b>1</b> <b>1</b>	<b>X</b> <b>•</b>	<b>•</b> <b>X</b>							
<b>1</b>	<b>Center Panel &amp; Reconnect Panel Riveted Assembly, Includes:</b> Reconnect Panel Rivet Plain Washer	<b>M18803-A</b>  S20937 T9701-4 S9262-39	<b>1</b>  1 2 2	<b>X</b>  X X X	<b>X</b>  X X X							
<b>3</b>	<b>Receptacle</b>	<b>T14530-1</b>	<b>4</b>	<b>X</b>	<b>X</b>							
4A	Fuseholder	S10433-1	1	X	X							
<b>4B</b>	<b>Fuse, 0.6A,250 Volt</b>	<b>T10728-30</b>	<b>2</b>	<b>X</b>	<b>X</b>							
5	#6-32 x .375 Phillips Pan Head Screw	CF000337	4	X	X							
6	Switch Pin	S20322	1	X	X							
7	Decal (380-460V)	T13086-118	1	X	•							
7	Decal (550-575V)	T13086-158	1	•	X							
8	Decal (200-230V)	T13086-119	1	X	•							
8	Decal (440-460V)	T13086-157	1	•	X							
9A	Control Box	M18309	1	X	X							
9B	Self Tapping Screw	S8025-70	4	X	X							
10	Support, PCB	S19300-2	8	X	X							
<b>11</b>	<b>Control PC Board Assembly</b>	<b>G3328-[ ]</b>	<b>1</b>	<b>X</b>	<b>•</b>							
<b>11</b>	<b>Control PC Board Assembly</b>	<b>G3490-[ ]</b>	<b>1</b>	<b>•</b>	<b>X</b>							
<b>12A</b>	<b>Diode Bridge</b>	<b>M15454-6</b>	<b>1</b>	<b>X</b>	<b>X</b>							
12B	Socket Head Cap Screw	T9447-10	2	X	X							
12C	Spring Washer	T12735-4	2	X	X							
<b>12D</b>	<b>Input Rectifier Heat Sink</b>	<b>S23862</b>	<b>1</b>	<b>X</b>	<b>X</b>							
<b>13</b>	<b>MOV Assembly</b>	<b>S18491</b>	<b>1</b>	<b>X</b>	<b>•</b>							
<b>13</b>	<b>MOV Assembly</b>	<b>S18491-1</b>	<b>1</b>	<b>•</b>	<b>X</b>							
<b>14</b>	<b>Line Switch (Part of Harness)</b>	<b>S20456</b>	<b>2</b>	<b>X</b>	<b>X</b>							
15	Grommet	S18543-1	2	X	X							

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# Wraparound Assembly



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**Recommended Spare Parts are Highlighted in Bold**

ITEM	DESCRIPTION	PART NO.	QTY.	1	2	3	4	5	6	7	8	9
	<b>Wraparound Assembly, Includes:</b>	<b>M18805-3</b>	<b>1</b>	<b>X</b>	•							
	<b>Wraparound Assembly, Includes:</b>	<b>M18805-4</b>	<b>1</b>	•	<b>X</b>							
<b>1</b>	<b>Wraparound, Door &amp; Hinge Assembly, Includes:</b> (Item 1A thru 1D)	<b>M19258</b>	<b>1</b>	<b>X</b>	<b>X</b>							
1A	Wraparound	L11000	1	X	X							
1B	Access Door	S24405	1	X	X							
1C	Hinge	S21250-7	1	X	X							
1D	Rivet	T9701-3	4	X	X							
2	Warning Decal	S19720	1	X	X							
3	Wiring Diagram	L10942	1	X	•							
3	Wiring Diagram	L10972	1	•	X							
4	Connection Instructions	S21230	1	X	•							
4	Connection Instructions	S24180	1	•	X							
6	Warning Decal	S20900	1	X	•							
6	Warning Decal	S20900-1	1	•	X							
7	Side Decal (Left)	L10997	1	X	X							
8	Side Decal (Right)	L10997	1	X	X							
9	Nut Retainer	T10097-2	2	X	X							
10	Thread forming Screw	S9225-61	2	X	X							
11	Self Tapping Screw	S24739-1	11	X	X							

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# NOTES

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VIPER

