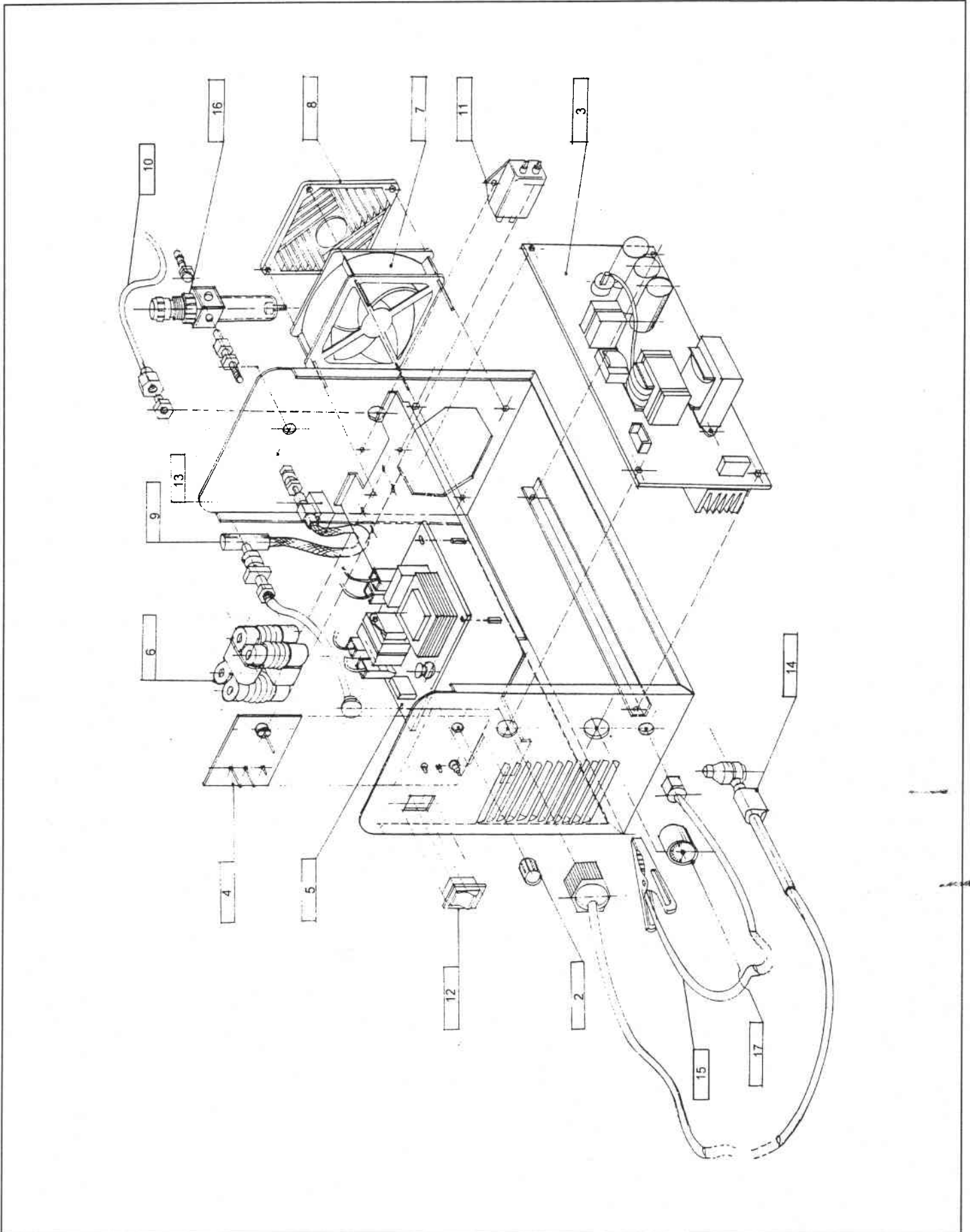


SPARE PARTS





Item	Pt. No.	Description	Cct. Ref.
1	Special Order	Lid with Handle/Strap (not shown)	
2	1416190	Knob	
3	1416191	Inverter/Main PCB	INVSS
4	1416192	Control PCB	SSPLA
5	1416193	HF PCB	HF
6	1416194	HF Coupling Tx	T1
7	1415480	Fan	VR1
8	1415715	Fan Grille	
9	95102	Flow Switch	FLUSS
10	N.A.	Main Power Cable w/Plug 10ft	
11	1415481	EMI Filter	EM1
12	1415485	ON/OFF Switch	S1
13	1415483	Solenoid Valve Assembly	EV1
14	558 001 446	Plasma Torch	
15	1415709	Earth Cable w/Clamp	
16	1416195	Air Regulator/Filter	
17	1416196	Pressure Gauge	

PLEASE SEE ADDENDUM SHEET FOR SABRE-ARC 351iAS CIRCUIT DIAGRAM AND SPARE PARTS INFORMATION



Addendum Sheet (100577.1 Add)

Sabre-arc 351iAS 110/230V Model

The Murex Sabre-arc 351iAS air plasma cutter operates from either 230V or 110V single phase 50/60Hz mains electricity. The unit contains an "Auto Switch" system that automatically sets the internal circuitry for the relevant supply voltage. On 230V supplies the unit has the same ratings etc. as the 351i model, refer to the main instruction manual 100577.1 supplied with this sheet. On 110V supplies, because of the increased supply current draw for the same output, cutting current settings in excess of 25A or so may cause the unit to trip the front panel mounted supply circuit breaker (35A rated). A solid 110V supply capable of delivering at least 30A (3kVA) must be used. 25A cutting current is adequate for cutting mild steel up to 6mm or so and 4-5mm of aluminium. Note that long mains extension cables should not be used on 110V supplies.

The 351iAS unit has slightly different external dimensions to the "non AS" 230V only model, in this regard the SPECIFICATION section on page 6 of manual 100577.1 is incorrect and should read:



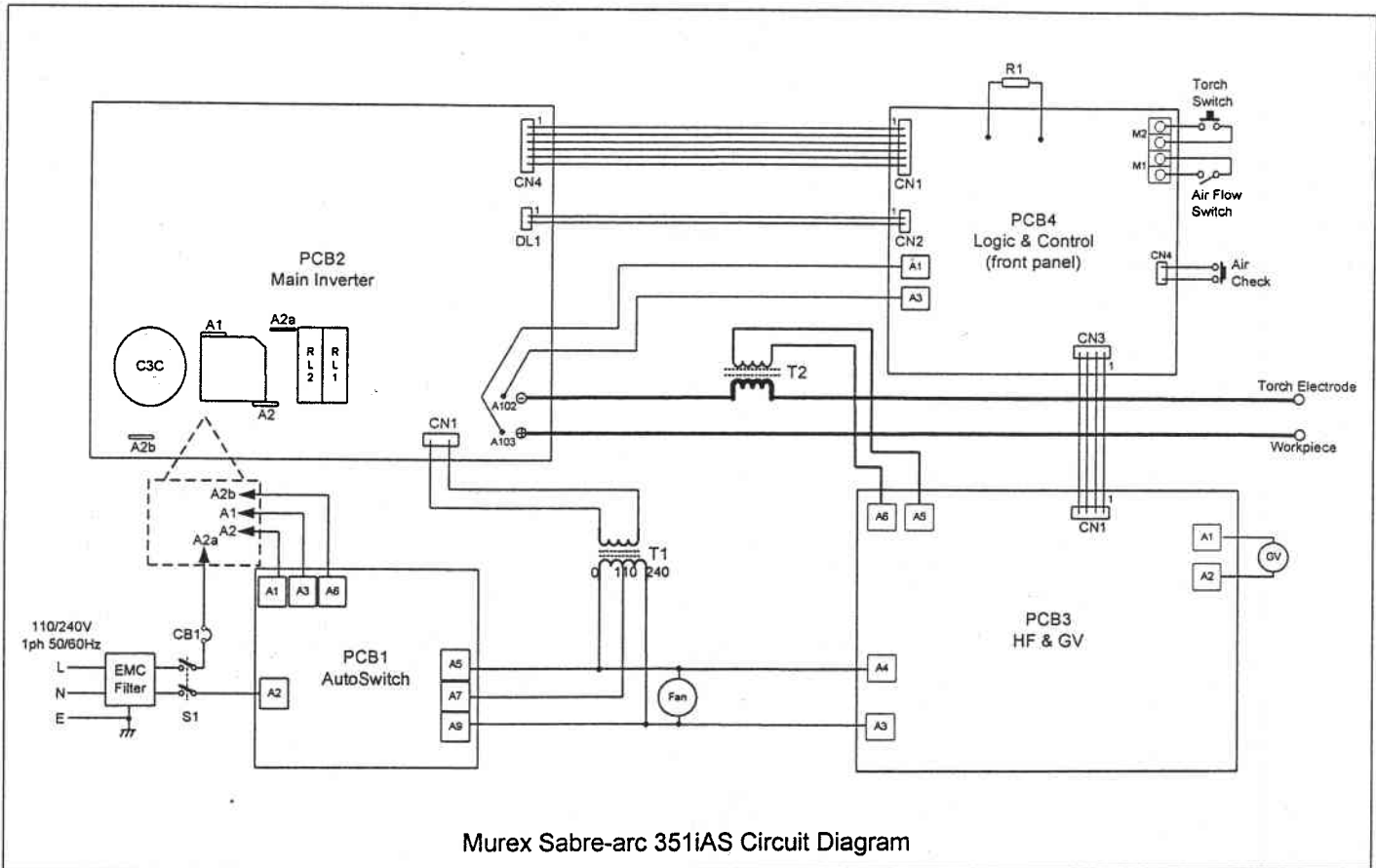
Dimensions:

Height	285mm
Width	145mm
Depth	525mm
Weight	13kg (incl torch etc.)

Both the Sabre-arc 351i and the new 351iAS model use the Murex PT-50 plasma torch (4.5m long std.) and details on this and other operator information can be found in the main instruction manual. It should be noted that the air pressure gauge on the Sabre-arc 351iAS is located on the left hand side rear of the unit rather than on the lower front panel per the 351i.

ELECTRICAL SPECIFICATION

Input		
Mains Supply	220-240V 1ph 50/60Hz	100-120V 1ph 50/60Hz
Fuse (for full rating)	16A (13A slow for most applications)	30A slow (3000VA minimum)
Output		
Current range	10-35A continuous	10-25A (duty cycle falls above this value)
Rating	35A/110V at 40% duty, 28A at 60%	25A/110V at 35% duty
OCV	230Vdc	230Vdc
Inlet Air Pressure	6-10 bar	6-10 bar
Inlet Air Flow	125 litres/m approx. (250cuft/hr)	125 litres/m approx. (250cuft/hr)
Rec Torch Pressure	70-80 psi	70-80 psi



Sabre-arc 351iAS Spare Parts

Part Number	Description	Cct. Ref.
1415492	Auto Switch PCB	PCB1
1416302	Main Inverter PCB Ass'y	PCB2
1416193	HF & GV PCB	PCB3
1416192	Control & Logic PCB	PCB4
1415495	Control Transformer	T1
1415481	Mains Filter	EMC
1415485	On/Off Switch	S1
1416301	Circuit Breaker (35A)	CB1
1415480	Fan	Fan
1415483	Solenoid Valve	GV

For other items refer to parts list in main manual 100577.1