

***powermax900***<sup>®</sup>

**Wheel Kit Installation**

Kit: 128316

**Field Service Bulletin**

**IM-324**

**(P/N 803240)**

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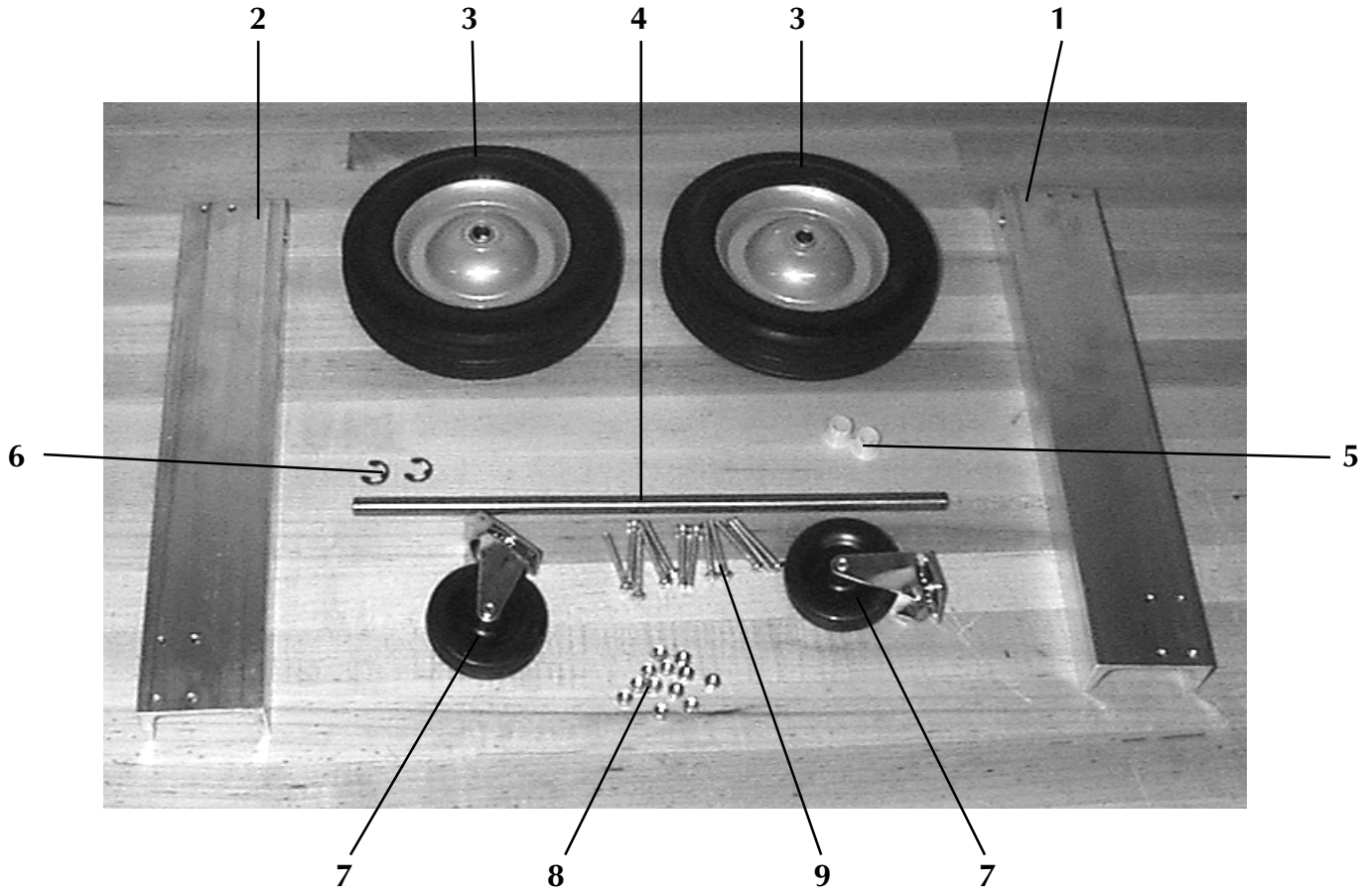
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# Installation of Wheels to **powermax900**

Kit: 128316

## Kit Contents - 128316

### Powermax900 Wheel Kit



Item	Part Number	Description	Qty.
1	001528	Chassis Stiffener: Pmx900 - Left	1
2	001555	Chassis Stiffener: Pmx900 - Right	1
3	027057	Wheel: 8"	2
4	004672	Axle: Pmx900 Wheels	1
5	008907	Shoulder Washer: 1/2" x 1/2"	2
6	027249	Retaining Ring	2
7	027299	Caster	2
8	075160	Kepnut: 10-32	12
9	075472	M/S: 10-32 x 1-3/4" PH Pan	12
	803240	FSB: Pmx900 Wheel Kit	1

# Installation of Wheels to **powermax900**

Kit: 128316



## WARNING



**SHOCK HAZARD:** Always turn off power and unplug cord from wall before installing wheels on the power supply. If power unit is directly connected to a line disconnect box, place line disconnect switch to OFF position. Lock out and tag out switch before proceeding!

1. If the torch is connected to the power supply, unscrew and remove it.
2. Remove the screws (075467- qty. 18) that secure the cover to the power supply chassis.
3. Remove the power supply cover.
4. Carefully tilt the power supply forward on to its front handle.
5. Align the right chassis stiffener (001555) to the bottom of the power supply - see Fig. 2 for outside view. Be certain that the holes in the chassis stiffener are offset to the far left side with two holes on the top and four holes on the bottom.
6. Attach the right chassis stiffener to the power supply chassis:
  - Push 2 of the screws (075472) through the top 2 holes of the chassis stiffener from the outside (bottom) of the power supply - see Fig. 1. Be certain that the screws also go through the holes of the chassis floor.
  - Hand tighten 2 of the kepnuts (075160) to the screw ends that protrude through the chassis floor.

Push 075472 screws through these 2 holes from the outside (bottom) of the power supply.

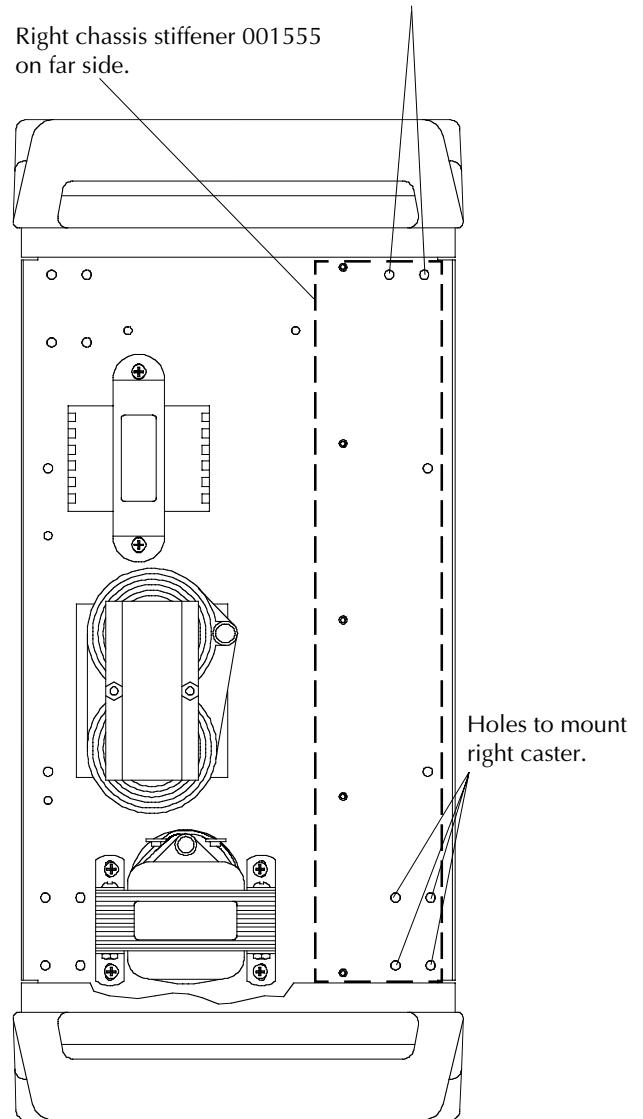


Figure 1 Power Supply on Front Handles - Inside Floor View

## Installation of Wheels to **powermax900**

Kit: 128316

- Attach one of the casters (027299) to the right chassis stiffener as shown in Fig. 2. Insert 4 screws (075472) through the bottom 4 holes of the chassis stiffener from the outside of the power supply as in the previous steps.

- Hand tighten 4 kepnuts to the screw ends that protrude through the chassis floor.
- Using a 3/8" (10 mm) nut driver, tighten the 2 upper chassis stiffener kepnuts and the 4 caster kepnuts **firmly**.

- Repeat steps 5 through 7 to mount the left chassis stiffener (001528) and remaining caster. (Chassis stiffener holes offset to the right)

- Snap a retaining ring (027249) on one end of the axle (004672).

- Slide one of the wheels (027057) onto the axle.

- Slide one of the shoulder washers (008907) over the end of the axle with the larger diameter end of the washer facing the mounted wheel.

- Slide the axle through the axle hole in the right chassis stiffener as shown in the figure.

- Continue sliding the axle through to the axle hole in the left chassis stiffener and mount the other wheel as shown in the figure.

- Tilt the power supply back on the wheels and replace the power supply cover. Note that the rear wheels interfere with the replacement of 2 of the power supply cover screws. It is not necessary to insert these 2 screws.

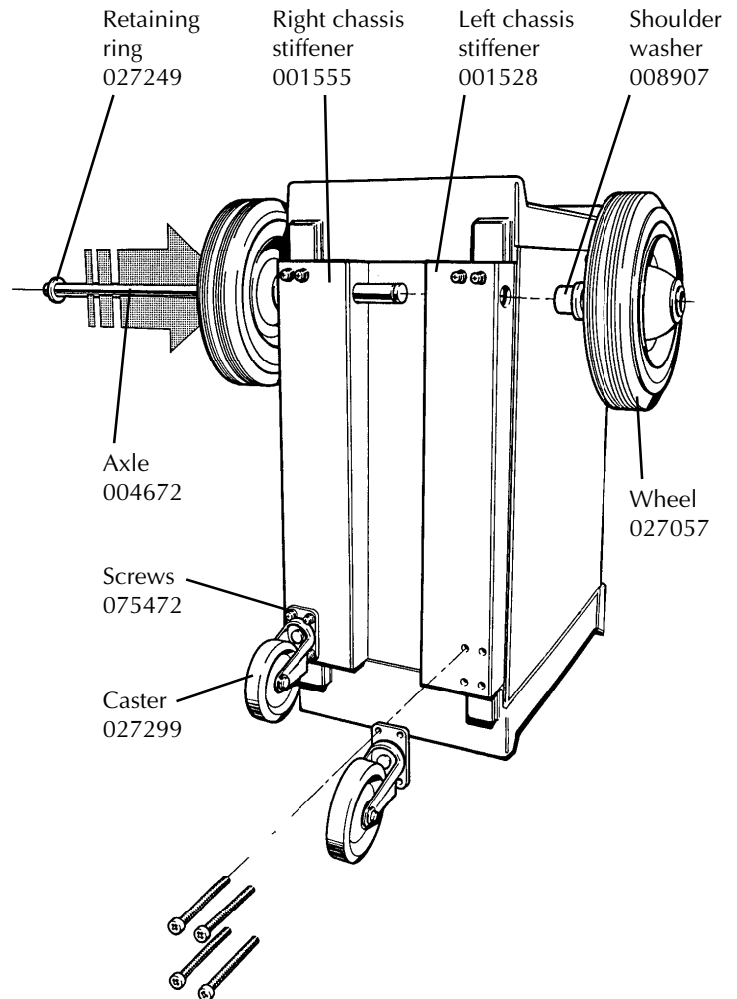


Figure 2 Power Supply on Front Handles  
Outside Bottom View

Wheel installation is complete. See Powermax900 operator manual 803080 for further installation and operation instructions.