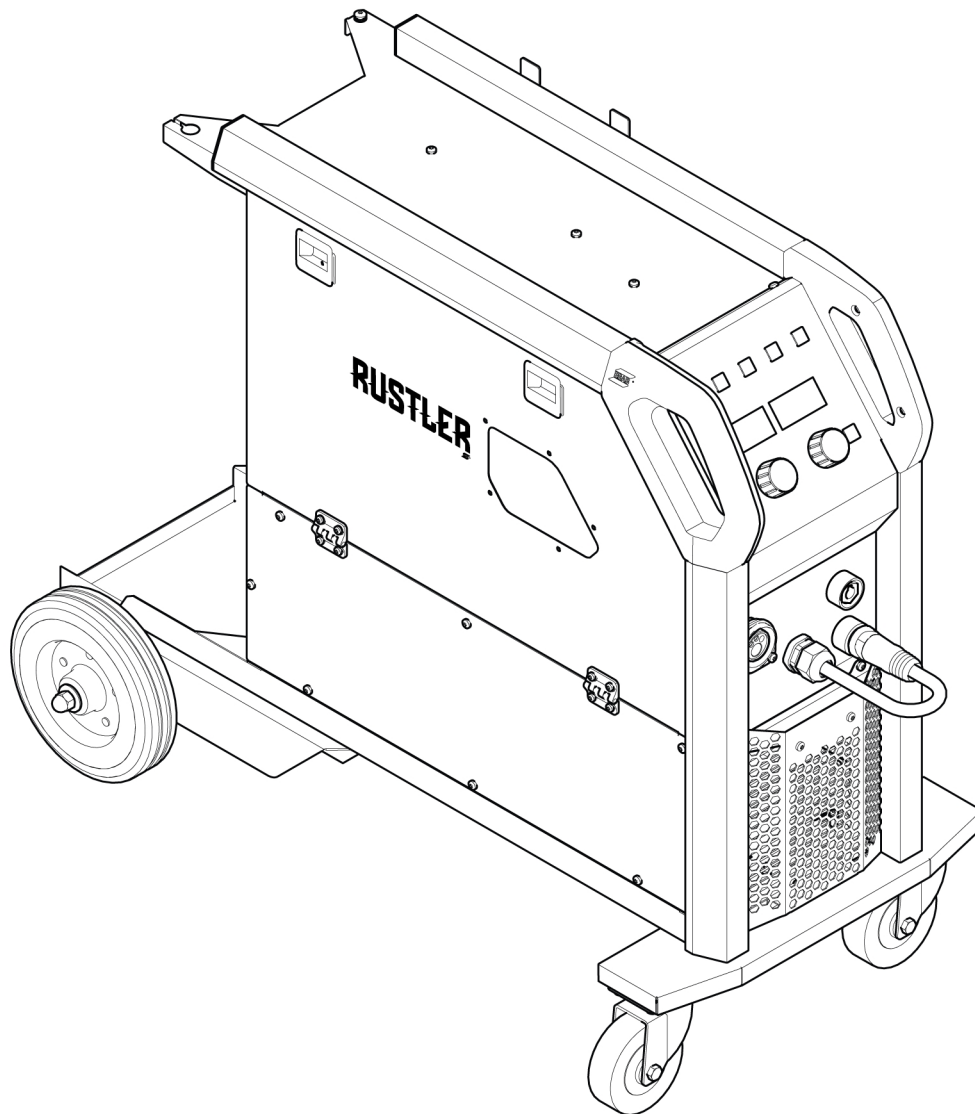


Rustler EM 253C



Spare parts list

Ordering no.	Denomination	Notes
0448 250 890	Rustler EM 253C	With torch MXL 271, 3 m EURO
0463 933 *	Rustler EM	Instruction manual

Spare parts may be ordered through your nearest ESAB dealer, see esab.com. When ordering, please state product type, serial number, denominations and ordering numbers according to the spare parts list. This facilitates dispatch and ensures correct delivery.

Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

For accessories to the product, see the instruction manual.

The three last digits in the document number of the manual show the version of the manual. Therefore they are replaced with * here. Make sure to use a manual with a serial number or software version that corresponds with the product, see the front page of the manual.

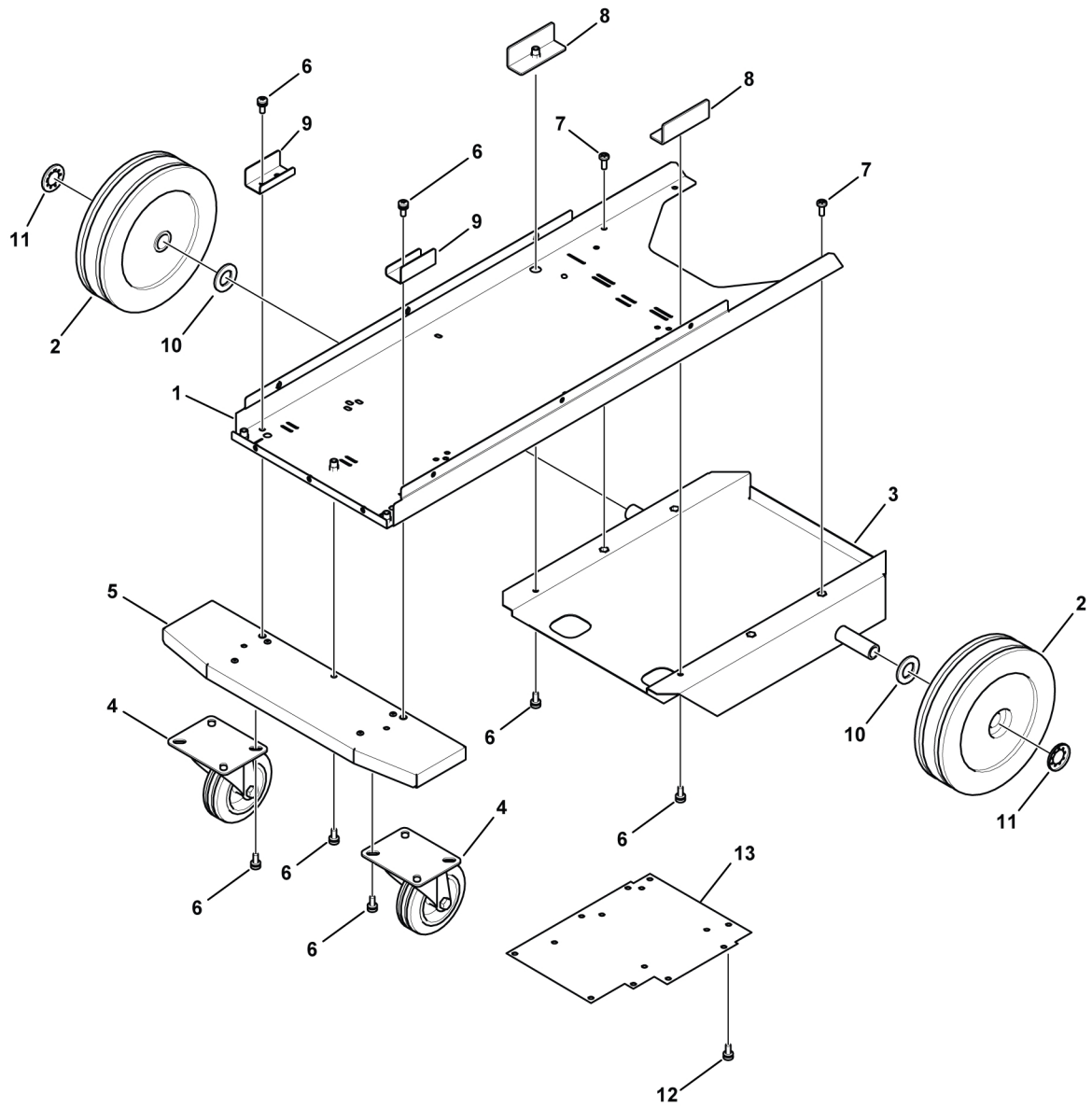
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1 SPARE PARTS

1.1 Chassis module

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	1		Base metal case assy		
2	2	0349 309 845	Wheel SR 200	Also order Pos 11	
3	1		Gas cylinder shelf		
4	2	0455 467 001	Castor wheel D100 H125		
5	1		Front wheels bracket		
6	15		Screw	MRT COMBI M6 x 16	
7	4		Screw	MRT M6 x 16 black	
8	2		Reinforcement assy		
9	2		Reinforcement RHS		
10	2		Plain washer	20-200 HV-A2K	
11	2	0192 859 026	Locking washer	Type P	
12	18		Screw	MRT COMBI M5 x 10	
13	1		Service plate		

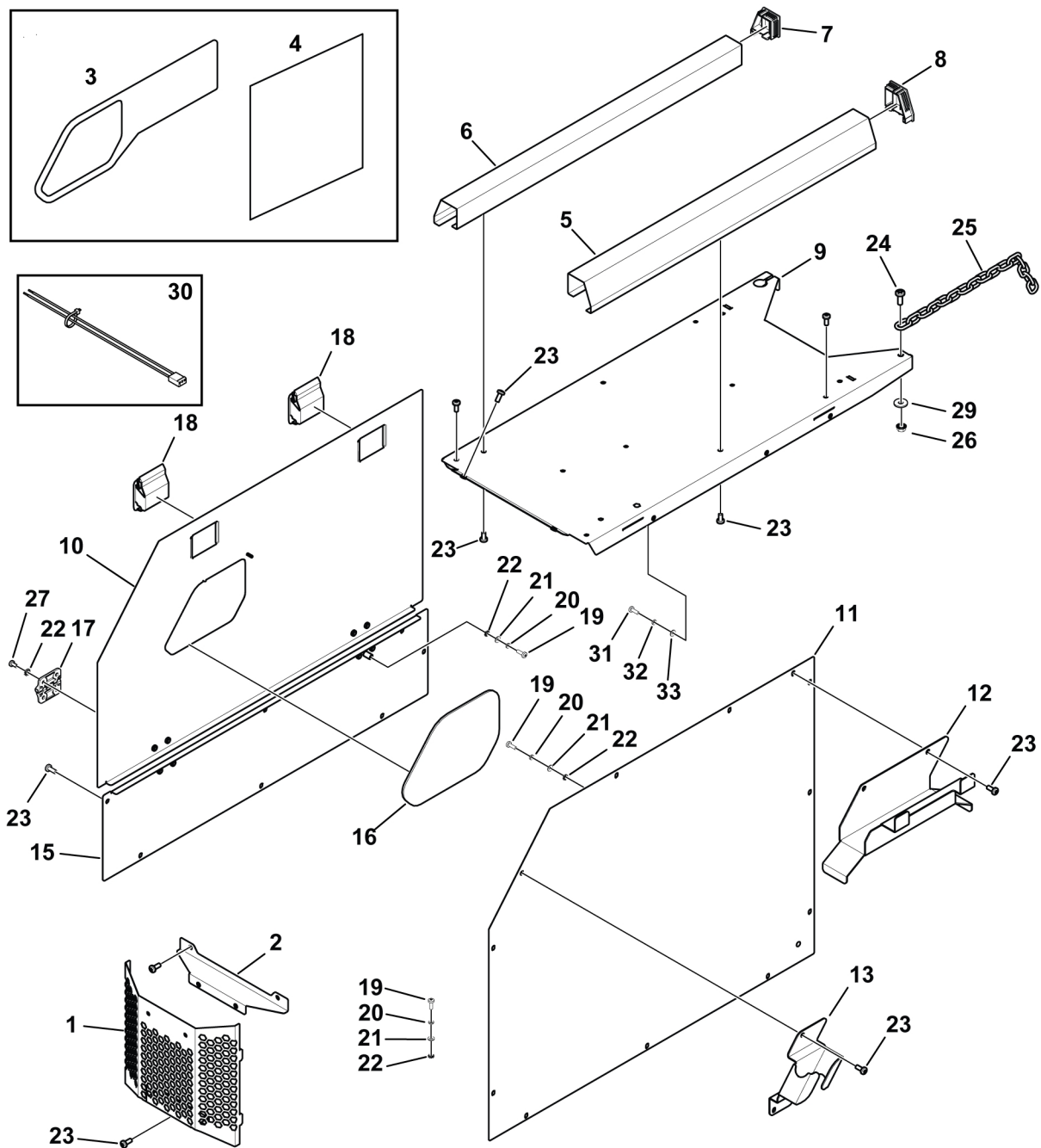


1.2 Housing module

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0448 206 001	Front metal shield		
2	1	0448 352 780	Front water proof plate cpl		
3	1		Rustler side panel label	See item 202	
4	1		Rustler weld parameter label	See item 202	
5	1	0448 381 001	Top metal trim strip 1		
6	1	0448 382 001	Top metal trim strip 2		
7	1		Cap for strip left	See item 201	
8	1		Cap for strip right	See item 201	
9	1		Top metal case		
10	1		Left metal door	See item 202	
11	1	0448 209 001	Right side panel		
12	1	0448 154 001	Cable holder		
13	1	0448 155 001	Torch holder		
15	1		Left lower metal cover	See item 202	
16	1	0448 405 011	Window cover	See item 202	
17	2	0448 433 780	Hinge	See item 202	
18	2	0448 406 001	Door hatch	See item 202	
19	5		Screw	MRT M4 x 12	
20	5		Spring washer		
21	5		Plain washer	4-200 HV-A2K, see item 202	
22	13		Washer lock	AZ 4,3 x 8 ST, see item 202	
23	32		Screw	MRT M5 x 12 black, see item 202	
24	1		Screw	MRT M6 x 16 black	
25	1		Chain	L=700	
26	1		Hexagon nut with flange		
27	8		Screw	MRT M4 x 8 black, see item 202	
29	1		Washer		
30	1		Harneses ground cable		
31	4		Screw	MRT M5 x 20	
32	4		Spring washer		
33	4		Plain washer	5-200 HV-A2K	
35	1		Sealing strip	Not in illustration, see item 202	

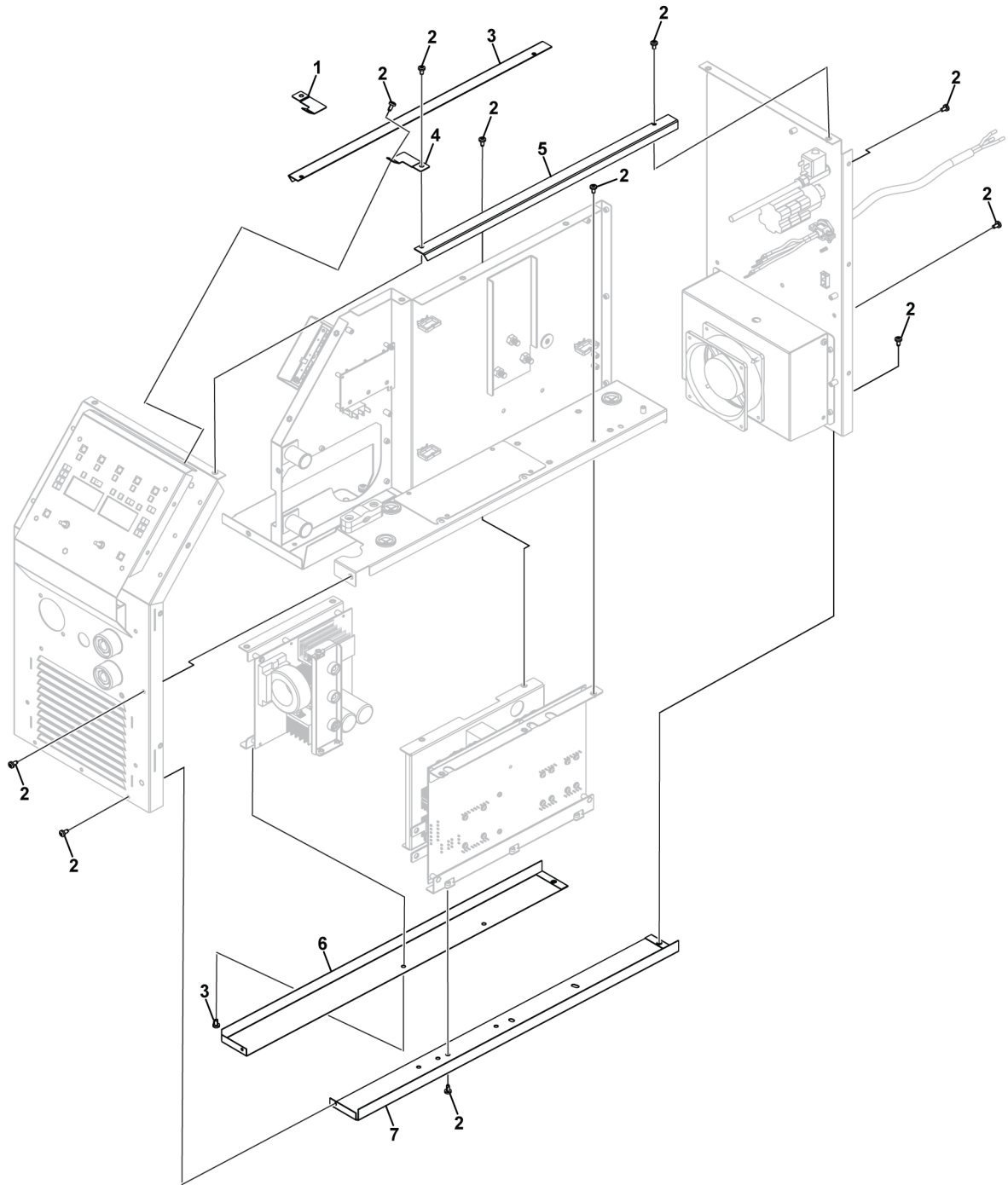
1 SPARE PARTS

Item	Ordering no.	Denomination	Notes
201	0464 751 071	Cap kit	Including items 7 and 8
202	0464 751 070	Left panel kit	Including items 3, 4, 10, 15, 16, 17, 18, 19 (1), 20 (1), 21 (1), 22 (9), 23 (7), 27 (8) and 35



1.3 Supporting module

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	1		Left bracket of control board		
2	33		Screw	M5 x 10	
3	1		Left metal bar upper side		
4	1		Right bracket of control board		
5	1		Right metal bar upper side		
6	1		Left metal bar down side		
7	1		Right metal bar down side		

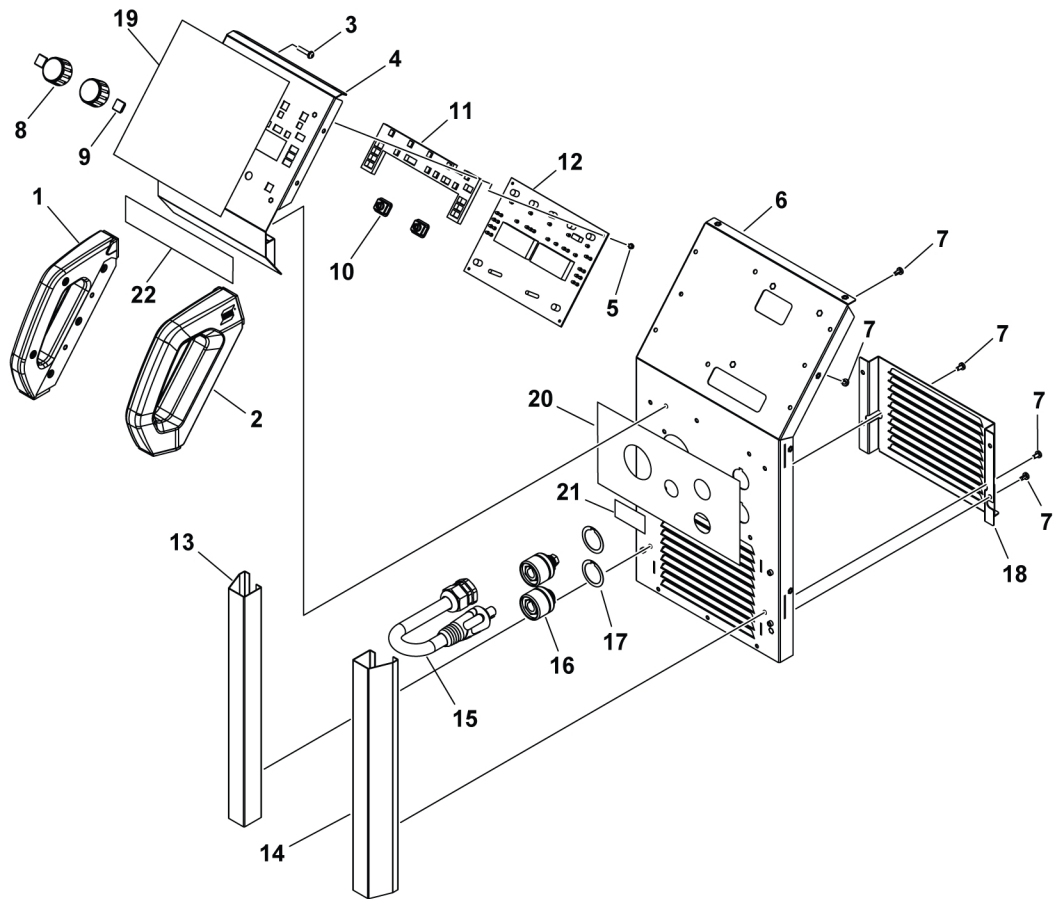


1.4 Front panel module

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0464 663 191	Left handle		
2	1	0464 663 158	Right handle		
3	4		Screw	M5 × 25	
4	1		Front use control metal panel	See item 301	
5	4		Screw	M3 x 8, see item 301	
6	1		Front metal panel	See item 302	
7	16		Screw	M5 × 10	
8	2	0321 475 893	Knob	D36-1/4IN AristoFeed	
9	7		Black rubber		
10	2		Rubber for encoder	See item 301	
11	1		Cotton shading of LED	See item 301	
12	1		Front panel PCB	See item 301	1AP1
13	1	0448 207 002	Front metal trim strip LHS		
14	1	0448 207 001	Front metal trim strip RHS		
15	1	0448 355 782	Polarity change cable	25mm ²	
16	2	0160 362 881	OKC		
			Seal rubber for OKC		
18	1	0464 663 301	Inside front louver		
19	1		Front panel label	See item 301	
20	1		Rustler light front label	See item 302	
21	1		ESAB logo decal	See item 302	
22	1		Rustler EM label		

Item	Ordering no.	Denomination	Notes
301	0464 663 273	Front panel kit	Including items 4, 5, 10, 11, 12 and 19
302	0464 663 300	Front metal panel kit	Including items 6, 20 and 21

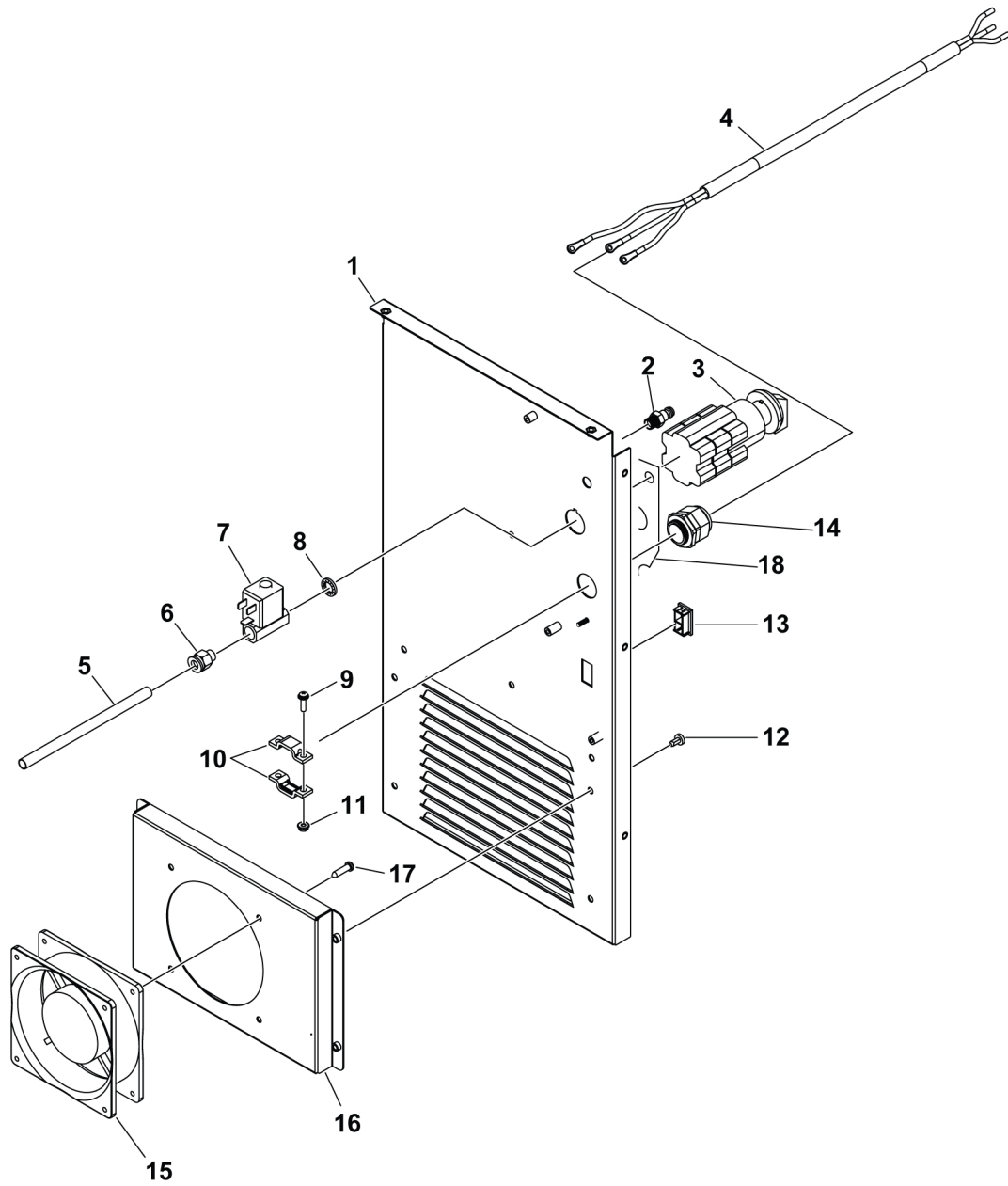
1 SPARE PARTS



1.5 Rear panel module

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0464 663 307	Rear panel		
2	1	0464 663 277	Inlet fitting		
3	1	0464 663 175	Main switch		2SW1
4	1	0464 663 282	Mains cable		
5	1		Gas tube		
6	1	0464 663 308	Quick connect fitting		
7	1	0464 663 177	Solenoid valve		
8	1	0464 663 309	Washer		
9	2		Screw	M4 x 16, see item 401	
10	2		Pressure lock for cord	See item 401	
11	2		Nut	M4, see item 401	
12	4		Screw	M5 × 10	
13	1		Cover for socket of heater		
14	1	0464 663 278	Cable gland		
15	1	0464 663 279	Fan		20EV1
16	1		Fan bracket		
17	4		Screw	ST5.0 × 20	
18	1		Main switch label PRO		

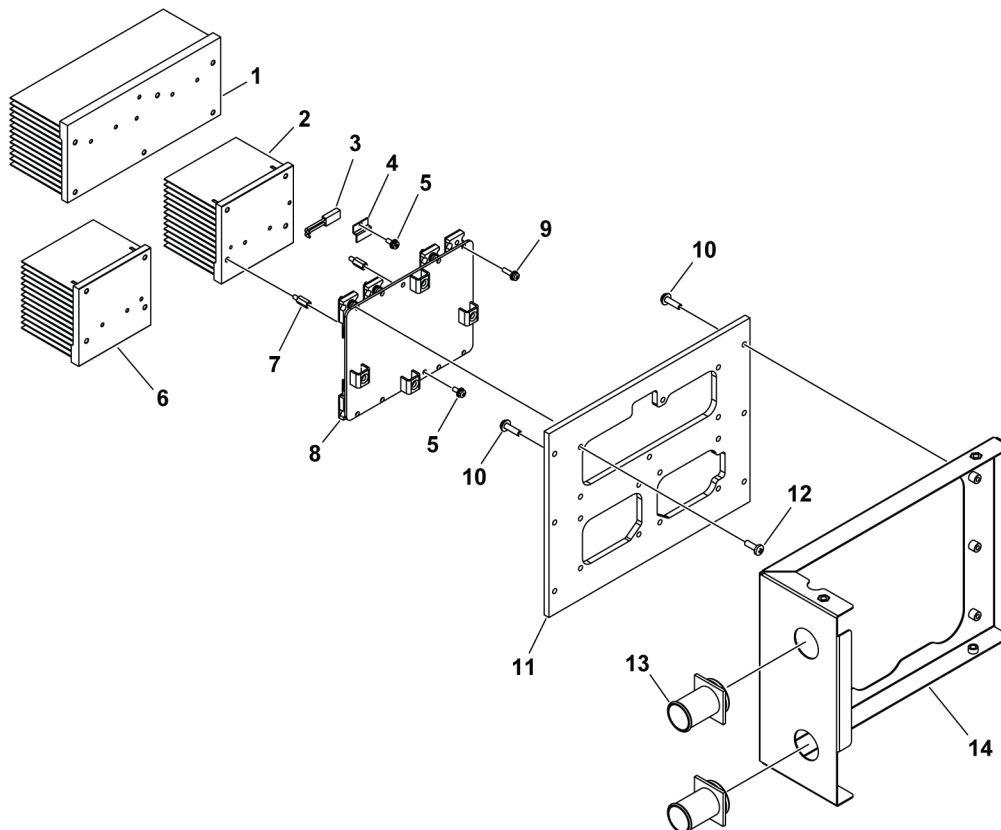
Item	Ordering no.	Denomination	Notes
401	0464 751 055	Pressure lock kit	Including items 9, 10, and 11



1.6 IGBT module

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	1		Heatsink of IGBT upper		
2	1		Heatsink of IGBT lower right		
3	1		Thermal protection	See item 501	
4	1		Cover of thermal protection	See item 501	
5	3		Screw	M3 × 8	
6	1		Heatsink of IGBT lower left		
7	2		Copper bolt		
8	1	0464 663 169	Inverter PCB kit		15Q
9	8		Screw	M3 × 12	
10	6		Screw	M4 × 16	
11	1		Insulation pad for heatsink of IGBT		
12	12		Screw	M4 × 12	
13	2	0464 663 275	Cable cover		
14	1		Bracket for heatsink of IGBT		

Item	Ordering no.	Denomination	Notes
501	0464 663 302	Thermal protection kit	Including items 3, 4, and 5 (1 qty)

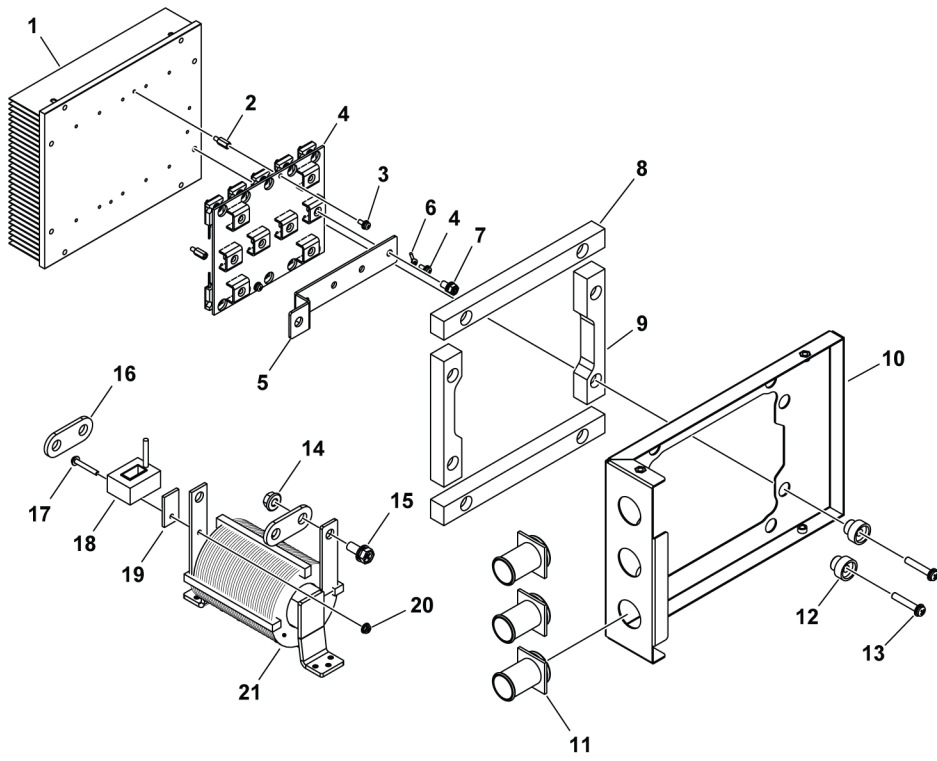


1.7 Rectifier module

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	1		Heatsink of recitifier		
2	2		Copper bolt		
3	3		Screw	M3 × 8	
4	1		Recitifier PCB	See item 601	
	10		Diode		
5	1		Copper rod		
6	1	0464 663 280	NTC		
7	4		Screw	M5×10	
8	2		Insulation bar for heatsink of recitifier		
9	2		Insulation bar for heatsink of recitifier 2		
10	1		Bracket for heatsink of recitifier		
11	3	0464 663 275	Cable cover		
12	8	0464 663 310	Insulation pad		
13	8		Screw	M5 × 30	
14	2		Nut	M8	
15	2		Screw	M8 × 20	
16	2		Copper and alu plate		
17	1		Screw	M4 × 30	
18	1	0464 663 159	Hall sensor		
19	1		Insulation board of hall		
20	1		Nut	M4	
21	1	0464 663 274	Inductor		

Item	Ordering no.	Denomination	Notes
601	0464 663 260	Rectifier PCB kit	Including item 4 and thermal paste

1 SPARE PARTS



1.8 Mounting plate module

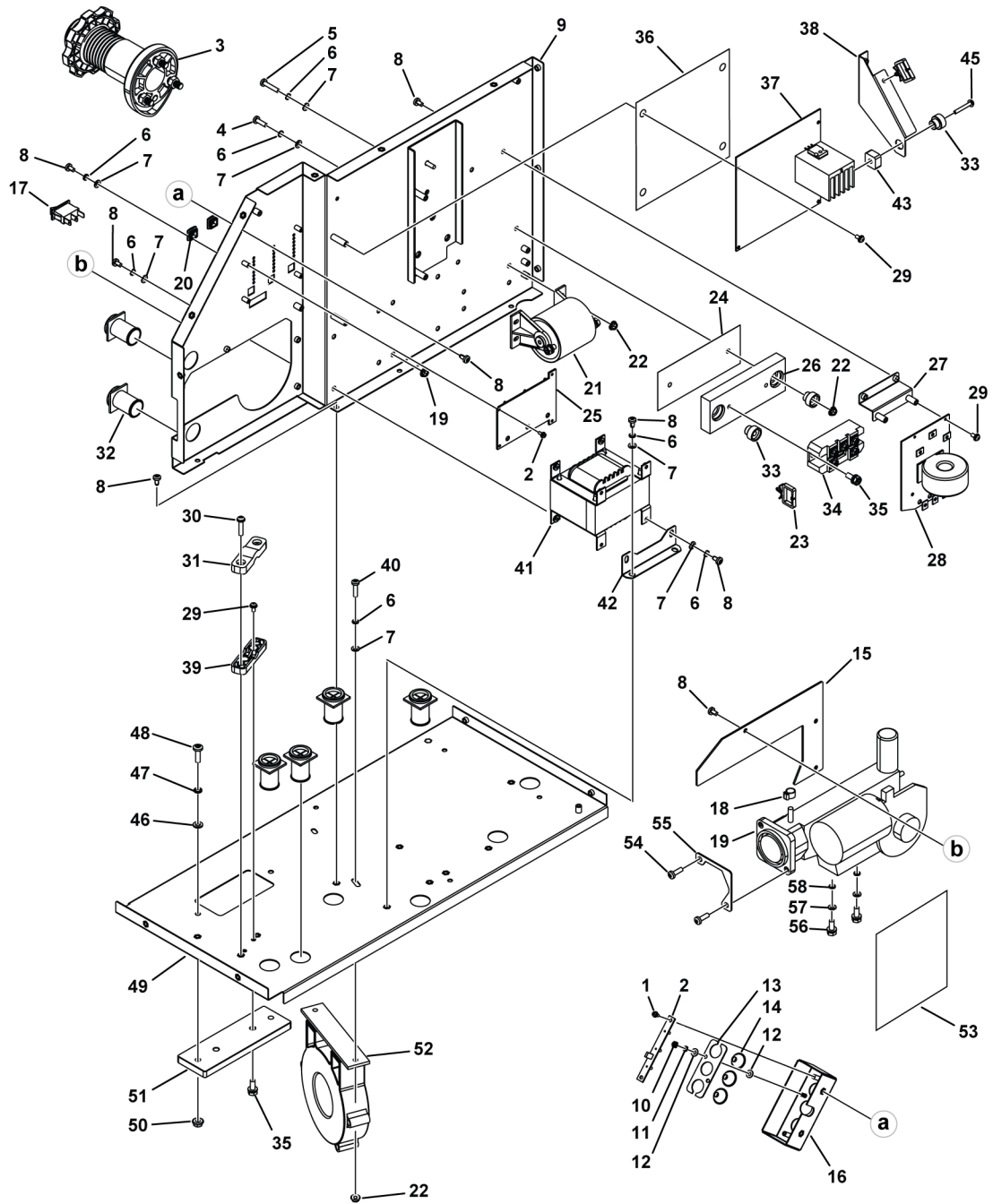
C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	6		Screw	M3 × 8, see item 701	
2	1		Inside LED PCB	See item 701	1AP3
3	1	0464 663 182	Spool	15 kg	
4	2		Screw	M5 × 16	
5	2		Screw	M5 × 25	
6	20		Washer	Φ5	
7	20		Washer	Φ5	
8	20		Screw	M5 × 10	
9	1		Middle support plate		
10	2		Nut	M4, see item 701	
11	2		Washer	Φ4, see item 701	
12	4		Washer	Φ4, see item 701	
13	1		Bracket of inside LED	See item 701	
14	3		Inside LED	See item 701	
15	1	0464 663 303	Insulate paper for wire feeder		
16	1		Inside LED shading	See item 701	
17	1	0464 663 184	Switch of side panel		
18	1		Hose clamp		
19	1	0349 308 476	Wire feeder		20M1
20	2		Black rubber		
21	1	0464 663 170	Capacitor		
22	8		Nut	M5	
23	2		Cable tie		
24	1		Heatsink insulate paper		
25	1	0464 663 257	SYN PCB		1AP2
26	1		Heatsink of bridge		
27	1		Bracket for EMC		
28	1	0464 663 259	EMC PCB		2AP1
29	8		Screw	M4 × 10, see item 702	
30	2		Screw	M5 × 25, see item 702	
31	1		Cable locker upper side	See item 702	
32	6	0464 663 275	Cable cover		
33	3	0464 663 310	Insulation pad		
34	1	0464 663 168	Bridge module with thermal paste		
35	4		Screw	M6×16	

1 SPARE PARTS

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
36	1	0464 663 305	Insulation paper of main PCB		
37	1	0464 663 258	Control PCB board		
38	1		Bracket of heaksink		
39	1		Cable locker down side	See item 702	
40	2		Screw	M5 × 20	
41	1	0464 663 161	Frequcnyc transformer		
42	1		Bracket of transformer		
43	1	0464 663 306	Insulation pad for heatsink of control board		
45	1		Screw	M4 × 30	
46	2		Washer	Φ6	
47	2		Washer	Φ6	
48	2		Screw	M6 × 20	
49	1		Mounting plate		
50	2		Nut	M6	
51	1		Insulate plate for wire feeder		
52	1	0464 663 276	Main transformer		
53	1	0700 401 103	Non synergic label		
54	2		Screw	MRT M5 x 16 black	
55	1		Feeding mechanism plate		
56	2		Screw M6S	M6 x 20	
57	2		Spring washer		
58	2		Plain washer		

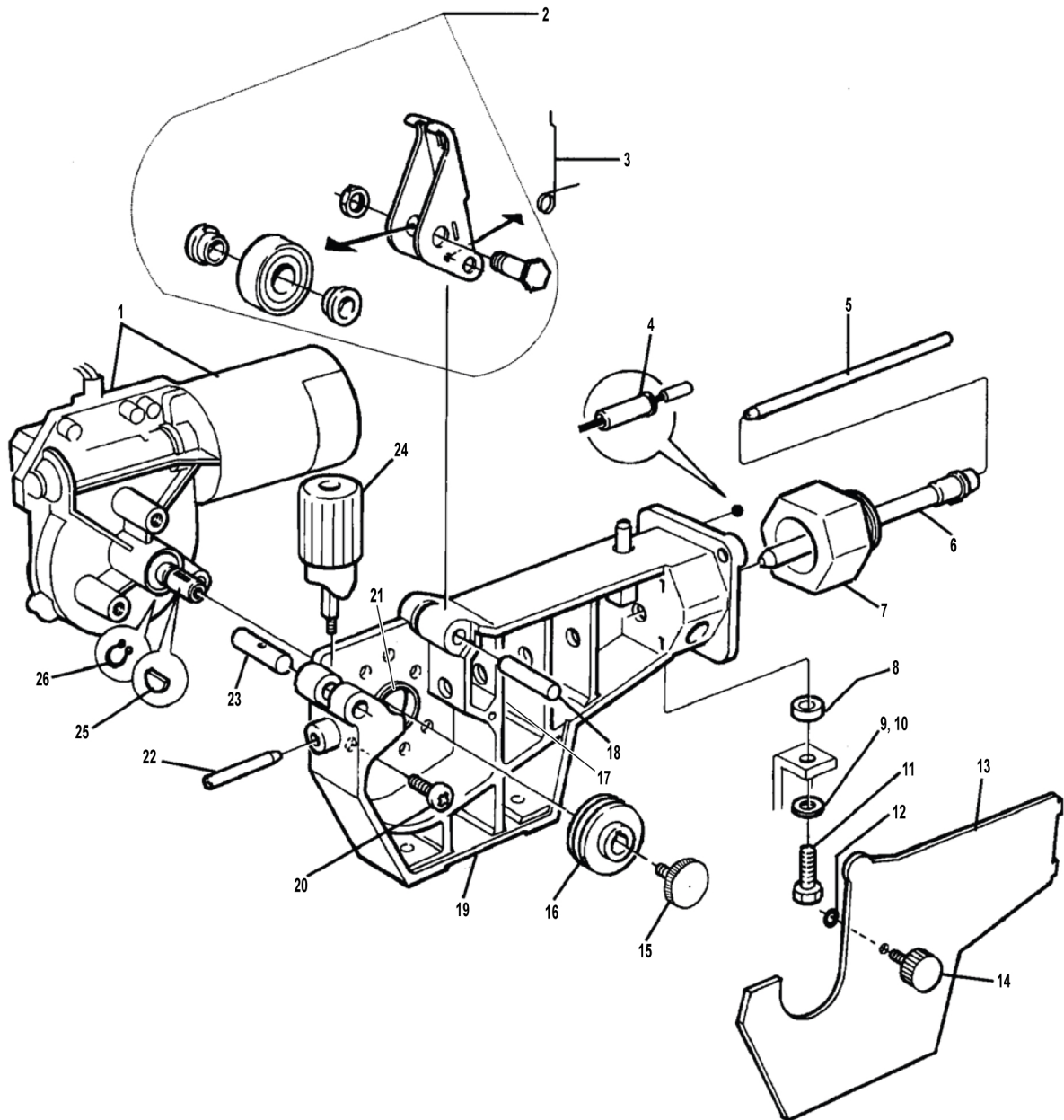
Item	Ordering no.	Denomination	Notes
701	0464 663 183	LED kit	Including items 1, 2, 10, 11, 12, 13, 14 and 16
702	0464 663 304	Cable lock kit	Including items 29, 30, 31 and 39

1 SPARE PARTS



1.9 Wire feed mechanism

C = Component designation in the circuit diagram					
Item	Qty	Ordering no.	Denomination	Notes	C
1	1	0469 397 001	Drive unit		
2	1	0367 529 001	Pressure arm		
3	1	0455 896 001	Spring		
4	2	0369 750 001	Insulating sleeve		
5	1	0455 889 001	Insert tube		
6	1	0455 886 001	Outlet nozzle		
7	1	0455 882 001	Current sleeve		
8	1	0455 883 001	Spacer sleeve		
9	1		Plain washer	16×8.4×1.6	
10	1		Spring washer	14.8×8.1×2	
11	1		Screw	M8×20	
12	1	0215 201 202	O-ring		
13	1	0455 881 001	Protect plate		
14	1	0455 898 001	Knurled screw	M5	
15	1	0349 308 502	Knurled screw		
16	1	0367 556 002	Feed roll	Ø0.8-1.0 mm Fe, Ss cored wire	
17	1		Nut	M5	
18	1	0455 893 001	Cylindric pin		
19	1	0455 884 001	Gearing housing		
20	1		Cross head plastic thread	TW 5.1×20	
21	1	0455 892 001	Spasing ring		
22	1	0466 074 001	Inlet nozzle		
23	1	0367 528 001	Pin bolt		
24	1	0368 749 880	Pressure transmitter		
25	1	0191 496 114	Key		
26	1	0215 701 007	Lock ring	D10	





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