

PAC-500

Flow Switch Upgrade Instructions

801230 - Rev. 0



**PAC-500
Flow Switch Upgrade
Kit # 028485
Instructions**

**IM-123
(P/N 801230)**

Revision 0 December 1990

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Purpose

The PAC-500 flow switch upgrade instructions provide the necessary information to allow the removal of the existing two flow switches and replacing them with the Kobold flow switch subassembly.

Customer Supplied Tools

Straight blade screwdriver
7/16" (11.11 mm) open-end wrench
9/16" (14.29 mm) open-end wrench
11/16" (17.46 mm) open-end wrench
1/4" (6.35 mm) hex wrench

Flow Switch Assembly Upgrade Kit (# 028485)

Kobold flow switch SA, PAC-500, # 029545
Flow switch, 0.25 GPM 1/4 NPT SPST, # 005139
Flow switch, 1.20 GPM 1/4 NPT SPST, # 005140
Flow switch manifold, # 004457
Plug 1/4, # 015561
Tyrap (5), # 074005

Procedure

Remove Existing Flow Switches

To remove the existing flow switches from the PAC-500 Console, refer to the following procedure and the figures called out in the PAC-500 Water-Injection Plasma Arc Cutting System Instruction Manual IM-37 (P/N 800370).

1. Prior to proceeding with the upgrade installation, shut the power supply down at the front panel and turn off power at the disconnect box. Disconnect the gas supply to the power supply. Disconnect the water supply to the power supply.
2. Open the cover to access the plumbing compartment. Locate flow switches 1FLS and 2FLS. Refer to Figure 8.
3. Remove the tyrap from around the flow switch leads which are connected to terminal strip 3TB.
4. Disconnect the four (4) flow switch leads from 3TB. These leads are marked 9, 15 (two leads), and 25.
5. Disconnect and discard hose assembly (024057) between flow switch 1FLS (005054) and the cathode block.
6. Disconnect hose assembly (024040) only at flow switch 2FLS (005053).
7. Remove the two (2) screws, washers, and nuts to remove the flow switch SA.

Install Upgrade Kit

To install the Kobold flow switch manifold subassembly upgrade kit, refer to Figure 1.

1. Position the Kobold flow switch manifold subassembly where the removed flow switch assembly was mounted. Secure with the two (2) screws, washers, and nuts.
2. Route the flow switch leads to terminal strip 3TB. Connect leads to the terminal strip as shown.
3. Replace Tyraps to secure flow switch leads.
4. Connect hose assembly (024090), which is part of PAC-500 upgrade kit, between the cathode block and Kobold flow switch 1FLS (005140/1.20 GPM).
5. Reconnect hose assembly end (024040) to Kobold flow switch 2FLS (005139/.25 GPM).

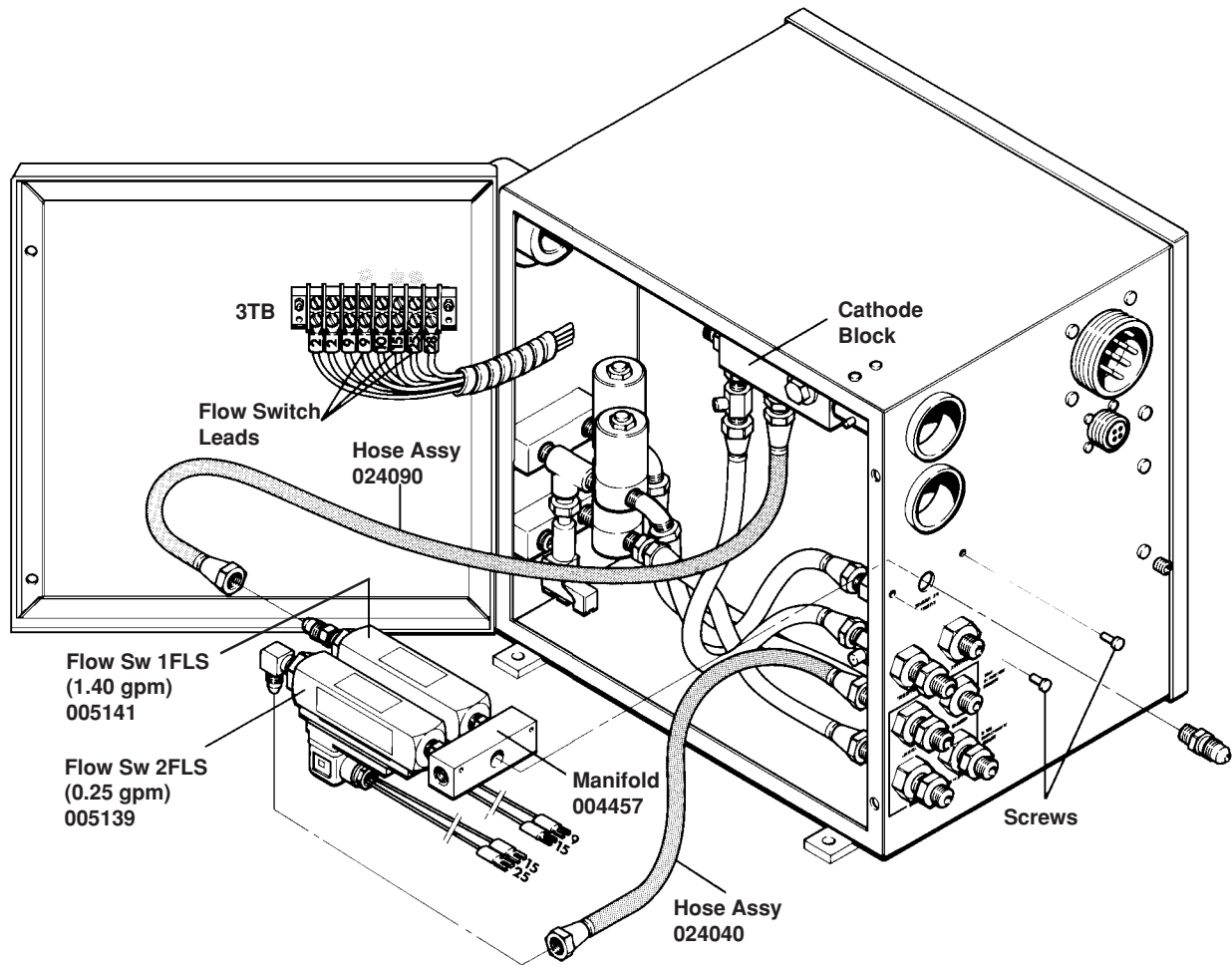


Figure 1 PAC-500 Upgrade Kit Installation