

MAX70

Pressure Switch Retrofit

**Field Service Bulletin
802110 - Rev. 0**

HYPERTHERM[®]


MAX70[®]
Pressure Switch
Retrofit

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(PN 802110)

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Pressure Switch Retrofit

Introduction

The MAX70 pressure switch retrofit kit is designed to change the existing pressure switch PS1 (005171) with new pressure switch (005174). **Note pressure switch is factory set to 45 psi, no adjustment is necessary.**

Pressure Switch Retrofit Kit # 029683

Part No.	Description	Quantity
005174	Pressure switch	1
015520	Elbow	1
015618	Nipple	1
074035	Terminal	2

Tools and Materials Required

#1 Phillips head screwdriver
7/16 -inch open end and adjustable wrench
Terminal crimping tool
Loctite

Procedure

To install the new pressure switch (005174), refer to the following procedure.

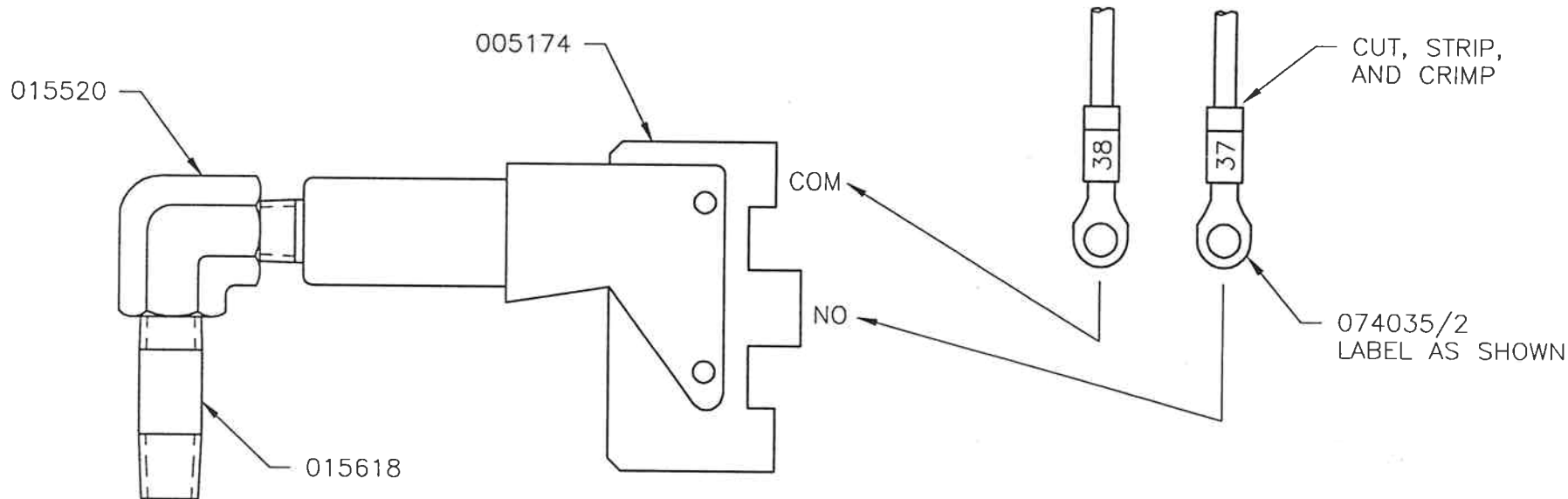
1. At MAX70 set power On/Off circuit breaker to Off and disconnect the input power at the water disconnect switch box.
2. Remove cover by removing screws.
3. Referring to IM-177 (801770), Figure 6-4, locate existing pressure switch (005171) item 5 behind large brown resistor. Remove wires labeled 37 and 38. Remove pressure switch with wrench.
4. Refer to drawing on next page and install the following:
 - a. Apply loctite to nipple (015618) and thread into manifold where pressure switch was removed.
 - b. Apply loctite to other end nipple (015618) and install elbow (015520).
 - c. Apply loctite to threads on pressure (005174) and thread into elbow (015520).
 - d. Remove terminals from wires 37 and 38, then strip wires back and crimp on new terminals.
 - e. Connect wires 37 and 38 to pressure switch according to drawing on next page.
5. This completes retrofit.

NOTES:

1. USE LOCTITE PIPE SEALANT #57141 OR EQUIVALENT ON ALL FITTINGS.

REVISIONS

REV	ECN	DATE	DRAWN	DATE	APPROVED
A	5078	11-14-94	BC		



MATERIAL	DRAWN BY	BC	DATE	11-14-94	<h1>HYPERTHERM, INC.</h1> <p>Hypertherm, Incorporated Box-5010 Hanover, NH 03755-5010 603/643-3441</p>		
	CHECKED BY		DATE				
	APP. BY		DATE				
THIS DRAWING AND ALL INFORMATION CONTAINED THEREON IS CONSIDERED PROPRIETARY AND MAY NOT BE USED FOR MANUFACTURING OR FABRICATION PURPOSES WITHOUT PERMISSION FROM HYPERTHERM, INC.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: 2 PL DECIMALS ±.015 3 PL DECIMALS ±.005 FRACTIONS ±1/64 BREAK SHARP CORNERS WITH CHAMFER OR RADIUS .015 MAX.				DESCRIPTION RETRO KIT: 029683 ⚠		
	STOCK NO.		DRAWING NO.		FILE NAME		
	028817		028-1-817		028817A		
	SCALE 1=1		MODEL		SHEET 1 OF 1		