

Installation of Off-Valve Hose to HT4001 and HT4000 Plasma Arc Cutting Systems

Kit: 028930



WARNING



SHOCK HAZARD: Turn off all power to the power supplies before attempting installation. Set line voltage disconnect box to OFF. Lock out and tag switch.

INTRODUCTION

General

This Field Service Bulletin provides information to install a new off-valve hose to the HT4001 or HT4000 systems. All new HT4001 systems shipped after November 20 have a factory installed 60" (1520 mm) off-valve hose.

Purpose of Change

The longer length plasma off-valve hose provides a greater available volume of plasma gas after shut down which, in turn, increases the gas pressure at the torch during arc current ramp down. The net result from this change is an even greater increase in consumable life.

Systems that now have a 12" (300 mm) off-valve hose should change to the 26" (660 mm) hose, and systems with a 46" (1170 mm) hose should change to the 60" (1520 mm) hose. This kit provides one hose of each length.

Part Numbers

028930 Kit: HT4000/4001 Off-Valve Hose Upgrade

024337 Hose Assy: 1/4 Blue RH'A' 26"

024317 Hose Assy: 1/4 Blue RH'A' 60"

802420 Off-Valve Hose Field Service Bulletin

INSTALLATION

1. Disconnect power from HT4000 or HT4001 systems - see warning above.
2. Turn off all gas to the system.
3. Using 7/16" (11 mm) wrenches, remove plasma off-valve hose from off valve - Fig.1.
4. Unscrew torch sleeve and slide back over torch leads to expose off-valve hose connection at torch.
5. Using 7/16" (11 mm) wrenches, remove off-valve hose from torch.
6. Replace off-valve hose with either the 26" or 60" hose.

Installation complete. See your instruction manual for further operating instructions. If you have any questions regarding this upgrade, call your distributor, Hypertherm's Technical Service at 1-800-643-9878 or your nearest Hypertherm office.

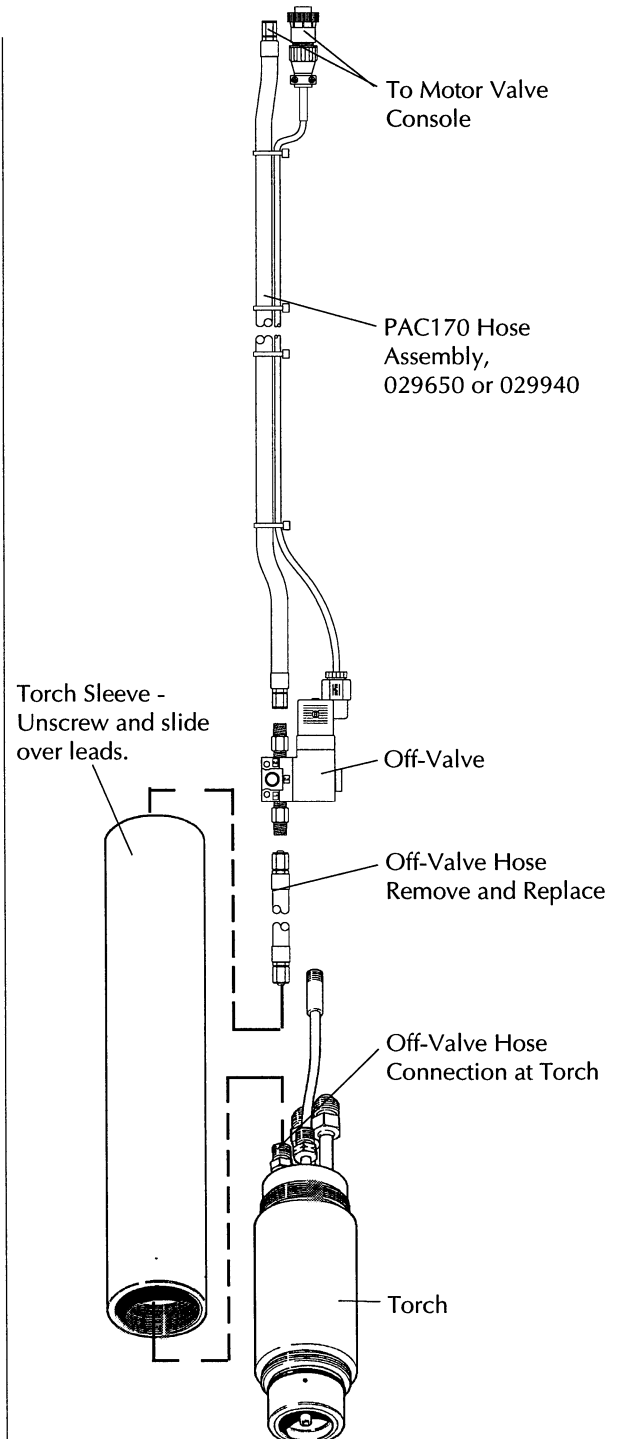


Figure 1 Off-Valve Hose Connection to Torch