

**Hypertherm<sup>®</sup>**

**PAC121TS  
Inner Assembly  
Repair**

**Field Service Bulletin  
IM-264  
(P/N 802640)**

**Revision 1 December, 1997**

**HYPERTHERM, Inc.  
P.O. Box 5010  
Hanover, New Hampshire 03755-5010  
Tel.: (603) 643-3441  
Fax: (603) 643-5352  
<http://www.hypertherm.com>**

**© Copyright 1997 Hypertherm, Inc.  
All Rights Reserved**

**HYPERTHERM is a trademark of Hypertherm, Inc. and  
may be registered in the United States and/or other countries**

## ***Hypertherm Offices Worldwide:***

### **Hypertherm, Inc.**

Etna Road, P.O. Box 5010  
Hanover, NH 03755 USA  
Tel.: (603) 643-3441 (Main Office)  
Fax: (603) 643-5352 (All Departments)  
Tel.: (800) 643-9878 (Technical Service – toll-free in USA and Canada)  
Tel.: (800) 737-2978 (Customer Service – toll-free in USA and Canada)  
email: info@hypertherm.com (General Information)  
email: service@hypertherm.com (Technical/Customer Services)

### **Hypertherm Plasmatechnik GmbH**

Technologiepark Hanau  
Rodenbacher Chaussee 6  
D-63457 Hanau-Wolfgang, Germany  
Tel.: 49 6181 58 2100  
Fax: 49 6181 58 2134

### **Hypertherm (S) Pte Ltd**

No. 19 Kaki Bukit Road 2  
K.B. Warehouse Complex  
Singapore 417847  
Tel.: 65 841 2489  
Fax: 65 841 2490

### **Hypertherm UK Ltd**

9 Berkeley Court, Manor Park  
Runcorn, Cheshire, England WA7 1TQ  
Tel.: 44 1928 579 074  
Fax: 44 1928 579 604

### **France**

15 Impasse des Rosiers  
95610 Eragny, France  
Tel.: 33 1 30 37 15 28  
Fax: 33 1 30 37 15 79

### **Hypertherm S.r.L.**

Via Torino 2  
20123 Milan, Italy  
Tel.: 39 02 725 46 312 (Customer Service)  
Tel.: 39 02 725 46 314 (Technical Service)  
Fax: 39 02 725 46 400 (All Departments)

### **Hypertherm B.V.**

Burg, Haverkampstraat 13  
7091 CN Dinxperlo, The Netherlands  
Tel.: 31 315 655 866 (Customer Service)  
Fax: 31 315 655 886

### **European Technical Support Organization (ETSO)**

Edisonstraat 12  
3281 NC Numansdorp, The Netherlands  
Tel.: 00 800 4973 7843 (00 800 Hypertherm) – (toll-free Technical Service)  
Tel.: 31 186 659494  
Fax: 31 186 659495

### **Japan**

Shinjuku Park Tower  
30th Floor  
3-7-1 Nishi-Shinjuku  
Shinjuku-ku, Tokyo  
163-1030, Japan  
Tel.: 81 03 5326 3142  
Fax: 81 03 5326 3001



**PURPOSE**

This field bulletin provides information to replace the inner assembly on a PAC121TS torch with a repair assembly.


**TOOLS AND MATERIALS REQUIRED**

- External snap ring pliers
- # 2 Phillips head screwdriver
- Water soluble lubricant (K-Y, etc)

**REPAIR PARTS KIT (128232)**

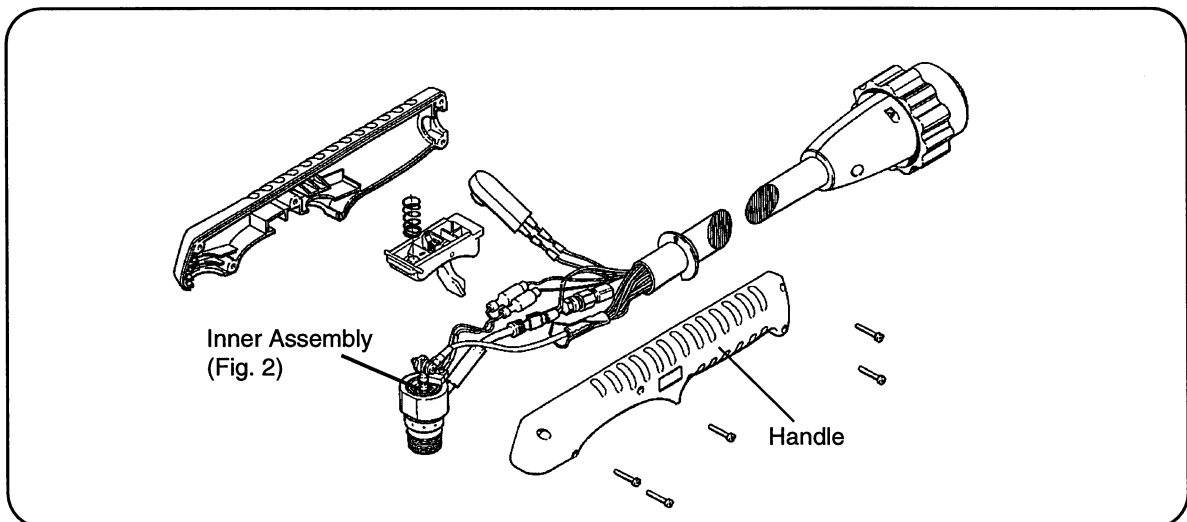
<u>Part No.</u>	<u>Description</u>	<u>Quantity</u>
120561	Assembly, PAC121TS Torch Repair	1
802640	Field Service Bulletin, PAC121TS Torch Repair	1

**REPLACEMENT PROCEDURE**

 **WARNING**

**Turn off power to the power supply before working on the torch. Set circuit breaker on power supply to OFF (O) and set the line disconnect switch to OFF. Lock-out and tag-out switch. Electric shock can cause serious injury or death.**

1. Turn off the gas supply to the power supply and disconnect the gas hose.
2. Remove the screws from the handle and separate to access the inner assembly (Fig. 1).



**Figure 1 Handle Removal and Torch Inner Assembly Location**

## PAC121TS TORCH REPAIR

2. To install the repair assembly, refer to the instructions on Fig. 2.

### Removal

- a. Disconnect the plunger wire from the torch main body by holding the plunger nut with a 1/4" (6 mm) wrench or nut driver and removing the plunger screw.
- b. Remove the large snap ring securing inner assembly to torch main body. Once removed, leave in cavity.
- c. Push inner assembly down and out the bottom of torch main body as shown.
- d. Ensure this O-ring is still in place after removing inner assembly.

### Replacement

- e. Push repair assembly up into torch main body. **Ensure top of plunger does not hit and damage microswitch actuator button during this step.** While keeping pressure on inner assembly from bottom, reinstall snap ring (removed in step b.) into groove to secure it in place.
- f. Reinstall the plunger wire. When connecting the plunger wire, be certain to keep the terminal at the proper angle (see inset). Tighten with screw with 8 in-lbs (9 kg-cm) of torque.

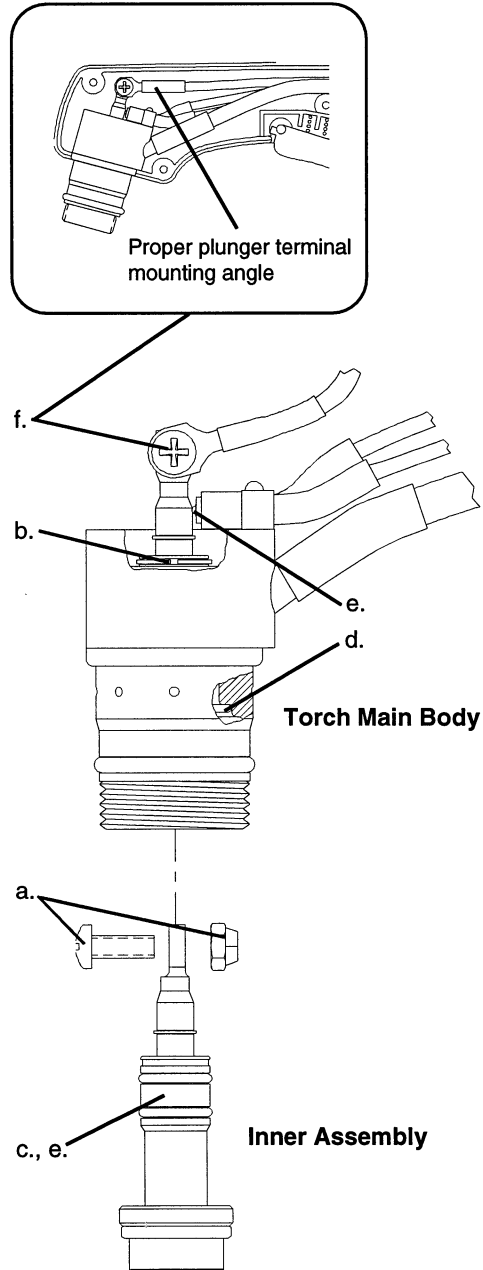


Figure 2. Repair Assembly Installation

