



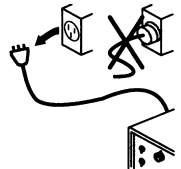
Contacts Replacement
HT4001/HT4400[®]
Field Service Bulletin

802890 – Revision 1 – August, 2003

Hypertherm[®]

*The world leader in
plasma cutting technology™*

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		<p>WARNING ELECTRIC SHOCK CAN KILL</p>
		<p>Disconnect electrical power before performing any maintenance. See the <i>maintenance</i> and <i>safety</i> sections of the Instruction Manuals for more safety precautions.</p>

Introduction

Purpose

This field service bulletin will enable a qualified electronics technician to replace worn contacts on the power supply's main contactor. The three contacts of the power supply will wear after approximately 150,000 to 200,000 plasma start operations. The result of this wearing can cause one or all of the choppers to fail. As a preventative measure, these contacts should be inspected every 2 months and replaced after 150,000 starts or after 1250 arc-on hours.

The contact replacement procedure takes approximately 1/2 hour to complete.

129972 Kit Contents (240/380/400/415/480/575/600V Power supplies)

Part Number	Description	Qty
003219	Replacement contacts for 003217 contactor	1 Box of 3

129973 Kit Contents (200/220 Power supplies)

Part Number	Description	Qty
003220	Replacement contacts for 003218 contactor	1 Box of 3



WARNING

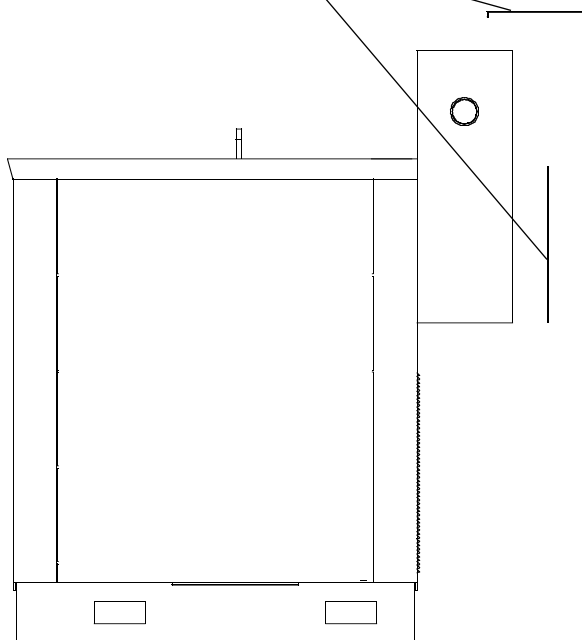


SHOCK HAZARD: Always turn off power and wait 5 minutes before removing any cover on the power supply system. If power unit is directly connected to a line disconnect box, place line disconnect switch to OFF position. Lock out and tag out switch before proceeding!

REMOVING THE REAR PANEL

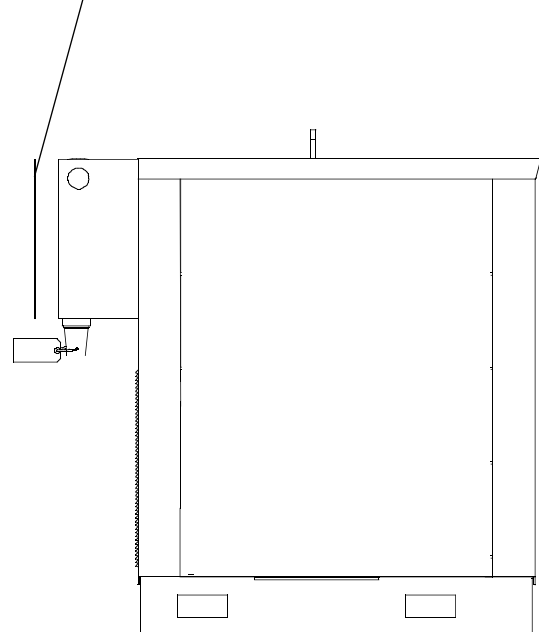
To replace contactor contacts, first remove the rear panel(s) of the power supply and locate the contactor.

Remove panels to access contactor



**HT4001 - 400V CE and 200/220V
Power Supplies**

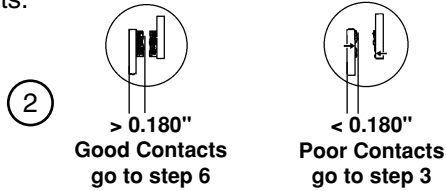
Remove panel to access contactor



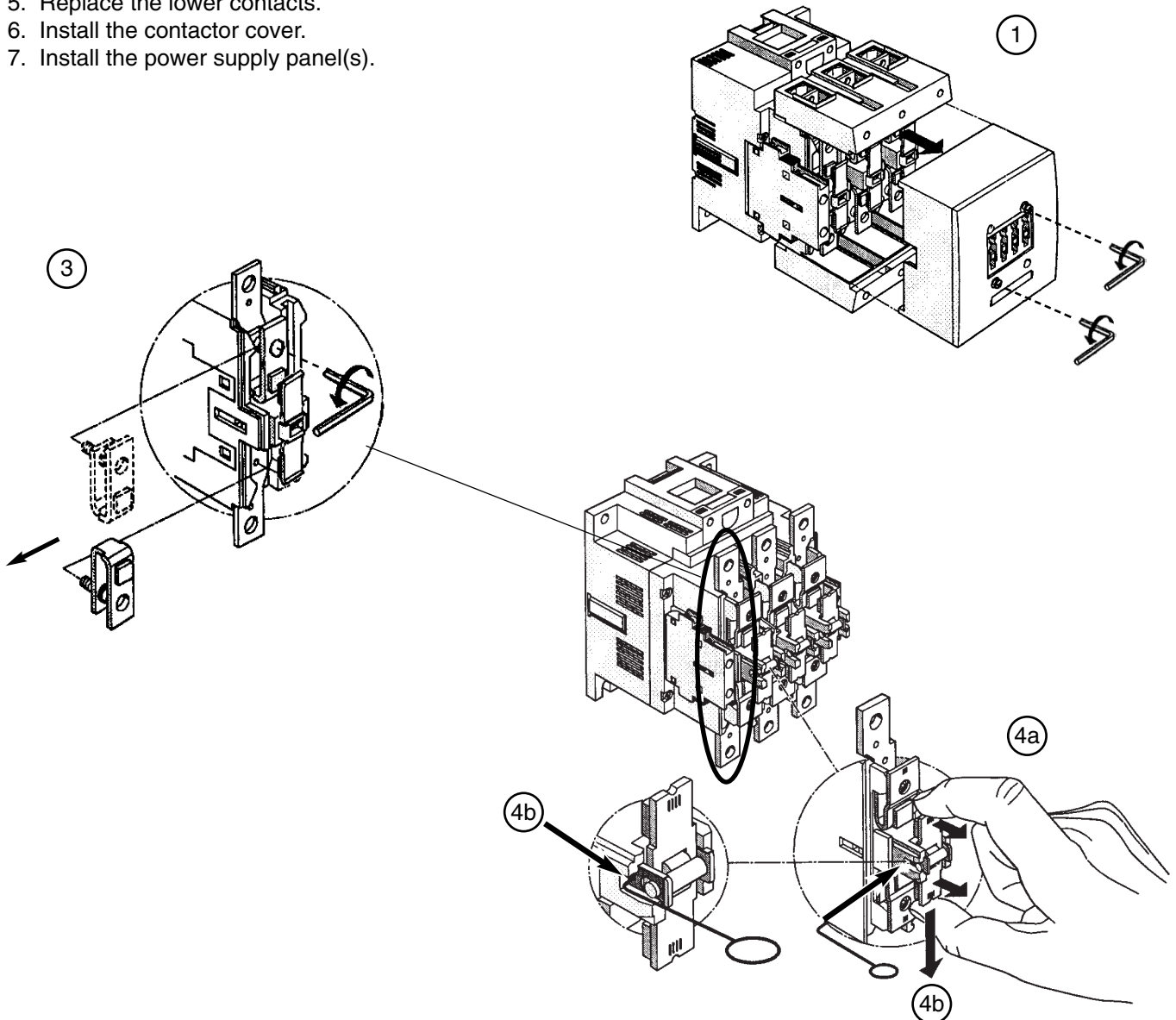
**HT4001 - 240/380/415/480/575/600V and
ALL HT4400 Power Supplies**

REPLACING THE CONTACTOR CONTACTS

1. Remove 2 allen head bolts from contactor cover as shown below and remove cover.
2. Inspect contacts.



3. Using an Allen wrench, remove lower contacts.
4. Remove the upper contacts.
 - 4a. Pull on upper contact until hole is revealed.
 - 4b. Place a 3/32 allen wrench in hole. Remove and replace upper contacts.
5. Replace the lower contacts.
6. Install the contactor cover.
7. Install the power supply panel(s).



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