HT400

Arc Transfer Sensor PCB Installation

Field Service Bulletin
IM-330
(P/N 803300)

Revision 0 July, 1998

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

Installation of Arc Transfer Sensor PCB to HT400 Power Supply

WARNING

INSTALLATION MUST BE PERFORMED ONLY BY HYPERTHERM DISTRIBUTORS OR QUALIFIED ELECTRONICS TECHNICIANS!!

SHOCK HAZARD: Always turn off power, unplug cord from wall and wait 5 minutes before removing cover of the power supply! 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!

General

The HT400 arc transfer sensor PCB has a new current sensor on it. In order to replace the new version of the 041089 arc transfer sensor PCB on existing HT400 power supplies, follow the directions below.

Tools Needed

- phillips head screwdriver
- flathead screwdriver
- wire clippers
- wire strippers
- wire crimpers

Removing Old Arc Transfer Sensor PCB

1. Disconnect the power from the power supply.
2. Remove the screws that secure the power supply cover to the power supply.
3. Remove the power supply cover.
4. Locate the center bail. See Figure 1.
5. Remove all of the wires that are attached to the arc transfer sensor PCB.
6. Remove the arc transfer sensor PCB.

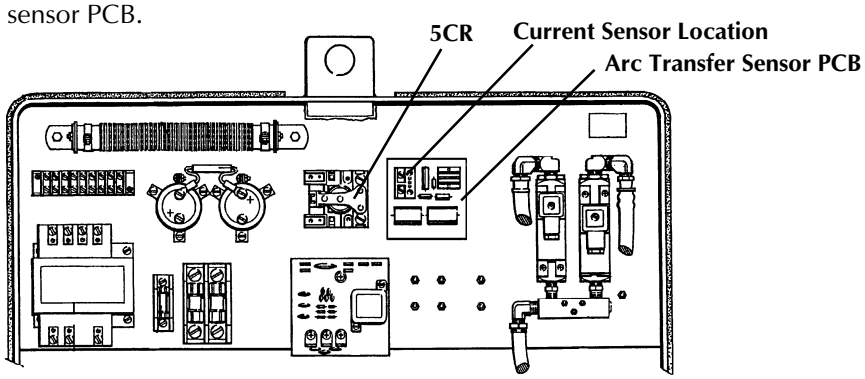

Figure 1 HT400 Center Bail and Location of Arc Transfer Sensor PCB

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Installing New Arc Transfer Sensor PCB - Figure 2

1. Cut the terminal lugs off of the two 10 AWG wires that were screwed into the old current sensor (Figure 1).
2. Strip back both wires 3/8" (10 mm) using an electrical wire stripping tool.
3. Install the new 041089 arc transfer sensor PCB onto the HT400 bail.
4. Connect wire terminals to AC1, AC2, 76 and 4 locations on the PCB.
5. Run the stripped wire coming from R6 through the hole in the new current sensor.
6. Place the stripped wire from R6 into one end of the 074250 splice.
7. Place the stripped wire from 5CR (Figure 1) into the other end of the 074250 splice.
8. Crimp both ends of the 074250 splice with a crimping tool.
9. Replace the HT400 power supply cover.

Installation is complete.

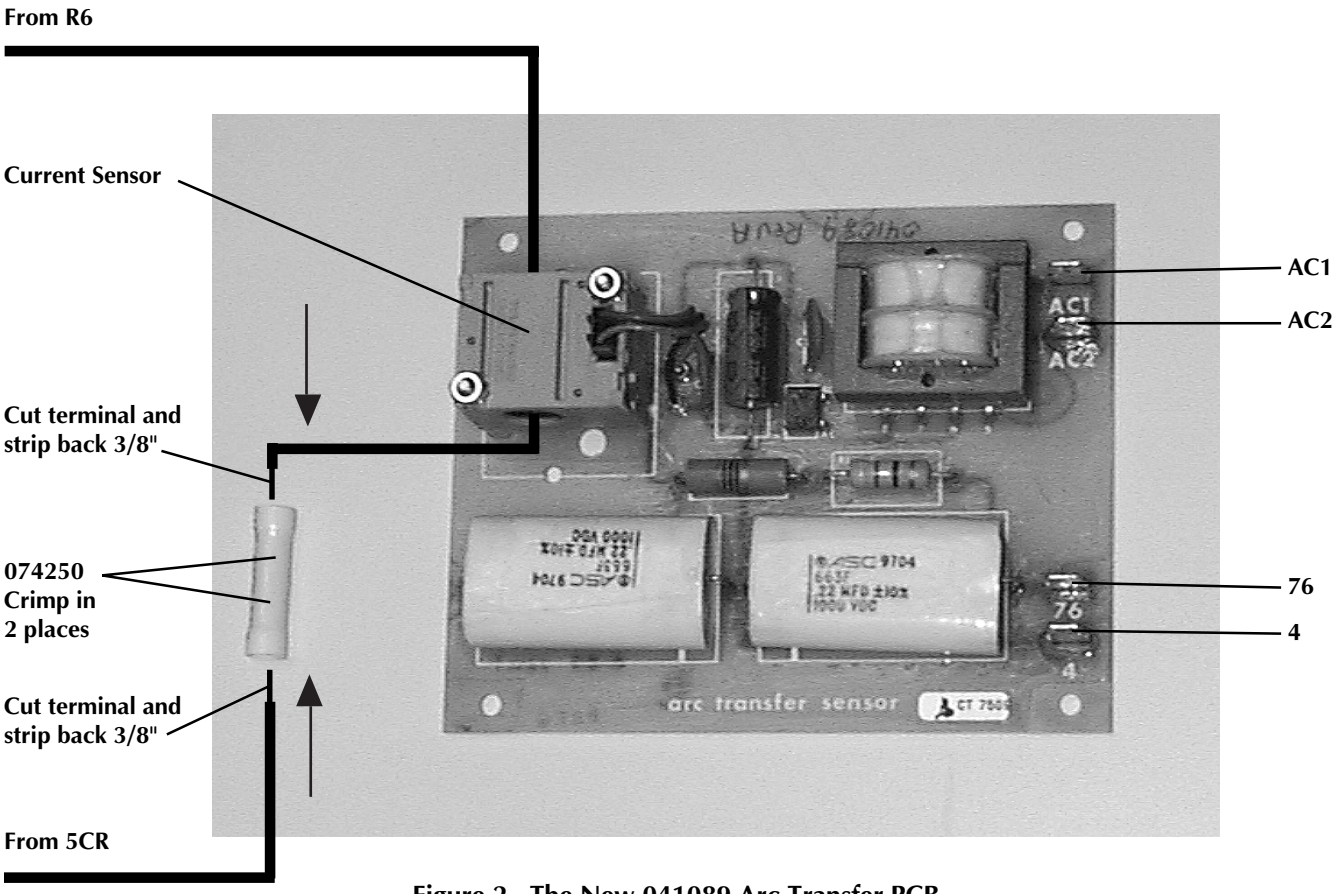

Figure 2 The New 041089 Arc Transfer PCB