

# ***PAC121M/40cs***

## **Torch Main Body Replacement**

**Kit: 128332**

### **Field Service Bulletin IM-332 (P/N 803320)**

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# Replacing PAC121M/40cs Torch Main Body

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## Kit Contents

| Part Number | Description   | Quantity |
|-------------|---|----------|
| 046066      | Heat Shrink:3/8"ID Black/1"   | 2        |
| 075322      | Machine Screw:4-40 X 1/4 Pan Head                                   | 1        |
| 120554      | PAC121M Torch Main Body w/switch Replacement                        | 1        |
|             | 6" Tie-wrap   | 3        |
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## WARNING



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

## REMOVAL OF TORCH BODY FROM TORCH LEAD

1. Set the power supply power switch to **O** (off), unplug the power cable, and disconnect the gas supply. Disconnect the torch lead from the power supply.
2. Unscrew the torch position sleeve from the torch mounting sleeve and slide it back out of the way.
3. Remove the 3 screws securing the torch mounting sleeve to the torch body. Save the torch mounting sleeve and the screws.
4. Remove the heat shrink from the terminals of the microswitch wires and disconnect all mating terminals between the torch body and the torch lead.
5. Disconnect the red wire(s) from the torch body using a Philips head screwdriver. Discard the screw.
6. Disconnect the gas lead from the torch body using 5/16" (8 mm) and 7/16" (11 mm) wrenches .
7. Remove the torch body from the torch lead.

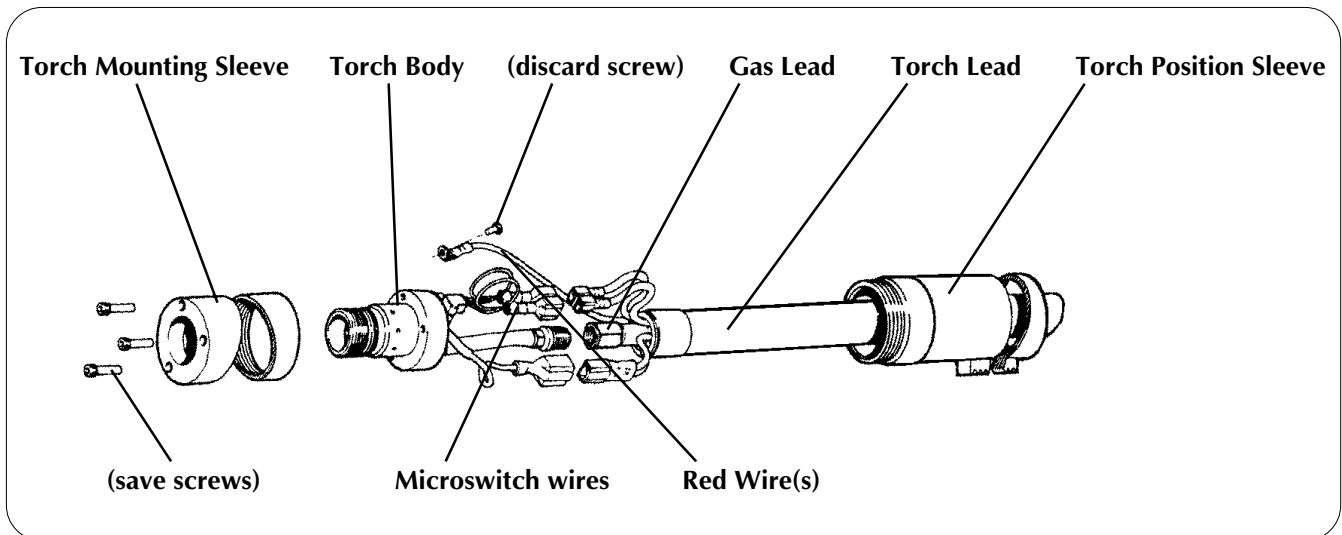


Figure 1 PAC121M/40cs Torch Body Removal

# Replacing PAC121M/40cs Torch Main Body

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## REPLACING TORCH BODY TO TORCH LEAD

1. Connect the gas lead to the new torch body using 5/16" (8 mm) and 7/16" (11 mm) wrenches . Tighten 1/4 turn beyond finger-tight.
2. Connect the red wire(s) to the torch body using the Phillips head screw included in the kit.
3. Slip the 2 pieces of the heat shrink included in the kit over the 2 microswitch wires.
4. Connect all mating terminals between the torch body and the torch lead.
5. Position the heat shrink over the mating terminals from the microswitch and apply heat until the heat shrink is snug.
6. Tie the plunger wire back on the torch lead as shown in Figure 2. With the ties in place and snugged down, adjust the wire so that there is 1/4" (6 mm) of slack between the wire and the gas nut.
7. Attach the torch mounting sleeve to the torch body by securing the 3 screws to the torch body (Figure 1). Torque to 7 in. lbs.
8. Screw the torch position sleeve to the torch mounting sleeve.
9. Reconnect the torch to the power supply.

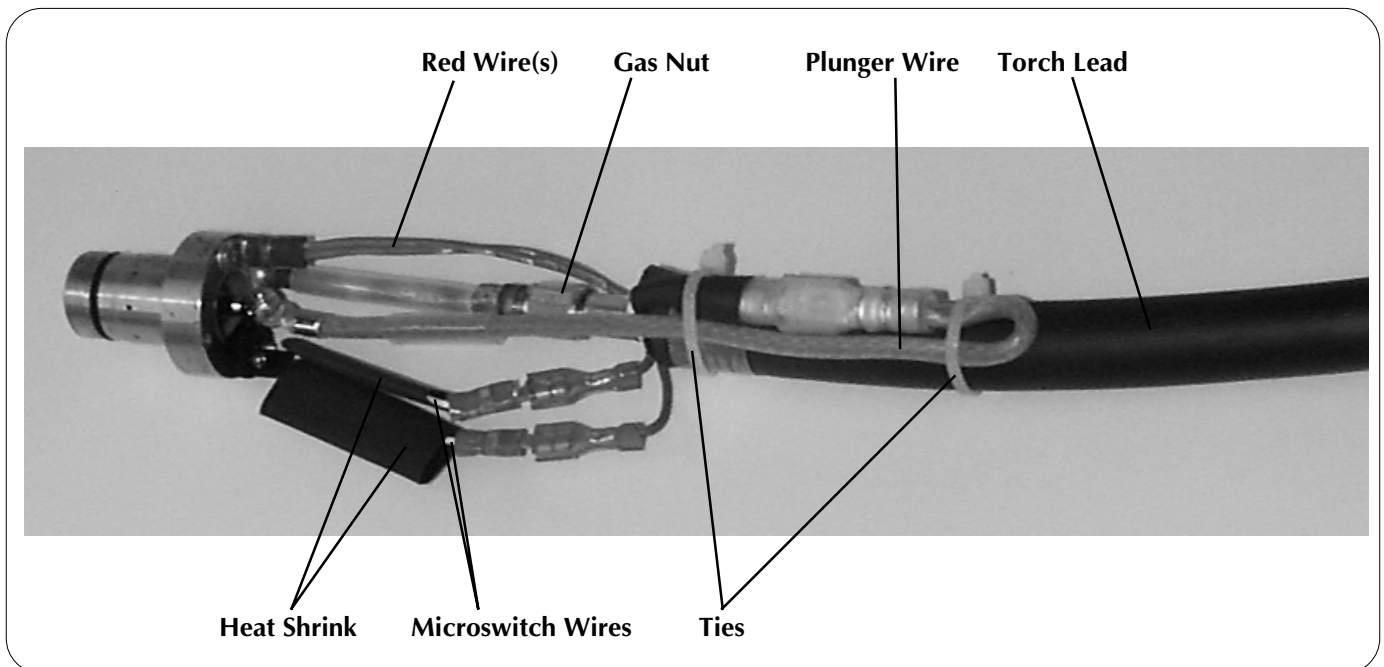


Figure 2 PAC121M/40cs Torch Body Replacement