

PAC121MS

Torch Main Body Replacement

Kit: 128333

Field Service Bulletin

IM-333

(P/N 803330)

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Replacing PAC121MS Torch Main Body

Kit: 128333

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
120558	PAC121MS Torch Main Body w/switch Replacement	1
	6" Tie-wrap	3
803330	Field Service Bulletin: PAC121MS Torch Main Body Replacement	1

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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.

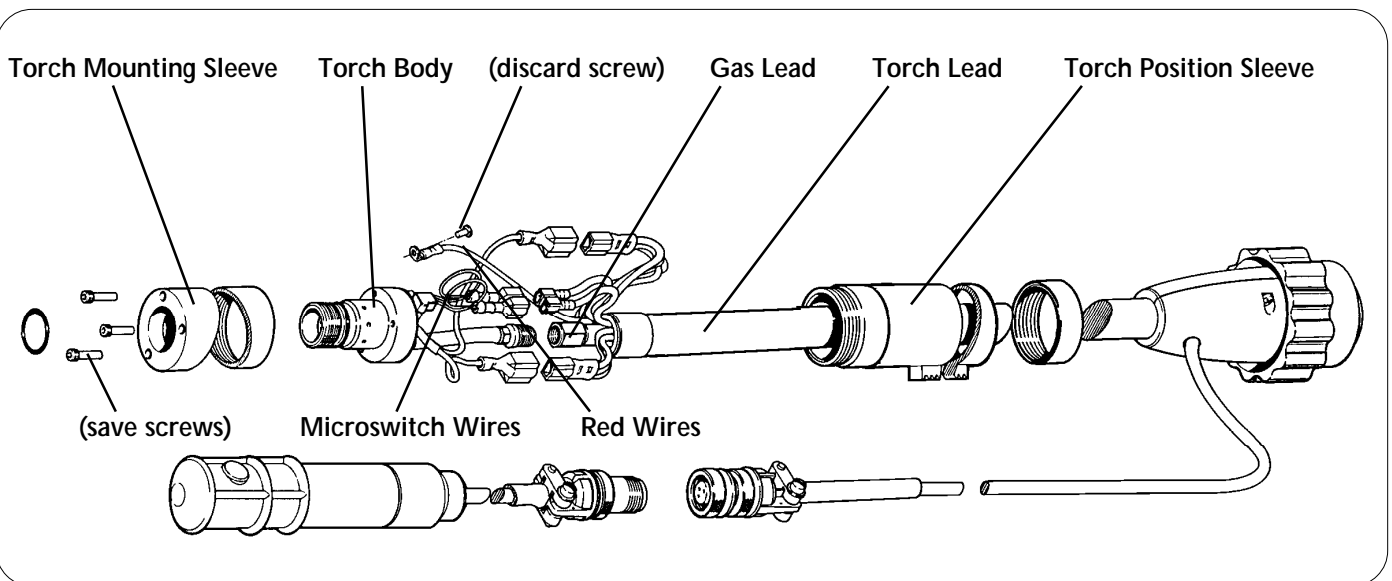


Figure 1 PAC121M Torch Body Removal

Replacing PAC121MS 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 wires back on the torch lead as shown in Figure 2. With the ties in place and snugged down, adjust the wires so that there is 1/4" (6 mm) of slack between the wires 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.

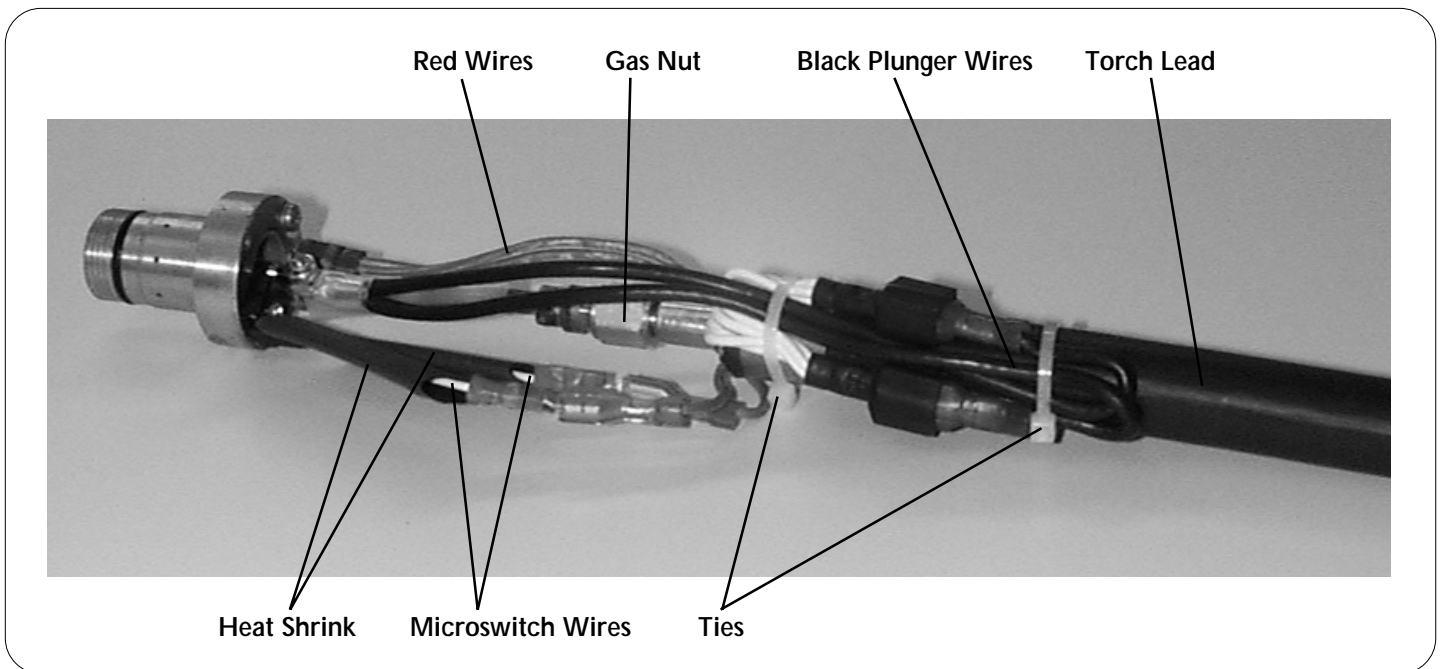


Figure 2 PAC121M Torch Body Replacement