

# ***PAC121M/40cs***

## **Torch Plunger Wire Replacement**

**Kit: 128335**

### **Field Service Bulletin IM-334 (P/N 803340)**

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# Replacing PAC121M/40cs Torch Plunger Wire

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## 128335 Kit Contents

Part Number	Description	Quantity
075503	Nut: 4-40	1
075504	Machine Screw: 4-40 X 5/16 in.	1
123382	PAC121M/40cs Torch Replacement Plunger Wire (w/clear heat shrink)	1
-	4-inch Tie-wrap	3
803340	Field Service Bulletin: PAC121M/40cs Torch Plunger Wire Replacement	1

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## WARNING



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

## TORCH LEAD PLUNGER WIRE - REMOVE (FIGURE 1)

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. Disconnect the plunger wire from the torch lead connector. Leave all other connections, including the red wire and the blue wires, intact.
5. Disconnect the plunger wire from the torch body plunger using a Philips head screwdriver. Some versions will also require a 1/4 inch (6 mm) nut driver. Discard the screw and nut, if applicable.
6. Remove the plunger wire.

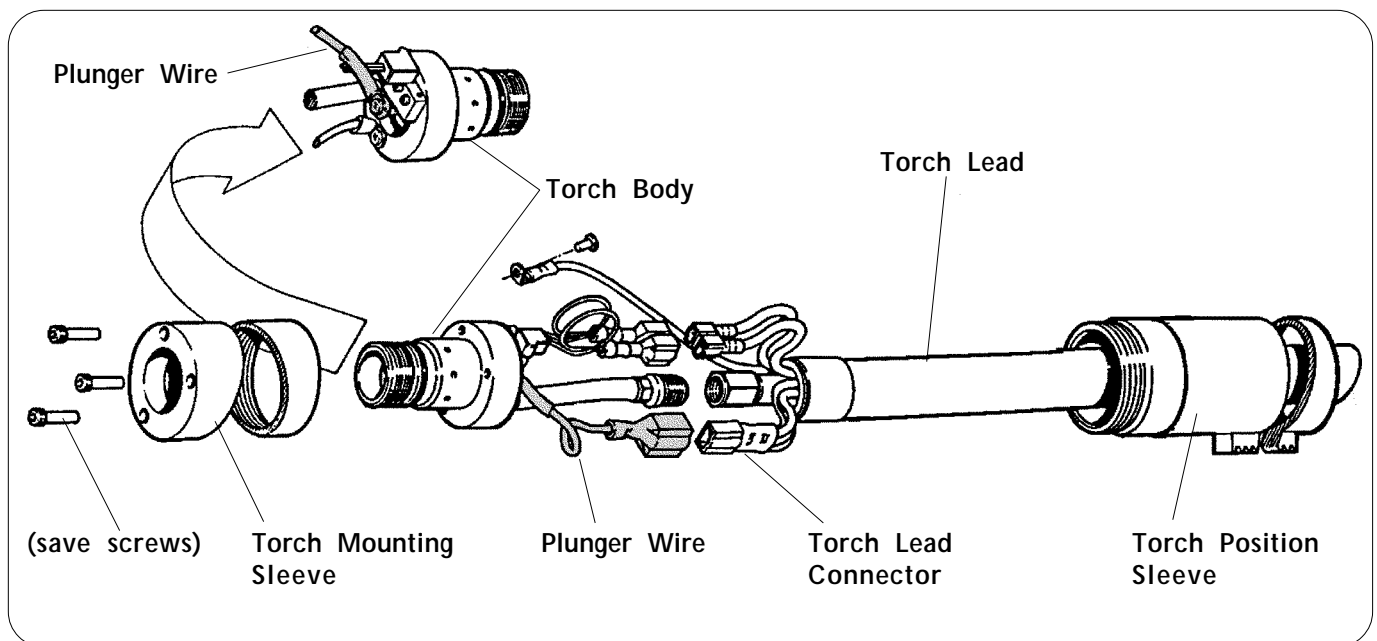


Figure 1 PAC121M/40cs Plunger Wire - Remove/Install

# Replacing PAC121M/40cs Torch Plunger Wire

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## TORCH LEAD PLUNGER WIRE - INSTALL (FIGURE 1 AND 2)

1. Install the new plunger wire to the plunger using the Phillips head screw (and nut if applicable) included in the kit. Some plunger designs will also require the use of the nut.
2. Torque the screw to 4 in. lb. If the screw and nut are required, torque to 7 in. lb.
3. Orient the terminal to point away from the torch body, bending the terminal if necessary.
4. Position the clear heat shrink tubing over the plunger terminal and apply heat until tubing is snug.
5. Connect the plunger wire to the torch lead connector.
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 inch (6 mm) of slack between the wire and the gas nut. Tighten and trim ties.
7. Attach the torch mounting sleeve to the torch body with the 3 screws (Figure 1). Torque to 7 in. lb.
8. Screw the torch position sleeve to the torch mounting sleeve.
9. Reconnect the torch to the power supply.

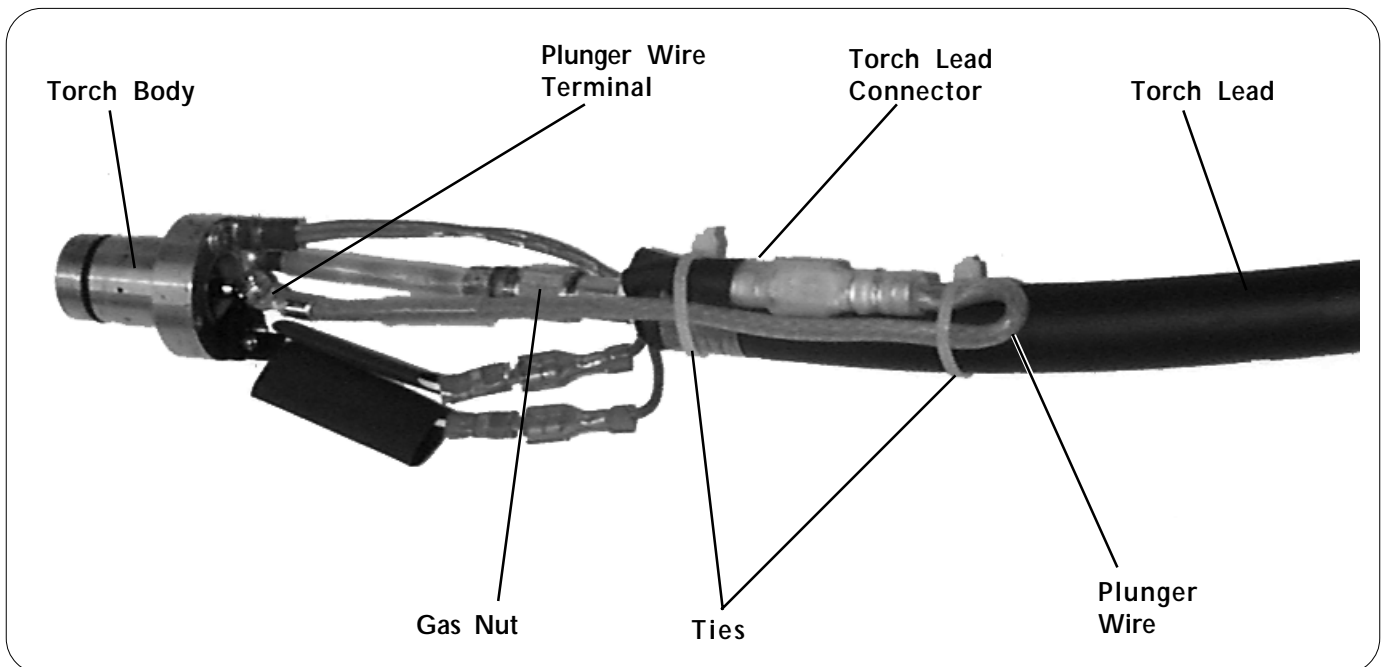


Figure 2 PAC121M/40cs Plunger Wire - Install