

***129252 Motor/Pump Replacement for  
HT2000/HT2000LHF/MAX200  
Power Supplies***

**Kit: 128340**

**Field Service Bulletin  
IM-337  
(P/N 803370)**

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## WARNING



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

## INTRODUCTION

This field service bulletin will enable a qualified technician to install the motor/pump assembly to either the HT2000, HT2000LHF or MAX200 power supplies.

## KIT 128340 CONTENTS

This kit also includes a coolant filter rerouting kit - 128343. See instruction manual 803380 to install kit 128343 in your power supply.

Part Number	Description	Qty
046047	Tubing:3/8"OD Black Air-Brake	9"
075538	Screw #10-24 x 3/8	2
075203	Flat washer:#10 .062 W	2
129252	Water Pump Sub Assembly	1
129383	Valve Assembly:HT2000 Power Supply	1
803370	FSB: Pump Replacement for HT2000/2000LHF and MAX200	1
128343	Kit:200/2000 Filter Reroute	1

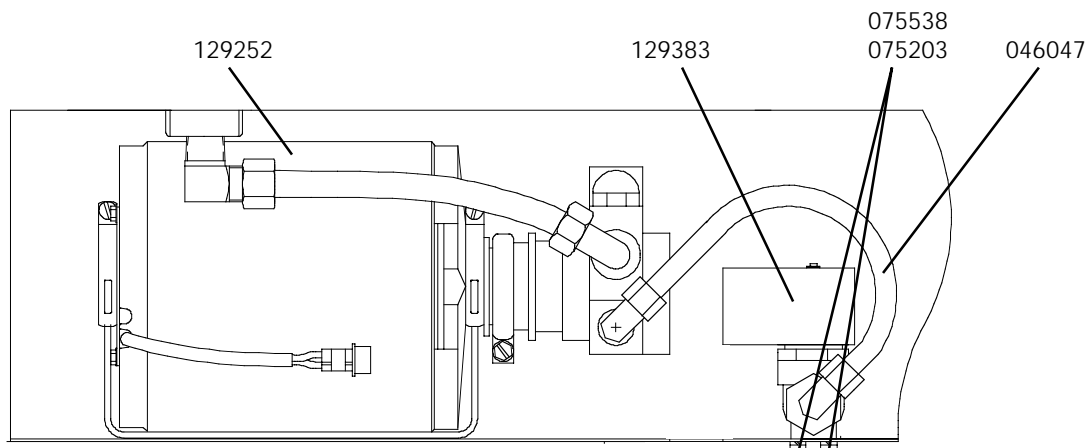
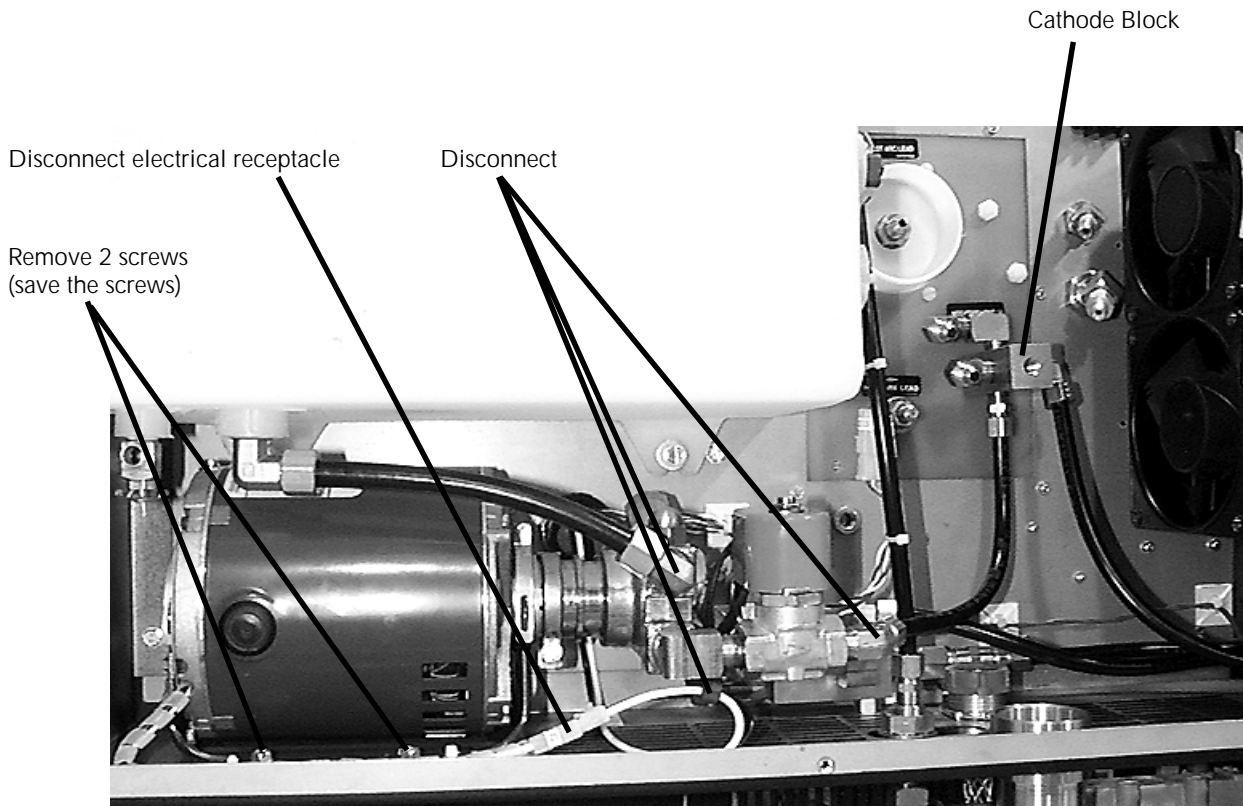


Figure 1 Kit 128340 Contents

## **PUMP ASSEMBLY INSTALLATION**

### **Removing Old Pump and Valve Assembly**

1. Set the power supply power switch to **O (off)**, unplug the power cable and turn off the supply gases.
2. Remove power supply rear cover.
3. Drain coolant from the system. See your instruction manual for torch coolant draining procedure.
4. Disconnect all hose and wiring connections to your pump and solenoid valve. Save hoses. See Figure 2.
5. Remove the 2 screws securing the pump motor to the power supply. Save the screws.
6. Remove the pump, motor and valve assembly from the power supply.



**Figure 2 Old Pump and Valve Removal**

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## Install the 129252 Motor/Pump and 129383 Valve Assemblies to Power Supply

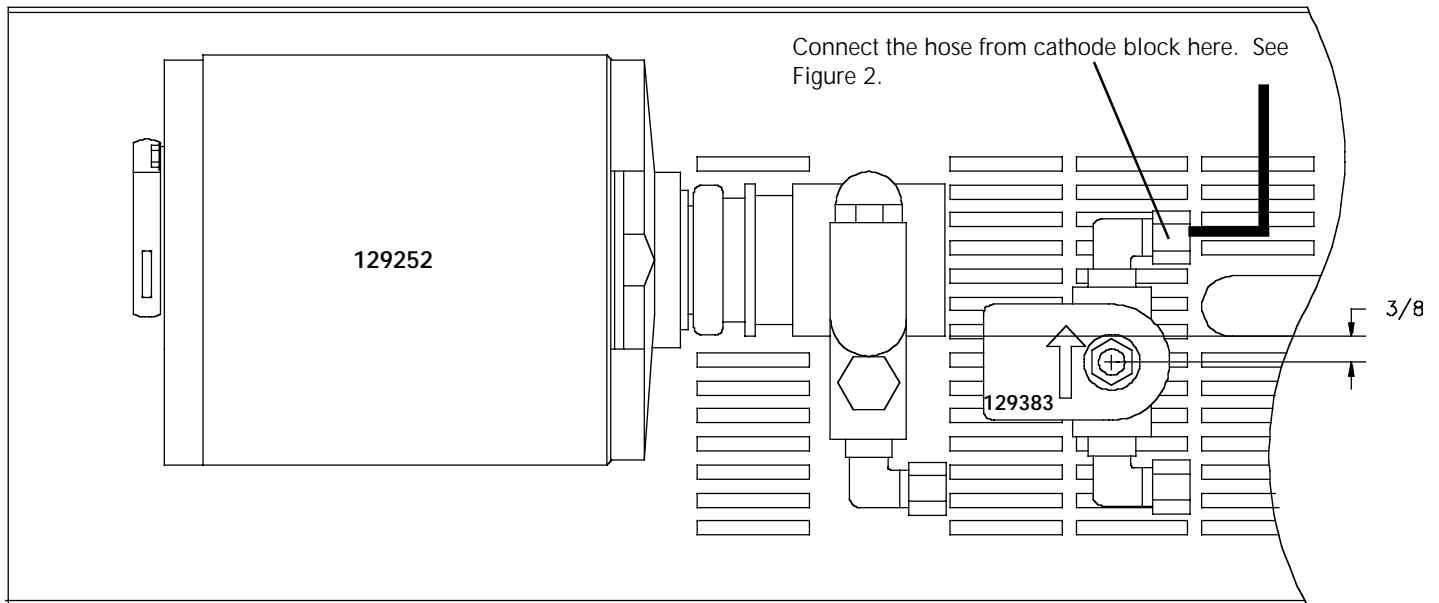


Figure 3 129252 and 129383 Assemblies Installed - View From Rear Top of Power Supply

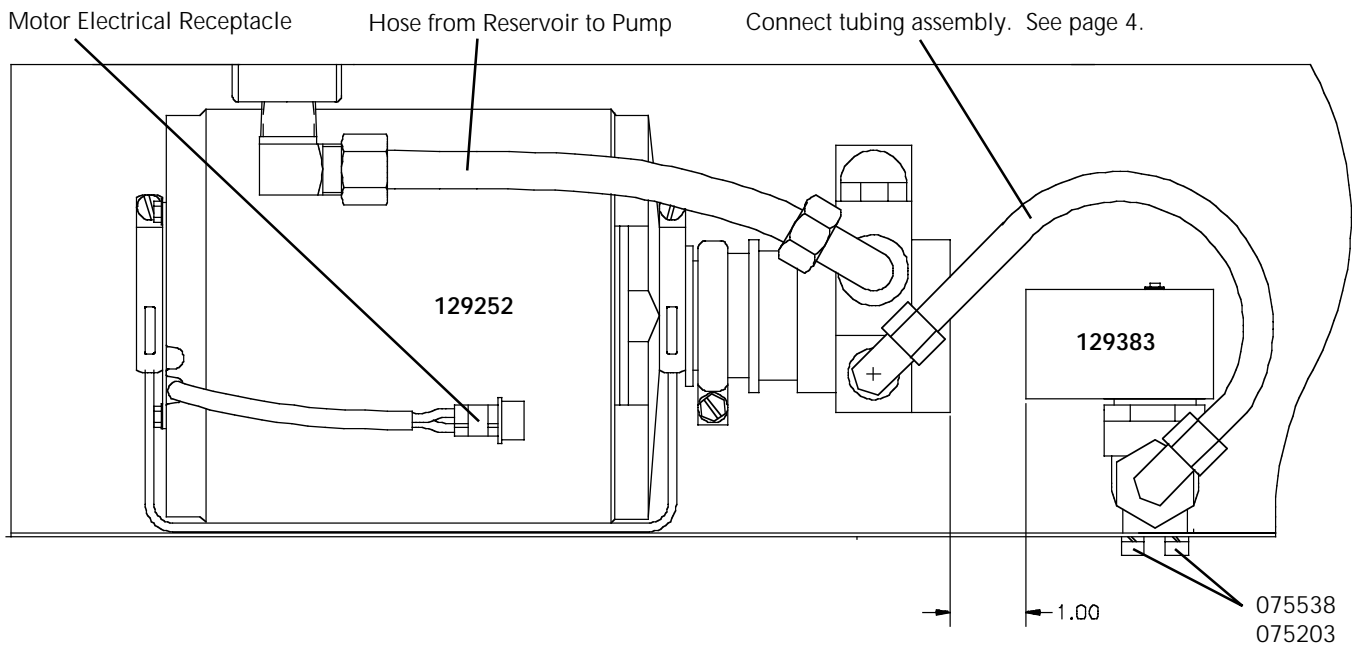


Figure 4 129252 and 129383 Assemblies Installed - View From Rear of Power Supply

1. Install the 129252 motor/pump assembly to the power supply and fasten in place using the screws saved from step 5 on the previous page.
2. Reconnect the hose from the reservoir to the pump. Tighten fittings to 75-85 lbf-in (86-98 kgf-cm) of torque.
3. Install the 129383 valve assembly to the power supply by screwing the 075538 screws and 075203 washers into the valve through 2 of the perforated slots in the power supply rear panel shelf. Note the valve placement dimensions in the 2 figures above

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4. Assemble tubing, insert, sleeve and adapter as shown in Figure 5 below. Note orientation of sleeve.
5. Assemble tubing assembly to the valve and pump. See Figure 4. Tighten fittings to 75-85 lbf-in (86-98 kgf-cm) of torque.
6. Reconnect the remaining hose from the cathode block to the valve assembly. See Figure 3. Tighten fittings to 75-85 lbf-in (86-98 kgf-cm) of torque.
7. Connect the motor electrical receptacle to the power supply harness plug. See Figure 4.
8. Connect the valve terminals to the tabs on the electrical wire harness. Connect 106 terminal to black wire and 107 wire to white wire.

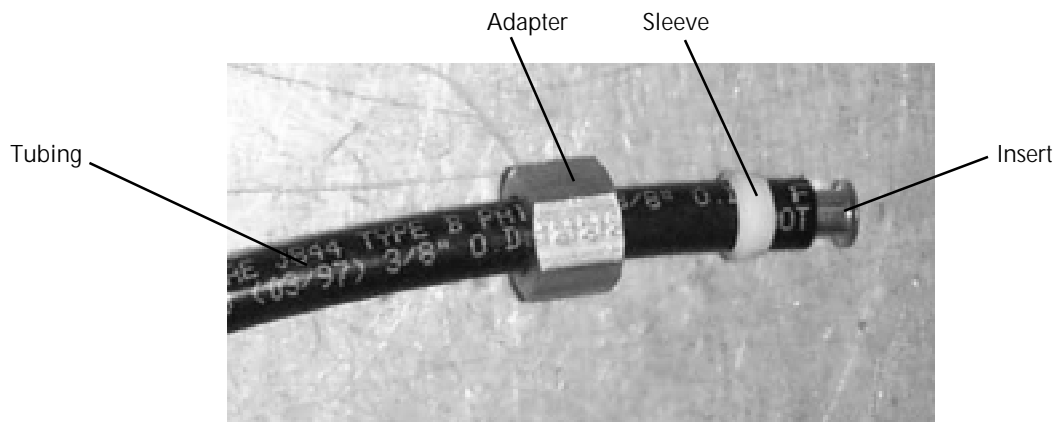


Figure 5 Tubing, Insert, Sleeve and Adapter Assembly

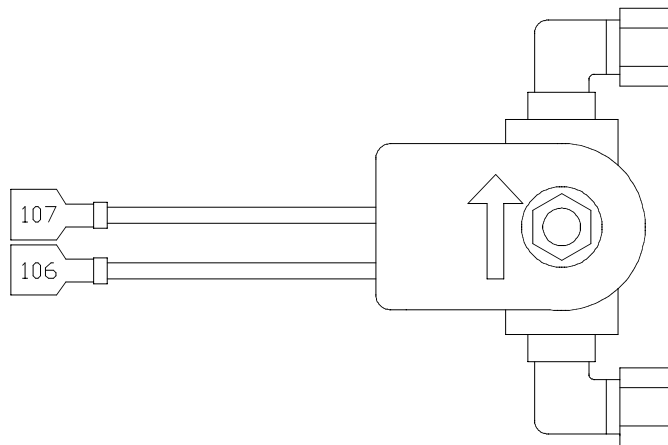


Figure 6 Valve Assembly

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Below is an example of the completed pump installation. Note that some connections not associated with these installation steps may be missing or have been modified to better show the motor/pump and valve installation detail.

After installation is complete, refill reservoir with coolant, attach power supply rear cover and resume operation.

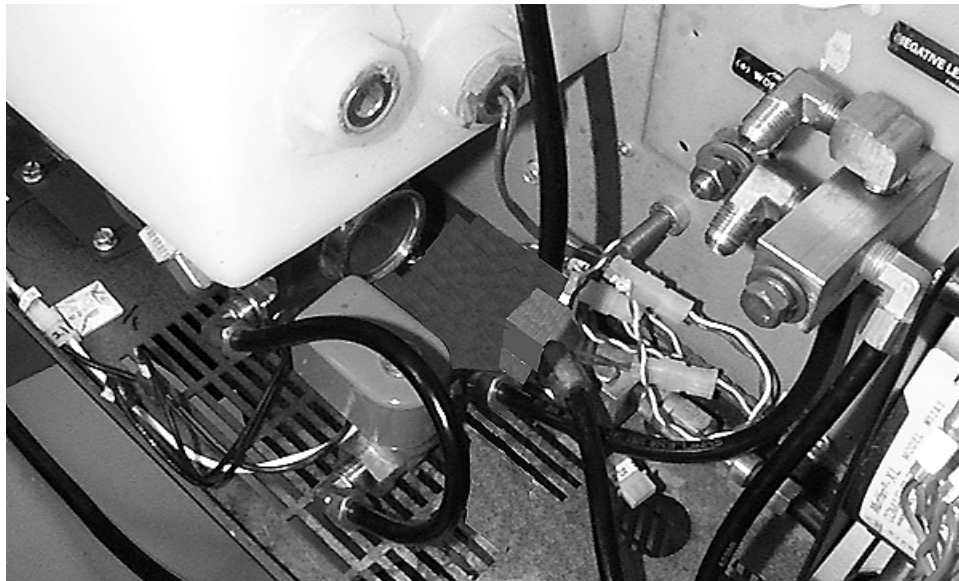
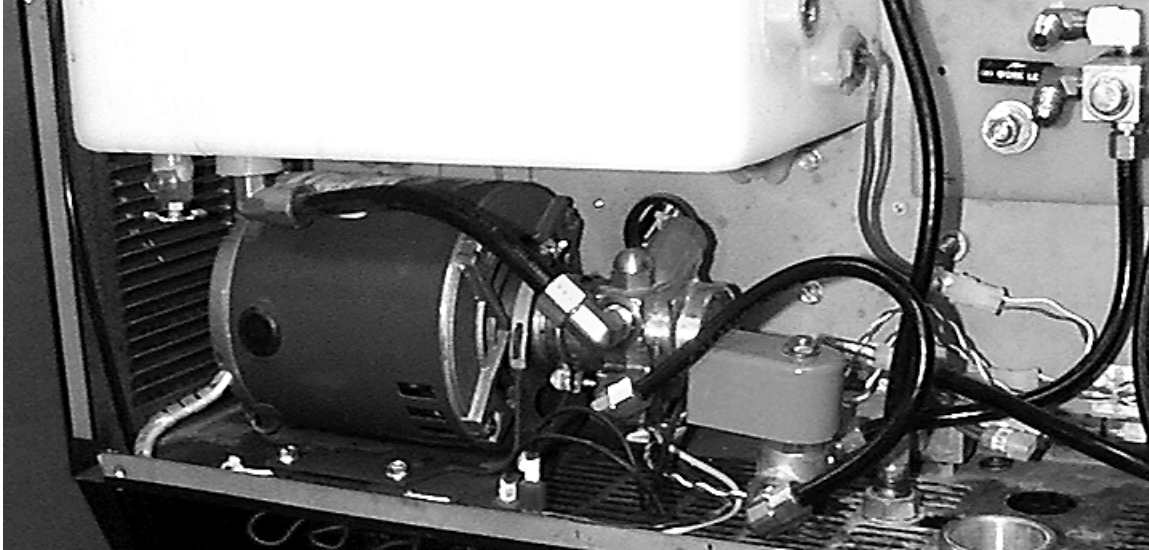


Figure 7 Rear and Rear Top View of Power Supply after Pump Installation