

Coolant Filter Re-Routing for HT2000/HT2000LHF/MAX200 Power Supplies

Field Service Bulletin

803380 – Revision 2 – April, 2007

Hypertherm®

Coolant Filter Re-Routing for HT2000/HT2000LHF/MAX200 Power Supplies

Kit: 128343



WARNING



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

INTRODUCTION

This field service bulletin will enable a qualified technician to re-route the coolant through the particulate filter on the HT2000, HT2000LHF or MAX200 power supplies. The re-routing will enable the coolant to be filtered before travelling to the flow switch.

KIT 128343 CONTENTS

This kit is included in the 128340 pump replacement kit. See instruction manual 803370 to install the pump kit.

Part Number	Description	Qty
024551	Tubing:3/8"OD Black TFE	1
015131	Adapter: 1/4NPT X 3/8	1
015132	Adapter: 1/4NPT X 3/8 90°	1
015133	Sleeve:3/8 Plastic Sleeve	8
015134	Insert:3/8 Plastic Tube Brass	8
803380	FSB: HT2000/LHF/MAX200 Coolant Filter Re-Routing	1

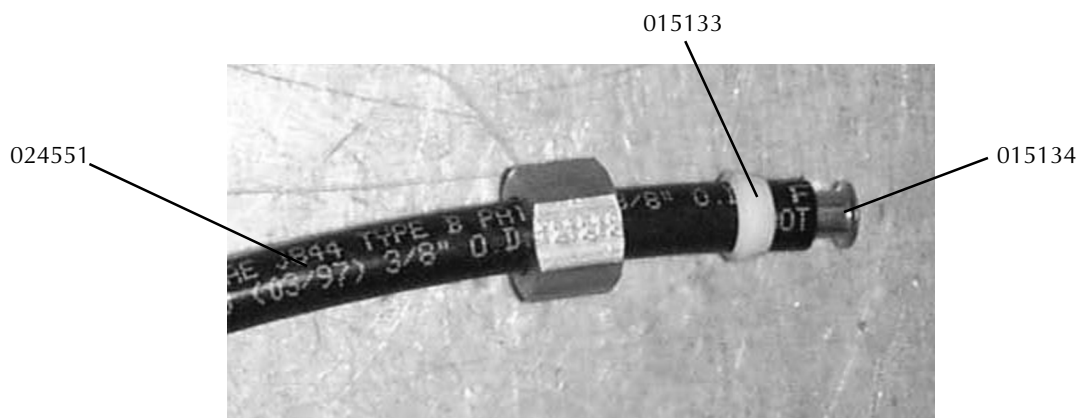


Figure 1 Kit 128343 Contents (adapters not shown)

Coolant Filter Re-Routing for HT2000/HT2000LHF/MAX200 Power Supplies

Kit: 128343

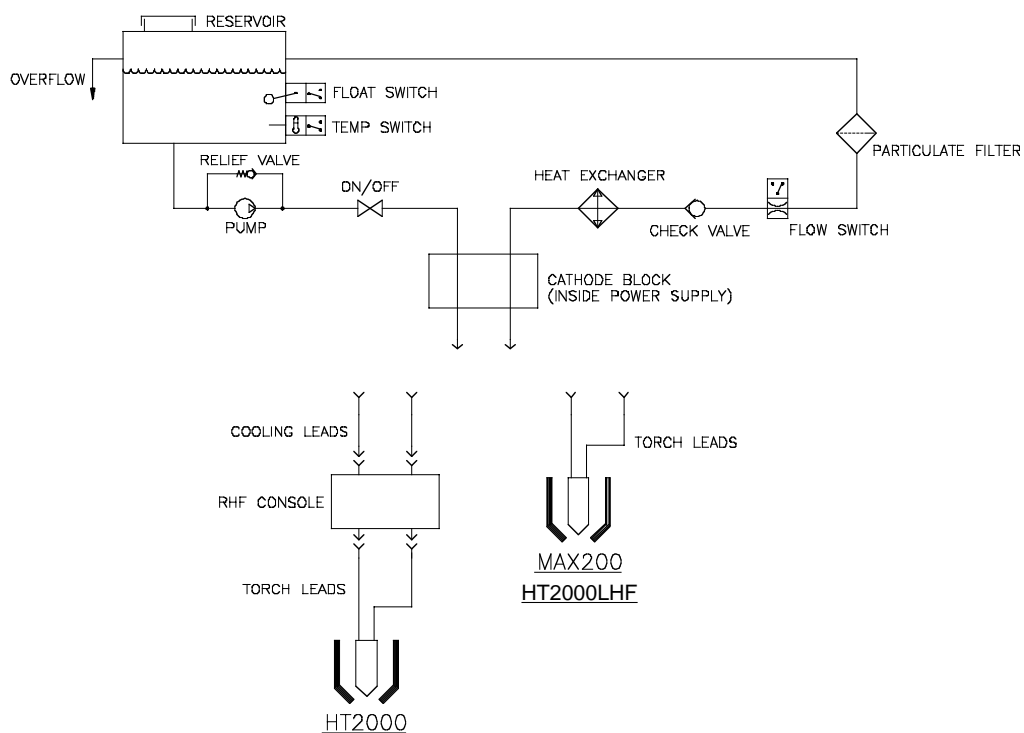


Figure 2 Coolant Flow Schematic Before Filter Re-Routing

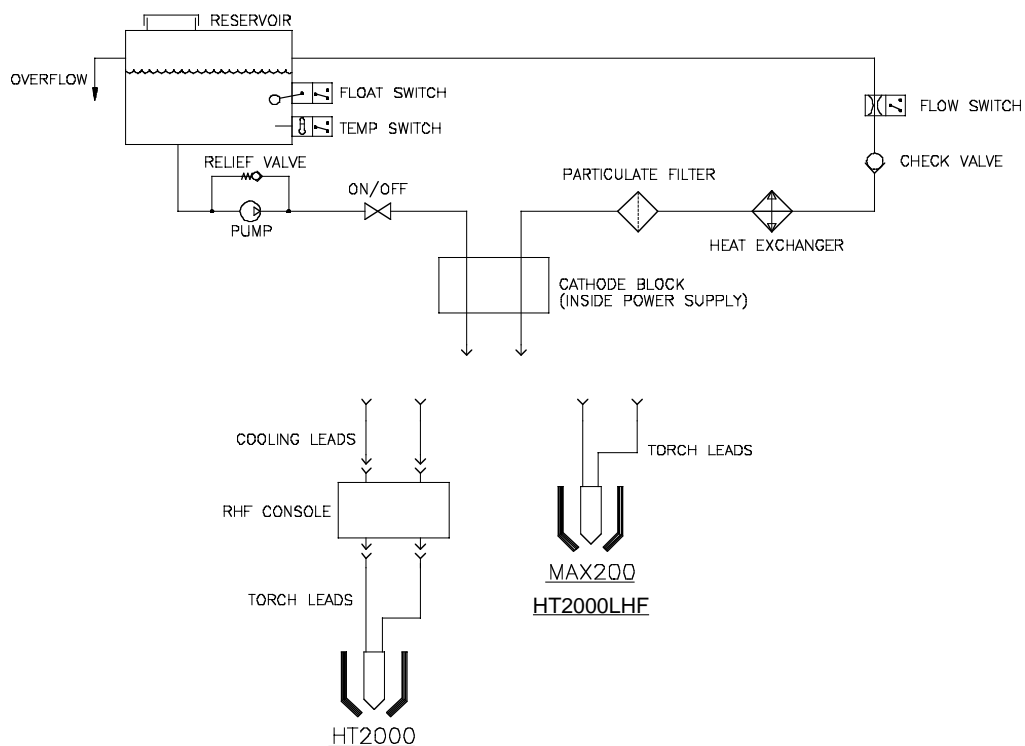


Figure 3 Coolant Flow Schematic After Filter Re-Routing

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Kit: 128343

REMOVE THREE HOSES FROM COOLANT DELIVERY SYSTEM

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. Remove the hoses that are shown in white below (3). The routing of these hoses will change.
5. Remove and save the hose fittings.

Remove Hose

Remove Hoses

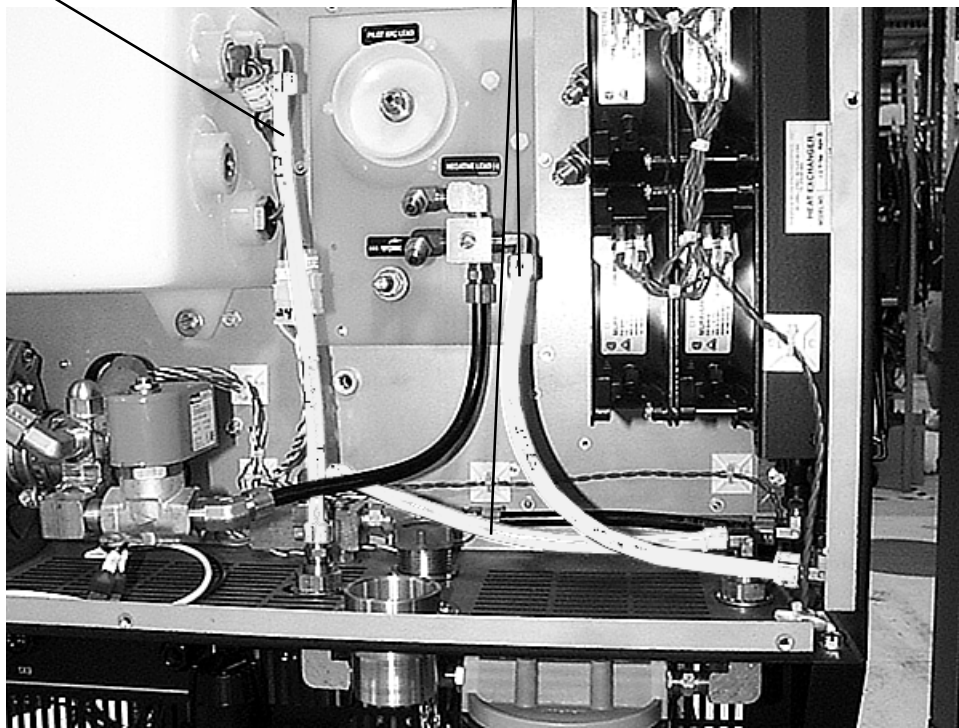


Figure 4 Removing Old Hoses

Coolant Filter Re-Routing for HT2000/HT2000LHF/MAX200 Power Supplies

Kit: 128343

ASSEMBLE KIT INSERT AND SLEEVE INTO KIT HOSES

1. Assemble the 015134 insert, and 015133 sleeve from the kit with the fittings saved from the old hoses into both ends of the three 024551 kit hoses, as shown in Figure 5 below (the kit includes an extra sleeve and insert). Note the orientation of the 015133 sleeve.

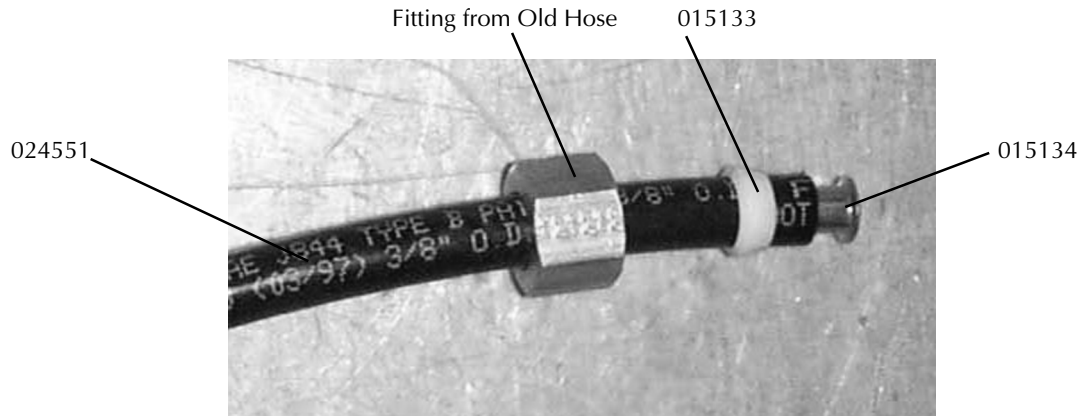


Figure 5 Tubing, Insert, Sleeve and Fitting Assembly

INSTALL THREE HOSES IN THE COOLANT DELIVERY SYSTEM

1. Attach the two adapters (015131 and 015132) from the kit in the two locations indicated in Figure 6.
2. Install the hoses that are shown in white to the locations indicated in Figure 6. Tighten fittings to 75-85 lbf-in (86-98 kgf-cm) of torque.

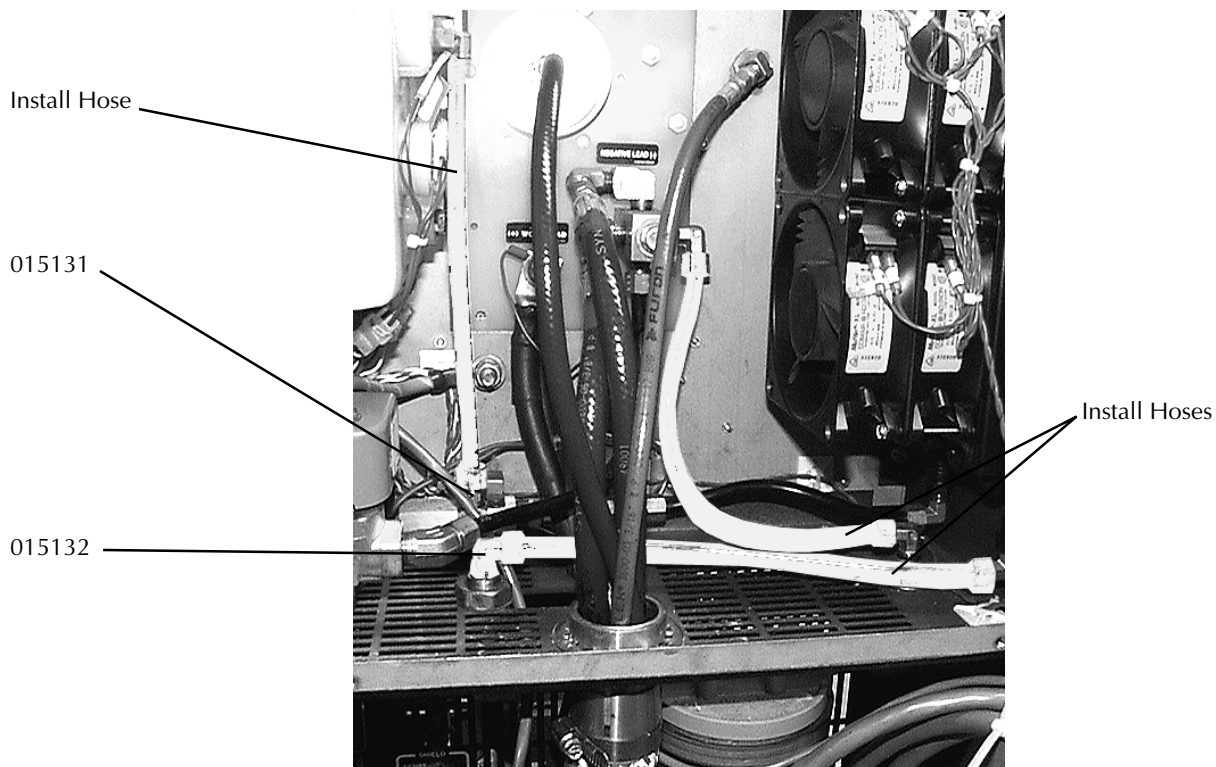


Figure 6 Installing New Hoses

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

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