

Hypertherm[®]

**THC Motherboard Relay
Replacement**

Kit: 128404

**Field Service Bulletin
IM-356
(P/N 803560)**

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**Hypertherm, Inc.
Hanover, NH
<http://www.hypertherm.com>
[email:info@hypertherm.com](mailto:info@hypertherm.com)**

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Hypertherm Offices Worldwide:

Hypertherm, Inc.

**Etna Road, P.O. Box 5010
Hanover, NH 03755 USA
Tel.: (603) 643-3441 (Main Office)
Fax: (603) 643-5352 (All Departments)
Tel.: (800) 643-9878 (Technical Service)
Tel.: (800) 737-2978 (Customer Service)**

Hypertherm Plasmatechnik GmbH

**Technologiepark Hanau
Rodenbacher Chaussee 6
D-63457 Hanau-Wolfgang, Germany
Tel.: 49 6181 58 2100
Fax: 49 6181 58 2134**

European Technical Support Organization (ETSO)

**Technologiepark Hanau
Rodenbacher Chaussee 6
D-63457 Hanau-Wolfgang, Germany
Tel.: 49 6181 58 2100
Fax: 49 6181 58 2134**

Hypertherm Singapore Pte Ltd

**No. 19 Kaki Bukit Road 2
K.B. Warehouse Complex
Singapore 417847, Republic of Singapore
Tel.: 65 841 2489
Fax: 65 841 2490**

Hypertherm U.K.

**9 Berkeley Court • Manor Park
Runcorn, Cheshire, England WA7 1TQ
Tel.: 44 1928 579 074
Fax: 44 1928 579 604**

France

**10, Allée de l'Isara
F-95000 Cergy-Pontoise, France
Tel.: 33 1 34 24 03 05
Fax: 33 1 34 25 09 64**

Italy



**Via Torino 2
20123 Milan, Italy
Tel.: 39 02 725 46 312
Fax: 39 02 725 46 400**

THC Motherboard Up / Down DC Relay Replacement

INTRODUCTION

This field replacement kit is for customers that have an HT4001, HT4100, HT2000, HT2000LHF or MAX200 power supply with the on-board torch height (THC) control system, and who need to interface the THC torch UP/DOWN motion signals with a DC torch-lifter motor.

128404 Kit Contents		
Part No.	Description	Qty
003111	Relay: .02-1A@10-200 VDC, Solid State	2
803560	FSB: THC Motherboard Up/Down DC Relay Replacement	1

		WARNING ELECTRIC SHOCK CAN KILL
MODIFICATION MUST BE PERFORMED ONLY BY HYPERTHERM TECHNICIANS, DISTRIBUTORS OR QUALIFIED ELECTRONICS TECHNICIANS		
HT2000, HT2000LHF, MAX200, HT4100: Push the OFF (O) button on the power supply and turn the main disconnect switch OFF before removing the front panel of the power supply.		
HT4001: Position the ON/OFF circuit breaker on the rear of the power supply to the OFF (O) position and turn the main disconnect switch OFF before removing the rear panel of the power supply.		

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Relay Replacement

The stock THC motherboard comes with AC relays for torch UP and DOWN control. These 2 relays, CR2 and CR3 must be removed from the motherboard and replaced with the 003111 DC relays from this kit.

HT2000, HT2000LHF, MAX200, HT4100:

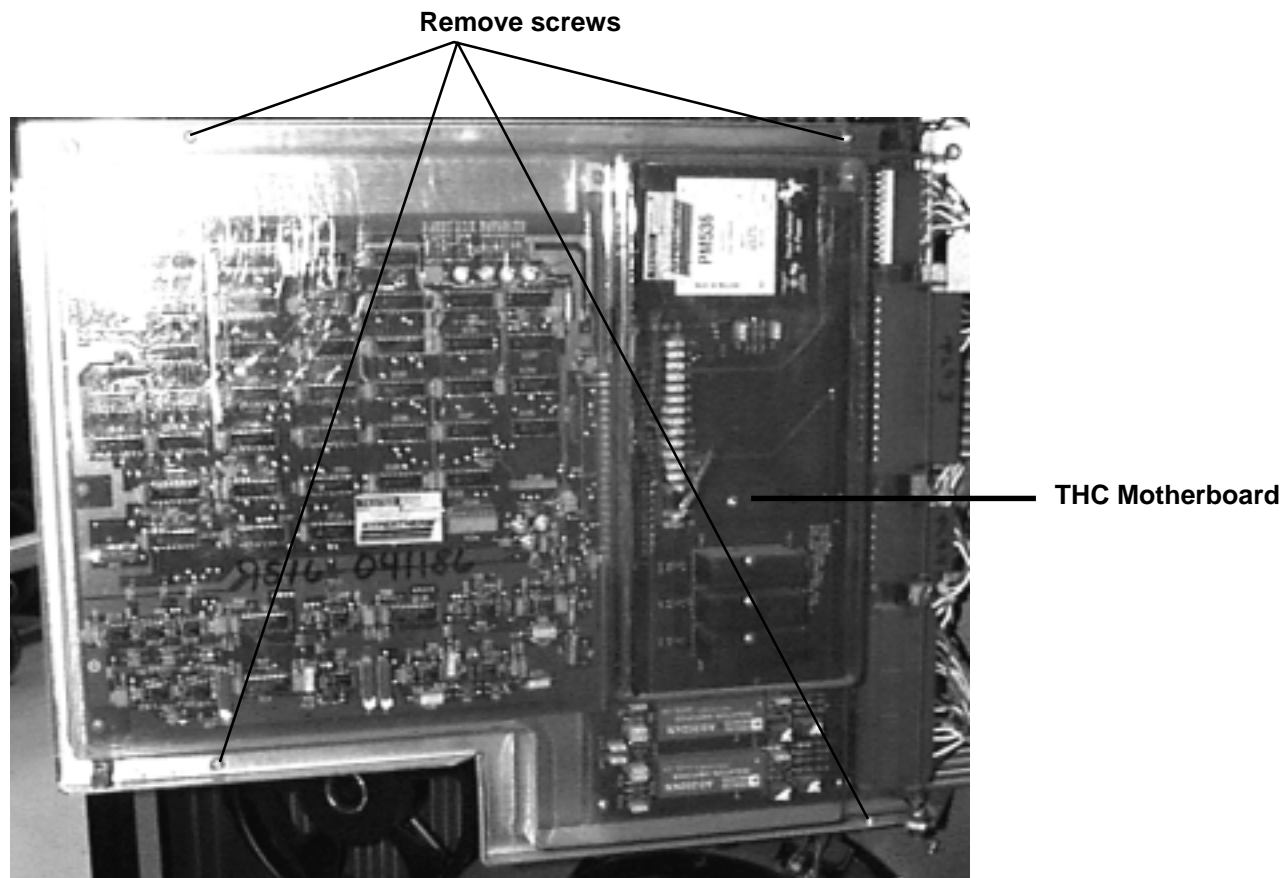
1. Remove the power supply front panel.

HT4001:

1. Remove the power supply rear panel.

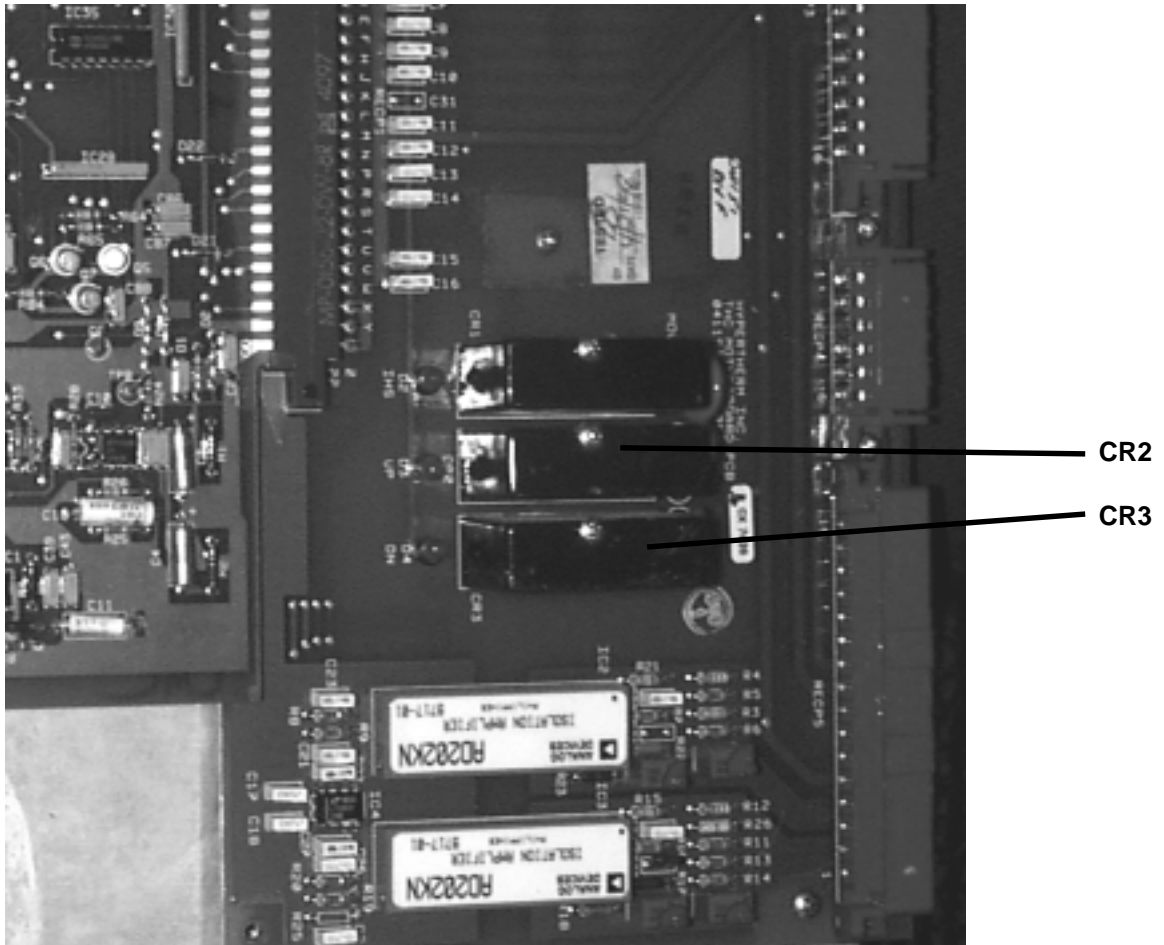
All Systems:

2. Locate the THC motherboard.
3. Remove 4 screws that fasten the plastic THC cover to the THC pcb assemblies.



THC Motherboard Up / Down DC Relay Replacement

4. Locate CR2 and CR3 on the THC motherboard.



5. Remove the screws securing CR2 and CR3 to the motherboard.
6. Gently pull the CR2 and CR3 relays from their sockets.
7. Insert the 003111 relays into the motherboard sockets.
8. Reinstall the CR2 and CR3 screws to secure the 003111 relays to the motherboard.
9. Refasten the THC plastic cover to the THC motherboard.
10. Reinstall the power supply covers.

Installation is complete. Refer to your system instruction manual to connect the machine interface cable to the torch lifter motor.