



PAC135T
Trigger and Switch
Replacement

Kit: 128409

Field Service Bulletin
IM-361
(P/N 803610)

Revision 0 June, 1999

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)
email: info@hypertherm.com (General Information)
email: service@hypertherm.com (Technical/Customer Services)

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

Field Service Bulletin 803610



128409 Contents			
Item	Part Number	Description	Qty.
1	005247	Push Button Switch, Lo-Profile	1
2	074069	Splice: 22-18 Butt	2
3	002299	Safety Trigger Assembly: PAC135T	1
4	803610	Field Service Bulletin: PAC135T Trigger and Switch Replacement	1

Replacing the PAC135T Trigger and Switch



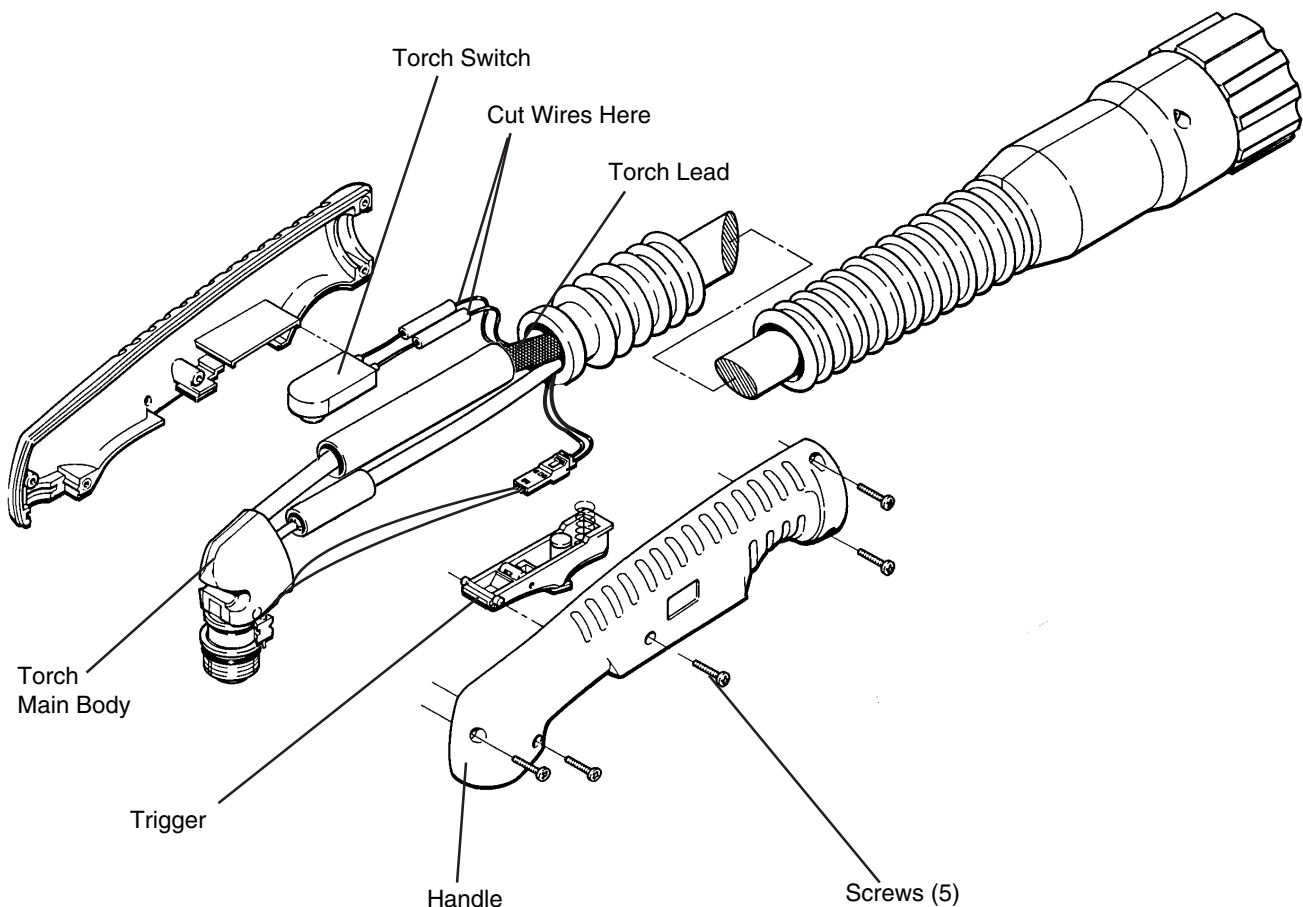
WARNING
ELECTRIC SHOCK CAN KILL

**MODIFICATION MUST BE PERFORMED ONLY BY HYPERTHERM TECHNICIANS,
DISTRIBUTORS OR QUALIFIED ELECTRONICS TECHNICIANS**

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 disconnecting the torch from the power supply.

Remove Torch Switch and Trigger from PAC135T

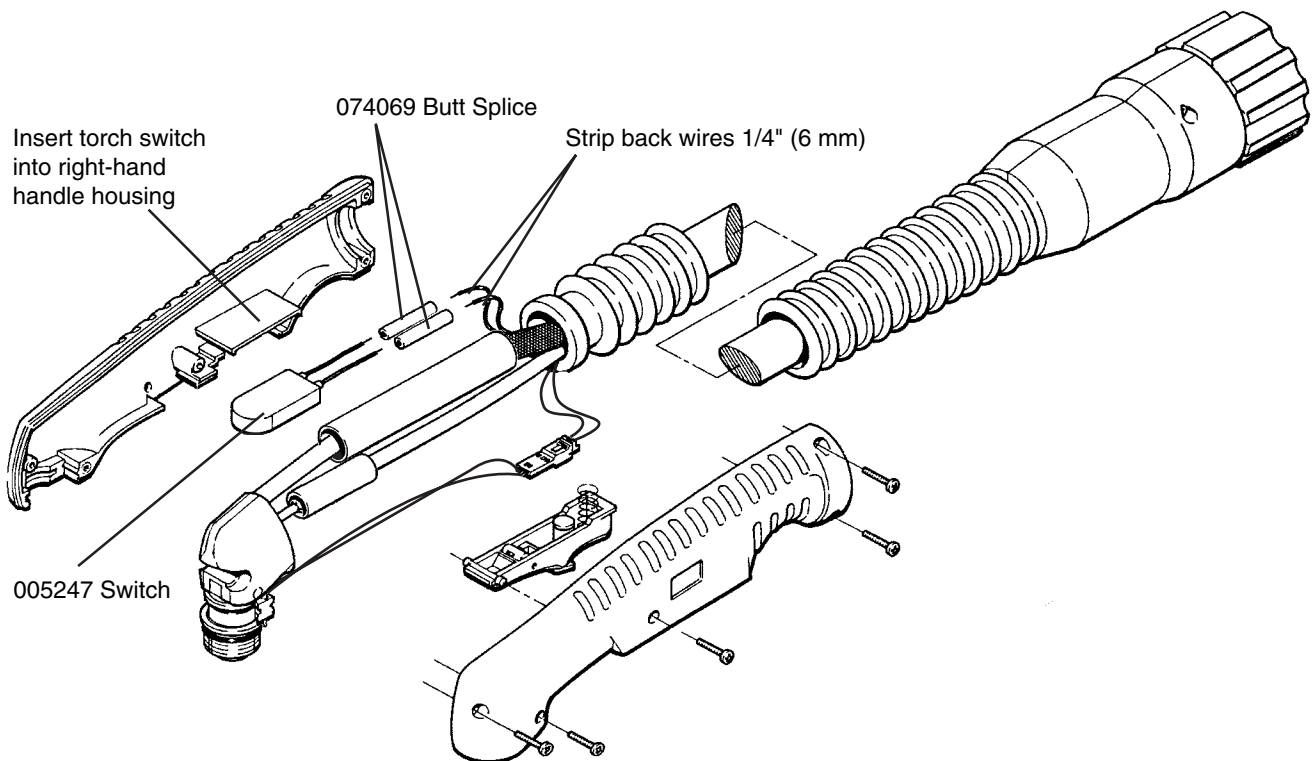
1. Disconnect the torch from the power supply.
2. Remove the 5 screws that secure the handle halves together.
3. Remove the torch switch and trigger from the handle halves.
4. Disconnect the torch switch by cutting the 2 wires on the torch lead side of the splices .



Replacing the PAC135T Trigger and Switch

Replace Torch Switch

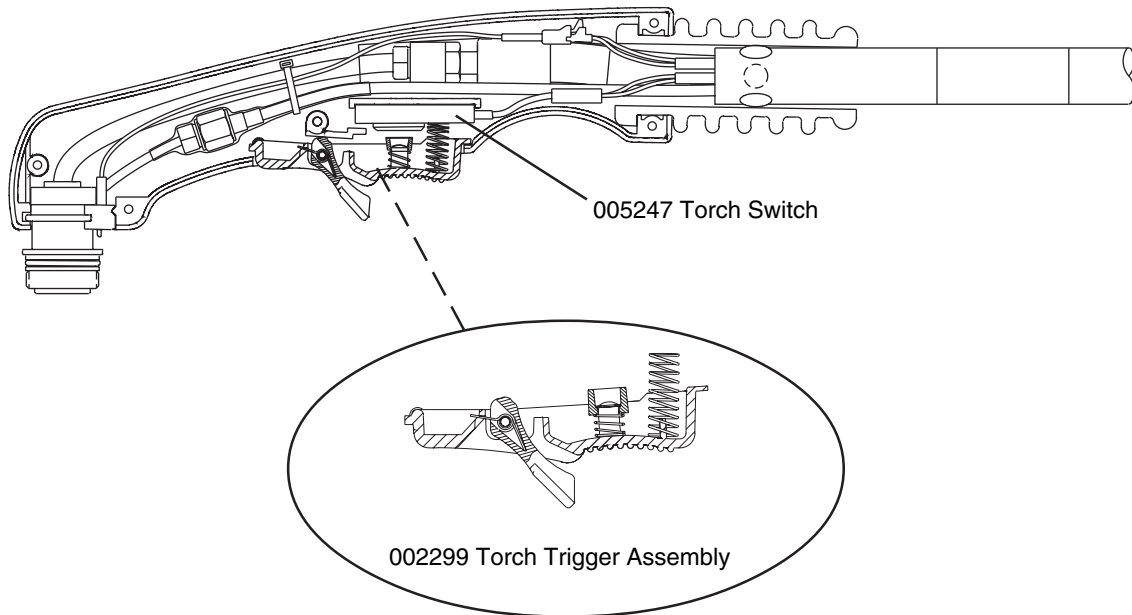
1. Strip back the 2 torch lead wires that connect to the torch switch approximately 1/4" (6 mm).
2. Trim the wires on the 005247 switch to approximately 1-1/2" (38 mm). Strip back the wires 1/4" (6 mm).
2. Push the stripped torch lead wire into one end of one of the 074069 butt splices and push one of the 005247 trimmed and stripped switch leads in the other end of the butt splice, and crimp using a crimping pliers. Repeat the crimping process for the remaining 2 wires. Verify that the crimps are secure.
3. Slide the torch switch into the right-hand handle housing.



Replacing the PAC135T Trigger and Switch

Replace Torch Trigger

1. Insert the 002299 torch trigger assembly into the torch handle housing as shown in the cut-away view below.
2. Verify that the torch trigger movement activates the torch switch push button.



Reassemble Torch

1. While positioning the handle halves together, be certain that the trigger pivots are properly inserted into the indents in the handle halves. Be careful not to pinch any wires..
2. Replace the 5 screws that secure the handle halves together. Refer to the figure on page 2, if necessary.

