



Coolant Tank Replacement

Kits: 128410, 128411

Field Service Bulletin IM-362 (P/N 803620)

Revision 1 January, 2000

Hypertherm, Inc.
Hanover, NH
<http://www.hypertherm.com>
email: 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 – toll-free in USA and Canada)
Tel.: (800) 737-2978 (Customer Service – toll-free in USA and Canada)
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

Hypertherm Singapore Pte Ltd

No. 19 Kaki Bukit Road 2
K.B. Warehouse Complex
Singapore 417847
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

15 Impasse des Rosiers
95610 Eragny, France
Tel.: 33 1 30 37 15 28
Fax: 33 1 30 37 15 79

Hypertherm Italy S.r.L.

Via Torino 2
20123 Milan, Italy
Tel.: 39 02 725 46 312 (Customer Service)
Tel.: 39 02 725 46 314 (Technical Service)
Fax: 39 02 725 46 400 (All Departments)

Hypertherm B.V.

Burg, Haverkampstraat 13
7091 CN Dinxperlo, The Netherlands
Tel.: 31 315 655 866 (Customer Service)
Fax: 31 315 655 886

European Technical Support Organization (ETSO)

Edisonstraat 12
3281 NC Numansdorp, The Netherlands
Tel.: +800 4973 7843 (+800 Hypertherm) – (toll-free Technical Service)
Tel.: 31 186 659494
Fax: 31 186 659495

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

INTRODUCTION

The 128410 kit is the coolant tank replacement for the HT2000, HT2000LHF and MAX200 power supplies. The 128411 kit is the coolant tank replacement for the HD3070 power supply. Replacement coolant is not provided with this kit.

KIT 128410 CONTENTS

Part Number	Description	Quantity
001731	Cover, MAX200/HT2000	1
015133	Sleeve: 3/8 plastic tube	2
015134	Insert: 3/8 plastic tube	2
046047	Tubing: 3/8 O.D. black	.6 ft
015125	Sleeve: 1/2 plastic tube	2
015126	Insert: 1/2 plastic tube	2
046043	Tubing: 1/2 O.D. black	.6 ft
075205	Flat washer	4
004504	Spacer	4
075563	M/S: 1/4-20 x 1-5/8	4
008876	Bushing: 2.94" I.D. x 3.5" hole	1
803620	Field Service Bulletin	1
002304	Coolant tank	1

The coolant tank comes with the following components already mounted:

022036	Liquid level cap	1
015135	Insert: 1/8 Plastic tube	1
015141	Adapter: 1/8 NPT x 1/8 comp. 90°	1
046048	1/8 O.D. Plastic tubing	2
015132	Adapter: 1/4 NPT x 3/8 comp. 90°	1
015292	Adapter: 1/2 x 1/2 90°	1
029323	Temp switch assy	1
006099	Bib drain valve	1
129618	Level switch assy	1

KIT 128411 CONTENTS

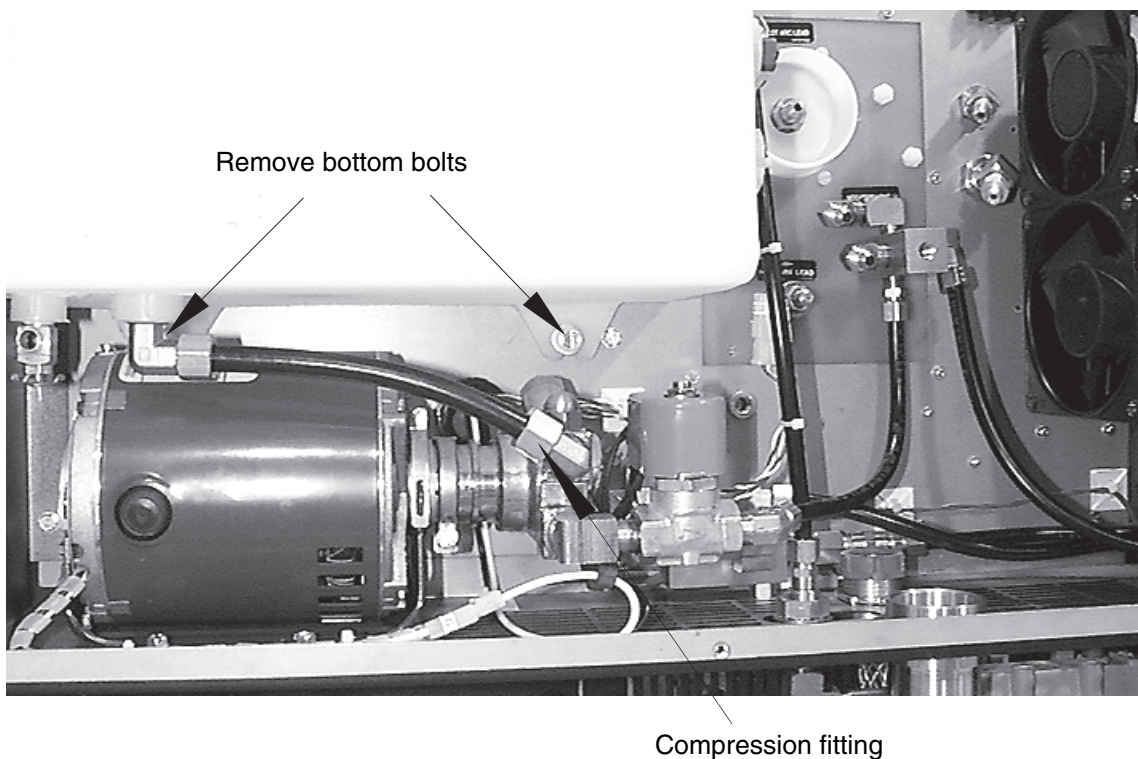
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006099	Bib drain valve	1
129618	Level switch assy	1
015560	Plug: 1/8 NPT Hex	1

REMOVE THE ORIGINAL TANK

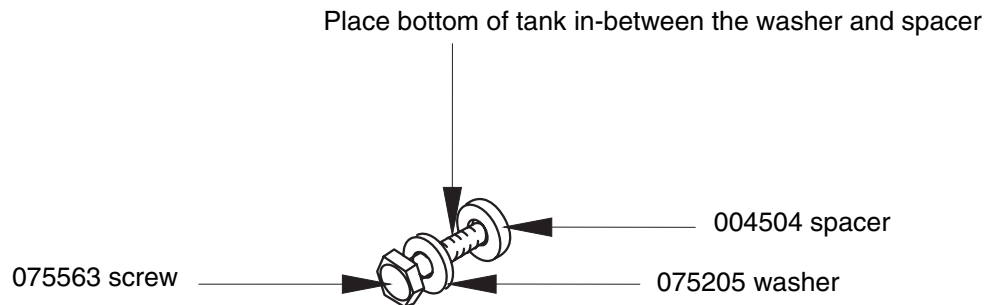
1. Drain the coolant system
 - Open the petcock at the bottom of the tank and allow the coolant to drain. Some older systems were not equipped with petcocks and must be drained by removing the hose from the supply side of the pump.
2. Remove all external connections from the tank
 - Remove 2 hoses and 2 twisted pair, 2-pin wire connectors. 2 hoses are provided in the upgrade kit (046047 and 046043). Remove the existing hoses by loosening the compression fittings. Do not discard the compression fittings.
3. Remove the coolant tank
 - Remove the coolant tank top mounting bolts.
 - Remove the coolant tank bottom mounting bolts as shown below, and remove the tank.
 - Discard the bolts.



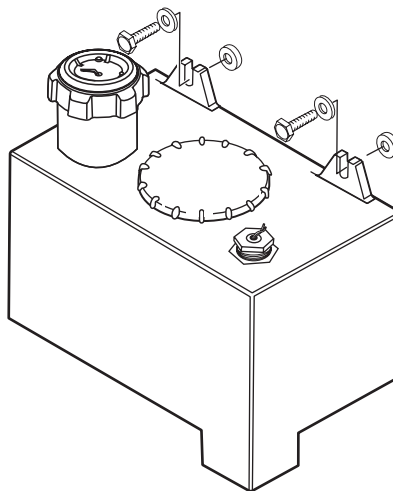
INSTALLING THE NEW TANK

1. Install the tank

- Loosely insert the 075563 screws, 075205 washers and 004504 spacers in the bottom 2 holes that will secure the tank to the power supply rear panel. See figure below for correct orientation.
- Lower the tank on the screws and in-between the spacers and washers as shown below.

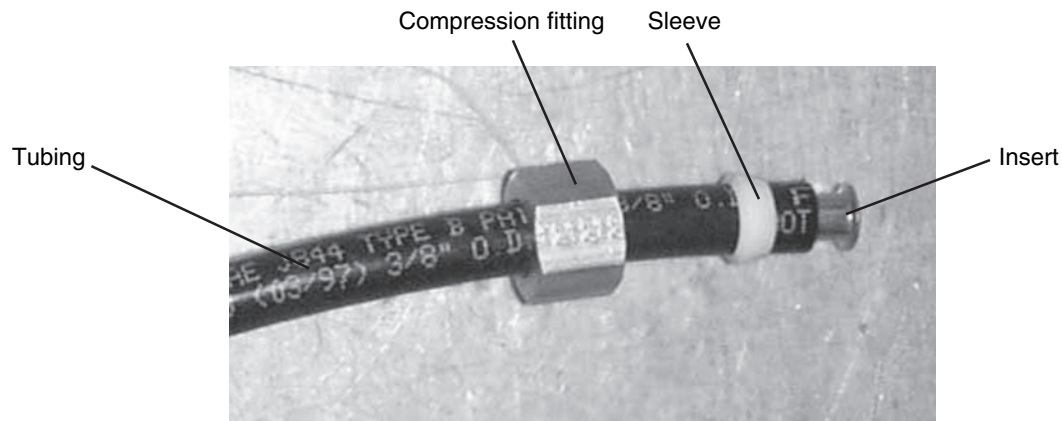


- Fasten the tank to the power supply wall by inserting the remaining screws, washers and spacers as shown below.
- Tighten all 4 screws securely.



ASSEMBLE AND CONNECT THE HOSES

1. Assemble one side of the 3/8" tubing (046047) with an insert (015134), sleeve (015133) and compression fitting (on an adaptor on the tank) as shown below. Note orientation of sleeve.
2. Use the compression fitting saved from step 2 on page 3 and assemble the other side of the 3/8" tubing with the remaining 3/8" insert and sleeve.
3. Connect the 3/8" hose assembly from the flow switch to the tank. Tighten fittings to 75-85 lbf-in (86-98 kgf-cm) of torque.
4. Assemble the 046043 1/2" tubing with the 015126 inserts and 015125 sleeves.
5. Connect the 1/2" hose assembly from the pump to the tank.



REMAINING CONNECTIONS AND PROCEDURES

- Attach wire connectors labeled 23 and 24 to their mating receptacles.
- Double check all fittings and connections before refilling the system with coolant.
- Hold down the power supply ON button as the coolant is added. The system holds up to 4 gallons of coolant, depending on the length of the leads.
- On the MAX200 and HT2000, run the coolant tank overflow tube out the bottom of the rear panel, clear of the pump motor and any electrical components.
- Replace the old rear panel cover with the new one provided in the kit.