

***Hypertherm***<sup>®</sup>

***PAC125M/PAC123M***

**Torch Main Body Replacement**

Kit: 128572

**Field Service Bulletin**  
(P/N 803930)

**Revision 0 November, 2000**

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

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# **Hypertherm®**

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## **Hypertherm, Inc.**

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

## **Hypertherm Automation**

5 Technology Drive, Suite 300  
West Lebanon, NH 03784 USA  
603-298-7970 Tel  
603-298-7977 Fax

## **Hypertherm Plasmatechnik GmbH**

Technologiepark Hanau  
Rodenbacher Chaussee 6  
D-63457 Hanau-Wolfgang, Germany  
49 6181 58 2100 Tel  
49 6181 58 2134 Fax  
**49 6181 58 2123 (Technical Service)**

## **Hypertherm Singapore Pte Ltd**

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

## **Japan**

Shinjuku Park Tower, 30th Floor  
3-7-1 Nishi-Shinjuku, Shinjuku-ku, Tokyo,  
163-1030, Japan  
81 03 5326 3142 Tel  
81 03 5326 3001 Fax

## **Hypertherm UK Ltd**

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

## **France**

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

## **Hypertherm S.r.L.**

Via Torino 2  
20123 Milan, Italy  
39 02 725 46 312 Tel  
39 02 725 46 400 Fax  
**39 02 725 46 314 Tel (Technical Service)**

## **Hypertherm B.V.**

Burg. Haverkampstraat 13  
7091 CN Dinxperlo, The Netherlands  
31 315 655866 Tel  
31 315 655886 Fax

## **Hypertherm B.V.**

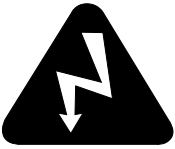
**European Technical Service Organization (ETSO)**  
Edisonstraat 12  
3281 NC Numansdorp, The Netherlands  
**00 800 49 73 7843 Toll Free in Europe**  
31 186 659494 Tel  
31 186 659495 Fax

## ***Replacing PAC125M / PAC123M Torch Main Body***

### **Kit # 128572 Contents**

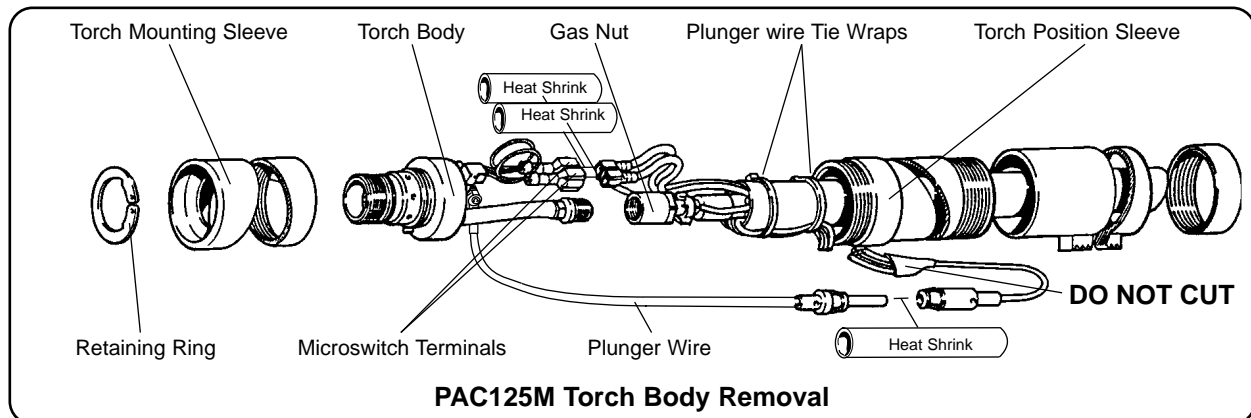
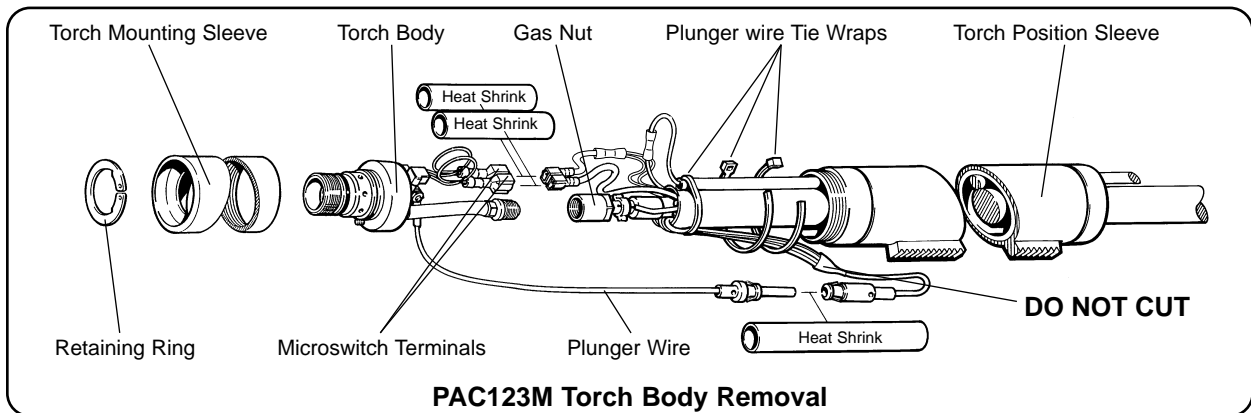
<b>Part Number</b>	<b>Description</b>	<b>Quantity</b>
046066	Heat Shrink:3/8"ID Black/1"	2
046072	Heat Shrink: 1/2"ID Black/2.5"	1
027599	External Retaining Ring	1
120583	PAC125M/123M Torch Main Body w/switch Replacement	1
	6" Tie-wrap	3
803930	Field Service Bulletin: PAC125M/PAC123M Torch Main Body Replacement	1

## Replacing PAC125M / PAC123M Torch Main Body

	<b>WARNING</b>
	<b>INSTALLATION MUST BE PERFORMED ONLY BY HYPERTHERM DISTRIBUTORS OR QUALIFIED TECHNICIANS!!</b>

### Removal of Torch Body from Torch Lead

1. Set the power supply power switch to O (off), unplug the power cable and disconnect the gas supply.
2. Remove consumables.
3. Unscrew the torch position sleeve from the torch mounting sleeve and slide it back out of the way.
4. Remove the retaining ring securing the torch mounting sleeve to the torch body. Remove and save the torch mounting sleeve. Discard old retaining ring.
5. Cut the tie wraps holding the plunger wire in place.
6. Carefully remove the heat shrink from the terminals of the microswitch and plunger wires. Do not cut wires under heat shrink. Disconnect the microswitch and plunger wire terminals.
7. Disconnect the gas nut from the torch body using 3/8" (9.5 mm) and 1/2" (13 mm) wrenches.
8. Remove the torch body



# Replacing PAC125M / PAC123M Torch Main Body

## Replacing Torch Body to Torch Lead

1. Connect the gas nut to the new torch body using 3/8" (9.5 mm) and 1/2" (13 mm) wrenches. Tighten 1/6 turn beyond finger-tight.
2. Slip the 2 pieces of smaller diameter heat shrink over the 2 microswitch wires. Slip the remaining piece of heat shrink over the large plunger wire.
3. Connect all mating terminals between the torch body and the torch lead.
4. Position the heat shrinks over the microswitch and plunger wire terminals. Apply heat until the heat shrink is snug.
5. Tie the plunger wire back on the torch lead as shown in figure 2. With the ties in place and snugged down, adjust the wire so there is 1/4" (6 mm) of slack between the wire and the gas nut.
6. Slide the torch mounting sleeve over the torch body and secure by installing the retaining ring supplied in this kit.
7. Screw the torch position sleeve to the torch mounting sleeve. Be careful not to let wires bunch up behind the plunger during installation of torch position sleeve.
8. Install consumables and test torch for proper operation.

Figure 1- PAC123M & 125M Torch Body Replacement

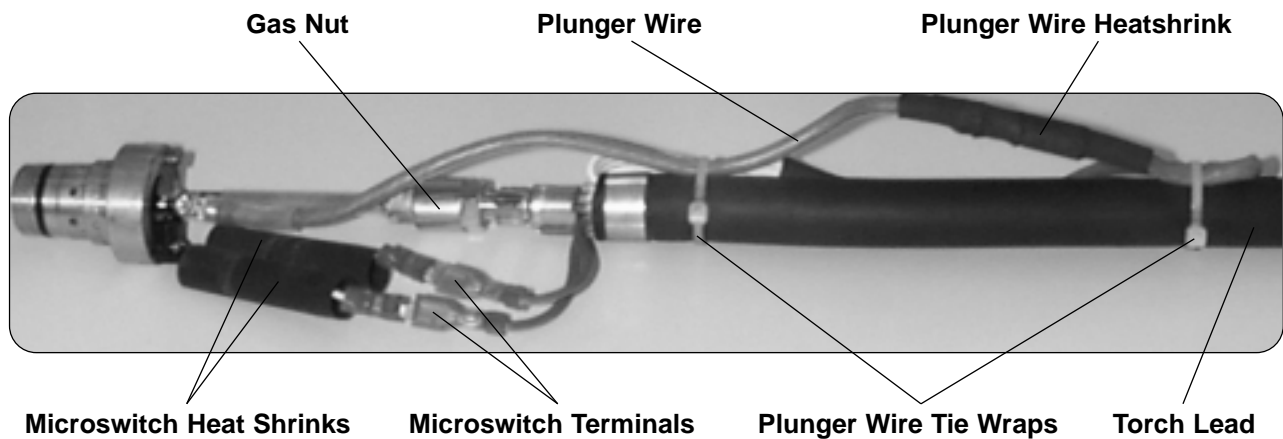


Figure 2- PAC123M & 125M Torch Body Replacement

