

Hypertherm[®]

powermax350[®]

Filter/Regulator Replacement

Kit # 128655



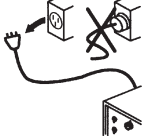
Field Service Bulletin
(P/N 804200)

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		<p>WARNING ELECTRIC SHOCK CAN KILL</p>
		<p>Disconnect electrical power before performing any maintenance. All work requiring removal of the power supply cover must be performed by a qualified technician. See <i>Section 1</i> of the Operator Manual for more safety precautions.</p>

Introduction

Purpose

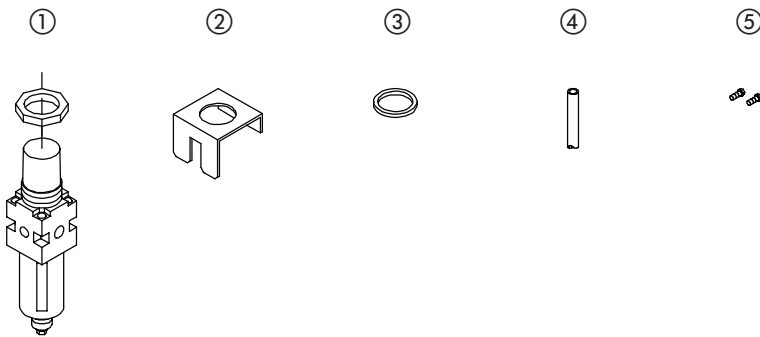
The float in the regulator may become dislodged in transit and cause the filter/regulator to leak. This kit provides instructions to replace the existing filter/regulator with a redesigned filter/regulator. This kit should also be used anytime the filter/regulator needs to be replaced.

Tools Needed

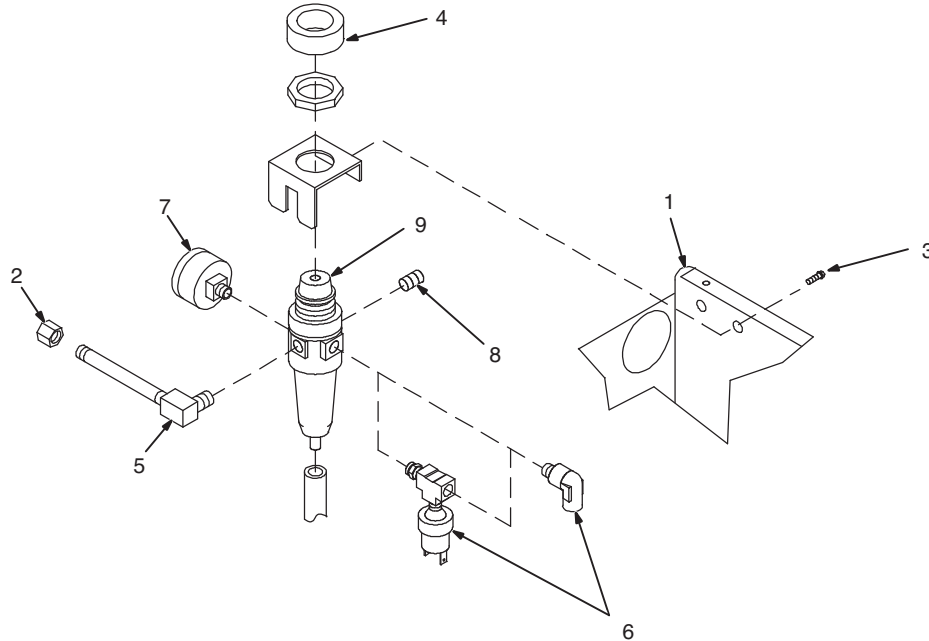
- Loctite 571 thread sealant
- 1/4" Allen wrench
- 1/4" nut driver
- 1/4, 7/16, 1/2, 5/8 and 11/16" wrenches

Kit Contents

Item	Part Number	Description	Qty
1	011095	Filter/Regulator with Nut	1
2	004959	Bracket	1
3	004958	Spacer	1
4	046124	Tubing	1
5	075590	Screw, 8-32 x .37 hexwhd	2



Removal Of Original Regulator



Turn OFF and disconnect input power.

1 Power Supply

Disconnect air supply. Remove screws securing cover and remove cover.

2 Pipe Coupling

Remove coupling from pipe nipple.

Disconnect plastic air hose from output elbow fitting. *See item 6.* Push up on end of fitting while pulling down on hose.

Note: If unit is equipped with sensor, disconnect leads.

3 Screws

Remove bracket screws using 1/4" nutdriver and 1/4" wrench. Discard screws.

4 Neoprene Ring

Remove neoprene ring.

5 Pipe Elbow and Nipple Assembly

Remove assembly from filter/regulator using 11/16" wrench.

6 Pipe Elbow Fitting

Remove fitting and sensor (if present) from filter/regulator using 7/16" wrench.

7 Gauge

Remove gauge using 7/16" wrench.

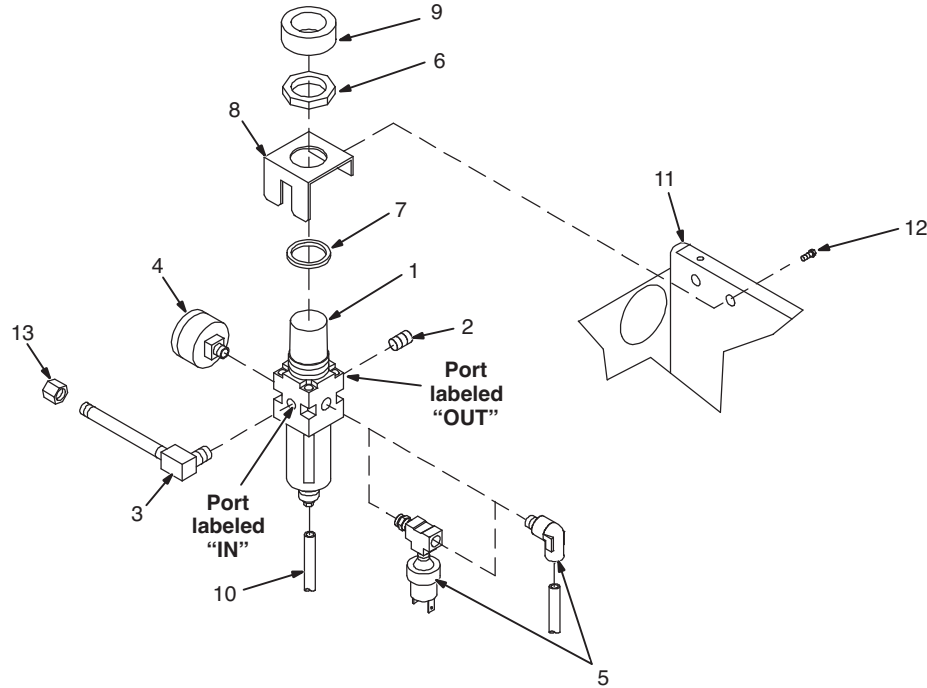
8 Pipe Plug

Remove plug using 1/4" Allen wrench.

9 Filter/Regulator

Discard filter/regulator.

Installation Of Replacement Regulator



Caution: Never use PTFE tape on gas fittings. Use approved liquid pipe thread sealant.

- 1 Replacement Filter/Regulator
- 2 Pipe Plug

Clean threads and apply thread sealant to threads. Install and secure plug into port labeled "OUT" using 1/4" Allen wrench.

- 3 Pipe Elbow and Nipple Assembly

Clean threads and apply thread sealant to threads. Install and secure assembly into regulator port labeled "IN".

- 4 Gauge

Clean threads and apply thread sealant. Install and secure gauge. Verify the orientation of the face of the gauge.

- 5 Pipe Elbow Fitting

Clean threads and apply thread sealant. Install and secure fitting and sensor (if present) to regulator using 7/16" wrench.

- 6 Nut

Remove nut from regulator.

- 7 Spacer

Install spacer.

- 8 Mounting Bracket

Place replacement mounting bracket over filter/regulator with forked end over "IN" brass fitting.

Reinstall and tighten nut against bracket.

- 9 Neoprene Ring

Install neoprene ring.

- 10 Tubing

Install tubing to bottom of regulator.

- 11 Power Supply

- 12 Screws

Note: Before installing the bracket on the power supply use the self-tapping screws to thread holes in bracket.

Install regulator assembly in power supply using supplied screws. Route tubing through hole in bottom of chassis. Trim tubing so that it extends 1/4" through the hole. See item 10.

Connect plastic air hose to output fitting by pushing hose up into fitting. See item 5.

Note: If unit is equipped with sensor, connect leads.

- 13 Pipe Coupling

Clean threads and apply thread sealant. Install and secure pipe coupling.

Reconnect air supply and input power according to the procedure in Section 3 of the Operator Manual. Check for leaks.

Reinstall cover.

Adjust the air pressure according to the procedure in Section 4 of the Operator Manual.