

***Hypertherm***<sup>®</sup>

***THC-1 and THC-2***

**Relay Replacement**

Kit P/N 128731 or 128732



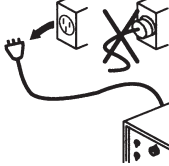
**Field Service Bulletin**  
(P/N 804420)

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

## Introduction

### Purpose

Replacement of the AC or DC relays, used before 2001, in the THC-1 and THC-2.

### Kit 128731: DC Relay Replacement – Contents

Part Number	Description	Qty
041818	DC Relay Board	1
075063	Screws: 6-32 x .375	2

### Kit 128732: AC Relay Replacement – Contents

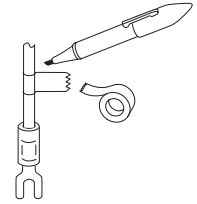
Part Number	Description	Qty
041786	AC Relay Board	1
075063	Screws: 6-32 x .375	2

## THC-1 and THC-2 RELAY REPLACEMENT

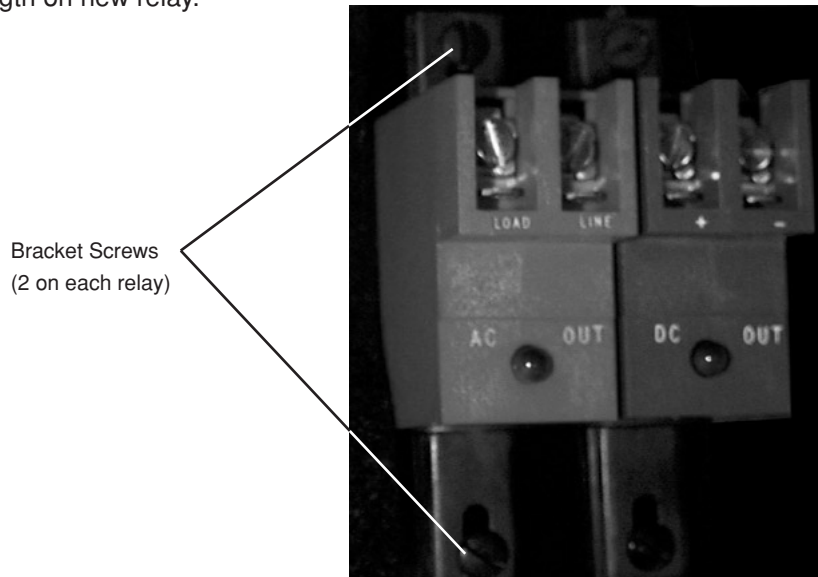
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### Procedure

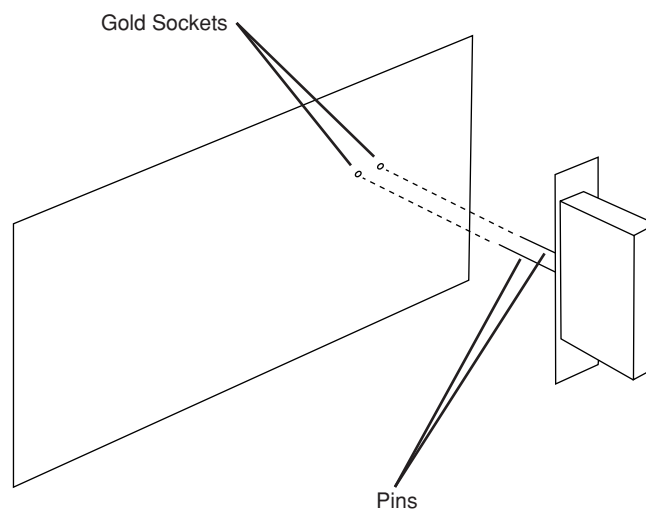
1 – Before removing wires: mark LOAD(+) and LINE(-) wires attached to the existing relay.



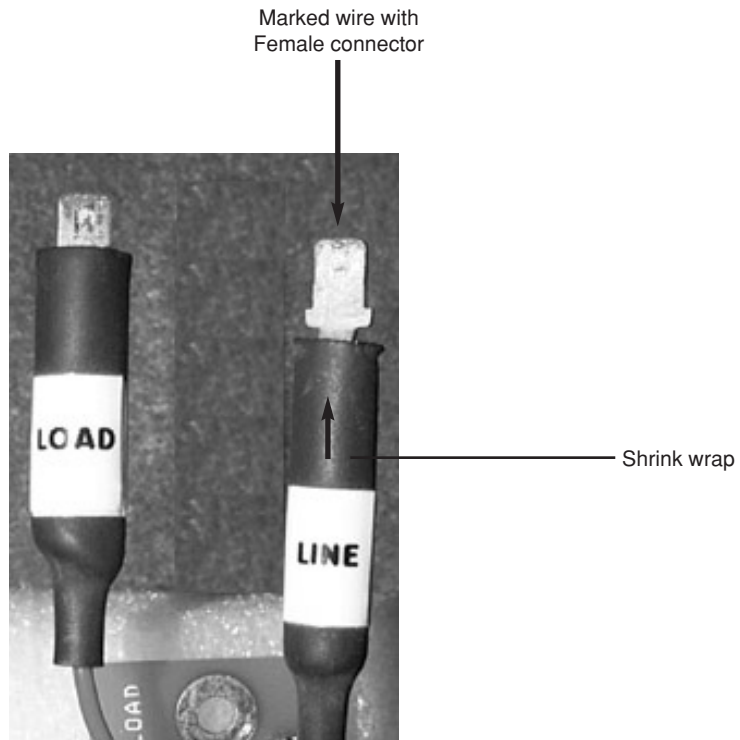
2 – Remove bracket screws holding the relays to the black panel. Remove old relay and save to compare pin length on new relay.



3 – Cut the pins on the new relay board to the same length as the ones on the old relay. Be careful to align the input pins on the new relay board (041786 or 041818) with the gold sockets in the panel. Insert pins into sockets and attach the new board onto the panel with 2 screws (075063) provided in this kit.



- 4 – Connect the wire marked LINE to the LINE connector on the new board and pull the shrink wrap cylinder over the connection.
- 5 – Connect the wire marked LOAD to the LOAD wire connector on the new board and pull the shrink wrap cylinder over the connection. Installation is complete.



New Board Connectors

