



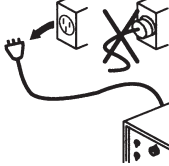
***RT80, RT80M***  
***Quick Disconnect Housing Repair***  
***Field Service Bulletin***

***804590 – Revision 0 – April, 2003***

***Hypertherm®***

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plasma cutting technology™*

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		<p><b>WARNING</b> ELECTRIC SHOCK CAN KILL</p>
	<p><b>Disconnect electrical power before performing any maintenance.</b> See <i>Section 1</i> of the Operator Manual for more safety precautions.</p>	

## Introduction

### Purpose

Describes necessary steps to repair the quick disconnect housing on either the RT80 or RT80M torches.

### Tools and Materials Needed

- #2 Phillips screw driver
- 11/32" drill bit (machine torch only)

### Kit Contents

#### Kit 128826

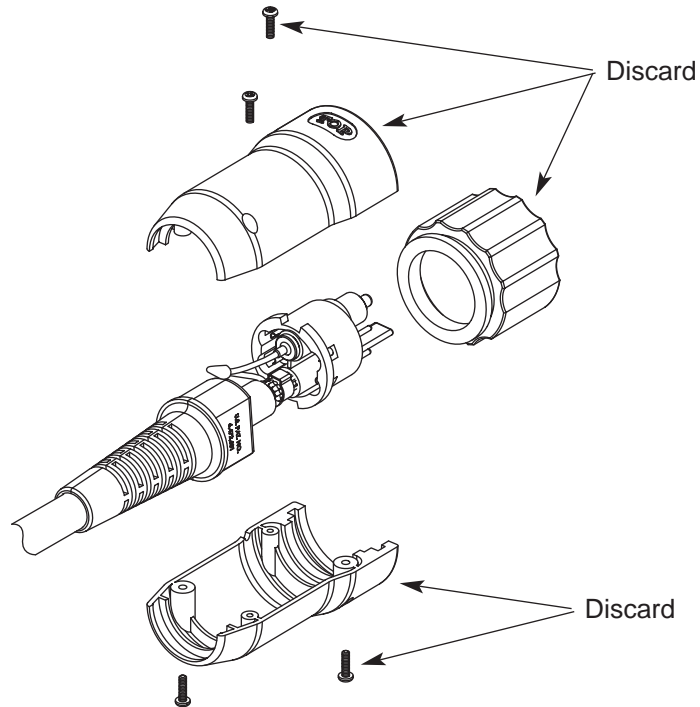
Item	Part Number	Description	Qty
1	004544	Upper Housing	1
2	004734	Nut	1
3	004909	Lower Housing	1
4	075365	Screws	4

## POSITIONING SLEEVE REPLACEMENT

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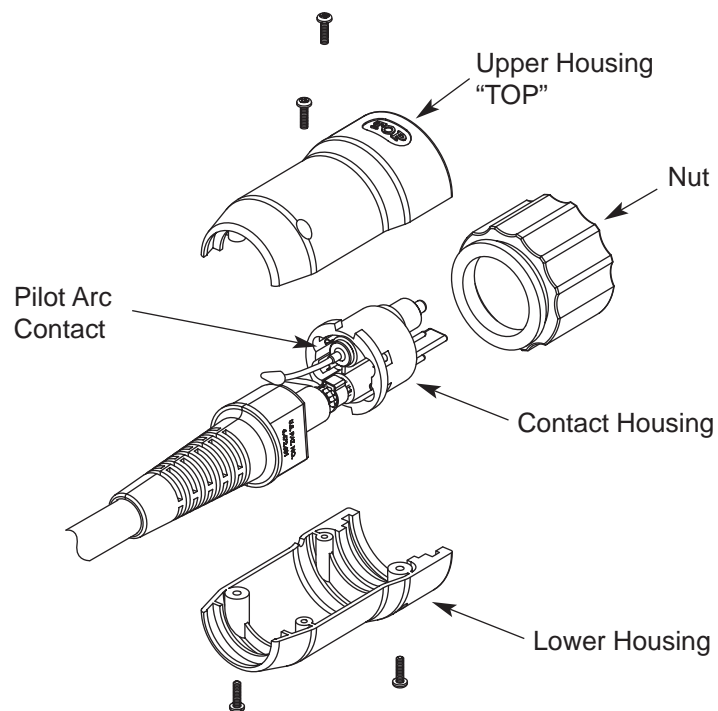
### Disassemble Quick Disconnect

1. Disconnect power and remove torch lead from power supply.  
See *Section 3* of the Owner Manual.
2. Remove screws (4) from housing
3. Discard screws (4), nut, and housing (2)



## Reassemble Quick Disconnect – Hand Torch

1. Align lead so that the pilot arc contact (red wire) is on top.
2. Slide nut on to contact housing.
3. Place nut and lead into lower housing.
4. Install upper housing (marked as "TOP") and secure with screws (4).
5. Connect torch lead to power supply and connect power.  
See Section 3 of the Owner Manual
6. Verify that the cap sensor works properly.
  1. Turn On the power supply without consumables installed.
  2. Torch Cap and Fault LEDs should illuminate.
  3. Turn Off the power supply.
  4. Install consumables.

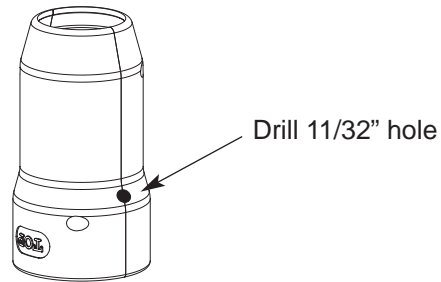


## POSITIONING SLEEVE REPLACEMENT

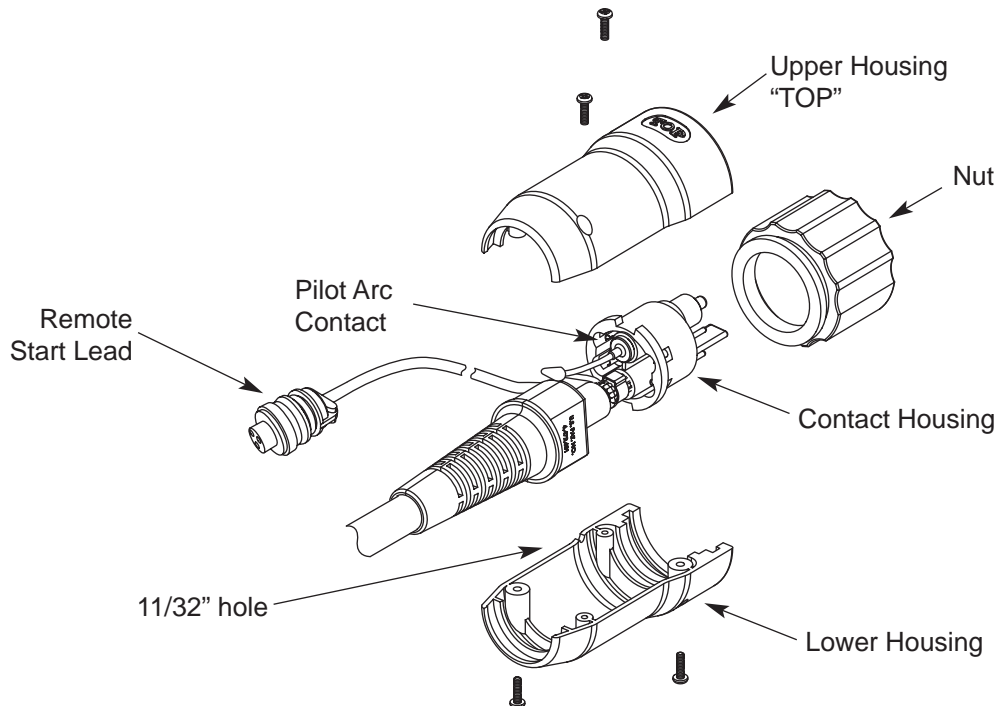
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### Reassemble Quick Disconnect – Machine Torch

1. Secure upper and lower housings together with the enclosed screws.
2. Drill a hole along the edge of the housing as shown below using a 11/32" drill bit.
3. Disassemble housing.



4. Align torch lead so that the pilot arc contact (red wire) is on top.
5. Slide nut on to contact housing.
6. Place nut and lead into lower housing.
7. Align remote start lead with the 11/32" hole in the housing.  
Note: At least 1" of the rubber jacket on the remote start lead should remain in the housing.
8. Install upper housing (marked as "TOP") and secure with screws (4).
9. Connect torch lead to power supply and connect power.  
See Section 3 of the Owner Manual
10. Verify that the cap sensor works properly.
  1. Turn On the power supply without consumables installed.
  2. Torch Cap and Fault LEDs should illuminate.
  3. Turn Off the power supply.
  4. Install consumables.



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