

# ***PAC200T/E Torch Handle Replacement***



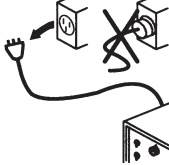
## ***Field Service Bulletin***

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# ***Hypertherm®***

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plasma cutting technology™*

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

## Introduction

### Purpose

Describes necessary steps to replace damaged handles on the PAC200T and PAC200E hand torch.

### Tools And Materials Needed

#2 Phillips screw driver

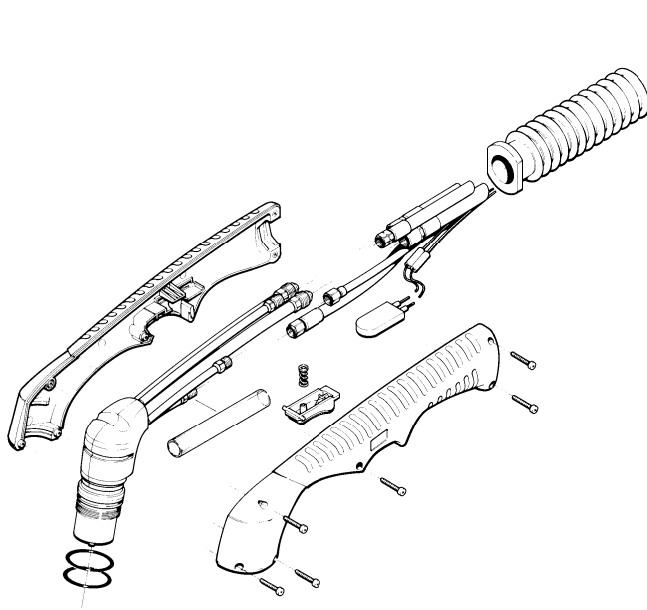
### Kit Contents

#### Kit 128904

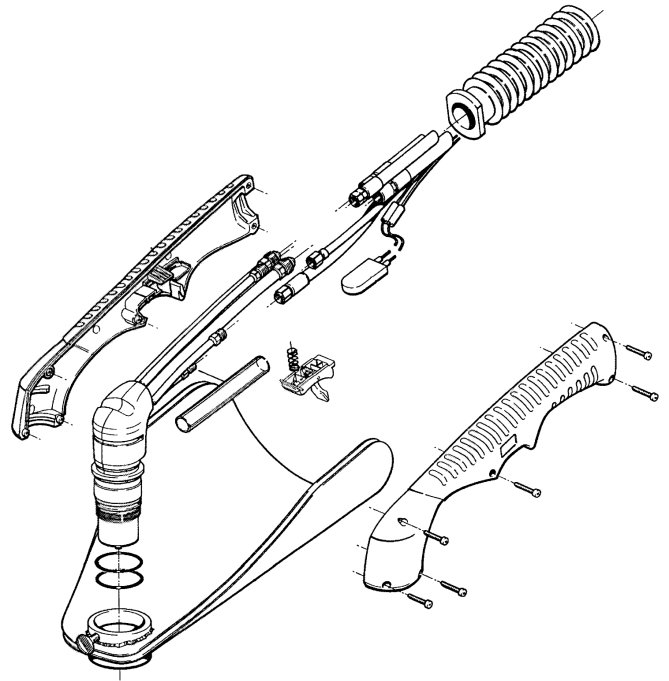
Item	Part Number	Description	Qty
1	001905	PAC200T/E 90° torch handle	1
2	002519	Boot	1
3	010758	PAC200T label	1
4	010759	PAC200E label	1
5	075365	Screws	6
6	110259	CE/CSA label	1

#### Kit 128905

Item	Part Number	Description	Qty
1	001906	PAC200T/E 65° torch handle	1
2	002519	Boot	1
3	010758	PAC200T label	1
4	010759	PAC200E label	1
5	075365	Screws	6
6	110259	CE/CSA label	1



**PAC200T**



**PAC200E**

## Remove Handles

1. Disconnect power and remove torch lead from power supply.  
See *Section 3* of the Instruction Manual.
2. Remove consumables.
3. Remove screws using a #2 Phillips screw driver and discard screws.
4. Remove handles.

**Note:** Open handles slowly so that the trigger spring is not lost.

## Install Handles

1. Place CE/CSA label on right handle.  
Place PAC200T or PAC200E label on left handle as appropriate.
2. Place torch into right handle and route wires as shown above.  
**Note:** Route start switch wires underneath the torch body gas tubes.
3. Place trigger and trigger spring into handle as shown above.
4. Attach left handle with the supplied screws using a #2 Phillips screw driver.  
**Note:** Verify that the start switch wires will not be pinched when the left handle is attached.
5. Connect torch lead to power supply and connect power.  
See *Section 3* of the Instruction Manual.
6. Verify that the Cap Off sensor works properly.
  1. Install consumables but leave the retaining cap loose.
  1. Turn On the power supply.
  2. Shield Gas/Cap LED should illuminate.
  3. Turn Off the power supply.
  4. Tighten retaining cap.

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