

HPR Flow Switch Replacement HyPerformance Plasma Systems

Field Service Bulletin

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Hypertherm®



DANGER ELECTRICAL SHOCK CAN KILL

The line disconnect switch must be in the OFF position before making the power cable connections. In the U.S., use a "lock-out/tag-out" procedure until installation or repair is complete. In other countries, follow appropriate national or local safety procedures. See the **Safety Section** of the system Manual for more safety precautions.

Introduction

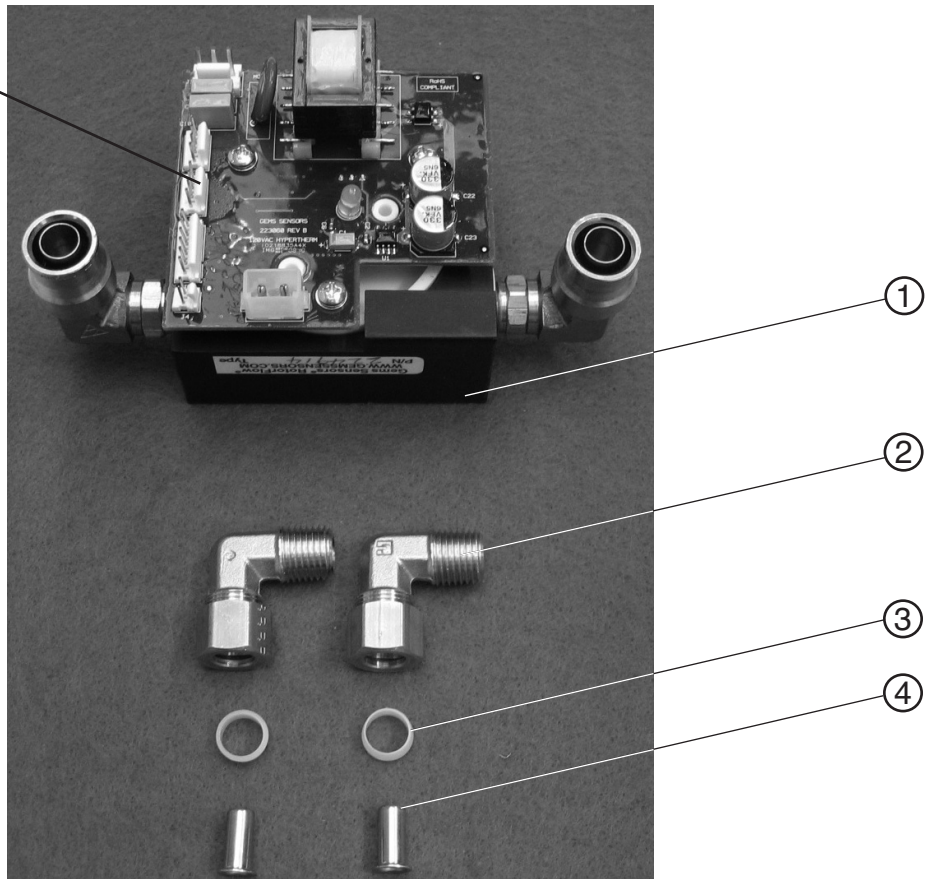
Purpose

This field service bulletin gives instructions for replacing the flow switch assembly in HPR power supplies.

Kit 228022 contents

| Item | Part Number | Description | Qty |
|------|-------------|-------------------------------------|-----|
| 1 | 229206 | Flow switch assembly | 1 |
| 2 | 015132 | Adapter: 1/4" NPT x 3/8", 90° brass | 2 |
| 3 | 015133 | Sleeve: 3/8" delrin | 2 |
| 4 | 015134 | Hose insert: 3/8" brass | 2 |

J6 connector
(for reference)



HPR FLOW SWITCH REPLACEMENT

Determine what type of fittings are on the flow switch that is being replaced.

Push-to-connect – The new flow switch assembly has push-to-connect elbow fittings that can be rotated.

Standard elbow fittings – The old style flow switch has elbow fittings that must be tightened in the correct orientation.

Note: If the flow switch that is being replaced has a ground wire (green/yellow), remove it with the old flow switch. The flow switch in this kit does not have a ground wire.

Push-to-connect fittings

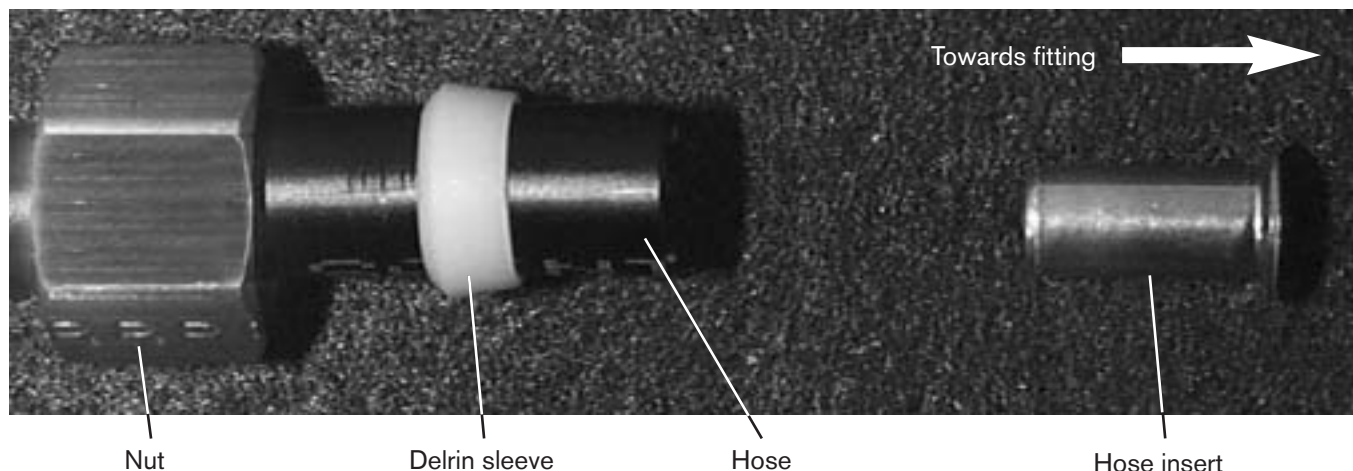
1. Remove the hoses from the existing flow switch and remove the flow switch.
2. Install the new flow switch and reconnect the hoses. For HPR260 systems, install the wire on the J6 connector. See picture on the previous page for reference.
3. Installation complete

Standard elbow fittings

1. Note the orientation of the 2 elbow fittings on the old flow switch. The new fittings will need to have the same orientation.
2. Remove the 2 push-to-connect fittings from the new flow switch.
3. Remove, and discard, the brass sleeves from the 2 elbow fittings provided in this kit. Install the fittings in the new flow switch. Use a thread sealant when installing the fittings. Do not use thread tape.
4. Install the flow switch in the power supply.
5. Connect the hoses to the new fittings and make sure the connections do not leak.

If the connections leak (see picture below for detail):

1. Cut the hose just behind the existing sleeve. Cut as little as possible off the hose.
2. Install the new inserts from this kit into the hoses.
3. Slide the nut onto the hose with the threads toward the fitting.
4. Slide the delrin sleeve from this kit (with the smaller diameter towards the fitting) onto the hose .
5. Connect the hoses to the fittings and make sure the connections do not leak.



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