

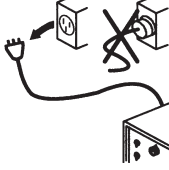


***Manual Gas Console  
Regulator Replacement  
HyPerformance Plasma***

**Field Service Bulletin**

***805460 – Revision 0 – April, 2007***

***Hypertherm<sup>®</sup>***

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

## Introduction

### Purpose

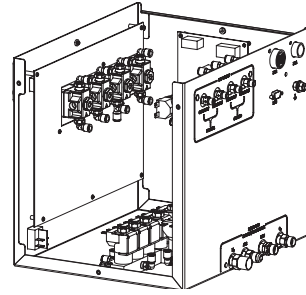
This field service bulletin enables a trained technician to replace the regulators in an HPR manual gas console.

### Kit 228147 contents

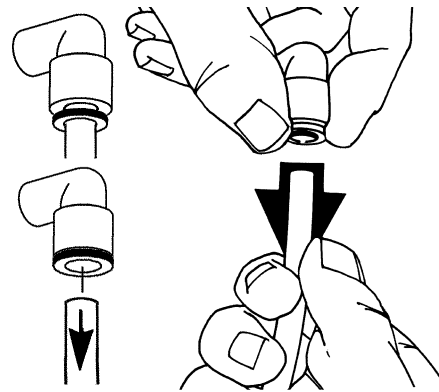
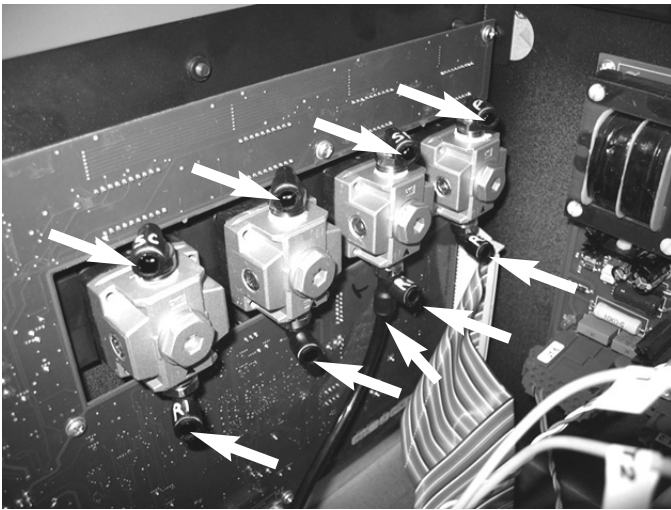
Part number	Description	Qty
104004	Spacer	1
229128	Regulator	3
229129	Regulator	1

## Remove the old regulators

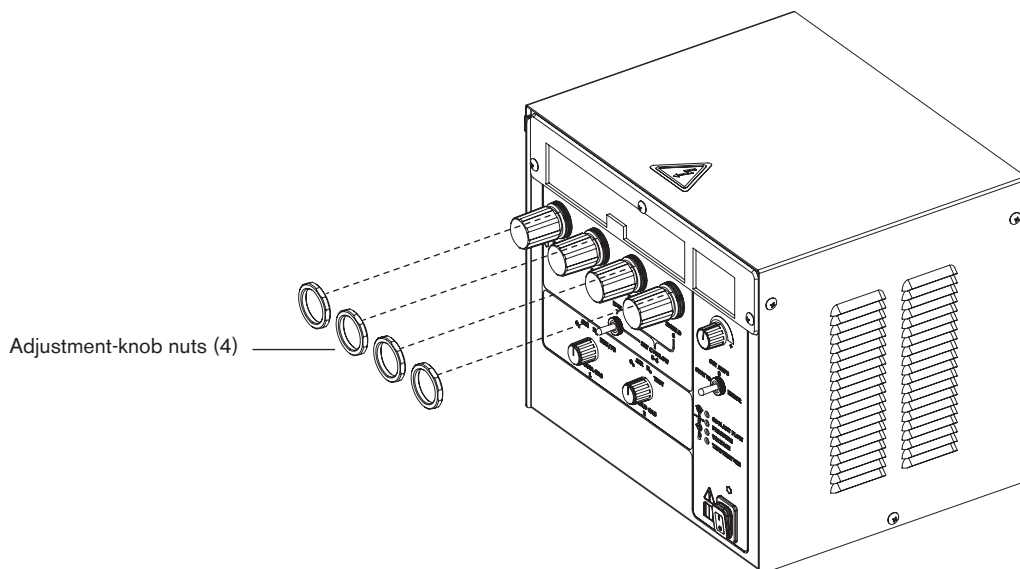
1. Turn OFF all power and incoming gas supplies to the system.
2. Remove the cover from the gas console to access the regulators.



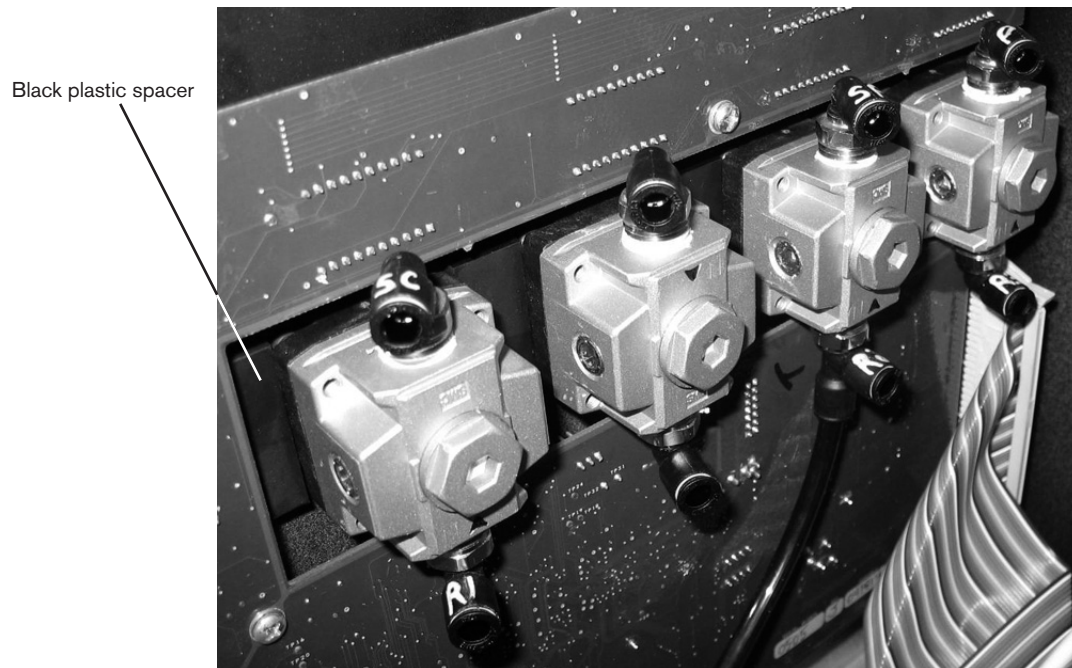
3. First label and then disconnect the gas hoses (9) from the regulators. Apply gentle pressure to the hose while pulling back on the collar of the elbow fitting to release the hose.



4. Remove the plastic nuts (4) from the adjustment knobs and remove the regulators.

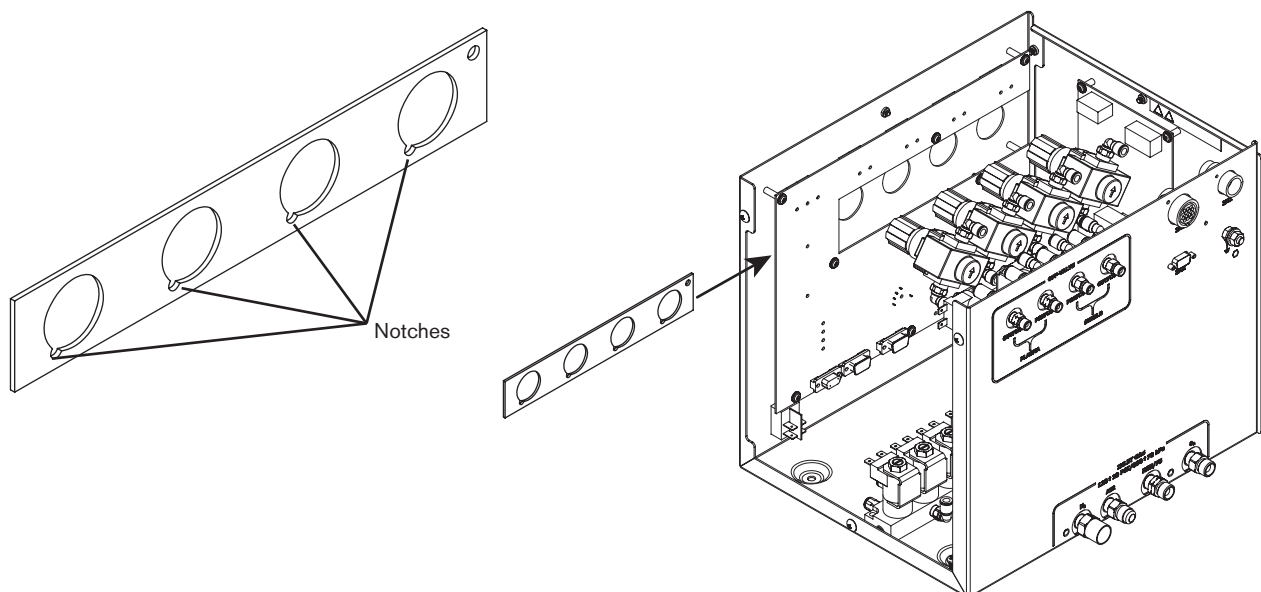


5. Remove the black plastic spacer. The regulators held it in place so it will be loose when the last regulator is removed.



### Install the new regulators

1. Slide the new spacer in between the PC board and the front panel. Orient the spacer with the notches down and to the left as shown in the figure below. The spacer needs to be held in place by hand until the regulators are installed.

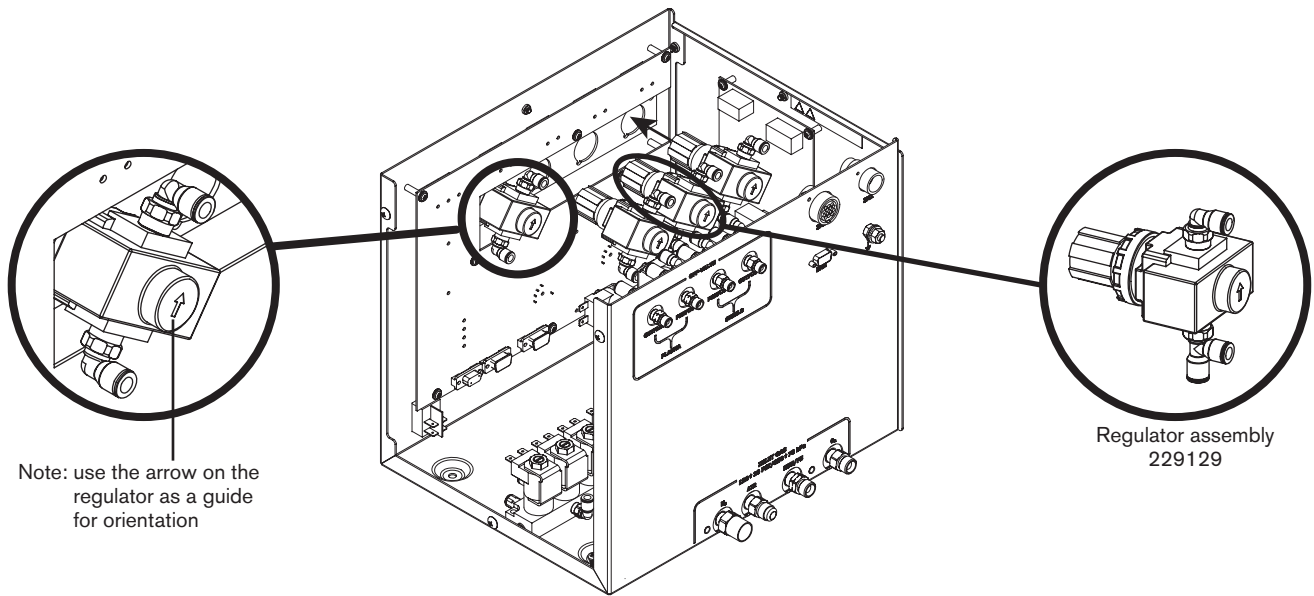


# HPR MANUAL GAS CONSOLE REGULATOR REPLACEMENT

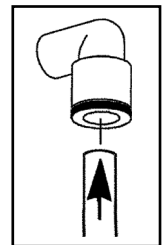
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**Note:** Regulator assembly 229129 has a tee fitting on the bottom and must be installed in the position shown in the diagram below.

2. Orient the new regulators as shown in the figure below and insert them through the holes in the spacer and the front panel of the gas console. Secure the regulator with the plastic nuts.



3. Reconnect the hoses to the regulators. Firmly push the hoses into the fittings until fully seated.
4. Re-install the cover.



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