

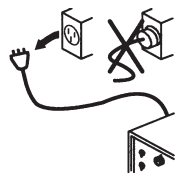
HT4400

Flowswitch Replacement

Field Service Bulletin

806390 – Revision 1 – October, 2009

Hypertherm®

		DANGER ELECTRIC SHOCK CAN KILL
	Disconnect electrical power before performing any maintenance. All work requiring the removal of a component's cover must be performed by a qualified technician. See the <i>Safety Section</i> of the system's Manual for more safety precautions.	

Introduction

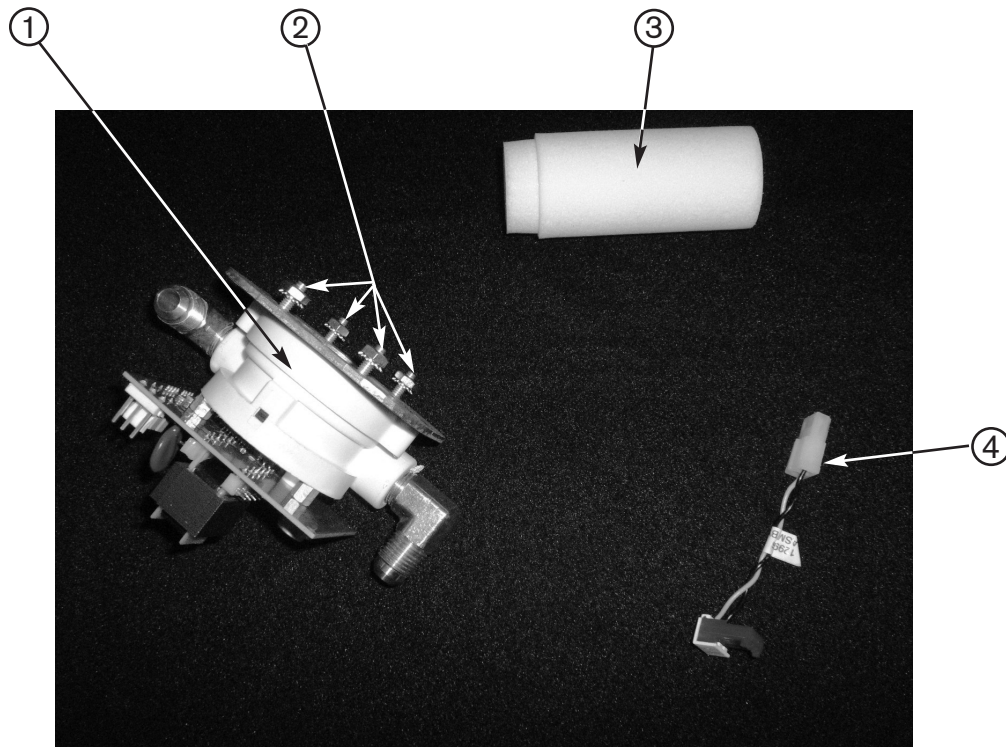
Purpose

This FSB gives instructions for replacing the flowswitch in HT4400 coolers.

Tools and materials needed

Kit 128882 contents

Item	Part Number	Description	Qty
1	129489	Flowswitch	1
2	075159	Nut 8-32	4
3	027664	Filter element	1
4	129996	Wire harness	1



Procedure

1. Turn OFF all power to the system.
2. Disconnect the power from the cooler.
3. Drain the coolant system. See *Cooler draining* in the HySpeed HT4400 Instruction Manual (803580).
4. Refill the system with water.
5. Reconnect the power to the cooler and turn ON the cooler.
6. Run the system for 5 minutes to flush out debris.
7. Turn OFF the system and disconnect the power to the cooler.
8. Drain the coolant system.
9. Remove the old flowswitch:
 - a. Unplug the connectors.
 - b. Remove the coolant lines.
 - c. Remove the mounting hardware.
10. Change the coolant filter (Part Number 027664)
11. Mount the new flowswitch using the 4, 8-32 nuts provided in this kit.
12. Reconnect the coolant hoses.
13. Plug in the electrical connectors. Use Part Number 129996 if necessary (only needed for older systems with a different wire harness).
14. Refill coolant system with Hyperthem coolant Part Number 028872.

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