

PAC110

Torch Repair Instructions

801200 - Rev. 0

HYPERTHERM[®]


PAC110
Torch Repair Instructions

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(P/N 801200)

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PAC110 TORCH REPAIR INSTRUCTIONS

Purpose

The PAC110 torch repair instructions provide the necessary information to allow a person to remove the existing torch main body from the torch assembly and replace it with the PAC100/110 torch main body.

Customer Supplied Tools

#1 Phillips head screwdriver
7/16" open-end wrench
Wire cutters
Sta-kon crimping tool

PAC100/110 Torch Repair Kit (# 028482)

Torch main body assembly, # 020588
Tyrap (1), # 074005

Procedure

Remove Torch Main Body

To remove the existing torch main body, refer to the procedure below and Figure 1. Note that the callouts on the figure correspond to the step numbers below.

1. Remove the five (5) screws holding the handle halves together.
2. Remove the torch main body and torch switch from the handle halves.
3. Cut the two (2) blue wires which connect to the microswitch. Cut at the top of the shrink tubing.
4. Cut the red wire at the pilot arc fitting.
5. Cut the two (2) black wires at the butt splice which connects to the plunger (black wire).
6. Disconnect the torch main body and torch lead gas fittings using the 7/16 inch open-end wrench.

Install PAC100/110 Torch Repair Kit

To install the torch repair kit, refer to the following procedure and Figure 2. Note that the callouts on the figure correspond to the step numbers. Ensure that all the required crimp connections in steps 2 through 4 make good electrical contact.

1. Connect the torch main body assembly (# 020588) and torch lead gas fitting using the 7/16 inch open-wrench.

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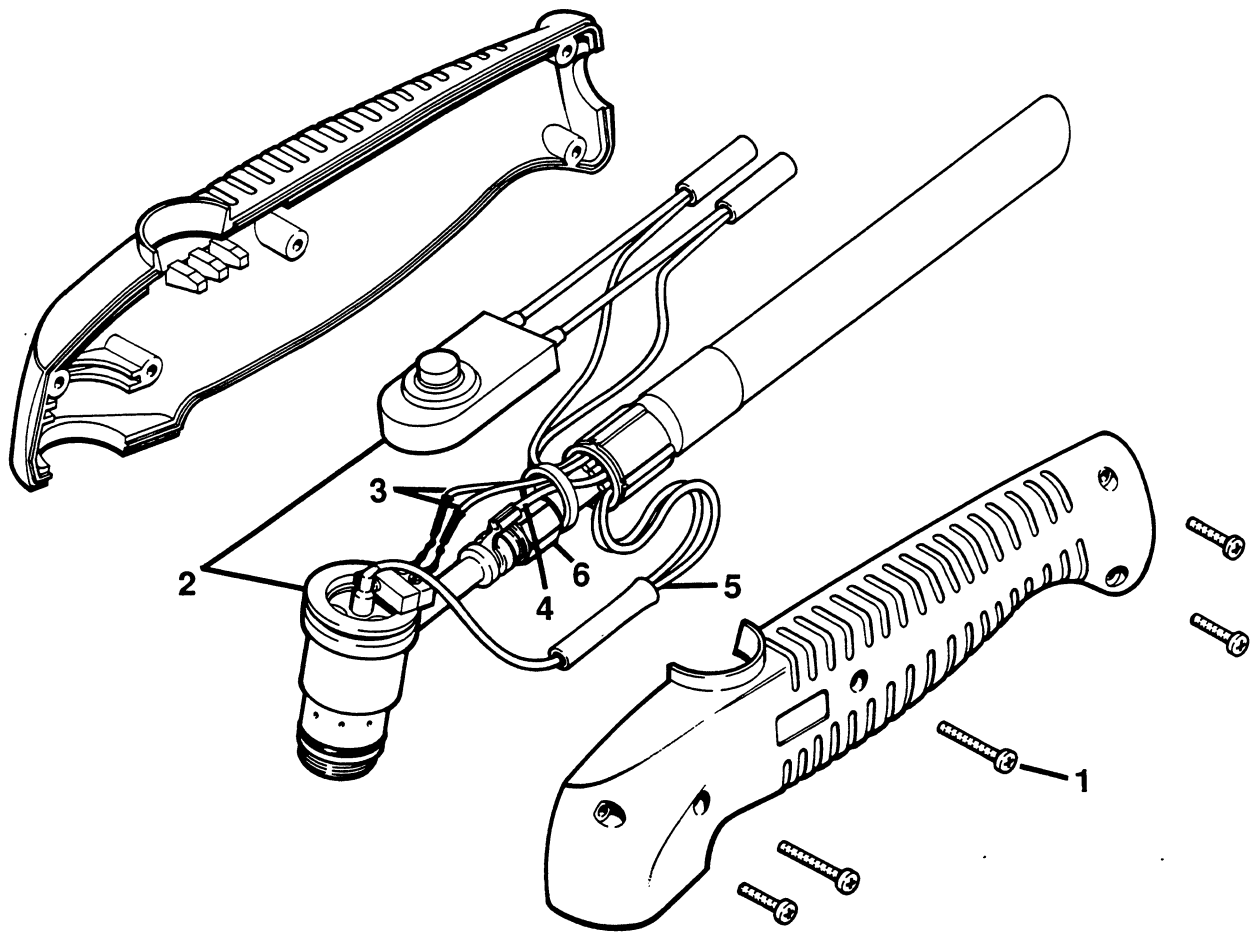


Figure 1 PAC110 Torch Main Body Removal

2. Connect the red wire from the torch lead to the butt splice connecting the red wire to the pilot arc fitting using the Sta-kon crimping tool.
3. Connect the two (2) blue wires from the torch lead to the butt splices connecting the white wires to microswitch using the Sta-kon crimping tool.
4. Connect the two (2) black wires from the torch lead to the butt splice connecting the black plunger wire to the torch main body using the Sta-kon crimping tool.

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5. Connect the Tyrap as shown.
6. Install the torch main body assembly and torch switch into one of the handle halves. While positioning the handle halves together, be careful not to pinch any wires. Be especially careful around the torch switch retainers.
7. Replace the five (5) screws to secure the handle halves together.

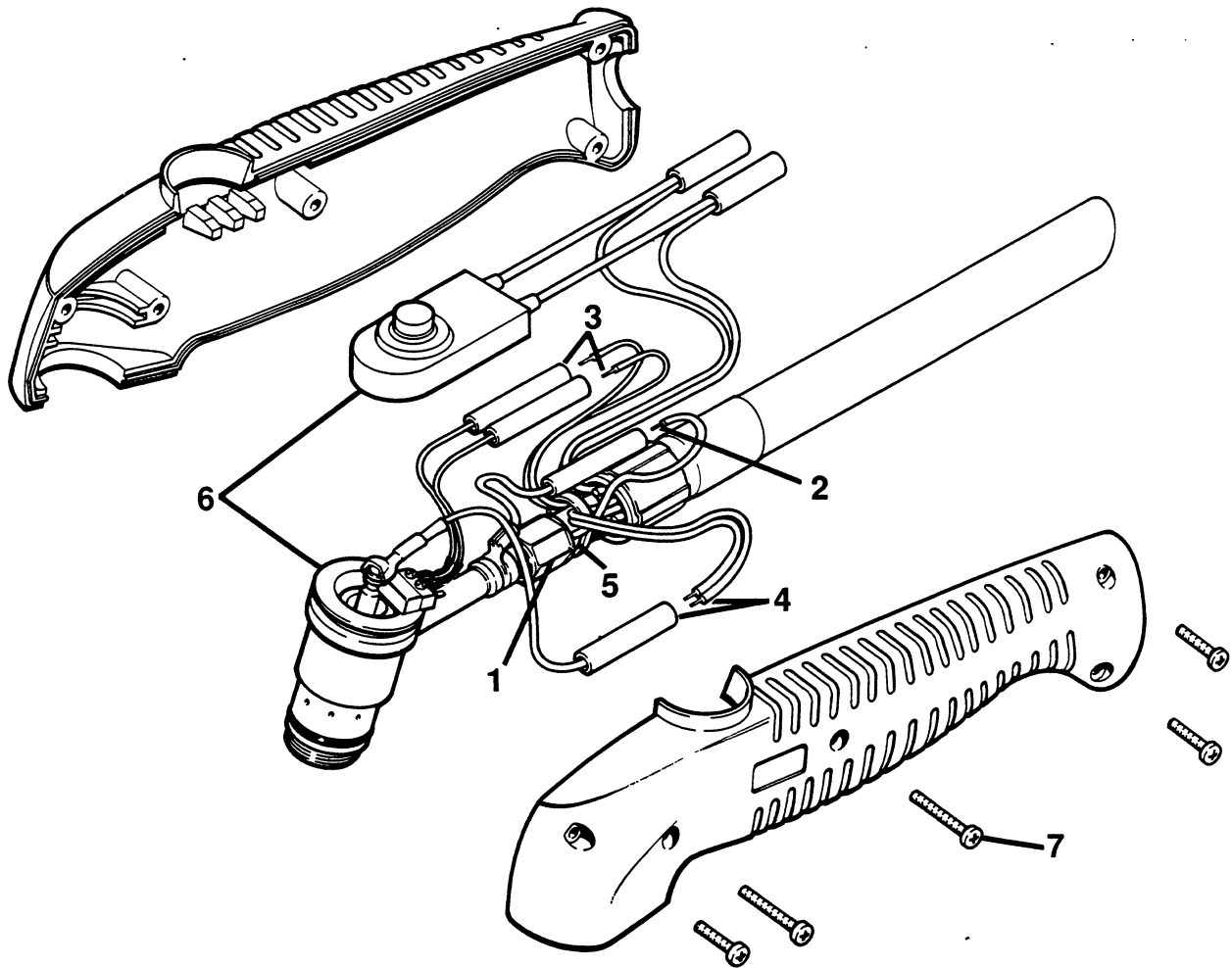


Figure 2 PAC100/110 Torch Repair Kit Installation

