

powermax350

Solenoid Valve Replacement

Kit: 128508

Kit Instructions

IM-381

(P/N 803810)

Revision 0 - January 2000

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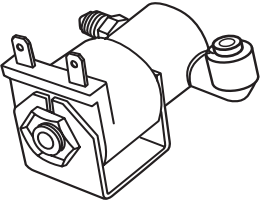
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powermax350 Solenoid Valve Replacement

128508 KIT CONTENTS

	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
	060150	Solenoid Valve Assembly	1
	-	Hose	13.5" (343 mm)
	-	Edging	4" (102 mm)
	803810	Instructions	1

PURPOSE


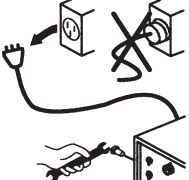
The brass hose fitting on the solenoid valve can come into contact with the main transformer and result in damage to the transformer insulation.

This kit provides instructions to inspect affected units and install a new solenoid valve that uses a lower profile plastic hose fitting.

This kit should also be used anytime the solenoid valve requires replacement.

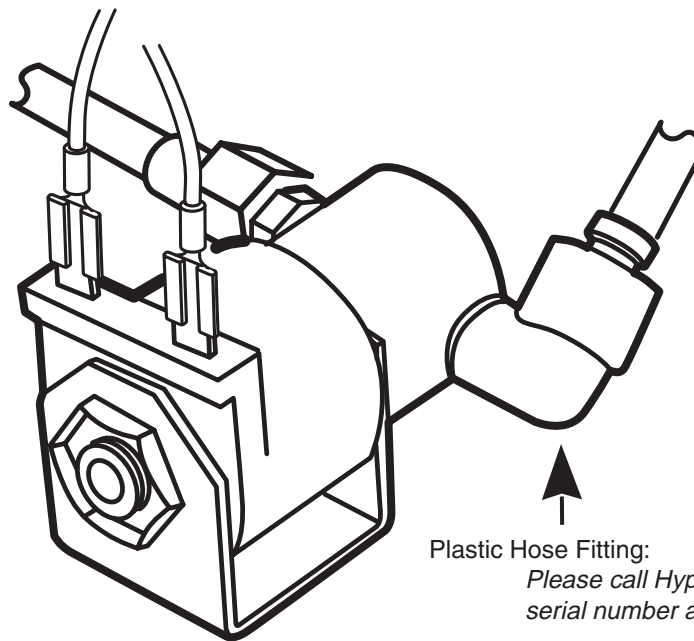
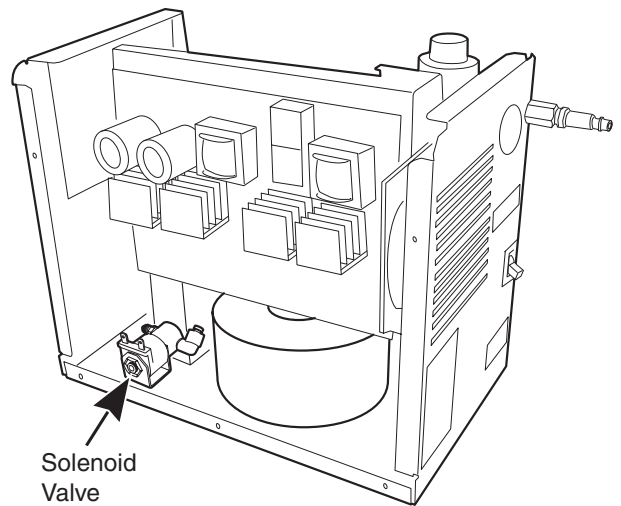
powermax350 Solenoid Valve Replacement

INSTRUCTIONS

	WARNING ELECTRIC SHOCK CAN KILL
	Disconnect electrical power before performing any maintenance. All work requiring removal of the power supply cover must be performed by a qualified technician.

Inspect Solenoid Valve Assembly

- Disconnect electrical power.
 - Disconnect gas supply.
 - Remove the power supply cover.
- ① Look at the solenoid valve hose fitting.
 - ② If the fitting is plastic, no further action is required. Please notify Hypertherm of the unit serial number for record of compliance.
 - ③ If the fitting is brass, solenoid valve replacement is required.



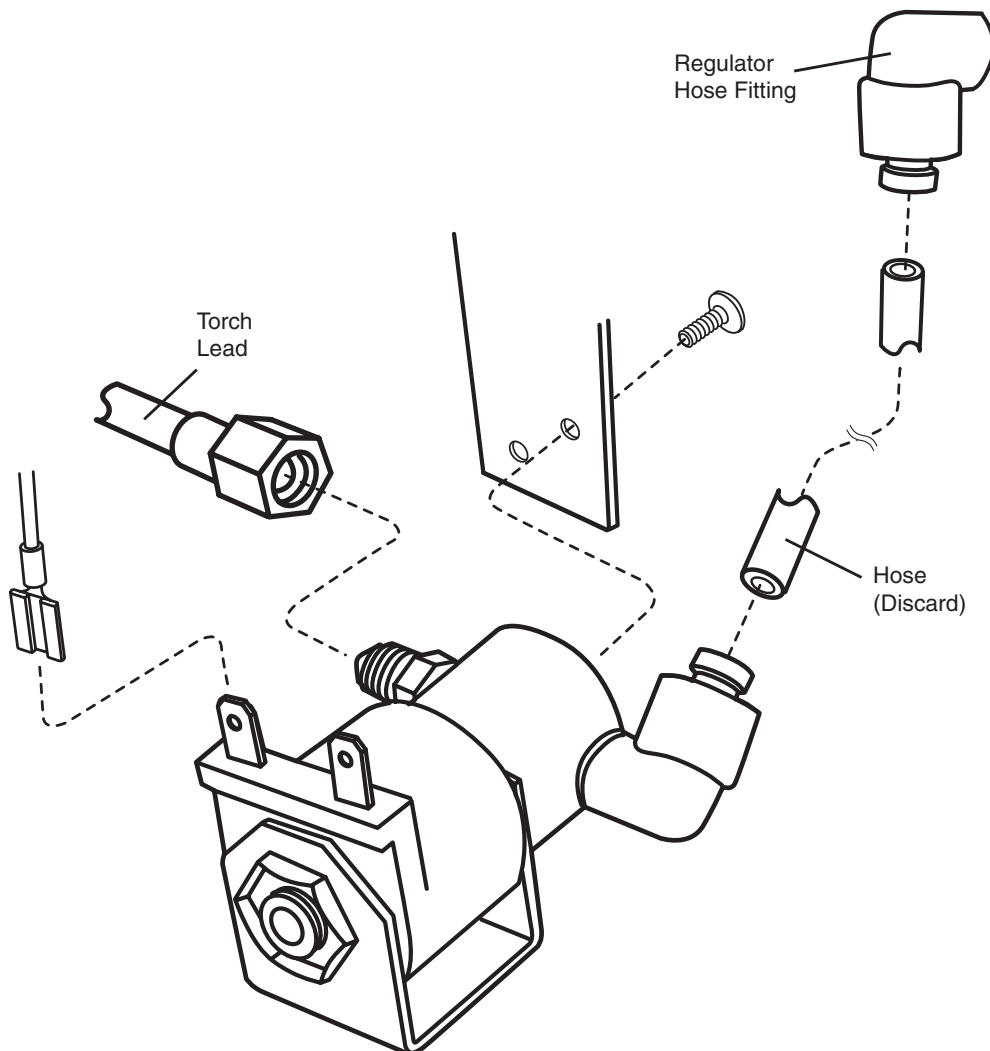
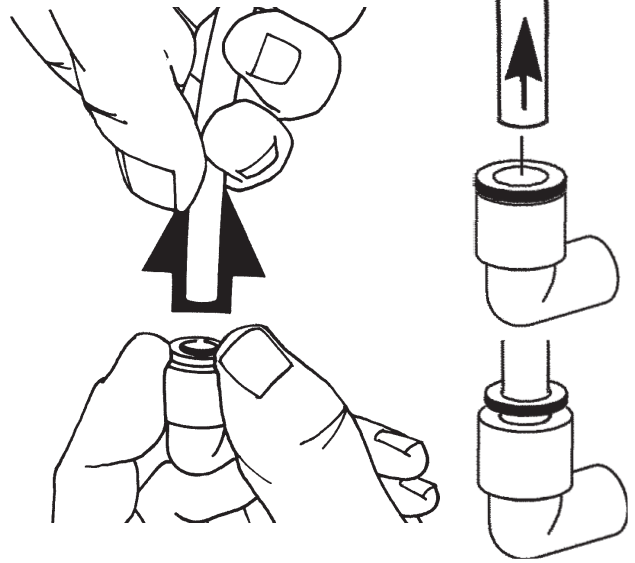
Plastic Hose Fitting:
Please call Hypertherm with unit serial number and return unit to service.

Brass Hose Fitting:
Replace Solenoid Valve

powermax350 Solenoid Valve Replacement

Remove the Solenoid Valve Assembly

- ① Compress the hose fitting collar and pull the gas hose from the solenoid valve and regulator hose fittings. Discard hose.
- ② Disconnect the 2 electrical connections from the solenoid valve assembly.
- ③ Disconnect the torch lead from the solenoid valve assembly. Remove the solenoid valve assembly from the power supply.

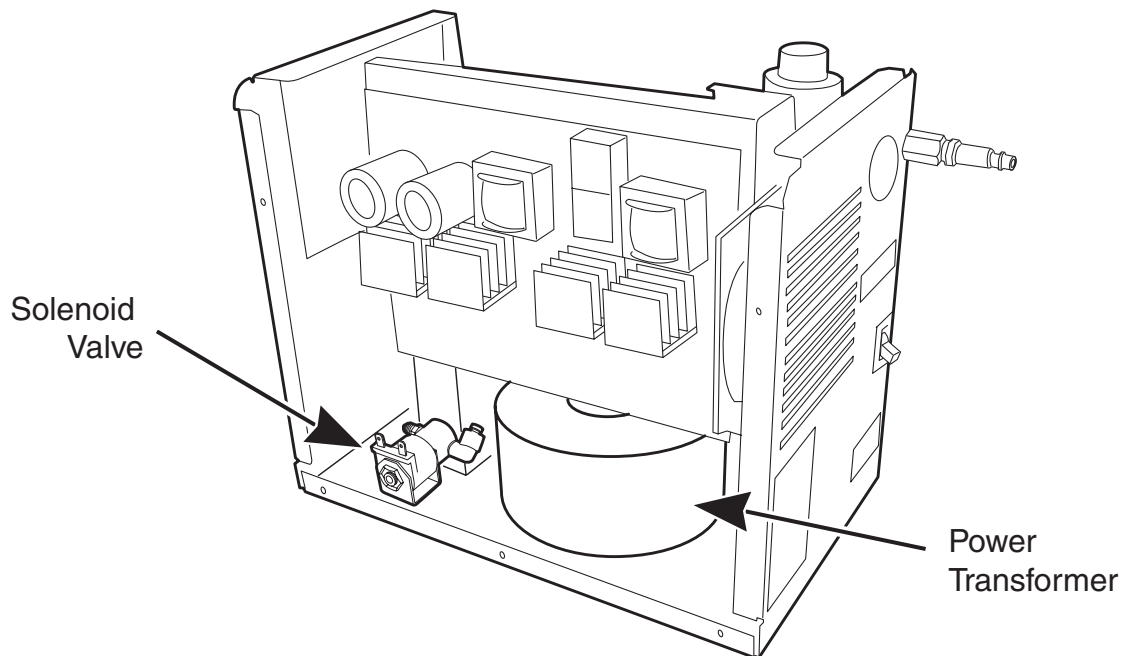


powermax350 Solenoid Valve Replacement

Inspect the Transformer

- ① Inspect the transformer insulation for evidence of abrasion with the solenoid hose fitting.
- ② If there is any evidence of abrasion, replace the transformer.
- ③ Transformer Part Numbers:

060148	115/230V
060149	115/230V (CE)



powermax350 Solenoid Valve Replacement

Install New Solenoid Valve Assembly

- ① Install kit edging on solenoid bracket.
- ② Install the new solenoid valve assembly and secure with two screws.
- ③ Connect the torch lead fitting to the solenoid valve assembly.
- ④ Install the new hose to the solenoid valve hose fitting and to the regulator.
- ⑤ Connect the 2 electrical connections to the solenoid valve assembly.
- ⑥ Connect 70-120 psi / 4.8-8.3 bar air pressure to the power supply and check for leaks (3 places).
- ⑦ Install power supply cover.

