

228613 – annual preventive maintenance parts kit (200-240 volt)

228622 – annual preventive maintenance parts kit (380-600 volt)

The kits include all the parts in the shaded boxes below

<b>Timeline</b>	<b>Component</b>	<b>Part number</b>	<b>Qty</b>
6 months or 300 arc hours	Coolant filter element	027664	1
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
	Air filter element	011110	1
1 Year or 600 arc hours	Coolant filter element	027664	1
	Coolant solution 70/30	028872	16 Gal
	Main contactor*	003218	2
	Main contactor**	003233	2
	Torch main body	220706	1
	Pilot arc relay	003149	1
	Air filter element	011110	1
1.5 Years or 900 arc hours+	Coolant filter element	027664	1
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
	Air filter element	011110	1
2 Years or 1200 arc hours	Coolant filter element	027664	1
	Coolant solution 70/30	028872	16 Gal
	Main contactor*	003218	2
	Main contactor**	003233	2
	Torch main body	220706	1
	Pilot arc relay	003149	1
	Chiller pump***	040296	1
	Chiller pump****	040297	1
	Torch leads	System dependent	1
	Quick-disconnect receptacle	220705	1
Air filter element	011110	1	
2.5 Years or 1500 arc hours	Coolant filter element	027664	1
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
	Air filter element	011110	1
3 Years or 1800 arc hours	Coolant filter element	027664	1
	Coolant solution 70/30	028872	16 Gal
	Main contactor*	003218	2
	Main contactor**	003233	2
	Torch main body	220706	1
	Pilot arc relay	003149	1
	Cooling fan 6"	127039	8
	Cooling fan 10"	027079	6
Air filter element	011110	1	
3.5 Years or 2100 arc hours	Coolant filter element	027664	1
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
	Air filter element	011110	1

4 Years or 2400 arc hours	Coolant filter element	027664	1
	Coolant solution 70/30	028872	16 Gal
	Main contactor*	003218	2
	Main contactor**	003233	2
	Torch main body	220706	1
	Pilot arc relay	003149	1
	Chiller pump***	040296	1
	Chiller pump****	040297	1
	Cooling fan 6"	127039	8
	Torch leads	Length dependent	1
	Quick-disconnect receptacle	220705	1
	Coolant pump motor kit	128385	1
	Air filter element	011110	1
4.5 Years or 2700 arc hours	Coolant filter element	027664	1
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
	Air filter element	011110	1
5 Years or 3000 arc hours	Coolant filter element	027664	1
	Coolant solution 70/30	028872	16 Gal
	Main contactor*	003218	2
	Main contactor**	003233	2
	Torch main body	220706	1
	Pilot arc relay	003149	1
	High voltage transformer	129854	1
	Power distribution board	041802	1
	Metering console	078184	1
	Pilot arc lead	Length dependent	1
	Gas leads	Length dependent	1
Air filter element	011110	1	
5.5 Years or 3300 arc hours	Coolant filter element	027664	1
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
	Air filter element	011110	1
6 Years or 3600 arc hours	Coolant filter element	027664	1
	Coolant solution 70/30	028872	16 Gal
	Main contactor*	003218	2
	Main contactor**	003233	2
	Torch main body	220706	1
	Pilot arc relay	003149	1
	Chiller pump***	040296	1
	Chiller pump****	040297	1
	Torch leads	Length dependent	1
	Quick-disconnect receptacle	220705	1
	Cooling fan 6"	127039	8
	Cooling fan 10"	027079	6
	Air filter element	011110	1

6.5 Years or 3900 arc hours Repeat schedule starting at 6 months or 300 arc hours

\* 200/208, 220 and 240 volt power supplies

\*\* 380, 400, 440, 480 and 600 volt power supplies

\*\*\* 200-240 and 380-460 volt chillers

\*\*\*\* 575-600 volt chillers