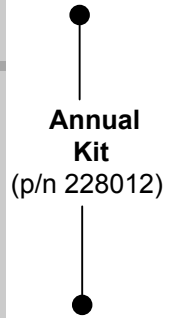


HD3070® Parts Replacement Schedule



Timeline	Component	Part number	Qty.
6 months or 250 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
1 Year or 500 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003133	1
	Contacto switch	003065	2
	Torch main body	120349	1
	Pilot arc relay	003021	1
	Light bulb	005168	1
	Lens (red)	005091	1
1.5 Years or 750 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
2 Years or 1000 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003133	1
	Contacto switch	003065	2
	Torch main body	120349	1
	Pilot arc relay	003021	1
	Light bulb	005168	1
	Lens (red)	005091	1
	Coolant pump	128384	1
	Torch leads	System dependent	1
Spark gap electrode	004061	3	
2.5 Years or 1250 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
3 Years or 1500 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003133	1
	Contacto switch	003065	2
	Torch main body	120349	1
	Pilot arc relay	003021	1
	Light bulb	005168	1
	Lens (red)	005091	1
	Off-valve assembly	System dependent	1
	Cooling fan	027080	1
Cooling fan	027079	1	
3.5 Years or 1750 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
4 Years or 2000 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003133	1
	Contacto switch	003065	2
	Torch main body	120349	1
	Pilot arc relay	003021	1
	Light bulb	005168	1
	Lens (red)	005091	1
	Coolant pump	128384	1
	Torch leads	System dependent	1
Spark gap electrode	004061	3	
4.5 Years or 2250 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4



5 Years or 2500 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003133	1
	Contacto switch	003065	2
	Torch main body	120349	1
	Pilot arc relay	003021	1
	Light bulb	005168	1
	Lens (red)	005091	1
	High voltage transformer	129199	1
	Power distribution board	041544	1
	Pilot arc lead	System dependent	1
	Gas leads	System dependent	1
5.5 Years or 2750 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
6.0 Years or 3000 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003133	1
	Contacto switch	003065	2
	Torch main body	120349	1
	Pilot arc relay	003021	1
	Light bulb	005168	1
	Lens (red)	005091	1
	Coolant pump	128384	1
	Torch leads	System dependent	
	Spark gap electrode	004061	3
	Off-valve assembly	System dependent	1
	Cooling fan	027080	1
	Cooling fan	027079	1
6.5 Years or 3250 arc hrs.	Repeat schedule starting at 6 months or 300 arc hrs.		

*First year shaded area indicates component is included in the annual preventive maintenance kit (p/n 228012)