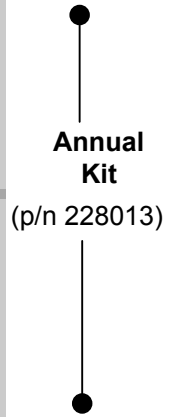


HD4070* Parts Replacement Schedule



Timeline	Component	Part number	Qty.
6 months or 300 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch bullet kit	128654	1
	O-ring	058224	1
	O-ring	044028	2
	O-ring	044030	1
1 Year or 600 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Main contactor	003201	1
	Pilot arc relay	003149	1
	O-ring	058224	1
	Filter element	027927	1
1.5 Years or 900 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch bullet kit	128654	1
	O-ring	058224	1
	O-ring	044028	2
	O-ring	044030	1
2 Years or 1200 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Main contactor	003201	1
	Pilot arc relay	003149	1
	O-ring	058224	1
	Filter element	027927	1
	Coolant pump	System dependent	1
	Torch leads	System dependent	1
	2.5 Years or 1500 arc hrs.	Coolant filter element	027664
Coolant solution 70/30		028872	4
Torch bullet kit		128654	1
O-ring		058224	1
O-ring		044028	2
O-ring		044030	1
3 Years or 1800 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Main contactor	003201	1
	Pilot arc relay	003149	1
	O-ring	058224	1
	Filter element	027927	1
	Off-valve assembly	129563	1
	Cooling fan	027080	2
Cooling fan	129634	1	
3.5 Years or 2100 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch bullet kit	128654	1
	O-ring	058224	1



	O-ring	044028	2
	O-ring	044030	1
4 Years or 2400 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Main contactor	003201	1
	Pilot arc relay	003149	1
	O-ring	058224	1
	Filter element	027927	1
	Coolant pump	System dependent	1
	Torch leads	System dependent	1
4.5 Years or 2700 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch bullet kit	128654	1
	O-ring	058224	1
	O-ring	044028	2
	O-ring	044030	1
5 Years or 3000 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Main contactor	003201	1
	Pilot arc relay	003149	1
	O-ring	058224	1
	Filter element	027927	1
	Power distribution board	041610	1
	Pilot arc lead	System dependent	1
	Gas leads	System dependent	1
5.5 Years or 3300 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch bullet kit	128654	1
	O-ring	058224	1
	O-ring	044028	2
	O-ring	044030	1
6.0 Years or 3600 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Main contactor	003201	1
	Pilot arc relay	003149	1
	O-ring	058224	1
	Filter element	027927	1
	Coolant pump	System dependent	1
	Torch leads	System dependent	1
	Off-valve assembly	129563	1
	Cooling fan	027080	2
	Cooling fan	129634	1
6.5 Years or 3900 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 228013)