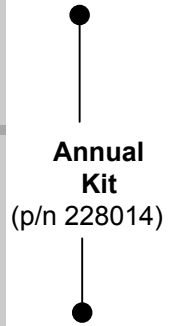


Timeline	Component	Part number	Qty.
6 months or 300 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
1 Year or 600 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	220162	1
	Main contactor	003201	1
	Pilot arc relay	003149	1
	Filter element	027927	1
1.5 Years or 900 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
2 Years or 1200 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	220162	1
	Main contactor	003201	1
	Pilot arc relay	003149	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	1
	Coolant solution 70/30	028872	4
	Torch kit	128879	1
	Quick-disconnect kit	128880	1
3 Years or 1800 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	220162	1
	Main contactor	003201	1
	Pilot arc relay	003149	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 kit	128879	1
	Quick-disconnect kit	128880	1
4 Years or 2400 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Main contactor	003201	1
	Torch main body	220162	1
	Pilot arc relay	003149	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 kit	128879	1
	Quick-disconnect kit	128880	1
5 Years or 3000 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	220162	1
	Torch main body	220162	1
	Pilot arc relay	003149	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 kit	128879	1
	Quick-disconnect kit	128880	1
6.0 Years or 3600 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Main contactor	003201	1
	Torch main body	220162	1
	Pilot arc relay	003149	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 228014)