

**HPR130™ - Manual Gas 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 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
	Main contactor	003139	1
	Torch main body	220162	1
	Pilot arc relay	003149	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
	Main contactor	003139	1
	Torch main body	220162	1
	Pilot arc relay	003149	1
	Coolant pump	129994	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
	Main contactor	003139	1
	Torch main body	220162	1
	Pilot arc relay	003149	1
	Off-valve assembly	129816	1
	Cooling fan	127039	2
	Cooling fan	027079	1
	Regulator sub-assembly	129992	3
	Regulator sub-assembly	129993	1
3.5 Years or 2100 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch kit	128879	1

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**Annual**  
**Kit**  
 (p/n 228015)  
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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
	Main contactor	003139	1
	Torch main body	220162	1
	Pilot arc relay	003149	1
	High voltage transformer	129854	1
	Power distribution board	041802	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	003139	1
	Torch main body	220162	1
	Pilot arc relay	003149	1
	Coolant pump	129994	1
	Torch leads	System dependent	1
	Off-valve assembly	129816	1
	Cooling fan	127039	2
	Cooling fan	027079	1
Regulator sub-assembly	129992	3	
Regulator sub-assembly	129993	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 228015)