

228167 – annual preventive maintenance parts kit
This kit includes all the parts in the shaded boxes below

| Timeline | Component | Part number | Qty |
|-----------------------------|-------------------------------------------------------|------------------|------------------|
| 6 months or 300 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| 1 Year or 600 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| | Main contactor | 003139 | 1 |
| | Torch main body | 220474 | 1 |
| | Air filter | 011093 | 1 |
| 1.5 Years or 900 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| 2 Years or 1200 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| | Main contactor | 003139 | 1 |
| | Torch main body | 220474 | 1 |
| | Air filter | 011093 | 1 |
| | Coolant pump | 229126 | 1 |
| | Torch leads | System dependent | 1 |
| 2.5 Years or 1500 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| 3 Years or 1800 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| | Main contactor | 003139 | 1 |
| | Torch main body | 220474 | 1 |
| | Air filter | 011093 | 1 |
| | Off-valve assembly | System dependent | 1 |
| 3.5 Years or 2100 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| 4 Years or 2400 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| | Main contactor | 003139 | 1 |
| | Torch main body | 220474 | 1 |
| | Air filter | 011093 | 1 |
| | Pilot arc relay | 003149 | 1 |
| | Coolant pump | 229126 | 1 |
| | Torch leads | System dependent | 1 |
| | Coolant pump motor | 128385 | 1 |
| | Cooling fan | 127039 | System dependent |
| 4.5 Years or 2700 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| 5 Years or 3000 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| | Main contactor | 003139 | 1 |
| | Torch main body | 220474 | 1 |
| | Air filter | 011093 | 1 |
| | High voltage transformer | 129854 | 1 |
| | Power distribution board | 041935 | 1 |
| | Pilot arc lead | System dependent | 1 |
| Gas leads | System dependent | 1 | |
| 5.5 Years or 3300 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| 6 Years or 3600 arc hours | Coolant filter element | 027664 | 1 |
| | Coolant solution 70/30 | 028872 | 4 |
| | Main contactor | 003139 | 1 |
| | Torch main body | 220474 | 1 |
| | Air filter | 011093 | 1 |
| | Coolant pump | 229126 | 1 |
| | Torch leads | System dependent | 1 |
| | Off-valve assembly | System dependent | 1 |
| | Cooling fan 6" | 127039 | System dependent |
| | Cooling fan 10" | 027079 | 1 |
| 6.5 Years or 3900 arc hours | Repeat schedule starting at 6 months or 300 arc hours | | |