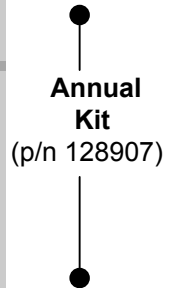


HT2000® Parts Replacement Schedule



Timeline	Component	Part number	Qty.
6 months or 300 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
1 Year or 600 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003139	1
	Torch main body	120584	1
	Pilot arc relay	003021	1
	Light bulb	005149	1
	Lens (white)	005089	1
1.5 Years or 900 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
2 Years or 1200 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003139	1
	Torch main body	120584	1
	Pilot arc relay	003021	1
	Light bulb	005149	1
	Lens (white)	005089	1
	Coolant pump	128384	1
	Torch leads	System dependent	1
	Spark gap electrode	004061	3
2.5 Years or 1500 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
3 Years or 1800 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003139	1
	Torch main body	120584	1
	Pilot arc relay	003021	1
	Light bulb	005149	1
	Lens (white)	005089	1
	Off-valve assembly	129840	1
	Cooling fan	027080	2
	Cooling fan	027079	1
3.5 Years or 2100 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
4 Years or 2400 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003139	1
	Torch main body	120584	1
	Pilot arc relay	003021	1
	Light bulb	005149	1
	Lens (white)	005089	1
	Coolant pump	128384	1
	Torch leads	System dependent	1
	Spark gap electrode	004061	3
4.5 Years or 2700 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
5 Years or 3000 arc hrs.	Coolant filter element	027005	1



	Coolant solution 70/30	028872	4
	Main contactor	003139	1
	Torch main body	120584	1
	Pilot arc relay	003021	1
	Light bulb	005149	1
	Lens (white)	005089	1
	High voltage transformer	129150	1
	Power distribution board	041534	1
	Pilot arc lead	System dependent	1
	Gas leads	System dependent	1
5.5 Years or 3300 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
6.0 Years or 3600 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Main contactor	003139	1
	Torch main body	120584	1
	Pilot arc relay	003021	1
	Light bulb	005149	1
	Lens (white)	005089	1
	Coolant pump	128384	1
	Torch leads	System dependent	1
	Spark gap electrode	004061	3
	Off-valve assembly	129840	1
	Cooling fan	027080	2
	Cooling fan	027079	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 128907)