

# HT4001® Parts Replacement Schedule



Timeline	Component	Part number	Qty.
6 months or 300 arc hrs.	Coolant filter element	027005	1
1 Year or 600 arc hrs.	Coolant filter element	027005	1
	Lens (green)	005177	1
	Lens (white)	005089	1
	Light bulb	005149	2
	Torch main body	020328	1
	Pilot arc relay	System dependent	1
	Main contactor	System dependent	1
1.5 Years or 900 arc hrs.	Coolant filter element	027005	1
2 Years or 1200 arc hrs.	Coolant filter element	027005	1
	Lens (green)	005177	1
	Lens (white)	005089	1
	Light bulb	005149	2
	Torch main body	020328	1
	Pilot arc relay	System dependent	1
	Main contactor	System dependent	1
	Torch leads	System dependent	1
	Spark gap electrode	004061	3
	Flowswitch	005140	1
	Flowswitch	005139	1
	Diode pack*	029571	1
	2.5 Years or 1500 arc hrs.	Coolant filter element	027005
3 Years or 1800 arc hrs.	Coolant filter element	027005	1
	Lens (green)	005177	1
	Lens (white)	005089	1
	Light bulb	005149	2
	Torch main body	020328	1
	Pilot arc relay	System dependent	1
	Main contactor	System dependent	1
	Off-valve assembly	129158	1
	Cooling fan	027080	5
	Cooling fan	027079	2
	3.5 Years or 2100 arc hrs.	Coolant filter element	027005
4 Years or 2400 arc hrs.	Coolant filter element	027005	1
	Lens (green)	005177	1
	Lens (white)	005089	1
	Light bulb	005149	2
	Torch main body	020328	1
	Pilot arc relay	System dependent	1
	Main contactor	System dependent	1
	Torch leads	System dependent	1
	Spark gap electrode	004061	3
	Flowswitch	005140	1
	Flowswitch	005139	1
Diode pack*	029571	1	
4.5 Years or 2700 arc hrs.	Coolant filter element	027005	1
5 Years or 3000 arc hrs.	Coolant filter element	027005	1
	Lens (green)	005177	1

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	Lens (white)	005089	1
	Light bulb	005149	2
	Torch main body	020328	1
	Pilot arc relay	System dependent	1
	Main contactor	System dependent	1
	High voltage transformer	029902	1
	Power distribution board	System dependent	1
	Pilot arc lead	System dependent	1
	Gas leads	System dependent	1
5.5 Years or 3300 arc hrs.	Coolant filter element	027005	1
6.0 Years or 3600 arc hrs.	Coolant filter element	027005	1
	Lens (green)	005177	1
	Lens (white)	005089	1
	Light bulb	005149	2
	Torch main body	020328	1
	Pilot arc relay	System dependent	1
	Main contactor	System dependent	1
	Torch leads	System dependent	1
	Spark gap electrode	004061	3
	Flowswitch	005140	1
	Flowswitch	005139	1
	Diode pack*	029571	1
	Off-valve assembly	129158	1
	Cooling fan	027080	5
	Cooling fan	027079	2
6.5 Years or 3900 arc hrs.	Repeat schedule starting at 6 months or 300 arc hrs.		

\* - older systems only

\* First year shaded area indicates component is included in the annual preventive maintenance kit (p/n 228068)