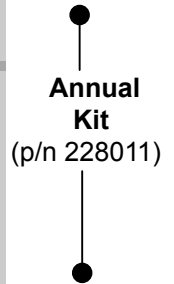


HT4400® Parts Replacement Schedule



Timeline	Component	Part number	Qty.
6 months or 300 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
1 Year or 600 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Pilot arc relay	003021	1
	Light bulb	005149	2
	Lens (green)	005177	1
	Lens (white)	005089	1
1.5 Years or 900 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
2 Years or 1200 arc hrs.	Coolant filter element	027005	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Pilot arc relay	003021	1
	Light bulb	005149	2
	Lens (green)	005177	1
	Lens (white)	005089	1
	Coolant pump	128968	1
	Torch leads	System dependent	1
	Flowswitch assembly	129489	1
2.5 Years or 1500 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
3 Years or 1800 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Pilot arc relay	003021	1
	Light bulb	005149	2
	Lens (green)	005177	1
	Lens (white)	005089	1
	Main contactor*	003217	1
	Main contactor*	003218	1
	Off-valve assembly	077035	1
	Cooling fan	027080	5
	Cooling fan	027079	2
	3.5 Years or 2100 arc hrs.	Coolant filter element	027664
Coolant solution 70/30		028872	4
4 Years or 2400 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Pilot arc relay	003021	1
	Light bulb	005149	2
	Lens (green)	005177	1
	Lens (white)	005089	1
	Coolant pump	128968	1
Torch leads	System dependent	1	
4.5 Years or 2700 arc hrs.	Flowswitch assembly	129489	1
	Coolant filter element	027664	1



	Coolant solution 70/30	028872	4
5 Years or 3000 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Pilot arc relay	003021	1
	Light bulb	005149	2
	Lens (green)	005177	1
	Lens (white)	005089	1
	Ignition module	027648	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
6.0 Years or 3600 arc hrs.	Coolant filter element	027664	1
	Coolant solution 70/30	028872	4
	Torch main body	120651	1
	Pilot arc relay	003021	1
	Light bulb	005149	2
	Lens (green)	005177	1
	Lens (white)	005089	1
	Main contactor*	003217	1
	Main contactor*	003218	1
	Coolant pump	128968	1
	Torch leads	System dependent	1
	Flowswitch assembly	129489	1
	Off-valve assembly	077035	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.		

* Denotes power supply specific

* First year shaded area indicates component is included in the annual preventive maintenance kit (p/n 228011)