

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
	Cooling fan	127039	System dependent
Cooling fan	027079	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
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		