

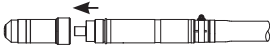
**⚠️ WARNING! READ THE SAFETY INFORMATION**

Before operating or maintaining any Hypertherm equipment, read the Safety and Compliance Manual (80669C) for important safety information.

You can find the Safety and Compliance Manual in the "Downloads library" at [www.hypertherm.com](http://www.hypertherm.com).

## Rebuild the torch

1. Turn OFF the power to the system.
2. Remove the quick-disconnect torch from the quick-disconnect receptacle.



3. Remove the consumables.



4. Replace the following parts:

▪ **Water tube ①**

- Insert the tube until it comes to a stop. The tube will move slightly from its base to allow it to align with the electrode, but the tube should not disconnect from the torch.

▪ **(2) O-rings ② on the front of the torch body**

- Apply a thin layer of silicon lubricant to each new O-ring before you install it. The O-rings should look shiny, but there should not be too much lubricant.

▪ **HPR only: Seal ③ on the front of the torch below the Hypertherm logo**

▪ **O-ring on the coolant-in connection ④ and (4) bullet plugs ⑤**

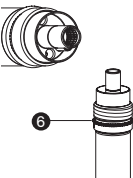
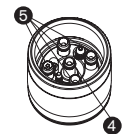
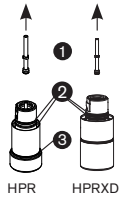
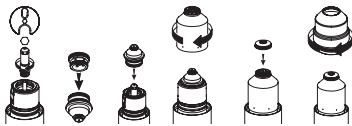
- A. Use pliers to pull the old bullet plugs straight out.
- B. Apply a thin layer of lubricant to the new O-ring.
- C. Carefully install the O-ring onto the coolant-in connector.
- D. Install the new bullet plugs. (Make sure each new bullet plug is fully seated and has 2 O-rings. Do not use tools to push the plugs into the slots. This can damage the plugs.)

▪ **O-ring ⑥ on the bottom of the quick-disconnect receptacle**

- Do not lubricate this O-ring.

5. Examine the consumables, and remove any contamination.

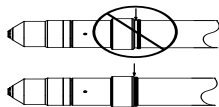
6. Install the consumables.



7. Assemble the quick-disconnect torch and receptacle.



- To prevent damage, make sure to correctly align the torch and receptacle.
- Make sure that there is no space between the torch body and the O-ring on the torch quick-disconnect receptacle.



8. Turn ON the power to the system.