



**XPR™**

Power-Indicator LED Upgrade Procedures

Field Service Bulletin

810570 | Revision 1 | December 2019

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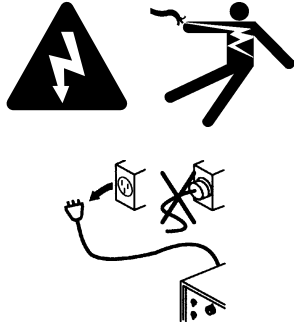
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One of Hypertherm's long-standing core values is a focus on minimizing our impact on the environment. Doing so is critical to our, and our customers', success. We are always striving to become better environmental stewards; it is a process we care deeply about.

## Introduction

### WARNING



#### ELECTRIC SHOCK CAN KILL

Disconnect electrical power before doing any installation or maintenance.

All work requiring removal of the plasma power supply outer cover or panels must be done by a qualified technician.

See the *Safety and Compliance Manual (80669C)* for more safety precautions.

## Purpose

This Field Service Bulletin describes how to upgrade the XPR power-indicator LED:

1. *Remove the power and panels from the plasma power supply*
2. *Replace the power distribution PCB and wire harness*
3. *Replace the power-indicator LED*

## Tools and materials needed

- 10 mm, hexagonal socket wrench or nut driver
- #1 Phillips® screwdriver

## Kit 428893 contents

Part number	Description	Quantity
141425	Power-distribution PCB	1
429002	Power-indicator LED	1
429015	Wire harness	1
210469	Label	1

## Remove the power and panels from the plasma power supply

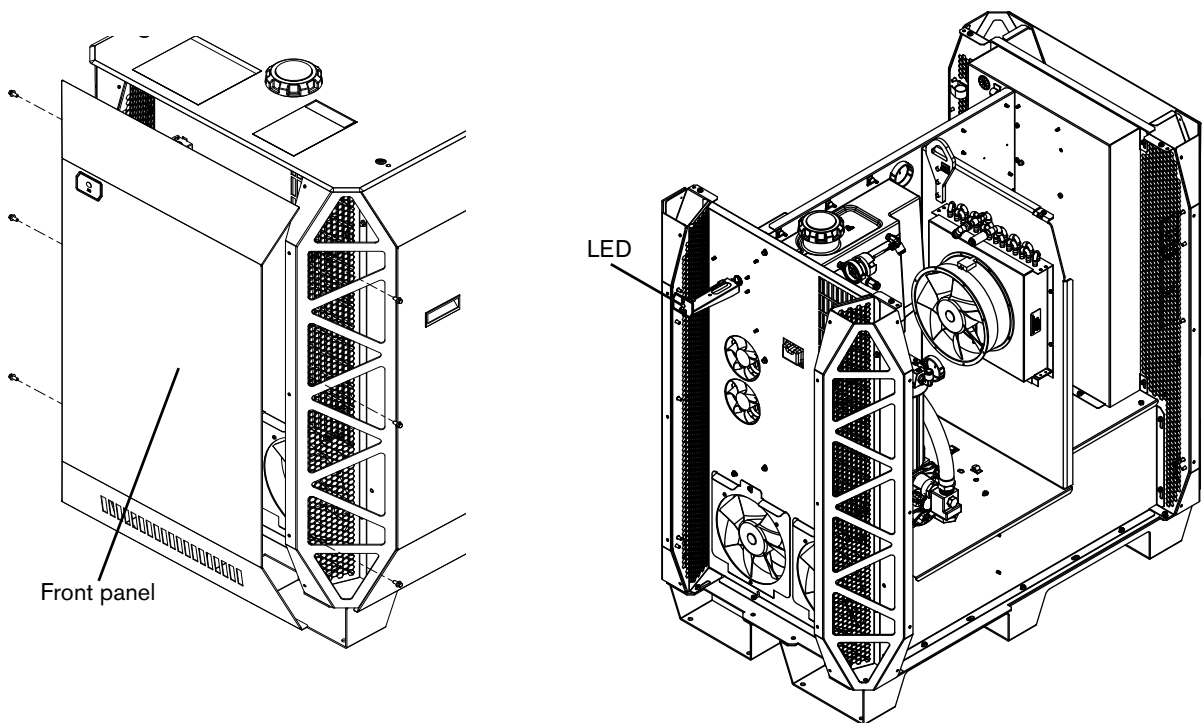
4. Complete the following procedures:

- a. Remove the power from the cutting system.
- b. Remove the front panel of the plasma power supply to get access to the LED (*Figure 1*).
- c. Remove the left (control-side) panel to get access to the power distribution PCB (*Figure 2*).

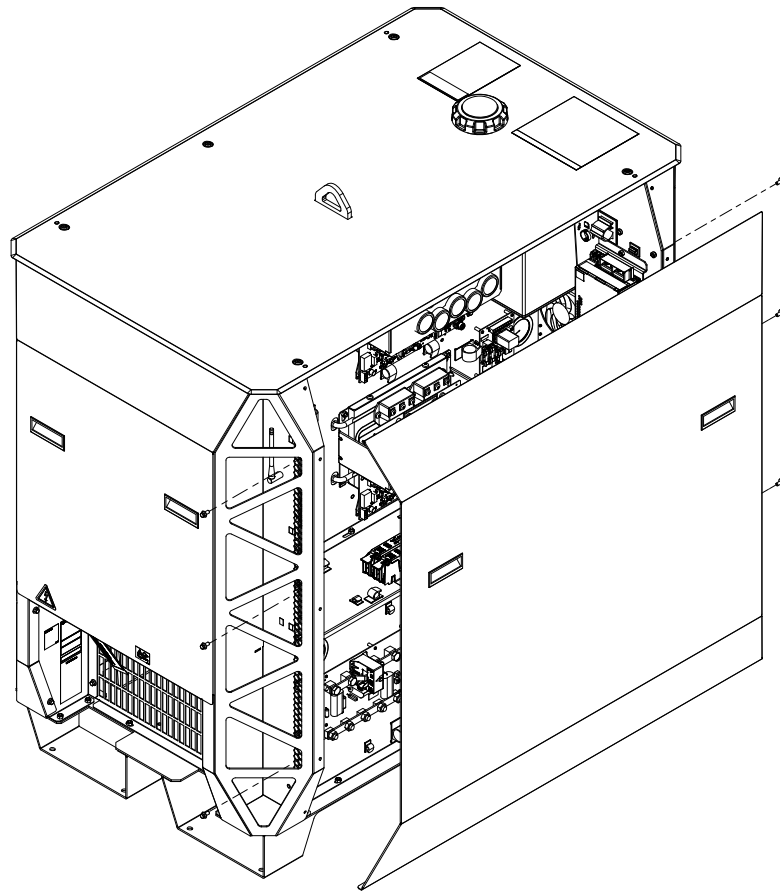


Keep all nuts and screws that you remove.

**Figure 1** – Front panel removal



**Figure 2** – Left (control-side) panel removal

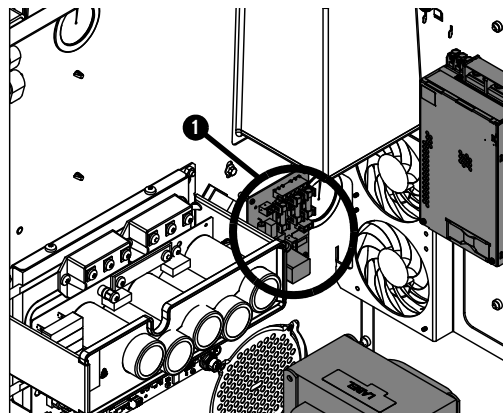


For information about how to remove plasma power supply panels, refer to the *XPR170 Replacement Part Procedures Field Service Bulletin (810410)* or *XPR300 Replacement Part Procedures Field Service Bulletin (809970)*.

## Replace the power distribution PCB and wire harness

1. Disconnect all wire connectors from the old power distribution PCB ❶ (Figure 3):

**Figure 3** – Power distribution PCB

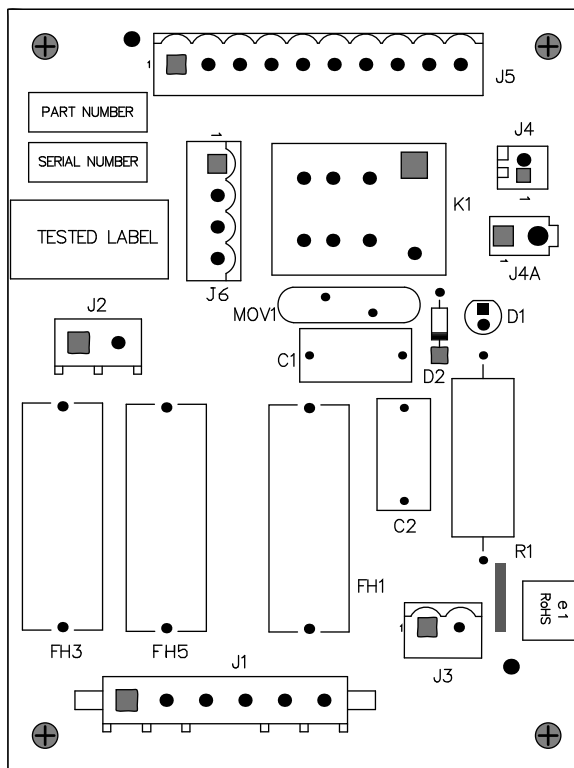


2. Use a #1 Phillips screwdriver to remove the 4 screws from the old PCB.
3. Remove the old PCB.
4. Install the new PCB. Position it with the J5 connector on top.
5. Use the 4 screws to install the new PCB.
6. Reconnect the following wire connectors on the new PCB:
  - J1
  - J2
  - J7.4
  - J7.5



Do **not** reconnect the J7.3 wire connector. Move it and any unused wire connectors away from the PCB and fan blades. Do not cut or remove the wire. You can use a nearby wire harness to hold it.

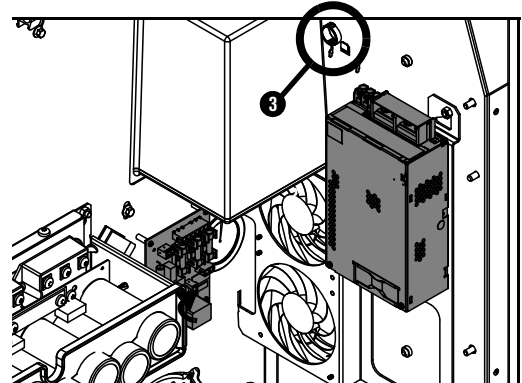
**Figure 4 – Power distribution PCB**



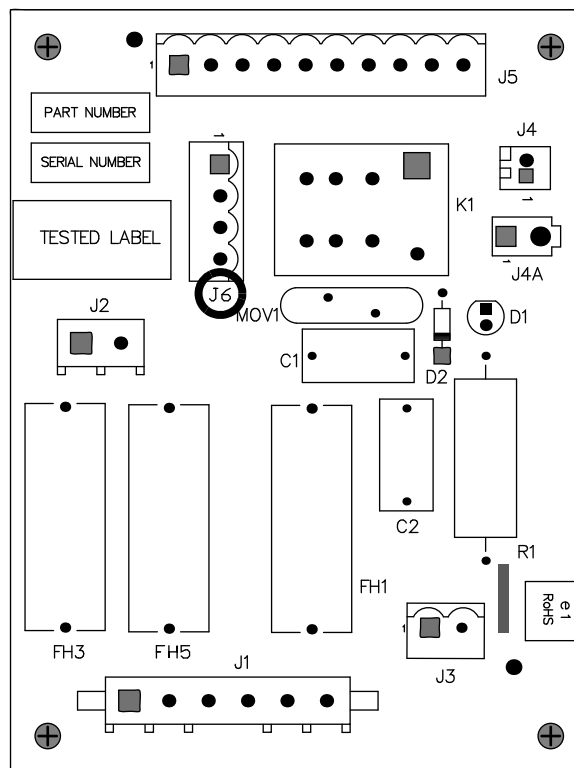
## Replace the power-indicator LED

1. Make sure that the 2-wire connector that connects the LED to the power distribution PCB is disconnected.
2. Remove the old LED.
3. Install the new LED.
4. Put the J4 wire connector from the new PCB through the hole ③ in the sheet metal (Figure 5). Pull it through the hole from the left (console-side) interior to the front-interior side of the plasma power supply.
5. Make sure the connector wire will not interfere with fan operation. You can use a nearby wire harness to hold the wire.
6. Connect J4 to the new LED wire connector (Figure 6).
7. Connect the wire connector for the LED (J7.6) to the PCB connector (J6) on the new PCB (Figure 6).

**Figure 5** – Install the J4 wire connector



**Figure 6** – Power distribution PCB



8. Install the left (control-side) panel on the plasma power supply.

**Power-Indicator LED Upgrade Procedures**

9. Install the front panel.
10. Remove the old label for the green-only LED from the front panel. Replace it with the label for the new LED (*Figure 7*).

**Figure 7** – Replace the label

