



## XPR® 170/300 I/O Board Upgrade Procedure

ONLY USE IF THE LAST 6 DIGITS OF THE XPR SERIAL NUMBER ARE LESS THAN:

XPR170: 002917

XPR300: 008654

IF THE XPR IS AN XPR460, OR THE SERIAL NUMBER IS GREATER THAN ABOVE, USE KIT 10085206

Field Service Bulletin

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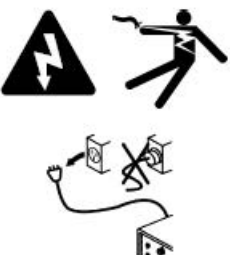
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## Introduction

**⚠ 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 install an adapter plate to allow compatibility of an upgraded I/O PCB. This is a one-time upgrade. Use kit 10085206 for future I/O PCB replacements after performing this upgrade.

### Tools and Materials Needed

- 10 mm, hexagonal socket wrench or nut driver
- #2 Phillips screwdriver
- 17 mm, hexagonal socket wrench
- Needle-nose pliers

### 10087255 Kit Contents

| Part Number  | Description                                               | Quantity |
|--------------|-----------------------------------------------------------|----------|
| 10085206     | I/O PCB Replacement Kit                                   | 1        |
| Not for Sale | I/O Pilot Arc Relay Adapter Plate                         | 1        |
| Not for Sale | M6 Kepnut pre-installed on Adapter Plate                  | 1        |
| 074354       | 1/2" Diameter Cable Holder pre-installed on Adapter Plate | 1        |
| 074356       | 1" Diameter Cable Holder pre-installed on Adapter Plate   | 1        |
| 10088369     | XPR 170/300 I/O Board Upgrade Procedure FSB               | 1        |

### Referenced Documents

The following documents are referenced in the instructions and are available on the Hypertherm Document Library:

- XPR300 Replacement Part Procedures (809970)
- XPR170 Replacement Part Procedures (810570)

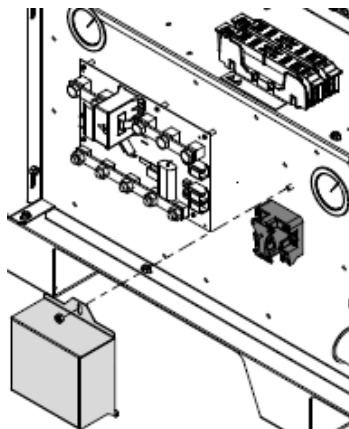
## Instructions

1. Determine if you need to install the included adapter plate.
  - a. If your system is an XPR170 and the last 6 digits of your serial number are greater than 002917, you **do not** need to install the adapter plate. Skip to step 13.
  - b. If your system is an XPR300 and the last 6 digits of your serial number are greater than 008654, you **do not** need to install the adapter plate. Skip to step 13.
  - c. If your system already has an adapter plate installed (reference images in step 9), you **do not** need to install the adapter plate. Skip to step 13.
  - d. Otherwise, proceed to step 2.
2. Complete the following procedures:
  - a. Remove the power from the cutting system
  - b. Refer to Remove the left-side (control-side) panel in the Replacement Parts Procedure FSB for your system.

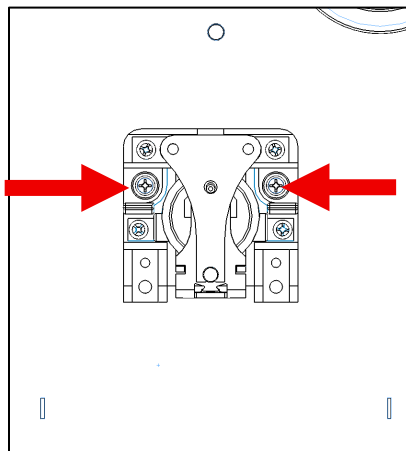


Keep all nuts and screws that you remove

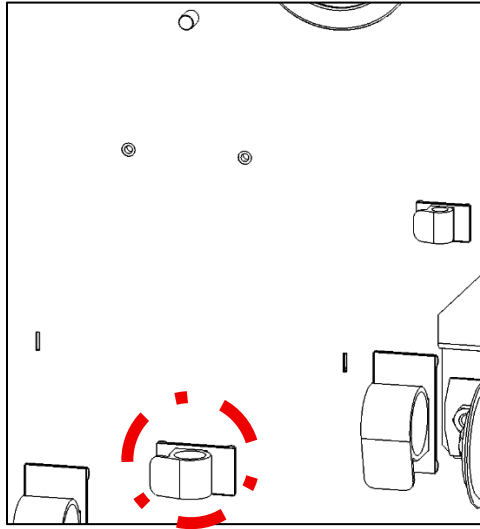
3. Remove the pilot arc relay cover.



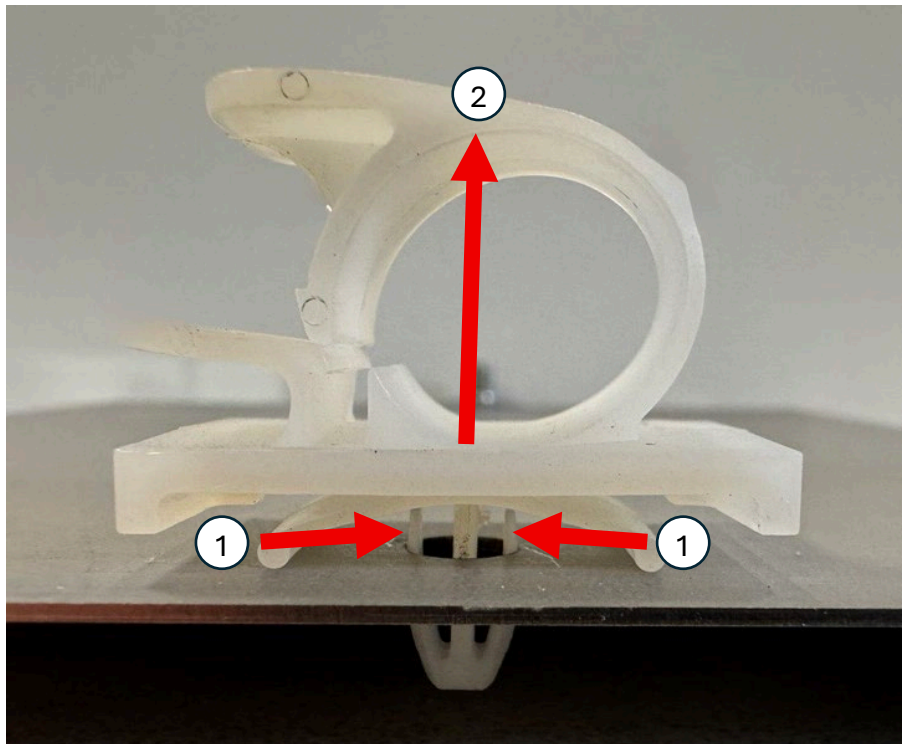
4. Remove the two screws that mount the pilot arc relay.



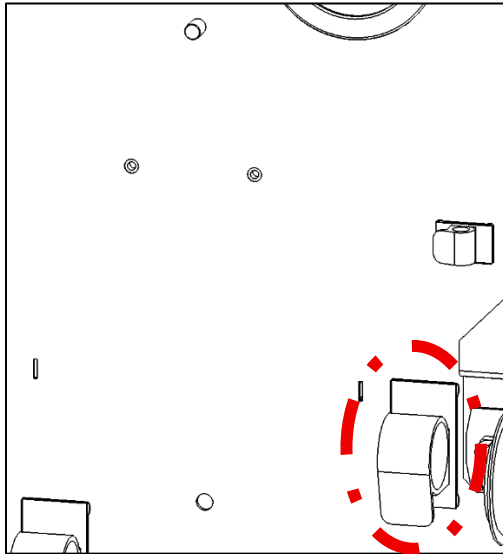
5. Remove the wires from the cable holder directly below the pilot arc relay.



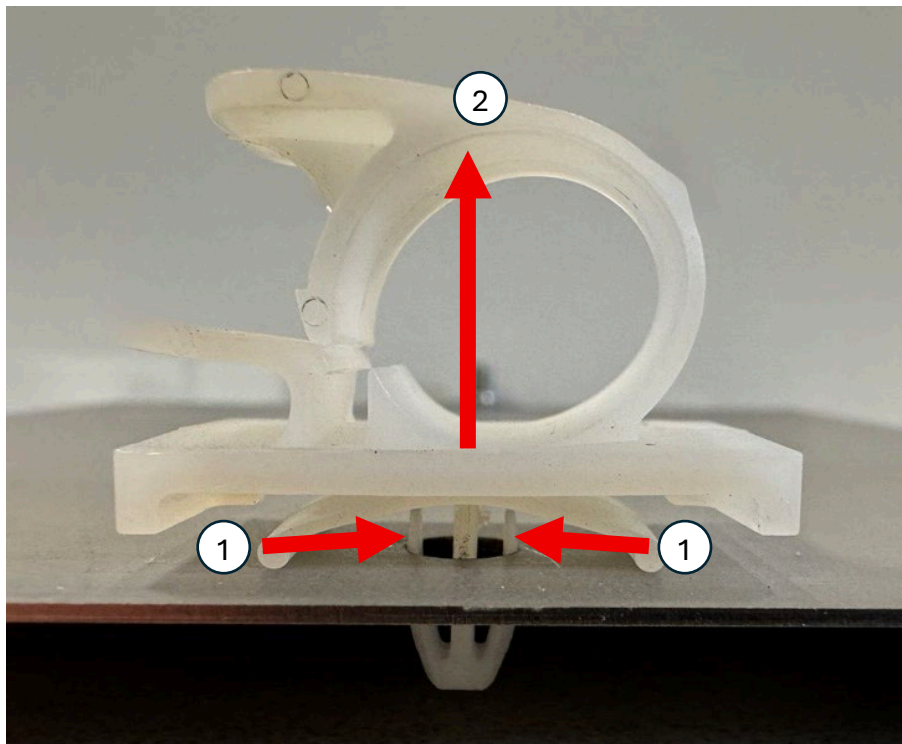
6. Remove and discard the cable holder by pinching the two locking tabs (1) on the part and lifting straight out (2).



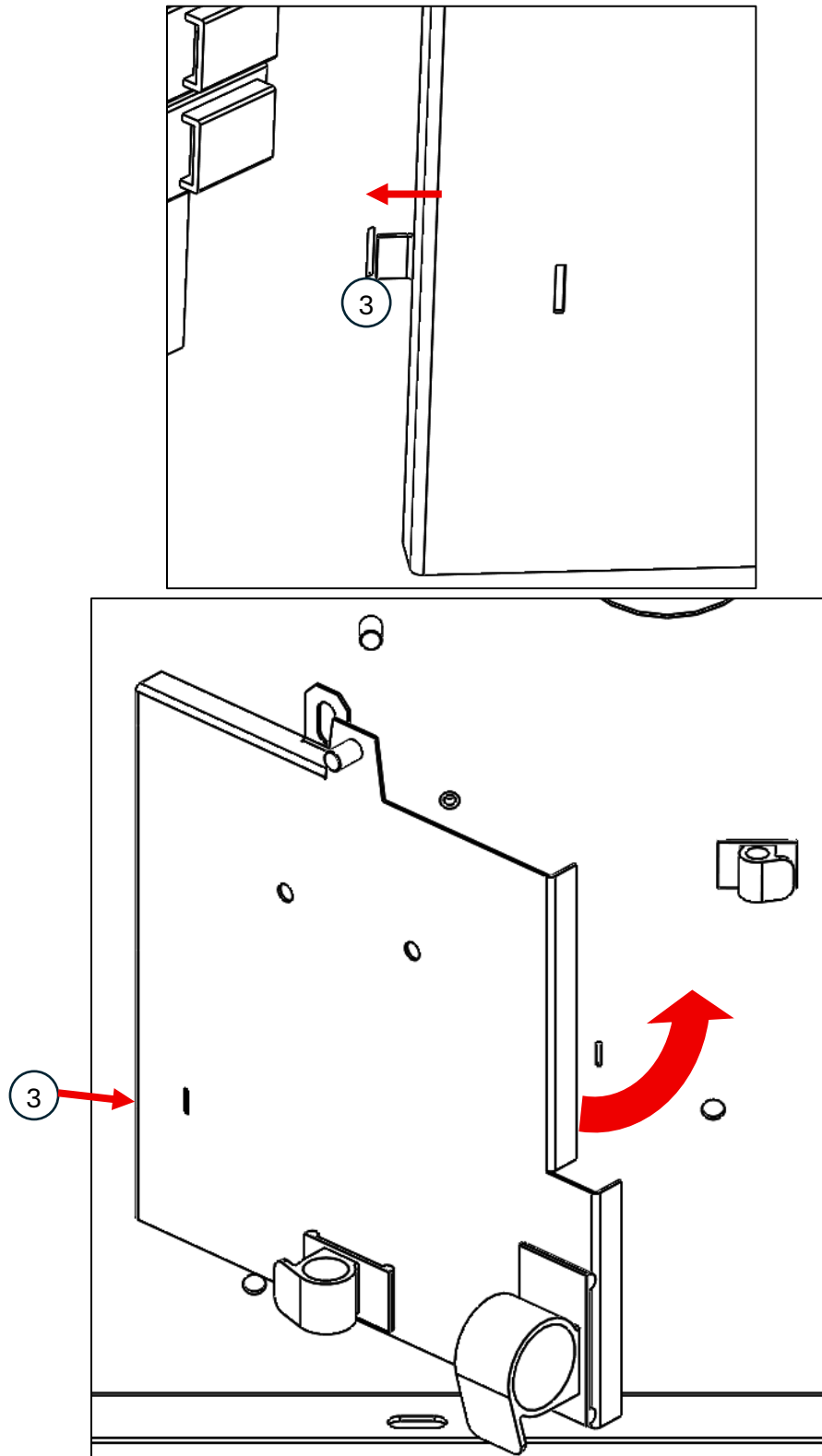
7. Remove the ferrite ring and/or cable from the cable holder just below the pilot arc relay.



8. Remove and discard the cable holder by pinching the two locking tabs (1) on the part and lifting straight out (2).



9. Take the adapter plate from the kit and insert the left tab in the small slot (3). Rotate the adapter plate flat and use the hardware that was removed from the cover to install the plate.



10. Use the 2 mounting screws to install the pilot arc relay onto the adapter plate.
11. Insert the cables into the cable holders.
12. Install the pilot arc relay cover and fasten the mounting nut.
13. Refer to Replace the I/O PCB in the replacement parts procedure FSB for your system.