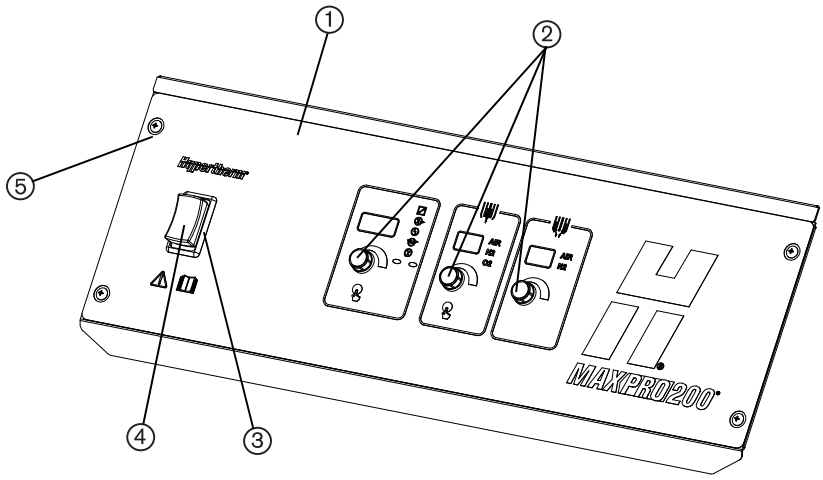
Chapter 5: Parts List

Control panel parts

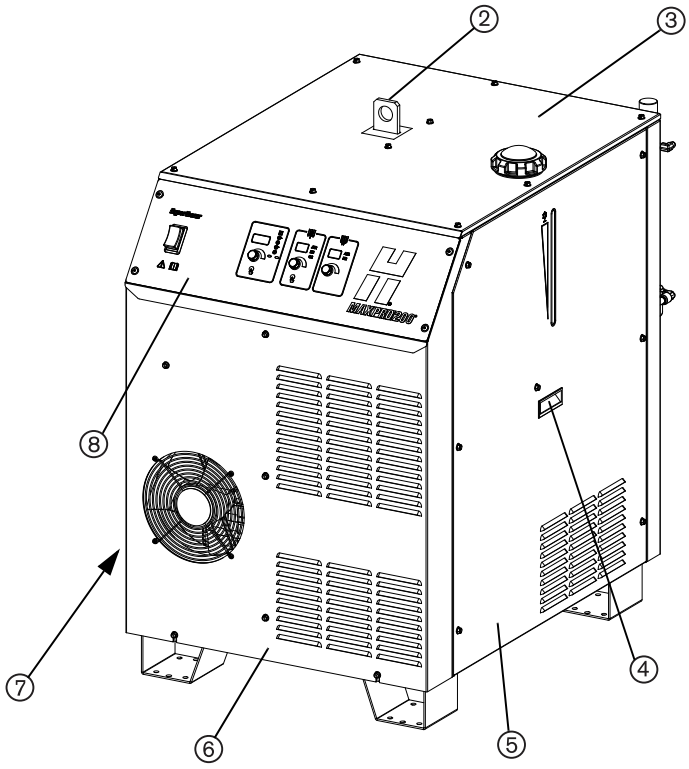


Item	Part Number	Description	Quantity
1	428032	Control panel replacement kit	1
2	108797	Knob: soft black, no pointer	3
3	007050	Rocker switch bezel	1
4	005678	Rocker switch	1
5	075237	Screw (control panel and enclosure panels): 10-32, TORX® T-25	18

Plasma power supply parts 1

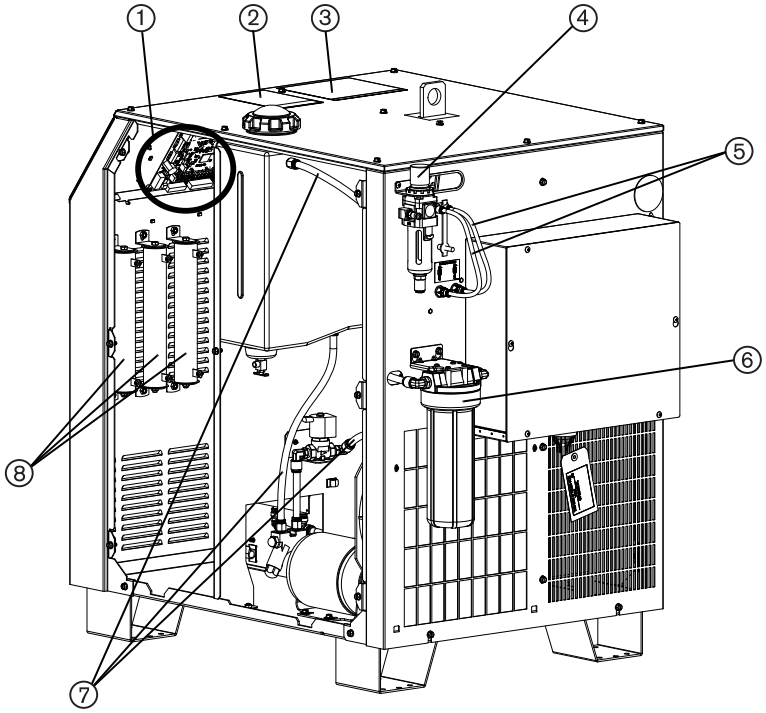
Part number	Voltage (AC)
078610	200/208 volt
078611	220 volt
078612	240 volt
078613	380 volt
078614	400 volt
078615	415 volt
078616	440 volt
078609	480 volt
078617	600 volt

Plasma power supply parts 2



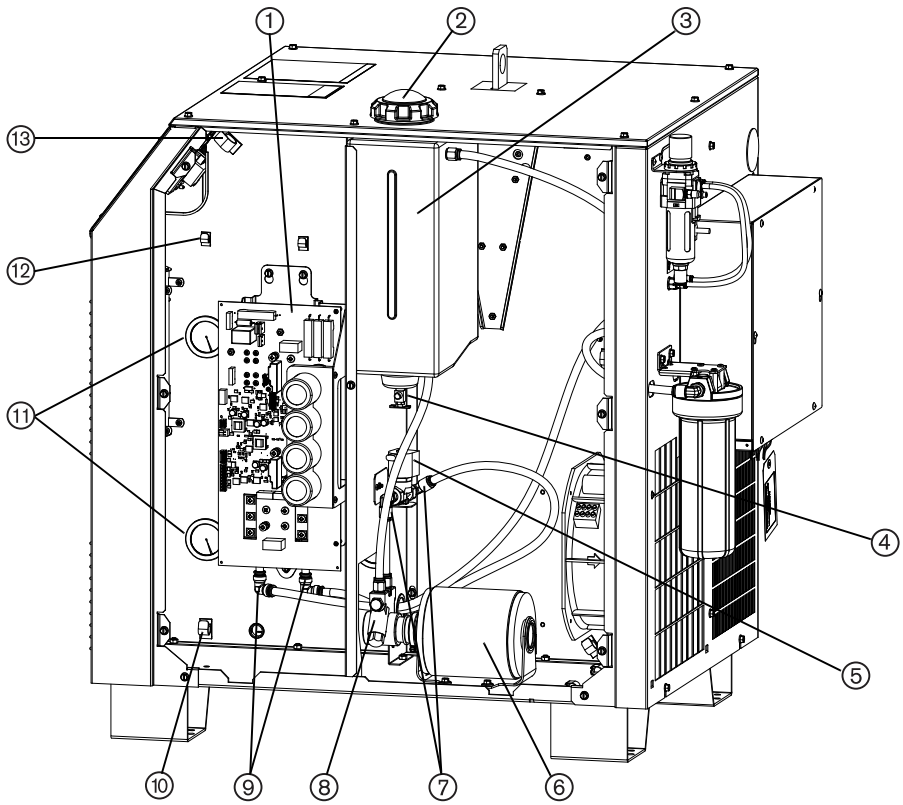
Item	Part Number	Description	Quantity
1	See Plasma power supply parts 1 on page 233.	Plasma power supply	1
2	428033	Lift eye replacement kit	1
3	428031	Top panel replacement kit	1
4	027967	Handle: side panels	2
5	428029	Right side panel replacement kit	1
6	101188	Front panel	1
7	428030	Left side (not shown) panel replacement kit	1
8	428032	Control panel replacement kit	1
Not shown	10087757	Rear-panel replacement kit	1
Not shown	428035	Optional caster (wheel) kit	1

Plasma power supply parts 3



Item	Part Number	Description	Quantity
1	141171	Control Board	1
2	110261	Label: Warning instant start	1
3	010298	Label: Warnings	1
4	011114	Air filter/regulator: 7-125 psi, 1/4 inch, auto drain with valve	1
	011093	Air filter element	1
5	228862	Gas hoses kit (not all hoses shown)	1
6	428038	Coolant filter replacement kit	1
	027005	Coolant filter element	1
7	228861	Coolant hose kit (not all hoses shown)	1
8	109377	Resistor: 1 ohm, 500 watts	3

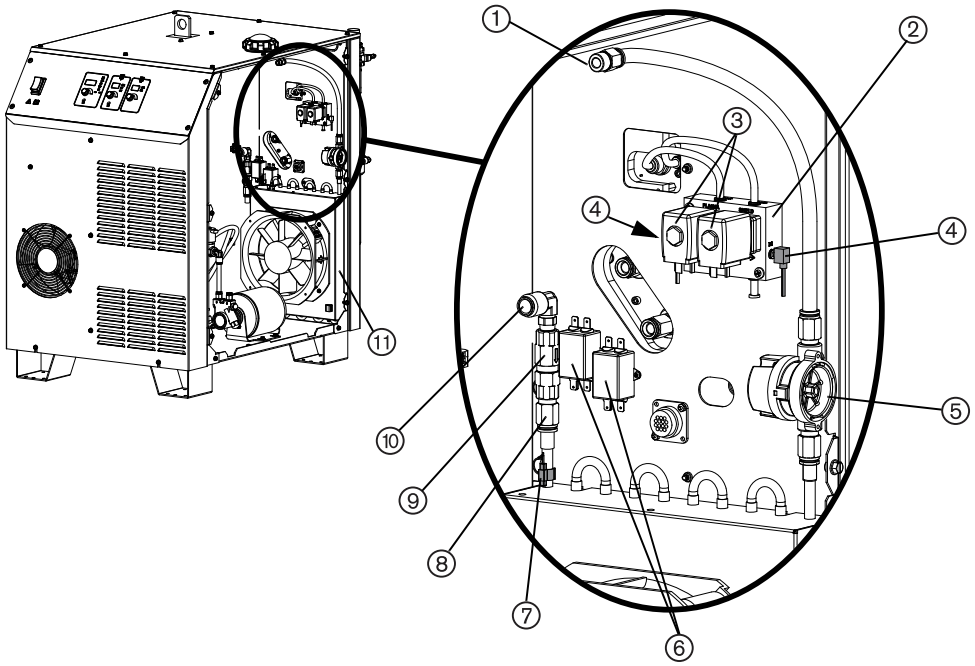
Plasma power supply parts 4



Item	Part Number	Description	Quantity
1	428036	Chopper replacement kit	1
2	127014	Coolant reservoir cap	1
3	002546	Coolant reservoir	1
4	006099	Coolant drain valve	1
5	228993	Coolant solenoid valve replacement kit	1
6	428039	Pump motor replacement kit	1
7	015665	Fitting: male elbow, 3/8 inch NPT x 1/2 inch push-in tube	2
8	428043	Pump replacement kit	1
9	015815	Fitting: elbow, 1/2 inch x 1/2 inch push-in tube, brass	2
10	074354	Cable holder: for 1/2 inch diameter cable	17

Item	Part Number	Description	Quantity
11	104407	Bushing: dust seal	6
12	074353	Cable holder: for 1/4 inch diameter cable	10
13	074355	Cable holder: for 3/4 inch diameter cable	10

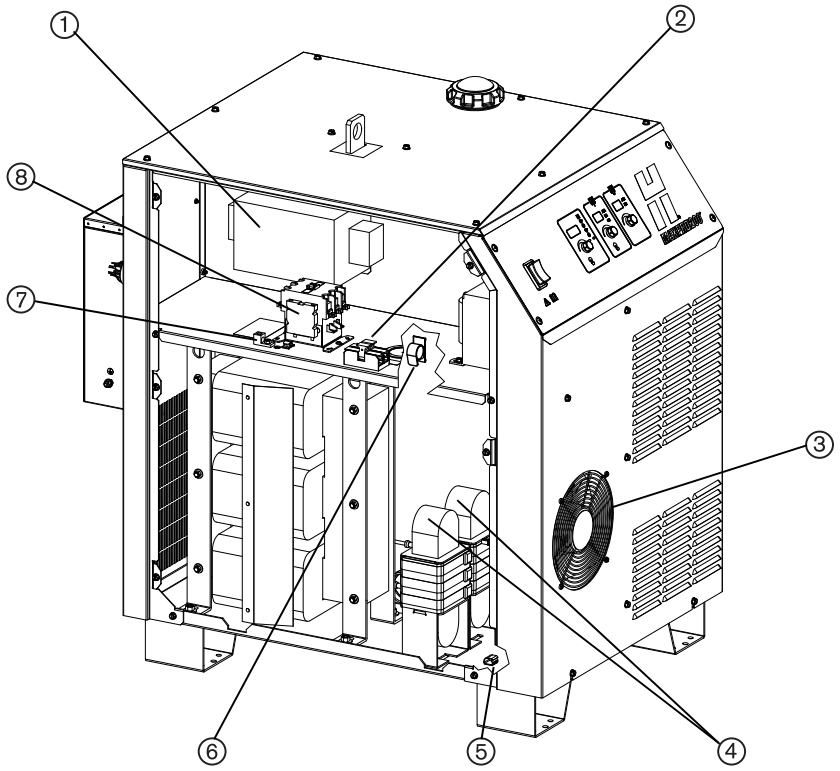
Plasma power supply parts 5



Item	Part Number	Description	Quantity
1	015669	Male connector 3/8 inch NPT x 1/2 inch	7
2	428034	Gas manifold replacement kit	1
3	006128	Solenoid valve	2
4	428042	Pressure transducer replacement kit	2
5	428037	Flow meter replacement kit	1
6	109636	EMI filter: 250 VAC, 1 amp, 1 phase	2
7	229474	Thermistor: 3/8 inch diameter, copper pipe clip with connector	1

Item	Part Number	Description	Quantity
8	015663	Male connector 1/4 inch NPT x 1/2 inch tube	1
9	006075	Check valve	1
10	015664	Male elbow 1/4 inch NPT x 1/2 inch push-in tube	1
11	229482	Heat exchanger (with fan)	1
	127091	Heat exchanger fan only	1

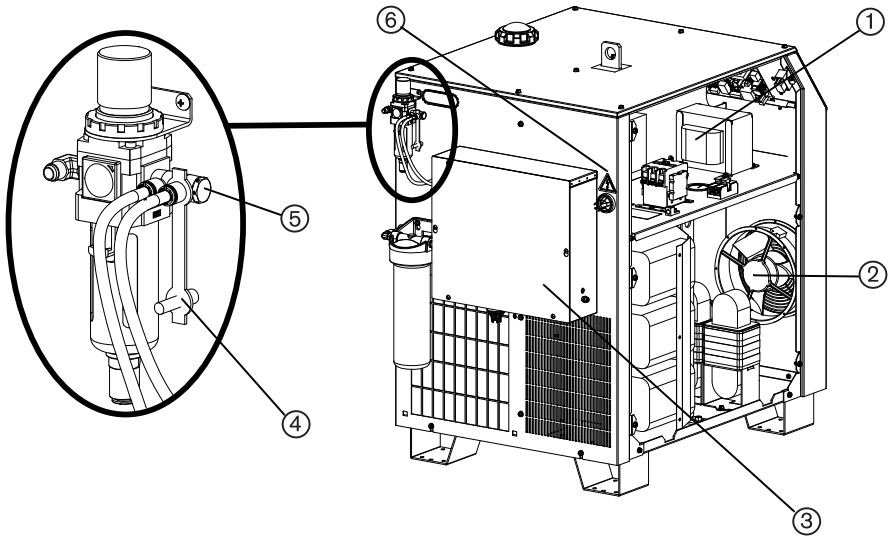
Plasma power supply parts 6



Item	Part Number	Description	Quantity
1	209177	EMI filter, 400V and 415V power supplies	
2	008301	Fuse holder	1
	108571	Fuse holder cover	1

Item	Part Number	Description	Quantity
	110513	Fuse label: F1-F2	1
	008551	Fuse: 7.5 amp, 600 volt: 380V, 400V, 415V, 440V, 480V, and 600V power supplies	2
	008709	Fuse: 20 amp, 500 volt: 200/208V, 220V, and 240V power supplies	2
3	027567	Fan guard	1
4	014373	Inductor	2
5	074212	Cable holder: self sticking, for 1/2 inch diameter cable	5
6	074356	Cable holder: for 1.0 inch diameter cable	5
7	108671	Terminal block: 14 AWG - 2/0	1
8	003249	Contactor: 380V, 400V, 415V, 440V, 480V, and 600V power supplies	1
	003233	Contactor: 200/208V, 220V, and 240V power supplies	1
	228309	Transformer thermistor (not shown)	1

Plasma power supply parts 7

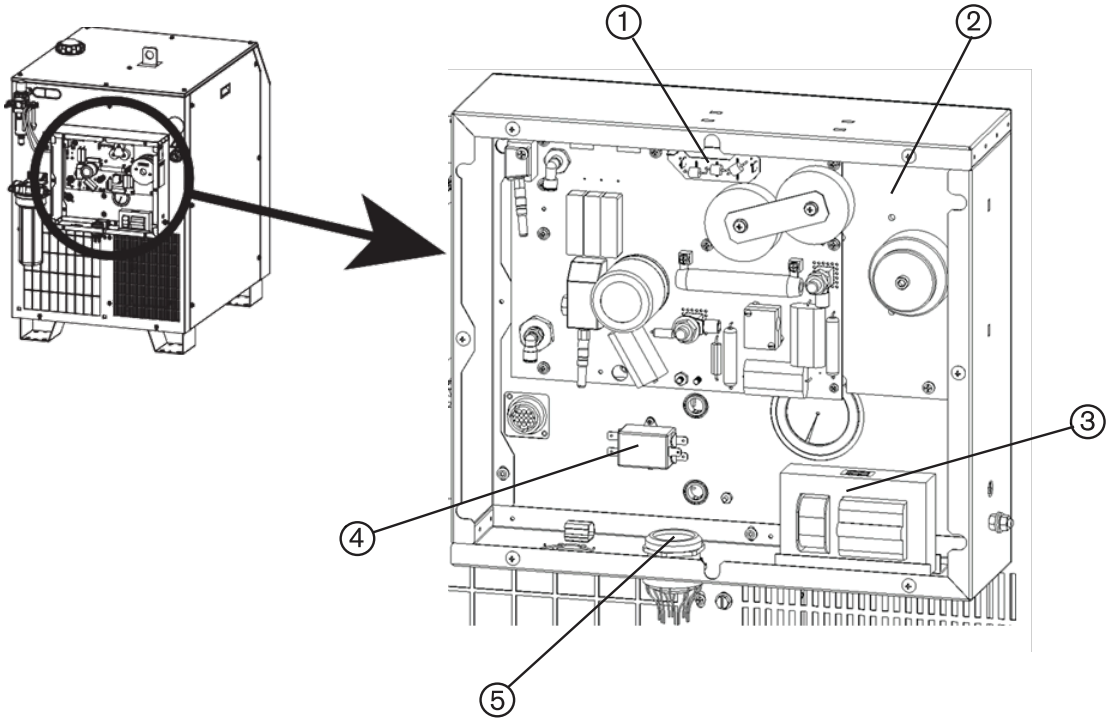


Item	Part Number	Description	Quantity
1	See Table 37 on page 240	Control transformer	1
2	027079	Fan: 450-550 cfm, 120 VAC 50-60 Hz	1
3	101205	Ignition enclosure panel (ignition)	1
4	428044	Inlet gas-plug replacement kit	1
5	015812	Adaptor:1/4 inch NPT O-ring x 5/16 inch	1
6	010875	Label: Danger voltage	1
Not shown	008482	Power cord strain relief (380 V, 400 V, 415 V, 440 V, 480 V, and 600 V plasma power supplies)	1
Not shown	008052	Power cord strain relief (200 V/208 V, 220 V, and 240 V plasma power supplies)	1
Not shown	428054	MAXPRO200 Oxygen fitting kit	1
Not shown	015015	Adapter: 1/4 inch NPT, #6, Male, 90 degree	1
Not shown	015817	Adapter: 3/8 inch FNPT x 1/2 inch push-in tube	1

Table 37 - Control transformers

Part number	Description	Part number	Description
229535	200 volt, 50-60 Hz	229538	415 volt, 50-60 Hz
229536	220 volt, 50-60 Hz	229539	440 volt, 50-60 Hz
229537	240 volt, 60 Hz	229488	480 volt, 60 Hz
229514	380 volt, 50 Hz	229540	600 volt, 50-60 Hz
229515	400 volt, 50 Hz		

Ignition enclosure parts



Item	Part Number	Description	Quantity
1	141595*	Replacement spark gap PCB	1
2	428041	I/O panel replacement kit (includes PCB)	1
3	229487	Ignition transformer	1
4	109636	EMI filter	1
5	008482	Work lead strain relief (380V, 400V, 415V, 440V, 480V, and 600V plasma power supplies)	1
	008052	Work lead strain relief (200 V/208V, 220V, and, 240V plasma power supplies)	1

Not all systems use the same spark-gap replacement kit. If the ignition PCB in your plasma power supply looks like the image that is shown and has a removable PCB, use the 141595 kit to replace the spark gaps. If the ignition PCB looks different, use the 428041 kit to replace the spark gaps.

Height control connection kits

Sensor THC connection kit - 428023



This kit should only be ordered when purchasing a Sensor THC torch height control and a Hypertherm CNC that is shipped with a voltage divider card (packaged separately from the CNC). If you only need the voltage divider card order part number 141201.

The kit contains two wire groups (229554 and 229602). A CNC interface cable is not supplied. The desired length should be ordered separately.

Sensor PHC connection kit - 428022

The kit contains a PHC plasma interface assembly (228256) with a 1.3 m (5 feet) interface cable attached. A CNC interface cable is not supplied. The desired length should be ordered separately.

Remote-start pendant

Part Number	Description
428061	Remote-start pendant for MAXPRO200, 7.5 m (25 feet)
428062	Remote-start pendant for MAXPRO200, 15 m (50 feet)

Wire groups and harnesses

Part Number	Description
229437	Main wire harness: all power supplies
229438	Primary power wire group for 380V, 400V, 415V, 440V, 480V, and 600V power supplies
229439	EMI filter wire group for 400V and 415V power supplies
229558	Contactor wire adaptors
229561	Primary power wire group for 200/208V, 220V, and 240V power supplies

USB cables for software updates

Cable for USB update - 223291

This cable allows the system software to be upgraded using a USB memory stick.



Cable for USB update - 223273

This cable allows the system software to be upgraded using a laptop.



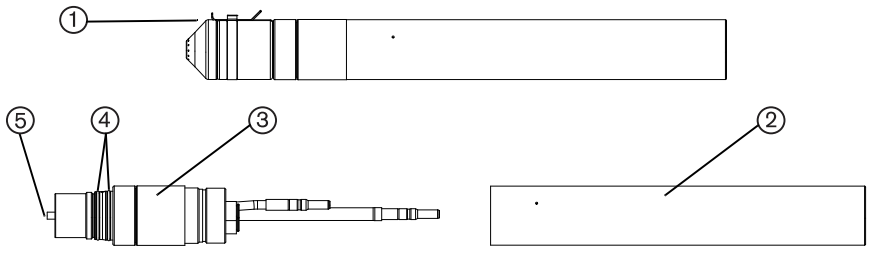
Plasma power supply gas hose kit - 228862

The kit contains:

Part Number	Description	Length
046077	Tubing: 1/4 inch OD, blue	1 foot
046078	Tubing: 1/4 inch OD, black	1 foot
046231	Tubing: 5/16 inch OD, black	2 feet

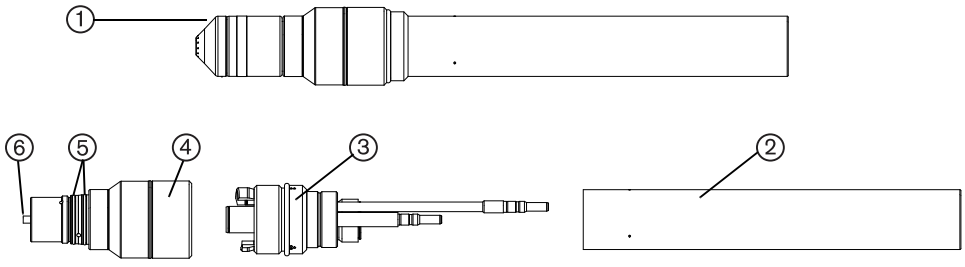
Machine torches

Straight torch



Item	Part Number	Description	Quantity
1	428024	Machine torch assembly with 2.0 inch mounting sleeve	1
	228937	Machine torch assembly with 1-3/4 inch mounting sleeve	1
2	220943	Torch Mounting sleeve: 2 inch	1
	220942	Torch Mounting sleeve: 1-3/4 inch	1
3	420087	Straight torch main body	1
4	044026	O-ring: 1.239 inch x 0.070 inch	2
5	220521	Water tube	1

Quick-disconnect torch



Item	Part Number	Description	Quantity
1	428027	Quick-disconnect torch assembly with 2.0 inch mounting sleeve	1
	428028	Quick-disconnect torch assembly with 1-3/4 inch mounting sleeve	1
2	220943	Torch Mounting sleeve: 2 inch	1
	220942	Torch Mounting sleeve: 1-3/4 inch	1
3	420033	Quick-disconnect torch receptacle	1
4	220921	Quick-disconnect torch main body	1
5	044026	O-ring: 1.239 inch x 0.070 inch	2
6	220521	Water tube	1

Leads and cables

Machine torch leads

Part number	Length
229477	7.5 m (25 feet)
229478	15 m (50 feet)
229479	23 m (75 feet)
229480	30 m (100 feet)

CNC cables

Part Number	Length
223327	1.3 m (5 feet)
223328	3.0 m (10 feet)
223329	7.5 m (25 feet)
223330	15 m (50 feet)
223331	23 m (75 feet)
223332	30 m (100 feet)

Work leads

Part number	Length
223335	7.5 m (25 feet)
223336	15 m (50 feet)
223337	23 m (75 feet)
223338	30 m (100 feet)

Work clamp

Part Number	Description
008539	Ground clamp

Hand torch leads

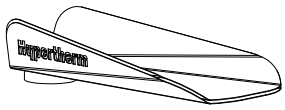
Part number	Length
229498	7.5 m (25 feet)
229499	15 m (50 feet)
229500	23 m (75 feet)
229501	30 m (100 feet)

Inline valve kit

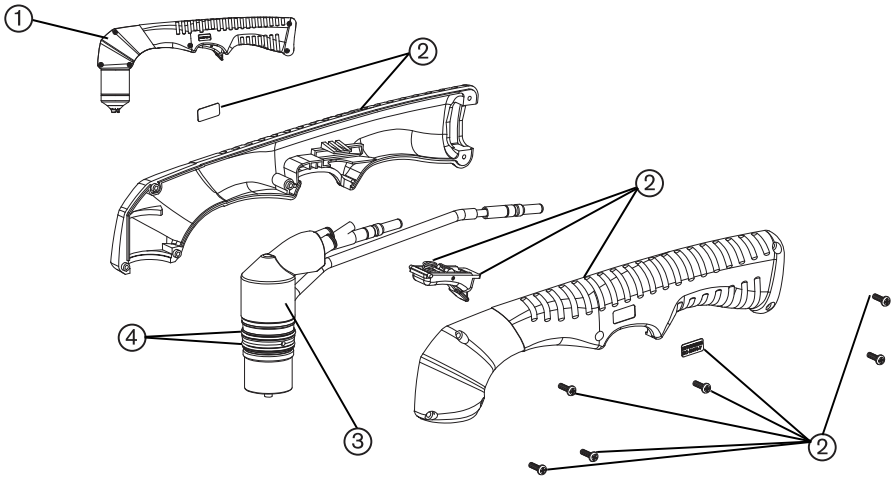
Part Number	Description
428055	Replacement for the valve located in the torch lead

Hand torch heat shield - 127389

Hand torch heat shield – 127389

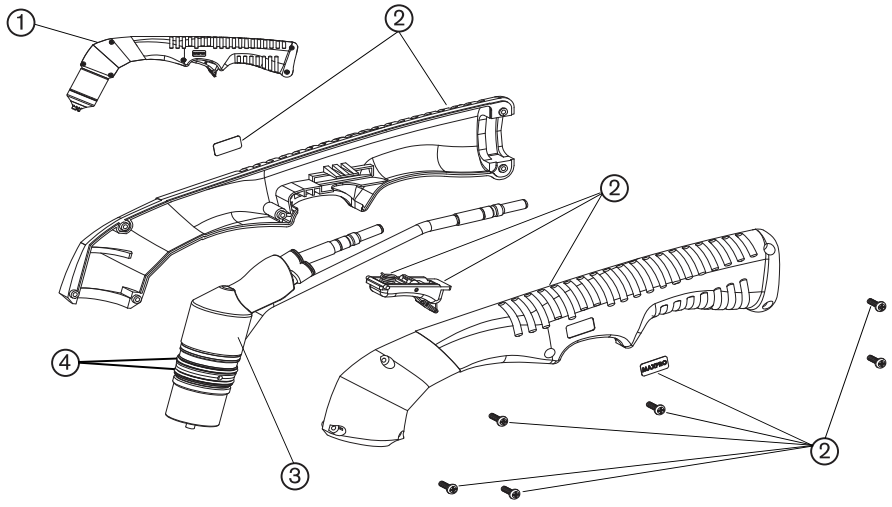


90-degree hand torch



Item	Part Number	Description	Quantity
1	420108	90 degree hand torch assembly	1
	228980	90 degree hand torch assembly with 7.5 m (25 feet) lead	1
	228981	90 degree hand torch assembly with 15 m (50 feet) lead	1
	228982	90 degree hand torch assembly with 23 m (75 feet) lead	1
	228983	90 degree hand torch assembly with 30 m (100 feet) lead	1
2	228985	Handle replacement kit	1
	001905	90 degree torch handle (left and right sides)	1
	002244	Safety trigger	1
	027254	Safety trigger spring	1
	075841	Pan head screws	6
	210185	Hand torch label	1
	210209	Hypertherm IEC label	1
3	420070	Torch main body	1
4	044026	O-ring: 1.239 inch x 0.070 inch	2

65-degree hand torch



Item	Part Number	Description	Quantity
1	420107	65 degree hand torch assembly	1
	228976	65 degree hand torch assembly with 7.5 m (25 feet) lead	1
	228977	65 degree hand torch assembly with 15 m (50 feet) lead	1
	228978	65 degree hand torch assembly with 23 m (75 feet) lead	1
	228979	65 degree hand torch assembly with 30 m (100 feet) lead	1
2	228986	Handle replacement kit	1
	001906	65 degree torch handle (left and right sides)	1
	002244	Safety trigger	1
	027254	Safety trigger spring	1
	075841	Pan head screws	6
	210184	Hand torch label	1
	210209	Hypertherm IEC label	1
3	420109	Torch main body	1
4	044026	O-ring: 1.239 inch x 0.070 inch	2

Consumable parts kits

Mechanized torch consumable kit - 428013

Part number	Description	Quantity
020415	Electrode: 200A and 130A, N_2	2
027055	Silicone lubricant: 1/4 ounce tube	1
044026	O-ring: 1.239 x 0.070	2
104119	Consumable tool	1
220487	Electrode: 130 A, O_2/Air	4
220488	Swirl ring: 130 A, O_2/Air and 200 A, Air	2
220491	Shield:130 A, O_2	1
220521	Water tube	1
220528	Electrode 50 A, O_2/Air	4
220529	Swirl ring: 50 A, O_2/Air and 130A or 200A, N_2	1
220532	Shield: 50A, O_2/Air	1
220536	Shield:130A, Air/N_2	1
220831	Nozzle: 200A, O_2	2
220832	Shield: 200A, O_2	1
220834	Swirl ring: 200A, O_2	1
220890	Nozzle: 50A, Air	2
220891	Nozzle: 50A, O_2	2
220892	Nozzle: 130A, Air/N_2	2
220893	Nozzle: 130A, O_2	2
220935	Shield cap: O_2/Air/N_2, clockwise	1
220936	Shield cap: O_2/Air/N_2, clockwise, with IHS tab	1
220937	Electrode: 200, O_2/Air	6
420044	Nozzle: 200A, Air/N_2	6

Part number	Description	Quantity
420045	Shield: 200A, Air/N_2	2
428054	MAXPRO200 Oxygen fitting kit	1
881430	MAXPRO200 machine torch brochure	1

Extreme bevel consumable kit - 528058

Part number	Description	Quantity
420823	Water tube: MAXPRO200 Extreme bevel	1
420732	Electrode: 200A Air/O_2 Extreme bevel	6
420824	Electrode: 130A Air/O_2 Extreme bevel	2
220488	Swirl ring: 200A	1
220529	Swirl ring: 130A	1
420734	Nozzle: 200A, Air Extreme bevel	3
420733	Nozzle: 200A, O_2, Extreme bevel	3
420829	Nozzle: 130A, Air Extreme bevel	1
420828	Nozzle: 130A, O_2 Extreme bevel	1
420737	Shield: 200A, Air/O_2 Extreme bevel	3
420735	Shield: 130A, Air/O_2 Extreme bevel	1
220935	Shield cap: O_2/Air/N_2, clockwise	1
220936	Shield cap: O_2/Air/N_2, clockwise, with IHS tab	1
027055	Silicone lubricant: 1/4 ounce tube	1
104119	Consumable tool	1
428054	MAXPRO200 Oxygen fitting kit	1
811270	MAXPRO200 Extreme bevel cut charts	1

Hand torch consumable kit - 428014

Part number	Description	Quantity
027055	Silicone lubricant: 1/4 ounce tube	1
044026	O-ring: 1.239 x 0.070	2
104119	Consumable tool	1
220488	Swirl ring: 130A, O_2/Air and 200 A, Air	2
220521	Water tube	1
220831	Nozzle: 200A, O_2	2
220834	Swirl ring: 200A, O_2	1
220935	Shield cap: O_2/Air/N_2, clockwise	2
220937	Electrode: 200A, O_2/Air	8
420044	Nozzle: 200A, Air/N_2	4
420058	Shield: 200A, Air/N_2	2
420059	Shield: 200A, O_2	1
420066	Nozzle: 200A, Air, Gouging	2
420067	Shield: 200A, Air, Gouging	2
428054	MAXPRO200 Oxygen fitting kit	1
881440	MAXPRO200 hand torch brochure	1

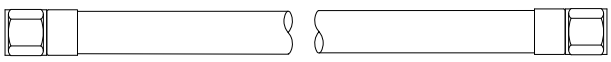
Supply gas hoses

NOTICE

PTFE TAPE CAN CAUSE CLOGGED VALVES, REGULATORS, AND TORCHES

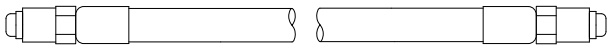
Never use PTFE tape on any joint preparation. Use only a liquid or paste thread sealant on male thread ends.

Oxygen



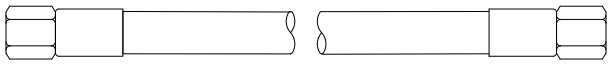
Part number	Length	Part number	Length
024607	3 m (10 ft)	024738	25 m (82 ft)
024204	4.5 m (15 ft)	024450	35 m (115 ft)
024205	7.5 m (25 ft)	024159	45 m (150 ft)
024760	10 m (35 ft)	024333	60 m (200 ft)
024155	15 m (50 ft)	024762	75 m (250 ft)
024761	20 m (65 ft)		

Nitrogen



Part number	Length	Part number	Length
024210	3 m (10 ft)	024739	25 m (82 ft)
024203	4.5 m (15 ft)	024451	35 m (115 ft)
024134	7.5 m (25 ft)	024120	45 m (150 ft)
024211	10 m (35 ft)	024124	60 m (200 ft)
024112	15 m (50 ft)	024764	75 m (250 ft)
024763	20 m (65 ft)		

Air



Part number	Length	Part number	Length
024671	3 m (10 ft)	024740	25 m (82 ft)
024658	4.5 m (15 ft)	024744	35 m (115 ft)
024659	7.5 m (25 ft)	024678	45 m (150 ft)
024765	10 m (35 ft)	024680	60 m (200 ft)
024660	15 m (50 ft)	024767	75 m (250 ft)
024766	20 m (65 ft)		

Recommended spare parts

Part number	Description	Quantity
003233	Contactor: 200/208V, 220V, and 240V power supplies	1
003249	Contactor: 380V, 400V, 415V, 440V, 480V, and 600V power supplies	1
011093	Air filter element	1
027005	Coolant filter element	1
027055	Silicone lubricant: 1/4 ounce tube	1
027079	Fan: 450-550 cfm, 120 VAC 50-60 Hz	1
028872	Coolant solution, 70/30 PG, 1 gallon	4
127091	Heat exchanger fan	1
141171	Control Board	1
220921	Quick-disconnect torch main body	1
220942	Torch Mounting sleeve: 1-3/4 inch	1
220943	Torch Mounting sleeve: 2 inch	1
420033	Quick-disconnect torch receptacle	1
420070	90 degree torch main body	1
420087	Straight torch main body	1
420109	65 degree torch main body	1
428034	Gas manifold replacement kit	1
428035	Castor wheel kit	1
428036	Chopper replacement kit	1
428037	Flow meter replacement kit	1
428038	Coolant filter replacement kit	1
428039	Pump motor replacement kit	1
141595	Replacement spark gap PCB	1
428041	I/O panel replacement kit (includes PCB)	1
428042	Pressure transducer replacement kit	1
428043	Pump replacement kit	1

Part number	Description	Quantity
428044	Inlet gas-plug replacement kit	1
428054	MAXPRO200 Oxygen fitting kit	1
428055	In-line valve replacement kit	1