How to Repair a KMT Style SL4 Dynamic Seal Assembly Using Kit #12137

These instructions will demonstrate how to replace components of a KMT Style SL4 Dynamic Seal Assembly with kit #12137

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INTRODUCTION

Hypertherm is in no way affiliated with the above mentioned manufacturer.

PARTS:

- Repair Kit #12137 (1)
- High-Pressure Seal with O-ring #12142 (included in kit) (1)
- Packing Follower #12135 (included in kit) (1)
- Dynamic Seal Back-up #12139 (included in kit) (1)
- SL4, High-Pressure Cylinder #11223 (1)
- SL4, Cylinder Liner #11605 (1)
- High-Vacuum Grease #11447 (included in kit) (1)
- Blue Goop #11111 (1)
- Isopropyl Alcohol (1)
Step 1 — How to Repair a KMT Style SL4 Dynamic Seal Assembly Using Kit #12137

- Remove the old components from the plunger end of the high-pressure cylinder with the proper tooling.
- Remove the cylinder liner from the high-pressure cylinder.
- Clean the high-pressure cylinder threads of all Blue Goop with isopropyl alcohol or similar cleaning agent.

Step 2

- Inspect the inside of the high-pressure cylinder, if scratches/galling have occurred, use Scotch Brite or a similar abrasive pad and roll back and forth to each end of the high-pressure cylinder to remove blemishes.
- Repeat the process (if needed) with 1500 grit abrasive to polish the inside of the bore.
- Apply high pressure grease to the O-ring.
Step 3

- Slide the O-ring onto the groove of the high-pressure seal.
- Put the high-pressure seal into the dynamic end of the high-pressure cylinder.
- Put the dynamic seal back-up behind the high-pressure seal.

Step 4

- Put the brass packing follower into the high-pressure cylinder, behind the dynamic seal back-up.
- Continue to static seal assembly. If complete, reassemble the high-pressure cylinder into the intensifier assembly.