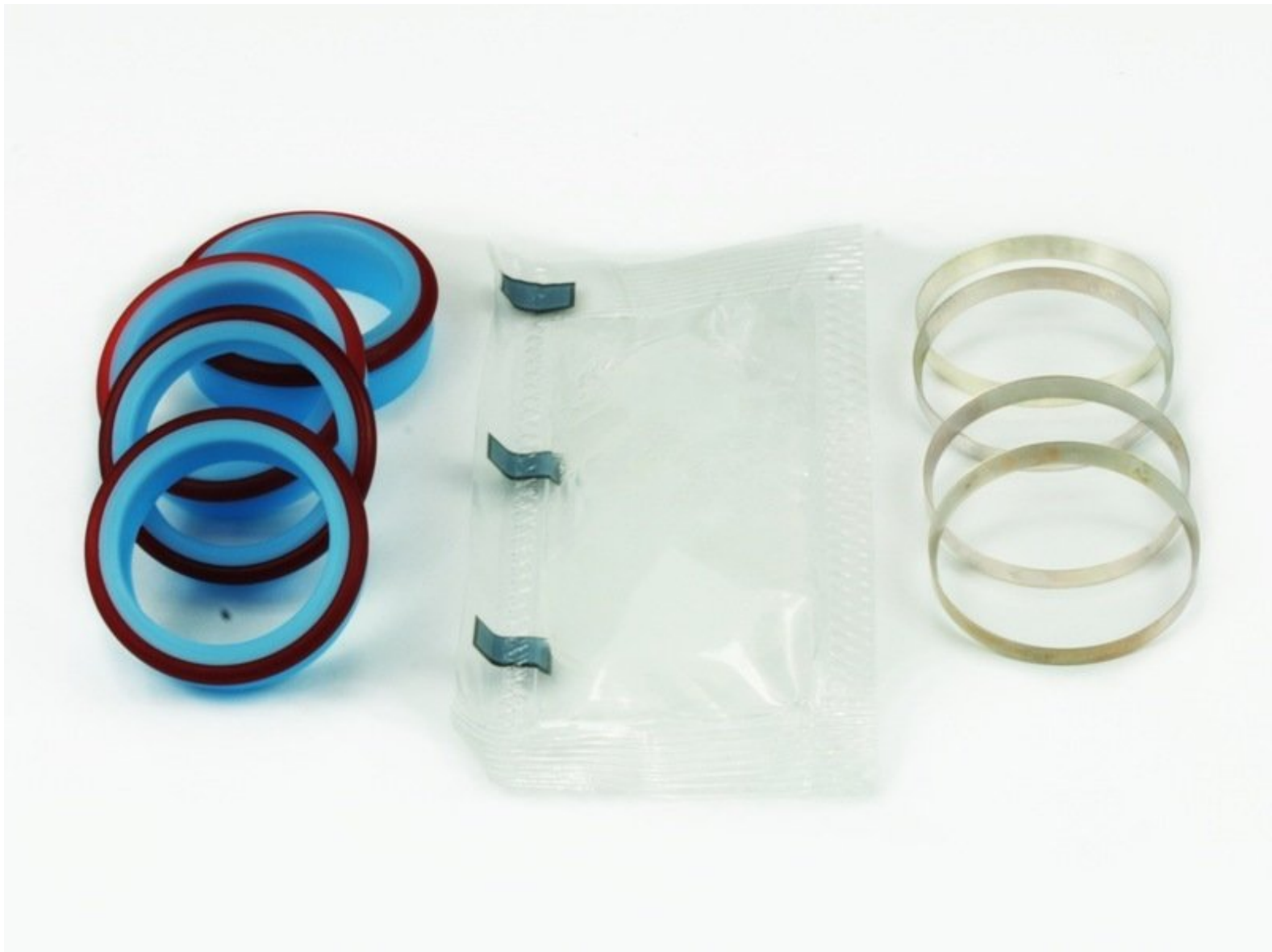




# How to Repair a JetEdge High-Pressure Seal Using Kit #11449

These instructions will demonstrate how to replace components of a JetEdge High-Pressure Seal with kit #11449

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## INTRODUCTION

Hypertherm is in no way affiliated with the above mentioned manufacturer

### TOOLS:

- [Rubber Mallet](#) (1)
- [JetEdge Seal Removal and Installation Tool](#) (1)

### PARTS:

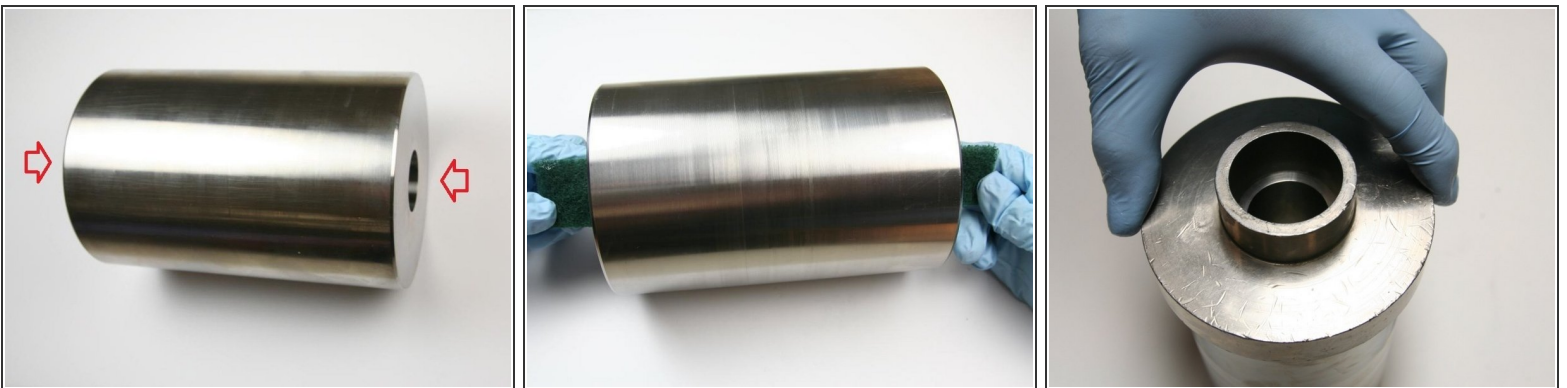
- [High-Pressure Seal Kit #11449](#) (1)
- [High-Pressure Seal with O-ring #11076 \(included in kit\)](#) (1)
- [High-Pressure Hoops \(4\) #11077 \(included in kit\)](#) (1)
- [High-Vacuum Grease #11447 \(included in kit\)](#) (1)
- [High-Pressure Cylinder #11123](#) (1)
- [Isopropyl Alcohol](#) (1)

## Step 1 — How to Repair a JetEdge High-Pressure Seal Using Kit #11449



- Use the small stepped end of the installation tool to push the internal back-up sleeve through the cylinder forcing the seal and hoop out of the other end of the [high-pressure cylinder](#).
- Turn over the high-pressure cylinder and repeat this process.
- Thoroughly clean the high-pressure cylinder with isopropyl alcohol or a similar cleaning agent.

## Step 2



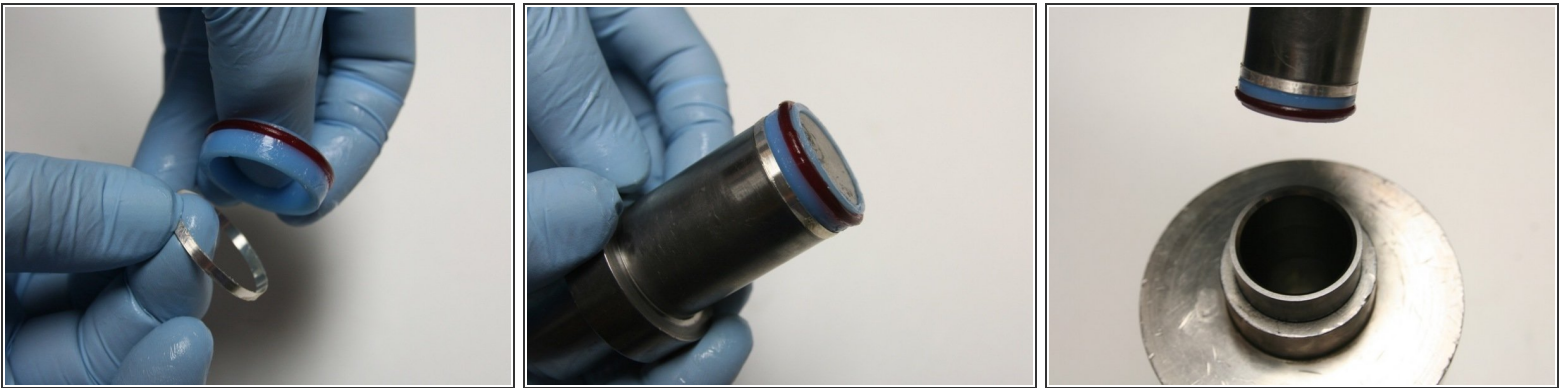
- Visually inspect the bore of the high-pressure cylinder and check for cracks/blemishes.
- Use Scotch Brite on both ends of the high-pressure cylinder to smooth out blemishes.
- Put the seal guide tool onto the one end of the high-pressure cylinder.
- ⓘ The seal guide should spin on the high-pressure cylinder when installed correctly.

### Step 3



- Put the installation sleeve into the sleeve guide with the larger ID, with the tapered end, up.
- Apply [high vacuum grease](#) to the O-ring.
- Put the O-ring on the [seal](#).

### Step 4



- Put the [hoop](#) with the sharp (tapered) end down onto the back of the seal.
- Put the seal and the hoop onto the bigger stepped side of the installation tool.
- Put the installation tool with the hoop and seal into the sleeve.



## Step 5



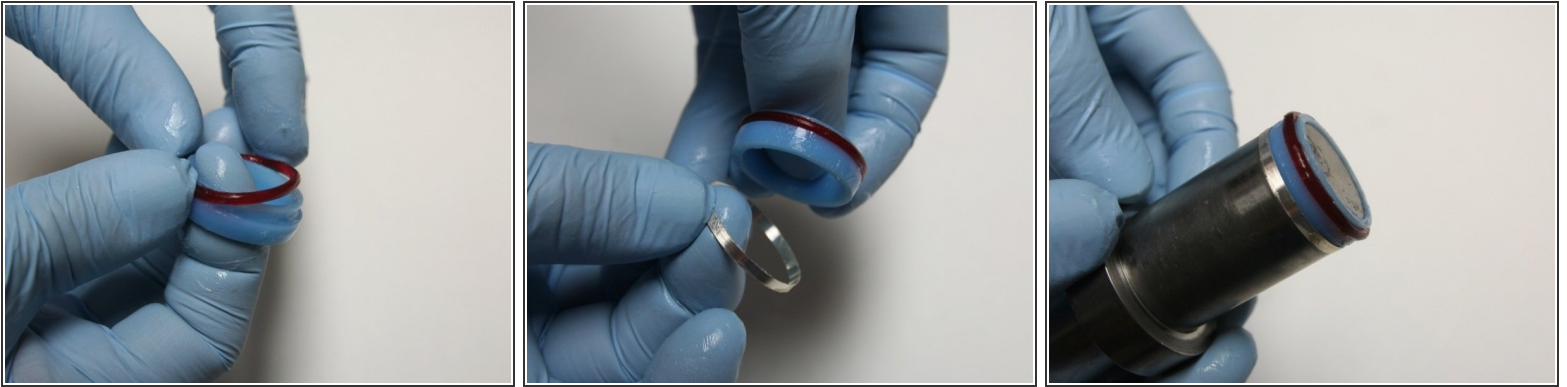
- Secure the hoop in place by tapping the installation tool with a rubber mallet until the tool bottoms out on the guide.
- Apply high vacuum grease to both ends of the [spacer tube](#).
- Remove the tools from the finished end of the high-pressure cylinder, turn the high-pressure cylinder over, and insert the spacer tube into the bore.

## Step 6



- Put the seal guide tool onto the end of the high-pressure cylinder and the seal guide should spin on the high-pressure cylinder when installed correctly.
- Put the installation sleeve into the sleeve guide with the larger ID, with the tapered end, up.
- Apply high vacuum grease to the O-ring.

## Step 7



- Put the O-ring onto the high-pressure seal.
- Put the hoop with the sharp (tapered) end down onto the back of the seal.
- Put the seal and hoop onto the bigger stepped side of the installation tool.

## Step 8



- Put the installation tool with the hoop and seal into the sleeve.
- Secure the hoop in place by tapping the installation tool with a rubber mallet until the tool bottoms out on the guide.
- Proceed to the installation of the cylinder on the intensifier.