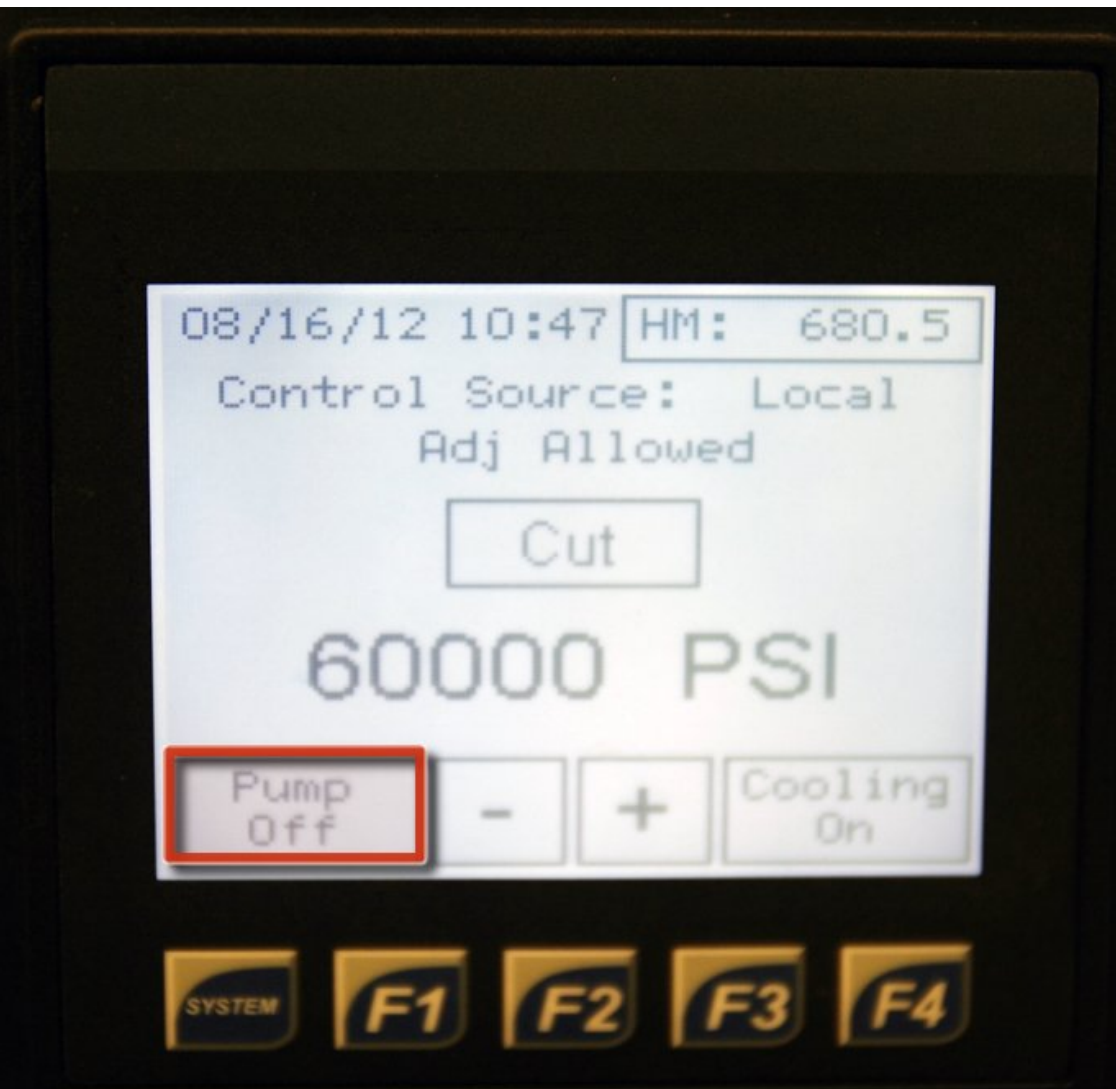




How to Repair a JetEdge On/Off Valve #12208

These instructions will demonstrate how to replace components of JetEdge On/Off Valve with kit #12208.

Written By: Ryan Engelhardt



INTRODUCTION

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



TOOLS:

- [1" wrench](#) (1)
- [13/16" wrench](#) (1)
- [7/8" wrench](#) (1)



PARTS:

- [Repair Kit 12208](#) (1)
- [Blue Goop #11111](#) (1)

Step 1 — How to Repair a JetEdge On/Off Valve #12208



! Always make sure all high pressure water has been removed from valve by following machine manufacturers' safety instructions. Failure to do so can cause severe injury or death.

- Turn OFF all water pressure to on/off valve.
- Turn on/off valve ON to raise needle from seat.

Step 2



i Valve kit components can be replaced with valve body in mounting collar.

- With air to actuator ON, unscrew nozzle tube from valve body using a 1" and 13/16" wrench.
- Turn air actuator OFF at controls and unscrew actuator from valve body using a 7/8" wrench.

Step 3



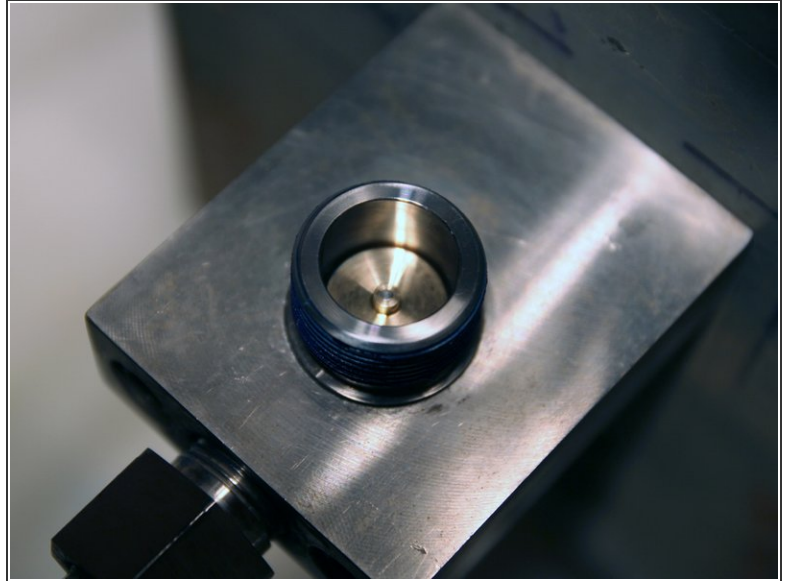
- Remove old valve components from valve body with included dowel.
- Thoroughly clean interior of valve body with isopropyl alcohol or similar cleaning agent before replacing components.
- Visually inspect top and bottom of valve bore for cracks or blemishes.

Step 4



- Insert Needle through HP Seal. Make sure the red o-ring is facing towards needle tip.
- Apply o-ring lubricant to outside diameter of HP Seal.
- Slide Needle Guide onto the back end of the Needle. Make sure larger diameter end of Needle Guide faces towards HP Seal.

Step 5



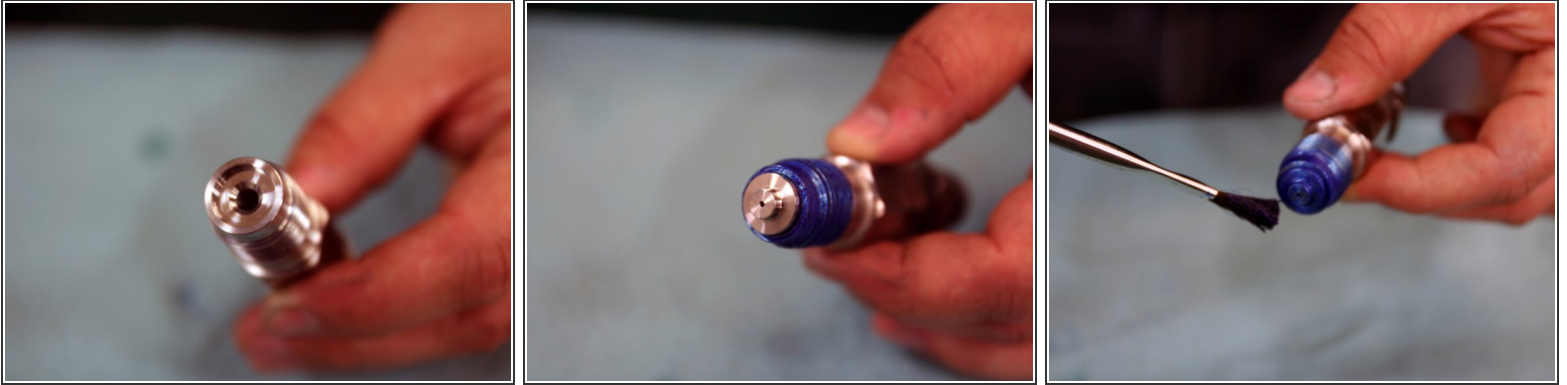
- Insert assembly into bore of valve body.
- Press assembly into place, using included dowel, until Needle Guide bottoms on valve bore.

Step 6



- Thread (hand tighten) actuator onto top of valve body
- Reconnect air line to top of actuator and
- turn air to actuator ON to relieve pressure from needle

Step 7



- Make sure to thoroughly clean nozzle tube with isopropyl alcohol or similar cleaning agent. Visually inspect nozzle tube for cracks or blemishes.
- Apply Blue Goop (11111) to top of nozzle tube and insert Seat.
- Apply Blue Goop to surfaces at top of Seat and to surface of Seat where Needle sits.

Step 8



- With actuator turned ON, thread nozzle tube into bottom of valve body.
- Torque adapter to valve using two wrenches (1" and 13/16").
- Turn air to actuator OFF to seat Needle into Seat.

Step 9

- Apply water pressure to valve assembly to verify there are no leaks.
- Quickly cycle valve on and off a few times to purge system of all contaminants before installing cutting head.
- Re-install cutting head and continue cutting process.