

Replace the hydraulic fluid

 CAUTION	Do not put too much hydraulic fluid in the tank.
	If it is not practical to analyze a sample of the hydraulic fluid, Hypertherm recommends replacing the hydraulic fluid every 3,000 hours.



Parts, tools, and materials

Hydraulic fluid replacement kit

Antiwear (AW) mineral oil or synthetic hydraulic fluid, ISO viscosity grade (VG) 32 or 46

Clean towels

Siphon or siphon pump

Torque wrench

15/16-inch crowfoot wrench or socket

Recommended materials

Clean funnel

Container for used hydraulic fluid

Isopropyl alcohol

Do this task when the pump is not operating.

1. Remove the top cover and the front panel from the pump.
2. Remove the filler cap or the filter head.
3. Use a siphon or a siphon pump to remove the hydraulic fluid from the tank.
4. Disconnect the lower ends of the hydraulic hoses that enter the top of the tank.
5. Remove the filter element and install a new element. Refer to [Hydraulic system](#) on page 68 for instructions.
6. Disassemble the hydraulic tank cover.
 - a. Disconnect the fluid level-and-temperature sensor cable.
 - b. Disconnect the hydraulic hose from the filter.
 - c. Remove the 2 hoses that pass through the cover.
 - d. Use a 7/16-inch open-ended wrench to remove the bolts and washers (10 each) from the tank cover.
7. Clean the inner surfaces of the tank with clean towels. Make sure that no debris is left in the bottom of the tank.

 CAUTION	Remove all towels from the tank before putting hydraulic fluid in it.
	Do not use soap, detergent, or solvents. Isopropyl alcohol can be used to clean the tank.

8. Assemble the hydraulic tank cover.
 - a. Install the tank cover bolts and washers (10 each).
 - b. Install the 2 hoses that pass through the cover.
 - c. Connect the hydraulic hose from the filter
9. Connect the temperature-level sensor cable.
10. Fill the tank with hydraulic fluid until the fluid is at the top mark on the sight gauge.
11. Install a new filler cap.
12. Discard the used parts.
13. Turn **ON** the pump in pierce-pressure mode.
14. Monitor for leaks.
15. Add hydraulic fluid, if necessary. Refer to [Add hydraulic fluid](#) on page 69.
16. Operate the pump in pierce-pressure mode for 15 to 20 minutes.



If air is in the hydraulic system, the pump can be noisy during operation. Refer to [The pump makes noise during operation](#) on page 115.