



How to Repair a KMT Sealing Head Using Kit #11368

These instructions will demonstrate how to replace components of a KMT Style On/Off Valve with kit #11368

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INTRODUCTION

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



TOOLS:

- [1-3/16" Wrench](#) (2)
- [Adjustable Wrench](#) (2)
- [Flat Head Screwdriver](#) (1)



PARTS:

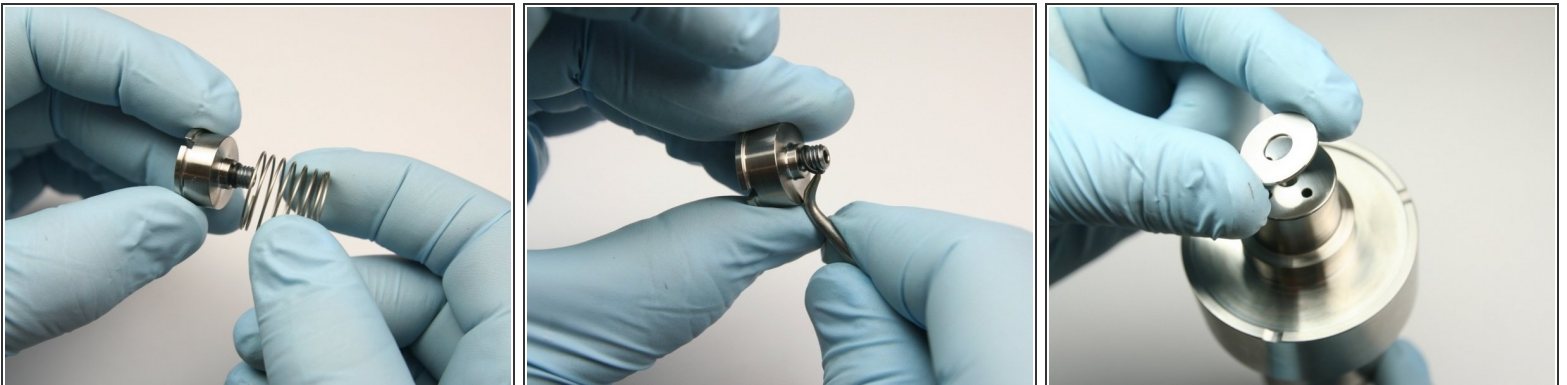
- [Sealing Head Repair Kit #11368](#) (1)
- [Inlet Compression Spring #11329](#) (included in kit) (1)
- [Poppet Valve #11265](#) (included in kit) (1)
- [High-Pressure Seat #11266](#) (included in kit) (1)
- [O-ring #12662-40](#) (included in kit) (1)
- [High-Pressure Spring #11330](#) (included in kit) (1)
- [Poppet Pin #11315](#) (included in kit) (1)
- [Inlet Poppet #11316](#) (included in kit) (1)
- [Sealing Head Body #11317](#) (1)
- [High-Pressure Sealing Head Gland #11319](#) (1)
- [Poppet Retainer #11314](#) (1)
- [Blue Goop #11111](#) (1)
- [Blue Loctite 242](#) (1)
- [Isopropyl Alcohol](#) (1)

Step 1 — How to Repair a KMT Sealing Head Using Kit #11368



- Loosen the [poppet retainer](#) from the top of the [sealing head body](#) with flat head screwdriver.
- Unthread the poppet retainer from the top of the sealing head body.
- Remove the poppet retainer with the [inlet compression spring](#).

Step 2



- Remove the inlet compression spring from the poppet retainer.
- Remove the [O-ring](#) from the poppet retainer with a pick.
⚠ Be careful to not damage the threads with the pick.
- Remove the [inlet poppet](#) from the top of the sealing head body.

Step 3



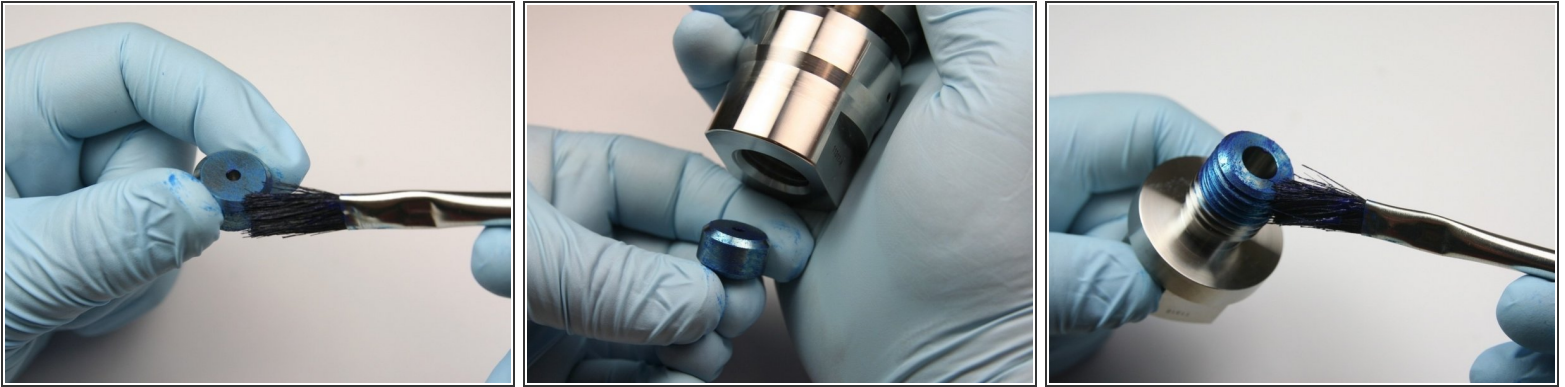
- Loosen the [high-pressure sealing head gland](#) from the sealing head body with adjustable wrenches.
 - ❗ If available, two 1-3/16" wrenches can be used instead of adjustable wrenches.
- Unthread the high-pressure sealing head gland from the sealing head body.
- Remove the [high-pressure seat](#) from the sealing head body.

Step 4



- Remove the [high-pressure spring](#), [poppet pin](#), and [poppet valve](#) from the high-pressure sealing head gland.
- Clean the sealing head body and the high-pressure sealing head gland with isopropyl alcohol or a similar cleaning agent.
- Lap the sealing head body on 1600 grit or finer lapping paper to achieve a mirror finish.

Step 5



- Apply a layer of Blue Goop to the side and one face of the high-pressure seat.
- Insert the high-pressure seat into the sealing head body with the Blue Goop side first.
- Apply blue goop to the high-pressure sealing head gland threads and the end.

Step 6



- Place the high-pressure spring on the poppet pin with the flared end away from the poppet pin.
- Insert the poppet pin with the high-pressure spring into the high-pressure sealing head gland.
- Place the [poppet valve](#) into the high-pressure sealing head gland with the solid end away from the poppet pin.

Step 7



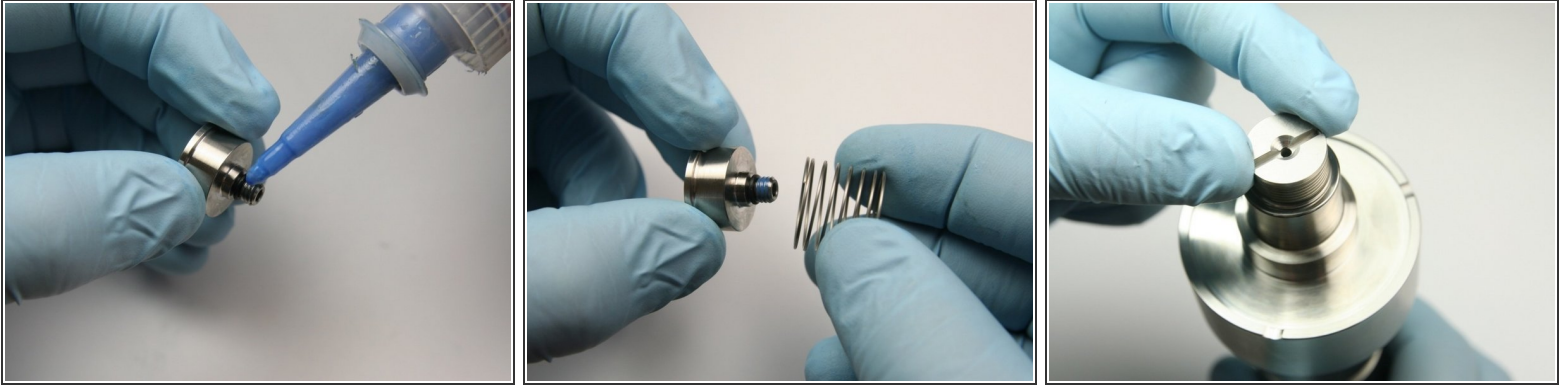
- Insert the high-pressure sealing head gland into the sealing head body.
 - Thread the high-pressure sealing head gland into the sealing head body.
 - Tighten the high-pressure sealing head gland into the sealing head body using adjustable wrenches.
-  If available, two 1-3/16" wrenches can be used instead of adjustable wrenches.

Step 8



- Apply a layer of O-ring lube to the O-ring.
- Place the O-ring below the threads of the poppet retainer.
- Set the new inlet poppet so it is centered on the top of the sealing head body (covering 4 holes).

Step 9



- Apply a small amount of blue loctite to the threads of the poppet retainer.
- Place the inlet compression spring on the poppet retainer.
- Thread the poppet retainer into the sealing head body.

Step 10



- Tighten the poppet retainer into the sealing head body with the flat head screwdriver.