

# 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

Written By: Adam Dumas



#### **INTRODUCTION**

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

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# **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 <u>high-pressure cylinder</u> with the proper tooling.
- Remove the <u>cylinder liner</u> from the high-pressure cylinder.
- Clean the high-pressure cylinder threads of all <u>Blue Goop</u> with isopropyl alcohol or similar cleaning agent.

### Step 2

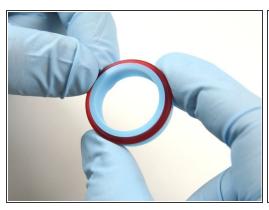






- Inspect the inside of the high-pressure cylinder, if scratches/galling have occurred, use Scotch Brite or a similar abrasive pad and roll back and forth to each end of the high-pressure cylinder to remove blemishes.
- Repeat the process (if needed) with 1500 grit abrasive to polish the inside of the 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-pressue 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 <u>static seal</u> assembly. If complete, reassemble the highpressure cylinder into the intensifier assembly.