



How to Repair a KMT Style SL5 Dynamic Seal Using Kit #12339

These instructions will demonstrate how to replace components of a KMT Style SL5 Dynamic Seal Assembly with kit #12339

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INTRODUCTION

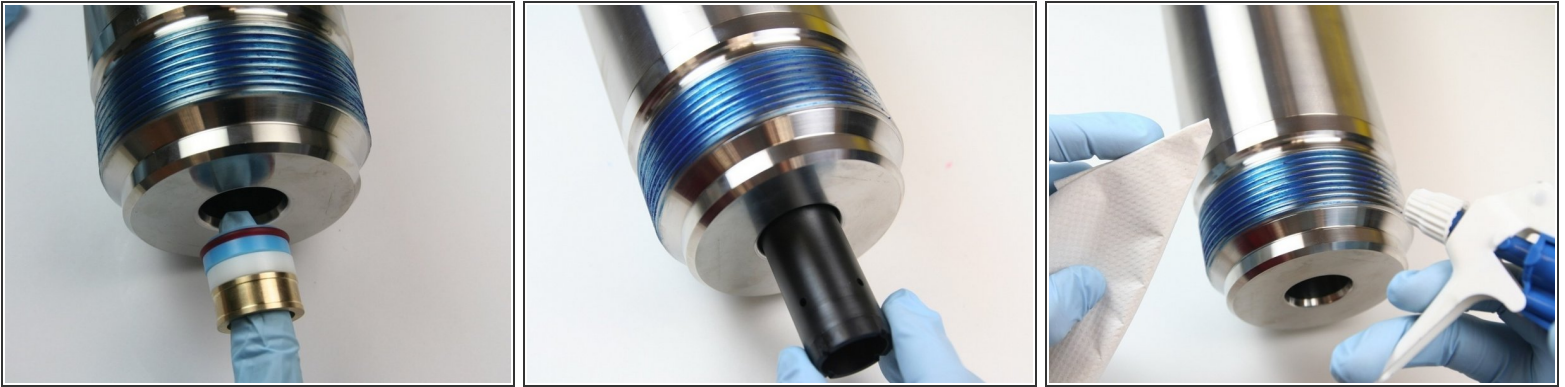
Hypertherm is in no way affiliated with the above mentioned manufacturer.



PARTS:

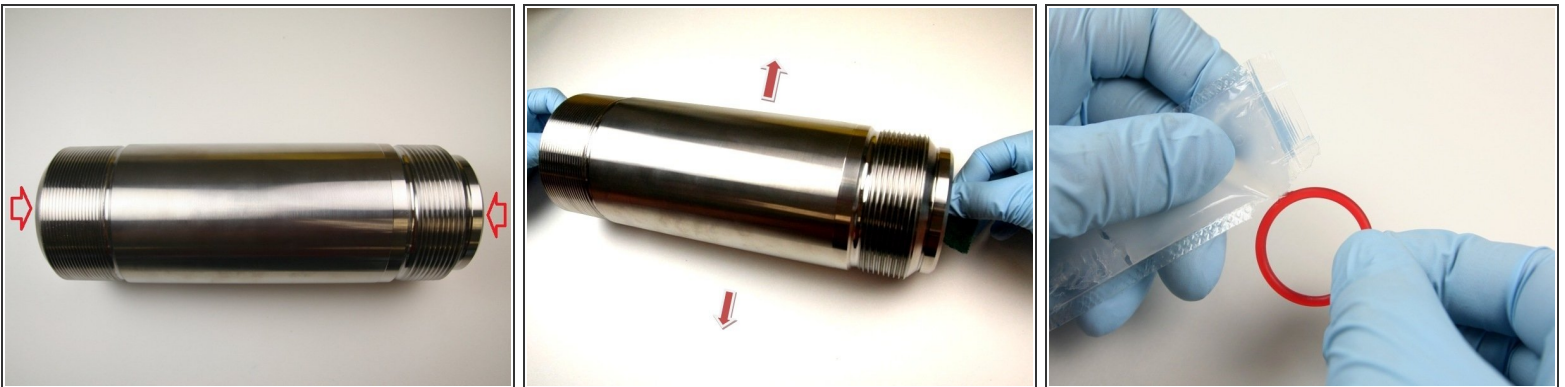
- [Repair Kit #12339](#) (1)
 - [High-Pressure Seal W/O-ring #12142 \(included in kit\)](#) (1)
 - [Packing Follower #12135 \(included in kit\)](#) (1)
 - [Dynamic Seal Back-up #12139 \(included in kit\)](#) (1)
 - [SL5, High-Pressure Cylinder #12342](#) (1)
 - [SL5, High-Pressure Cylinder Liner #12565](#) (1)
 - [High-Vacuum Grease #11447 \(included in kit\)](#) (1)
 - [Blue Goop #11111](#) (1)
 - [Isopropyl Alcohol](#) (1)
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Step 1 — How to Repair a KMT Style SL5 Dynamic Seal Using Kit #12339



- Remove the old components from the plunger end of the [high-pressure cylinder](#) with the proper tooling.
- Remove the [cylinder liner](#).
- Clean the high-pressure cylinder threads of all [Blue Goop](#) with isopropyl alcohol or a similar cleaning agent.

Step 2



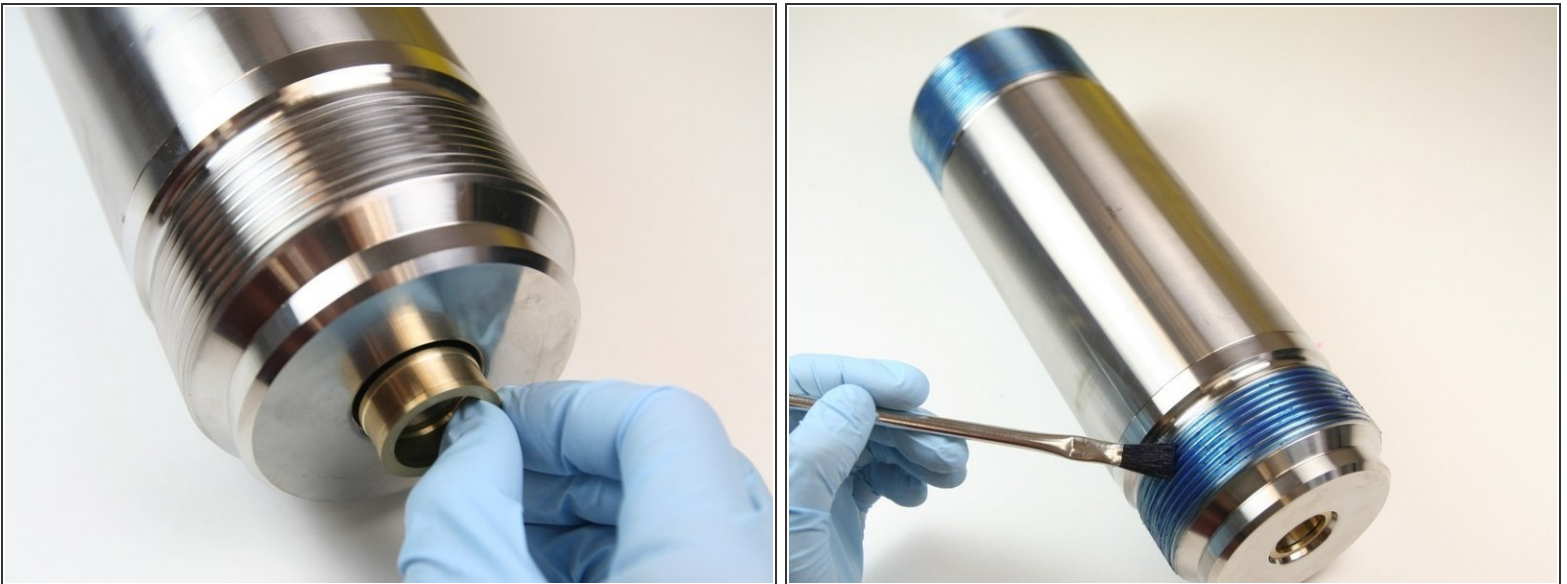
- Inspect the inside of the high-pressure cylinder. If scratches/galling have occurred, use Scotch Brite or similar abrasive pad to each end of the high-pressure cylinder to remove blemishes.
- Repeat the process (if needed) with 1500 grit abrasive to polish the inside of the bore.
- Apply [high vacuum 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 high-pressure 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.
- Apply Blue Goop to the threads of the high-pressure cylinder.
- Reassemble the high-pressure cylinder into the intensifier assembly.