



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



INTRODUCTION

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



PARTS:

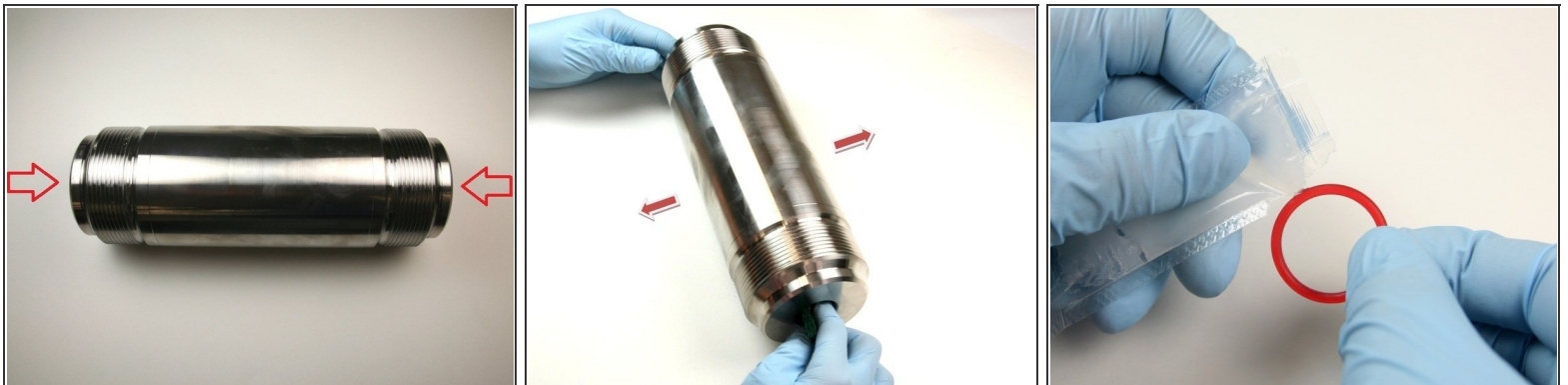
- [Repair Kit #12137](#) (1)
 - [High-Pressure Seal with O-ring #12142 \(included in kit\)](#) (1)
 - [Packing Follower #12135 \(included in kit\)](#) (1)
 - [Dynamic Seal Back-up #12139 \(included in kit\)](#) (1)
 - [SL4, High-Pressure Cylinder #11223](#) (1)
 - [SL4, Cylinder Liner #11605](#) (1)
 - [High-Vacuum Grease #11447 \(included in kit\)](#) (1)
 - [Blue Goop #11111](#) (1)
 - [Isopropyl Alcohol](#) (1)
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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 [high-pressure cylinder](#) with the proper tooling.
- Remove the [cylinder liner](#) from the high-pressure cylinder.
- Clean the high-pressure cylinder threads of all [Blue Goop](#) 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-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.
- Continue to [static seal](#) assembly. If complete, reassemble the high-pressure cylinder into the intensifier assembly.