



# 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



## 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:

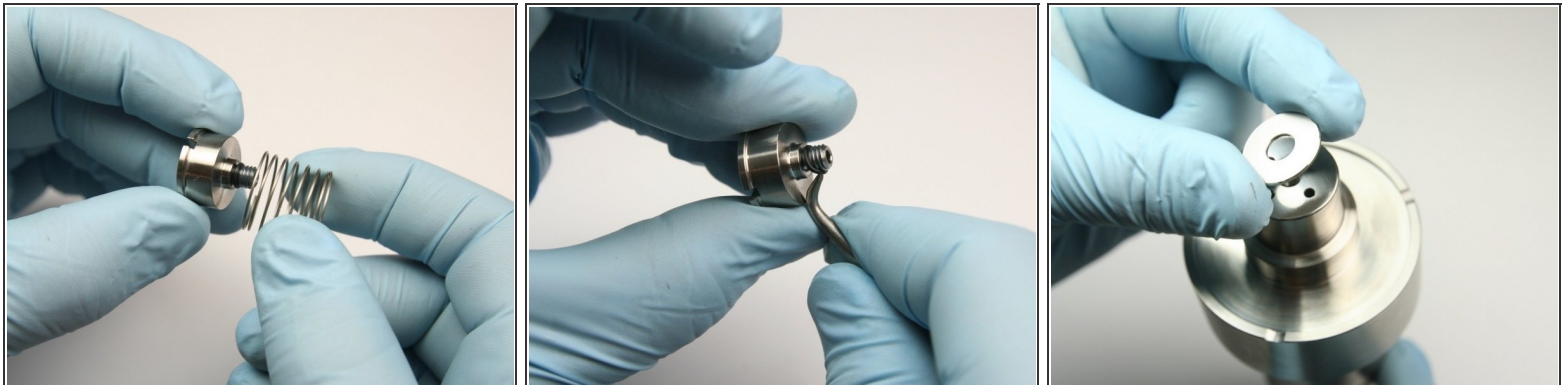
- Sealing Head Repair Kit #11368 (1)
- Inlet Compression Spring #11329 (included in kit) (1)
- Poppet Valve #11265 (included in kit) (1)
- High-Pressure Seat #11266 (included in kit) (1)
- O-ring #12662-40 (included in kit) (1)
- High-Pressure Spring #11330 (included in kit) (1)
- Poppet Pin #11315 (included 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



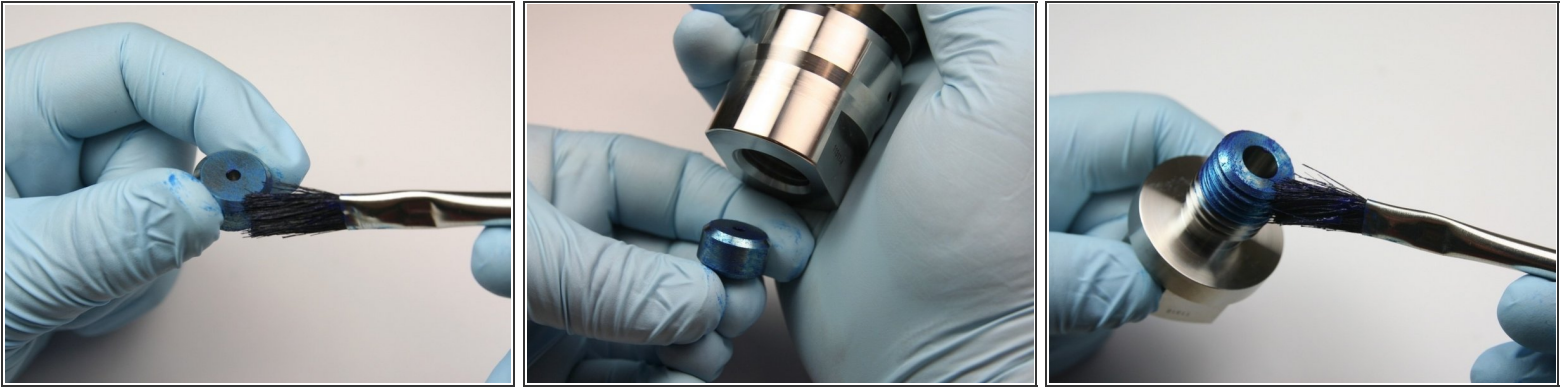
- Loosen the [high-pressure sealing head gland](#) from the sealing head body with adjustable wrenches.
  - ⓘ If available, two 1-3/16" wrenches can be used instead of adjustable wrenches.
- Unthread the high-pressure sealing head gland from the sealing head body.
- Remove the [high-pressure seat](#)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



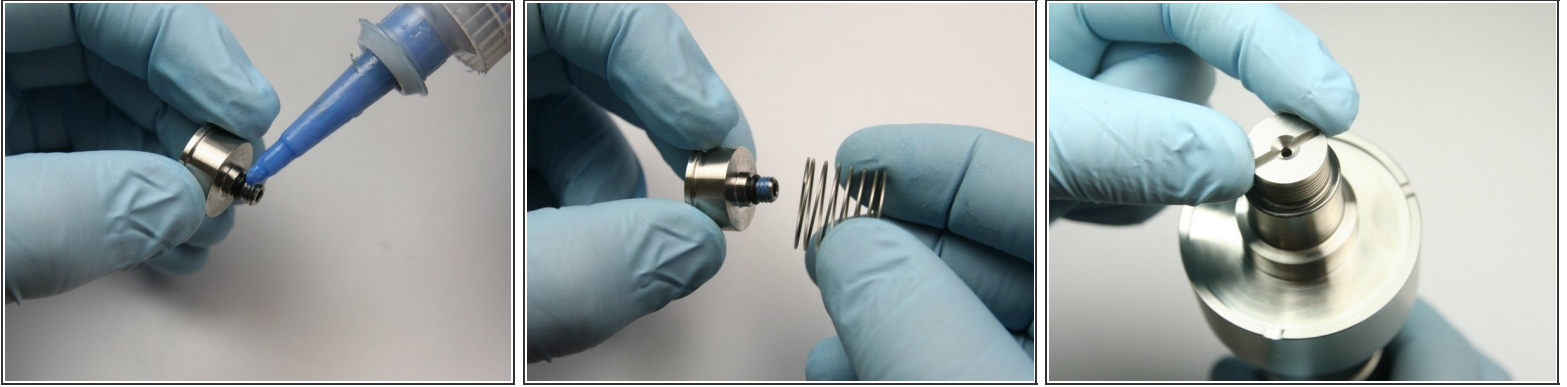
- Insert the high-pressure sealing head gland into the sealing head body.
  - Thread the high-pressure sealing head gland into the sealing head body.
  - Tighten the high-pressure sealing head gland into the sealing head body using adjustable wrenches.
- ⓘ If available, two 1-3/16" wrenches can be used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