



Hypertherm 11241 How to Repair a KMT Style On or Off Valve Using Kit Instruction Manual

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Hypertherm

Hypertherm 11241 How to Repair a KMT Style On or Off Valve Using Kit



INTRODUCTION

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

TOOLS:

1-1/4" wrench (1)

PARTS

- Repair Kit #11241 (1)
- Valve Stem #11102 (included in kit) (1)
- O-ring #11240 (included in kit) (1)
- Seat #11099 (included in kit) (1)
- Brass Back-up Ring #11104 (included in kit) (1)
- Seal Assembly #11100 (included in kit) (1)
- Stainless Steel Back-up Ring #12733 (1)
- Actuator #12089 (1)
- High-Pressure Gland Fitting #12347 (1)
- Valve Body #11320 (1)
- Nozzle Tube #11436 (1)
- Blue Goop #11111 (1)
- Isopropyl Alcohol (1)

Repairing

Step 1 — How to Repair a KMT Style On/Off Valve Using Kit #11241



Always make sure all high-pressure water has been removed from the valve by the following machine manufacturers' safety instructions. Failure to do so can cause severe injury or death.

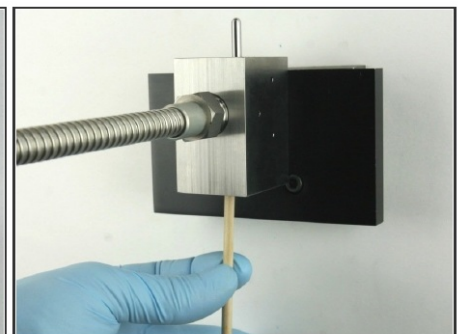
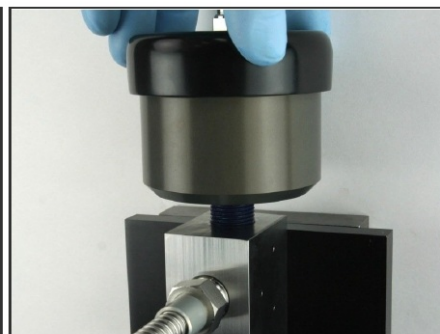
- Turn OFF all water pressure to the on/off valve.
- Turn the on/off valve ON to raise the valve stem from the seat.

Step 2



- The valve components can be replaced with the valve body mounted to the table.
- Loosen the high-pressure gland fitting using a 1-1/4" wrench.
- Turn the air to the actuator OFF at the controls.

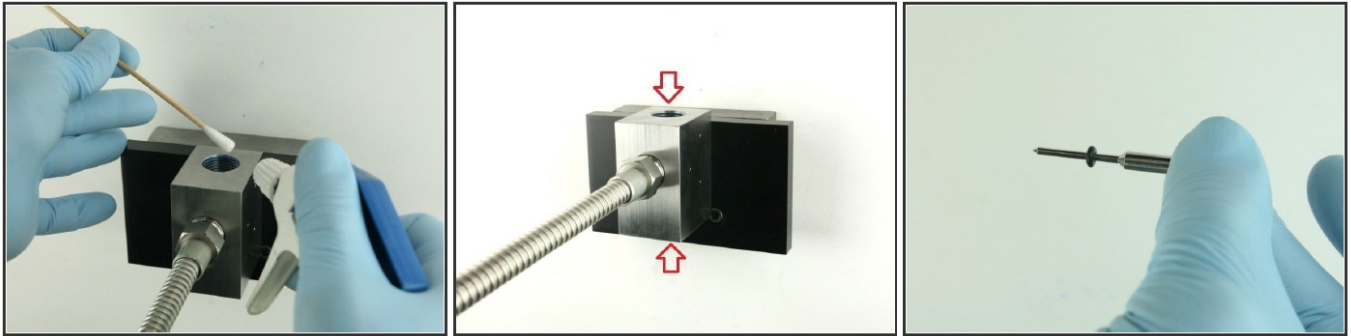
Step 3



- Disconnect the air line from the actuator.

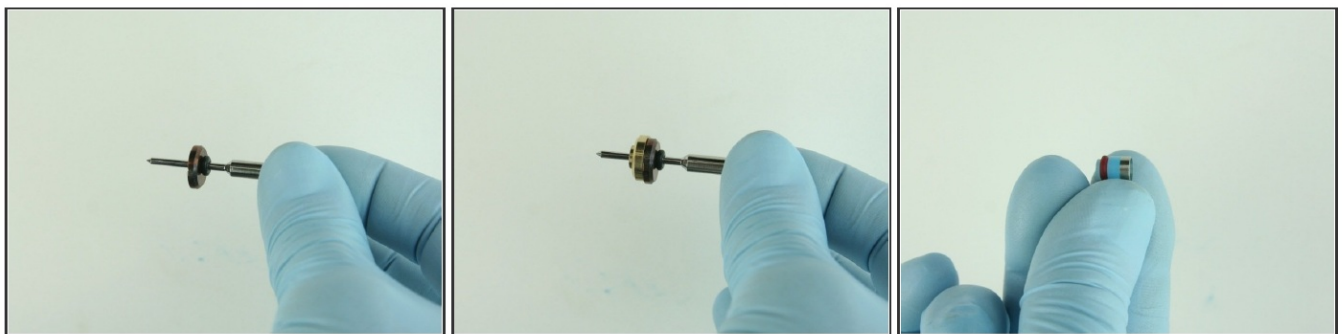
- Unthread the actuator from the valve body.
- Remove all the valve components from the valve body with the included dowel.

Step 4



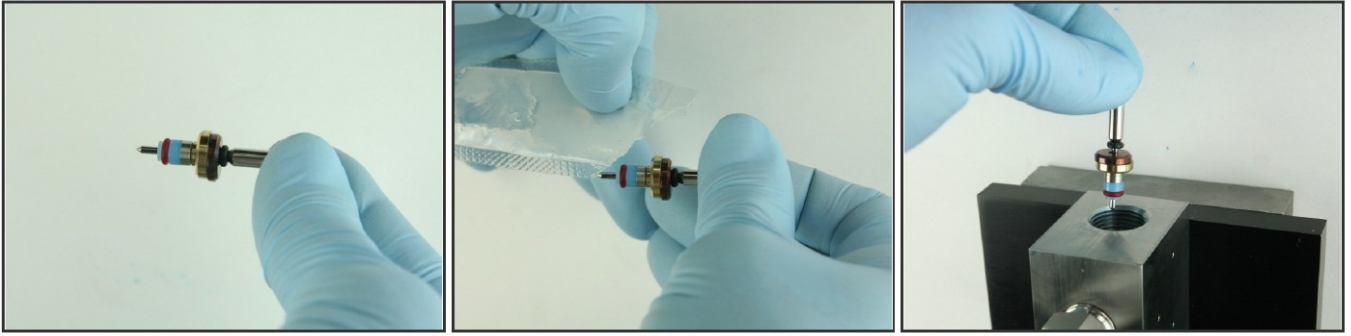
- Thoroughly clean the interior of the valve body with isopropyl alcohol or a similar cleaning agent before replacing the components.
- Visually inspect the top and bottom of the valve bore for cracks/blemishes. If excessive wear or cracks are visible, replace the valve body.
- Slide the O-ring on to the point of the valve stem.

Step 5



- Slide the stainless steel back-up ring on to the valve stem point with the chamfer side towards the O-ring.
- Slide the brass back-up ring on to the valve stem point with the chamfer side away from the stainless steel back-up ring.
- Put the hoop on the high-pressure seal with the sharp edge of the hoop towards the seal.

Step 6



- Slide the hoop and the high-pressure valve seal onto the valve stem with the hoop towards the brass back-up ring.
- Apply the high-pressure lubricant to the outside diameter of the high-pressure valve seal.
- Put the point of the valve stem into the valve body.

Step 7



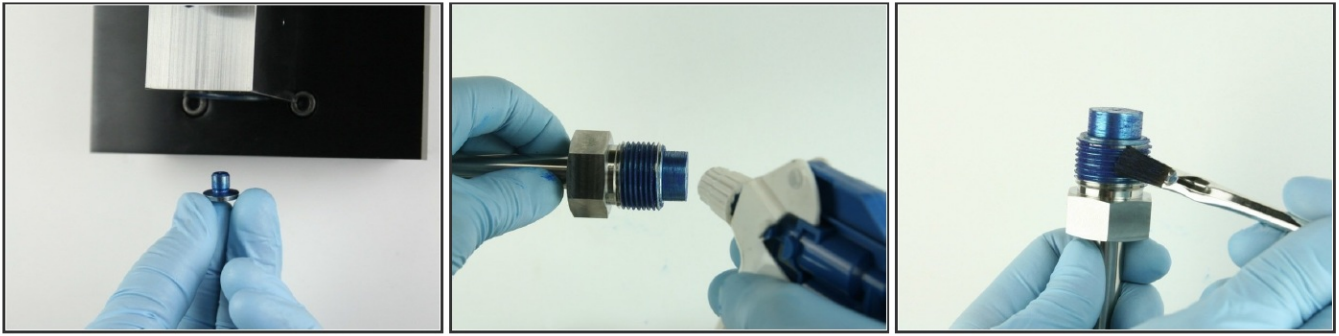
- Push the valve stem with the dowel until it bottoms out.
- Apply Blue Goop to the actuator threads.
- Thread (hand tighten) the actuator into the top of the valve body until it bottoms out.

Step 8



- Reconnect the air line to the top of the actuator.
- Turn the air to the actuator ON at the controls.
- Apply Blue Goop to all surfaces of the seat.

Step 9



- Put the seat into the bottom of the valve body.
- Clean the high-pressure gland fitting threads and at the top of the nozzle tube of all Blue Goop.
- Reapply Blue Goop to the threads of the high-pressure gland fitting and at the top of the nozzle tube.

Step 10



- Thread the high-pressure gland fitting into the bottom of the valve body.
- Tighten the high-pressure gland fitting using a 1-1/4" wrench.
- Turn the air to the actuator OFF at the controls.

Step 11



- Apply water pressure to the valve assembly to verify there are no leaks.
- Quickly cycle the valve on and off a few times to purge the system of all contaminants before installing the cutting head.
- Re-install the cutting head and continue the cutting process.

Documents / Resources



[Hypertherm 11241 How to Repair a KMT Style On or Off Valve Using Kit](#) [pdf] Instruction M anual
1-11241, 11241 How to Repair a KMT Style On or Off Valve Using Kit, 11241, How to Repair a KMT Style On or Off Valve Using Kit, KMT Style On or Off Valve Using Kit

References

- [D Waterjet Mobile Assistant by Hypertherm Associates - Mobile Assistant](#)
- [Waterjet Replacement Parts | AccuStream](#)
- [AccuStream Part# 1-11104- Replaces KMT Part# 10188233](#)
- [1-11111- Replaces Flow A-2185| KMT 20460486 - AccuStream](#)
- [AccuStream Part# 1-11240-Replaces KMT Part# 49895584](#)
- [On/off Valve Repair Kit Part# 1-11241 Replaces KMT - AccuStream](#)
- [AccuStream Part# 1-11320- Replaces KMT Part# 10189181](#)
- [AccuStream Part# 1-11436- Replaces KMT Part# 10138428](#)
- [AccuStream Part# 1-12089- Replaces KMT Part# 10177855](#)
- [AccuStream Part# 1-12347- Replaces KMT Part# BV701184](#)
- [AccuStream Part# 1-12733- Replaces KMT Part# 10187250](#)