General Information

This kit is for use only with Victor Thermal Dynamics XT-Series Torches. Do not use this kit with any other equipment.

Read these instructions before starting the replacement procedure. Keep these instructions for future reference.

Parts Supplied

The kit includes:

- Torch O-Rings
- Cartridge O-Rings
- Cartridge Baffle O-Ring (xx-1022)
- Victor Thermal Dynamics Cat. No. 9-4893 O-Ring Lubricant
- Instructions

Procedure

1. If necessary, raise the torch away from the cutting table to provide working room.

2. Remove the Shield Cup Assembly (including the cartridge assembly and consumables).

3. Disconnect primary power at the source and bleed down the system before starting this procedure.

4. Find and open the bag labeled Torch O-Ring Kit. Verify that you have a new O-Ring for each of the ones being replaced on the Torch. See Illustration.

5. Clean each of the O-Ring grooves with a soft bristle brush or lint free cloth.

6. Find the large yellow O-Ring and place it on the Torch where the old one was. Do Not Lubricate the yellow O-Ring.

O-Ring Kit No. 9-9488 for XT-Series Torch

Installation Instructions

CAUTION

Use only Victor Thermal Dynamics No. 9-4893 O-Ring Lubricant (Christo Lube MCG-129) with this torch part. Use of other lubricants may cause irreparable damage to the torch.
5. Lubricate each of the red or purple (black on older models) O-Rings with a thin film of the lubricant provided with this kit. See earlier Caution.
   a. Place a small amount of lubricant on your index finger.
   b. Rub the lubricant between your thumb and index fingers until it becomes clear.
   c. Apply this lubricant to the O-Ring by rolling it between your thumb and index fingers.
   d. Repeat this process until the entire O-Ring is coated in a thin film of lubricant.

6. Place each of the O-Rings in the proper groove on the Torch. See Previous Illustration.

Use the following Torch O-Ring scale to verify proper size.

**NOTE**

*Older model torches may have brown and black O-Rings.*

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**Cartridge O-Ring Change 300 Amp and Less**

1. Find and open the bag labeled Cartridge O-Ring Kit. Verify that you have a new O-Ring for each of the ones being replaced on the Cartridge. See Illustration.

   - Inner O-Ring (Cat. No. 9-3030)
   - Location (Under Locking Ring)
   - O-Ring, Cat. No. 9-3029
   - O-Ring, Cat. No. 9-3028

   **Cartridge Assembly**
   - Snap Ring
   - Cartridge Retaining Ring (Cat. No. 9-9489)
   - Cartridge View
   - Cartridge Body
   - Baffle
   - Shield Cup

   **NOTE**

   For 300 and 400 Amp cartridges the Shield Cup, Baffle and Speed Lock Ring will need to be removed to access the largest of the O-Rings noted above.

2. Remove the snap ring on the cartridge assembly and slide the locking ring downward for access to the O-Ring under the retaining ring.

3. Remove and discard each of the old O-Rings from the cartridge. Remove and discard the Baffle O-ring.
CAUTION

Use only Victor Thermal Dynamics No. 9-4893 O-Ring Lubricant (Christo Lube MCG-129) with this torch part. Use of other lubricants may cause irreparable damage to the torch.

4. Lubricate each of the O-Rings with a thin film of the lubricant provided with this kit. See previous Caution.
   
a. Place a small amount of lubricant on your index finger.
   
b. Rub the lubricant between your thumb and index fingers until it becomes clear.
   
c. Apply this lubricant to the O-Ring by rolling it between your thumb and index fingers.
   
d. Repeat this process until the entire O-Ring is coated in a thin film of lubricant.

5. Place the Baffle O-Ring inside the Baffle. Place each of the O-Rings in the proper groove on the Cartridge. See Previous Illustration.

6. Secure the locking ring in place by reversing step 2 above. Take extra care to insure the snap-ring is properly seated and the locking ring is secure and rotates freely. There should be a gap of 1/8” or less between the ends of the snap-ring.

7. Reinstall the Shield Cup Assembly (including the cartridge assembly and consumables) on the torch.

8. Reconnect the gas supply. Adjust gas pressure as needed. Test the system for proper operation.

Use the following Cartridge O-Ring scale to verify proper size.
Cartridge O-Ring Change 400 Amp

1. Find and open the bag labeled Cartridge O-Ring Kit. Verify that you have a new O-Ring for each of the ones being replaced on the Cartridge. See Illustration.

   Inner O-Ring (Cat. No. 9-3030)
   Location (Under Speed Lock Ring)

   O-Ring, Cat. No. 9-3029
   O-Ring, Cat. No. 9-3028

   O-Ring, Cat. No. 9-3029
   O-Ring, Cat. No. 8-0561

   Cartridge Assembly
   Speed Lock Ring and
   Threaded Ring
   removed for clarity

   400 Amp Only

   O-Ring, Cat. No. 8-0547

   Outer Cartridge

   Cartridge View

   NOTE

   For 300 and 400 Amp cartridges the shield Cup, Baffle and Speed Lock Ring will need to be removed to access the largest of the O-Rings noted above.

2. Remove the Outer Cartridge by holding the Cartridge with the removal tool and unthreading the Outer Cartridge. Slide the Threaded Ring and Speed Lock ring off the Cartridge body for access to the O-Ring.

3. Remove and discard each of the old O-Rings from the two Cartridge sections.

   CAUTION

   Use only Victor Thermal Dynamics No. 9-4893 O-Ring Lubricant (Christo Lube MCG-129) with this torch part. Use of other lubricants may cause irreparable damage to the torch.

4. Lubricate each of the O-Rings with a thin film of the lubricant provided with this kit. See previous Caution.

   a. Place a small amount of lubricant on your index finger.

   b. Rub the lubricant between your thumb and index fingers until it becomes clear.

   c. Apply this lubricant to the O-Ring by rolling it between your thumb and index finger.

   d. Repeat this process until the entire O-Ring is coated in a thin film of lubricant.

5. Place each of the O-Rings in the proper groove on the Cartridge sections. See Previous Illustration.

6. Secure the locking ring in place by reversing step 2 above. Be sure the tabs on the Threaded Ring go first and align with the notches before attaching the Outer Cartridge.

   CAUTION

   Do not use wrenches to tighten the assembly pieces. Hand tighten ONLY.
Use the following Cartridge O-Ring scale to verify proper size.

7. Reinstall the Shield Cup Assembly (including the cartridge assembly and consumables) on the torch.

8. Reconnect the gas supply. Adjust gas pressure as needed. Test the system for proper operation.

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**CAUTION**

If O-Rings from the Torch Head and Cartridge are mixed, the O-Ring scale charts must be used to determine the correct O-Rings. Some of these O-Rings are very close in size and if they are mixed they will leak.

If you are printing these pages from an electronic source, i.e. PDF, measure the “1 inch Scale” provided with the illustration. If it does not measure 1”, DO NOT USE IT. Many printing defaults for “PDF” files are set to “Fit to Printer Margins”. This has to be changed so that no changes or “None” is selected in the “Page Scaling” so the print out will be at 100%.

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