



1. Start by removing the 2 screws on each foot (Side and Bottom) and plastic bumpers (Front and Rear). Keep all front parts & screws separate from the Rear parts & screws.



2. Remove the 4 screws from the handle. NOTE: the front screws are longer than the rear screws.



3. Keep front and rear parts separate.



4. Remove the 6 bottom screws on both sides first and set those aside. Then remove the 8 side and top screws and set aside. NOTE: the top screws are on the outer holes.



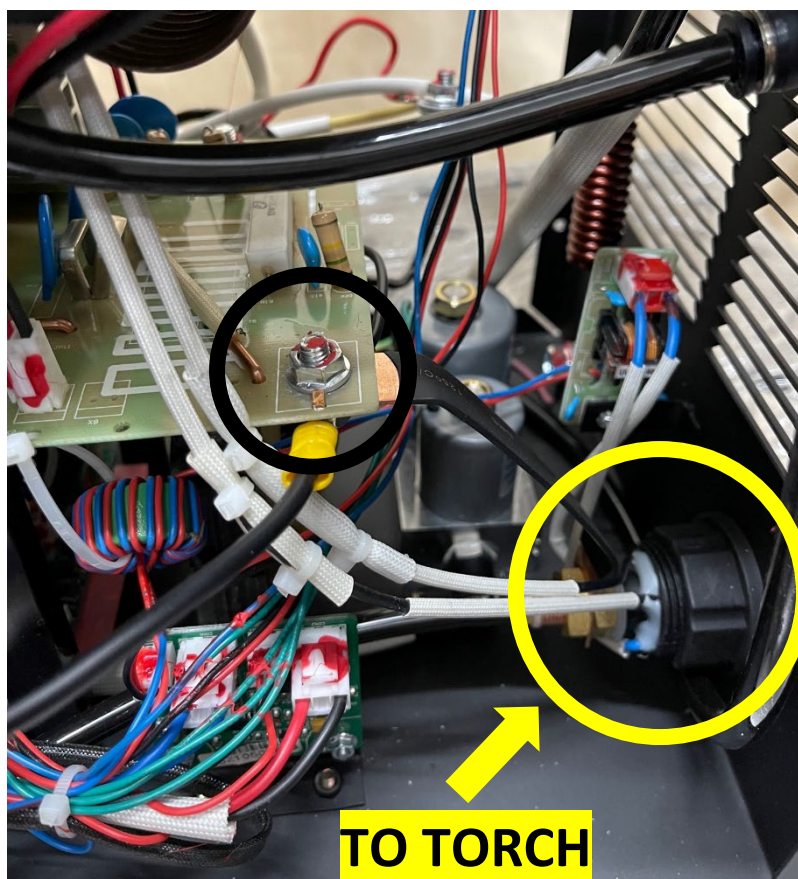
5. Carefully lift the front of the cover and slide it towards the back. You'll notice a ground wire attaching the cover to the back of the main chassis. The cover should hang freely from the ground wire allowing you to work on the inside of the cutter.



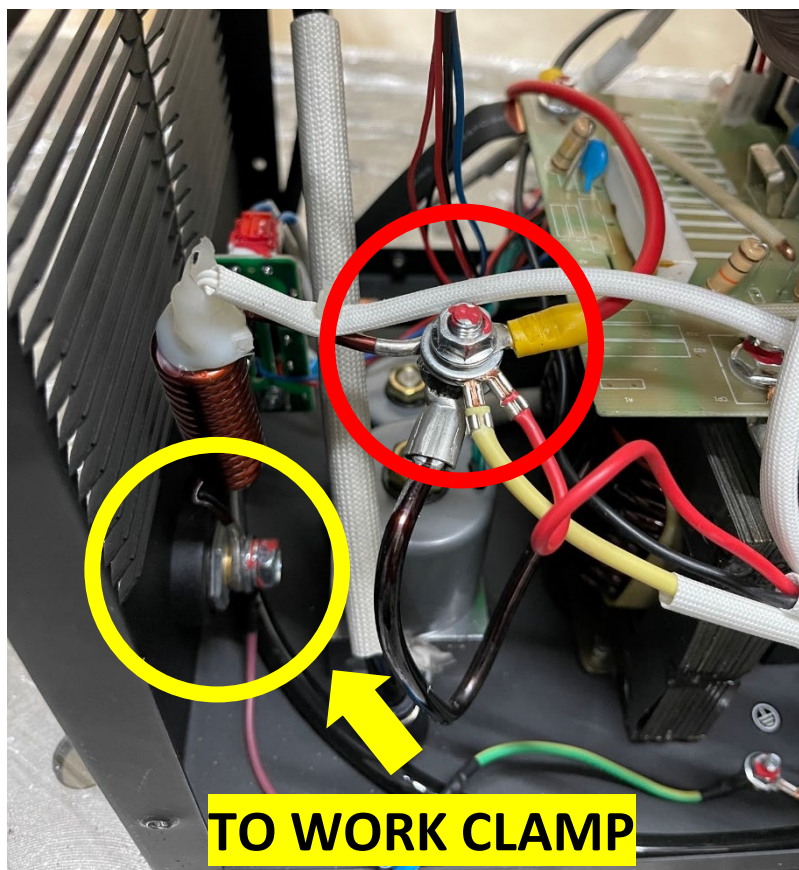
6. Crimp a 16-14 gauge $\frac{1}{4}$ " ring terminal to the end of each RAW voltage pigtail wire.



7. Feed the ring ends thru the fins on the cover. You can also feed the Raw Voltage Pigtails thru first then crimp on the ring terminals after.



8. From the Torch side of the cutter and using 2 10mm wrenches, loosen and remove the nut (circled in black) from the top of the circuit board. Carefully remove the bolt from the bottom and attach the BLACK Raw Voltage cable ring to the bolt and feed the bolt back thru the bottom of the circuit board. Replace and tighten nut.



9. From the Work Clamp side, using 2 10mm wrenches, loosen and remove the top nut (circled in red) then attach the RED Raw Voltage cable ring to the bolt. Replace and tighten nut.



10. Slide the cover back to the front. Carefully pull the Raw Voltage cables from the fins to take up any slack from the inside. Loosely Secure the 8 side and top cover screws first then the 6 bottom screws (See step 4). Tighten all screws.
11. Place the handle on top of the cutter then slide each metal cover underneath each side and loosely secure with screws. Once all are installed, tighten the 4 screws.
12. Install and loosely secure the plastic bumpers then the feet. Tighten all screws.