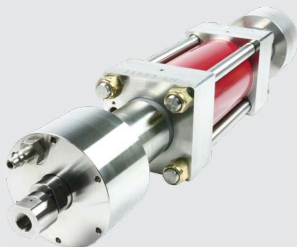




Waterjet parts book

Every brand of waterjet can be better
Replacements parts suitable for Flow®



We have worked a lifetime on your shop floor

AccuStream has been in the waterjet business from the beginning. Our founder is an industry pioneer, leading research and development on the first generations of high-pressure intensifier pumps. Early on, he opened a waterjet job shop – the shop that would be the genesis of AccuStream.

Born and raised as a waterjet job shop, we proved ourselves by overcoming the same challenges you confront every day: staying competitive in the market, keeping machines running, finding affordable replacement parts and technical service and quickly making repairs to get back into production. In our search for the best ways to be competitive and conquer other keep-you-up-at-night dilemmas, we found a recurring truth – we were uniquely positioned to develop replacement parts for waterjets. And not just any replacement parts, but parts that met our own high standards for component life, quality, availability and price. This is the idea that launched AccuStream and our products for all waterjets.

We felt from the beginning that providing long-lasting, high quality parts was not enough. As a waterjet user, you need a partner who you can depend on to pick up the phone when you call, answer your waterjet questions, help with your day-to-day waterjet dilemmas and deliver parts with the sense of urgency demanded by your business. A partner who can get you what you need when you need it. How do we know? We've been there.

As a brand of Hypertherm, we're taking that care to a whole new level. We are 100% Associate-owners of Hypertherm, which means that each of us has a vested interest in your satisfaction and a strong drive to provide the best products and services. Let us earn your business with replacement parts engineered and manufactured in America. Parts that can lower your cost of ownership by delivering more cuts, more work hours, increased productivity and ultimately greater profitability. Parts delivered with a level of service that you will only find with AccuStream.



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Hypertherm waterjet OEM products



HyPrecision™ Intensifier Pumps

Reduce operating costs with Hypertherm HyPrecision intensifier pumps, which deliver the lowest total cost of ownership in the industry by 20%. Our Advanced Intensifier Technology (AIT) provides extreme reliability with ease of service and operation that will keep you cutting.

- Easier servicing
- Longer lasting
- Streamlined access
- Optimized shifting
- Simplified high-pressure ends
- Prolonged seal life



DiaLine™ Cutting Heads

Optimize cutting efficiency and extend nozzle life by aligning the orifice to the nozzle precisely with the DiaLine Cutting Head.

- The best diamond warranty in the industry
- Increased nozzle life of up to 15%
- Average diamond life of 1,000 hours
- A customizable head to change the orifice size easily for different jobs



Hypertherm Abrasive Regulator II

Optimize abrasive usage and minimize production costs with the accuracy and versatility of the Hypertherm Abrasive Regulator II.

- 30 precision settings
- On-the-go adjustment
- Quick access for maintenance



Hypertherm Reverse Osmosis System

Extend component life and lower operating costs by delivering purified water directly to the pump with Hypertherm's Reverse Osmosis System.

- Adjustable total dissolved solids (TDS) settings
- Supports up to 2,000 gallons of water per day

Increased productivity for long-term profitability

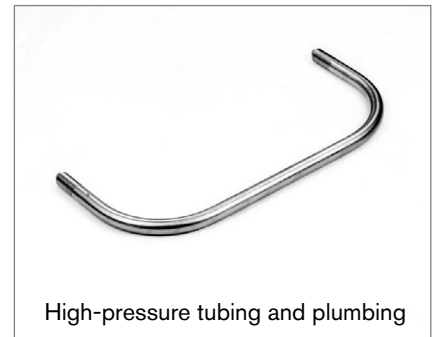
Regular maintenance is a way of life with waterjet cutting. The key to maximizing uptime is doing the right maintenance at the right intervals. Long-life components ensure that you are using your equipment more and servicing it less. What does an extra day of downtime waiting for technical support or parts mean to your business? If you don't have the luxury of waiting, then where you order waterjet replacement parts matters just as much as the quality of the parts. Put us to the test. Your test. AccuStream delivers replacement parts for pumps, cutting heads, abrasive delivery products and high-pressure plumbing and tubing for all major brands of waterjet. We'll keep you running, especially when you need us most.



Seal kits



On/off valve kits



High-pressure tubing and plumbing



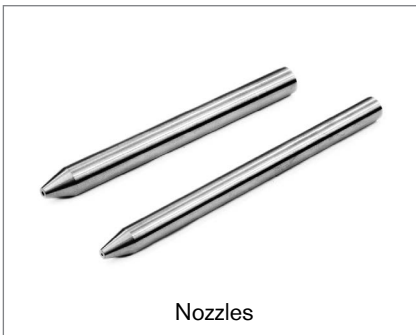
Check valves



Cylinders



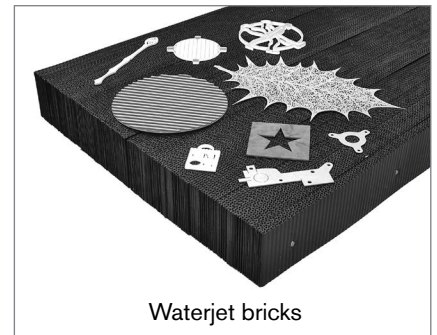
Adapters



Nozzles



Orifices



Waterjet bricks

Replacement parts for Flow®



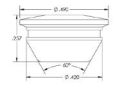
**American Built
Building America™**



Orifices

New-style orifices

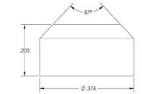
AccuStream #	Description	Replaces
1-12498-XXX	Ruby Orifice	014201-XX
1-12498DA-XXX	Diamond Orifice	014155-XX
1-12498D-XXX	Diamond Orifice, Water-only	—



These orifices are compatible with PASER® 3 and PASER® ECL® cutting heads.

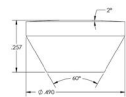
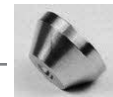
PASER® 4 orifices

AccuStream #	Description	Replaces
1-14446-XXX	Ruby Orifice	041759-XX
1-14447-XXX	Diamond Orifice	015849-XX



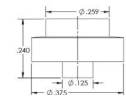
PASER® 3 orifices

AccuStream #	Description	Replaces
1-11226-XXX	Ruby Orifice	009519-XX TL-003002-XX



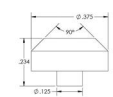
PASER® 2 orifices

AccuStream #	Description	Replaces
1-11398-XXX	Ruby Orifice	001821-XX
1-11398D-XXX	Diamond Orifice	D-5071-XX



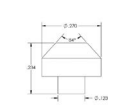
Standard-mount orifices

AccuStream #	Description	Replaces
1-11238-XXX	Ruby Orifice	004519-XX
1-11238D-XXX	Diamond Orifice	004519-XX



Low-mass orifices

AccuStream #	Description	Replaces
1-11462-XXX	Ruby Orifice	003788-XX TL-003003-XX
1-11462D-XXX	Diamond Orifice	D-5071-XX TL-003004-XX



-XXX indicates the availability of multiple sizes. Call us or visit AccuStream.com for details.

Orifices

Mixing tubes

Cutting heads

Nozzle tubes

On/off valves

Pump parts

Mixing tubes (nozzles)

.281 ROCTEC® 100 mixing tubes

AccuStream #	Description	Replaces
12779-020-30	.281 Mixing Tube, .020 in. × 3.00 in.	012680-20-30
12779-030-30	.281 Mixing Tube, .030 in. × 3.00 in.	012680-30-30
12779-030-35	.281 Mixing Tube, .030 in. × 3.50 in.	012680-30-35
12779-030-40	.281 Mixing Tube, .030 in. × 4.00 in.	012680-30-40
12779-035-30	.281 Mixing Tube, .035 in. × 3.00 in.	012680-35-30
12779-035-40	.281 Mixing Tube, .035 in. × 4.00 in.	012680-35-40
12779-040-20	.281 Mixing Tube, .040 in. × 2.00 in.	012680-40-20
12779-040-30	.281 Mixing Tube, .040 in. × 3.00 in.	012680-40-30
12779-040-35	.281 Mixing Tube, .040 in. × 3.50 in.	012680-40-35
12779-040-40	.281 Mixing Tube, .040 in. × 4.00 in.	012680-40-40
12779-045-30	.281 Mixing Tube, .045 in. × 3.00 in.	012680-45-30
12779-050-30	.281 Mixing Tube, .050 in. × 3.00 in.	012680-50-30
12779-050-35	.281 Mixing Tube, .050 in. × 3.50 in.	012680-50-35

Interchangeable with DiaLine

.281 ROCTEC® 100 mixing tubes with performance locating rings

AccuStream #	Description	Replaces
12779-030-30R	.281 Mixing Tube, .030 in. × 3.00 in.	014214-30-30
12779-030-40R	.281 Mixing Tube, .030 in. × 4.00 in.	014214-30-40
12779-035-40R	.281 Mixing Tube, .035 in. × 4.00 in.	014214-35-40
12779-040-30R	.281 Mixing Tube, .040 in. × 3.00 in.	014214-40-30
12779-040-40R	.281 Mixing Tube, .040 in. × 4.00 in.	014214-40-40

Not interchangeable with DiaLine

.281 ROCTEC® 500 mixing tubes

AccuStream #	Description	Replaces
11277-015-25	.281 Mixing Tube, .015 in. × 2.50 in.	010460-15-25
11277-020-20	.281 Mixing Tube, .020 in. × 2.00 in.	010460-20-20
11277-030-30	.281 Mixing Tube, .030 in. × 3.00 in.	010460-30-30
11277-030-40	.281 Mixing Tube, .030 in. × 4.00 in.	010460-30-40
11277-035-40	.281 Mixing Tube, .035 in. × 4.00 in.	010460-35-40
11277-040-30	.281 Mixing Tube, .040 in. × 3.00 in.	010460-40-30
11277-040-40	.281 Mixing Tube, .040 in. × 4.00 in.	010460-40-40
11277-050-30	.281 Mixing Tube, .050 in. × 3.00 in.	010460-50-30

Interchangeable with DiaLine

.281 ROCTEC® 500 mixing tubes with performance locating rings

AccuStream #	Description	Replaces
11277-030-30R	.281 Mixing Tube, .030 in. × 3.00 in.	014194-30-30
11277-030-40R	.281 Mixing Tube, .030 in. × 4.00 in.	014194-30-40
11277-040-30R	.281 Mixing Tube, .040 in. × 3.00 in.	014194-40-30
11277-040-40R	.281 Mixing Tube, .040 in. × 4.00 in.	014194-40-40

Not interchangeable with Dialine

Orifices

Mixing tubes

Cutting heads

Nozzle tubes








On/off valves

Pump parts

Cutting heads


PASER® 3 cutting heads

Replacement parts








AccuStream #	Description	Replaces	
1-11465	Abrasive Nozzle Clamp, 60K, PASER® 3	009939-1	
1-12765	Mixing Chamber, Single-inlet, 60K, PASER® 3 Use with 11465 Abrasive Nozzle Clamp and 11357 Retainer Collet.	—	
1-12249	Mixing Chamber, Dual-inlet, 60K, PASER® 3 Use with 11465 Abrasive Nozzle Clamp and 11357 Retainer Collet.	009940-2 TL-002005-1	
1-11357	Retainer Collet, PASER® 3	009941-1	
1-12894	Rubber Bumper, 60K, PASER® 3 Use with the abrasive metering valve.	A-111073	
1-13991	On/off Mounting Collar, 60K, PASER® 3	006144-1	
1-14495	Abrasive Inlet Cap	A-111080	

PASER® 4 cutting heads

Assemblies

AccuStream #	Description	Replaces	
1-14525	Cutting Head Assembly, PASER® 4	041136-1	

Replacement parts

AccuStream #	Description	Replaces	
1-14467	Mixing Tube Spacer, PASER® 4	712265-1	
1-14466	Precision Collet, PASER® 4	A-23161-8	
1-14464	Knurled Nut, New Style, PASER® 4	711589-1	
1-14468	Mixing Chamber, PASER® 4	041138-1	
1-14465	Blast Disk, New Style, PASER® 4	711933-1	
1-14469	V-ring Seal, PASER® 4	A-22752-11	
1-14495	Abrasive Inlet Cap	A-111080	

Orifices

Mixing tubes

Cutting heads

Nozzle tubes


On/off valves

Pump parts










Cutting heads

DiaLine cutting heads

Assemblies

AccuStream #	Description	Replaces	
1-12905	DiaLine Cutting Head Assembly, Clamp The clamp DiaLine is a cutting head upgrade.		

Replacement parts

AccuStream #	Description	Replaces	
1-12884	DiaLine Nozzle Nut, Clamp Style	—	
1-11357	Retainer Collet	009941-1	
1-12747	DiaLine Carbide Mixing Chamber	—	
1-12752	DiaLine Inlet Connector, 3/8 in.	—	
1-11679-012	DiaLine Inlet O-ring, -012	—	
1-11679-216	DiaLine O-ring, -216	—	
1-12836	DiaLine Set Screw	—	
1-14495	Abrasive Inlet Cap	A-11080	
1-12860	Dialine Nozzle Body, Clamp, 4.275 in.	—	

Orifices

Mixing tubes

Cutting heads












Nozzle tubes

On/off valves




Pump parts

Nozzle tubes (nozzle bodies)

Replacement parts

AccuStream #	Description	Replaces	
1-14164	Mini Precision Nozzle Body, 4.00 in.	017257-1	
1-13431	Nozzle Body, 4.00 in. Use with 94K cutting heads.	019519-1	
1-11358-4	Adapter, DiaLine to Flow® Short nozzle body, 4.330 in.	001995-1 TL-002001-1	
1-14463	PASER® 4 Nozzle Body, 4.330 in. Use with 60K or 94K cutting heads.	041137-1	
1-14222	Swivel Adapter Assembly, 4.330 in.	—	
1-11490	Nozzle Body, New Style, 4.332 in.	014196-1	
1-11389	Insta 2 Nozzle Body, 4.342 in.	003828-1	
1-14158	Low-mass Nozzle Body, 5.490 in. Use with 13406 Low-mass Nozzle Orifice Retainer.	006145-1 TL-002003-1	
1-14448	H2O Nozzle Body, 5.505 in. Use with 14516 H2O Orifice Retainer.	100037-1	
1-11463	Extended-length Low-mass Nozzle Body, 7.697 in. Use with 13406 Low-mass Nozzle Orifice Retainer.	—	
1-11358-8	Long Nozzle Body, 8.110 in.	001995-2 TL-002001-2	

Nozzle orifice retainers

AccuStream #	Description	Replaces	
1-11299	Nozzle Nut Retainer, PASER® 3	B-1041-1 TL-002002-1	
1-13406	Low-mass Nozzle Orifice Retainer Use with 11463 Extended Low-mass Nozzle Body and 14158 Low-mass Nozzle Body.	006146-1	
1-14516	H2O Orifice Retainer Use with 14448 H2O Nozzle Body.	B-5330-1	

Looking for orifices? See page 24.

Orifices

Mixing tubes

Cutting heads

Nozzle tubes



On/off valves

Pump parts


On/off valves

Insta 1 on/off valves

Repair kits








AccuStream #	Description	Replaces	
1-11146	Insta 1 and H2O On/off Valve Repair Kit Use with 11142 Insta 1 Valve Seal and 13380 H2O Pneumatic Valve Body. Includes poppet seat, seal backup ring, valve seal, on/off valve O-ring, poppet stem	001959-1 302001-1 TL-004001-1	
1-13685	Insta 1 High-cycle On/off Valve Repair Kit Includes poppet seat, seal backup ring, valve seal, on/off valve O-ring, high-cycle poppet stem	—	

Assemblies

AccuStream #	Description	Replaces	
1-14373-1-1	Insta 1 On/off Valve Assembly Includes nozzle body		
1-14373-1-2	Insta 1 On/off Valve Assembly Includes swivel adapter assembly		
1-14373-1-3	Insta 1 On/off Valve Assembly Includes low-mass nozzle body		
1-14373-1-4	Insta 1 On/off Valve Assembly Includes new-style nozzle body		

Looking for swivel adapters? See page 76.

Replacement parts

AccuStream #	Description	Replaces	
1-11144	Insta 1 Valve Body	006143-1 TL-004006-1	
1-11140	Insta 1 Nozzle Poppet Stem	006934-1 TL-004002-1	
1-11141	Insta 1 and Insta 2 Poppet Seat	006933-1 TL-004003-1	
1-11142	Insta 1 Valve Seal	001328-1 TL-004004-1	
1-11143	Insta 1 Bronze Backup Ring	001337-1 TL-004005-1	
1-11145	O-ring, -014	A-0275-014	
1-11218	Insta 1 Valve Screw (Retainer Cap)	001112-1 TL-004007-1	
1-12128	Insta 1 Air Actuator, Normally Closed	001323-1 TL-004018-1	

Orifices

Mixing tubes

Cutting heads

Nozzle tubes



On/off valves

Pump parts


On/off valves

Insta 2 on/off valves

Repair kits












AccuStream #	Description	Replaces	
1-11279	Insta 2 On/off Valve Repair Kit Includes poppet, backup ring, poppet seat, on/off valve O-ring, on/off seal	010200-1 TL-004010-1	
1-13687	Insta 2 High-cycle On/off Valve Repair Kit Includes poppet, backup ring, poppet seat, O-ring seals	—	

Assemblies

AccuStream #	Description	Replaces	
1-14373-2-1	Insta 2 On/off Valve Assembly Includes nozzle body		
1-14373-2-2	Insta 2 On/off Valve Assembly Includes swivel adapter		
1-14373-2-3	Insta 2 On/off Valve Assembly Includes low-mass nozzle body		
1-14373-2-4	Insta 2 On/off Valve Assembly Use with 11463 Extended-length Low-mass Nozzle Body and 14158 Low-mass Nozzle Body.		

Looking for swivel adapters? See page 76.

Replacement parts

AccuStream #	Description	Replaces	
1-11272	Insta 2 Valve Body	010104-1 TL-004016-1	
1-11387	Insta 2 Nozzle Poppet Stem	—	
1-11275	Insta 2 Poppet Needle	010105-1 TL-004011-1	
1-13686	Insta 2 Poppet Needle, High-cycle	—	
1-11141	Insta 1 and Insta 2 Poppet Seat	006933-1 TL-004003-1	
1-11276	Insta 2 Valve Seal	003831-1 TL-004015-1	
1-11274	Insta 2 Bronze Backup Ring	003832-1 TL-004012-1	
1-11273	Insta 2 Bushing Stem	003838-1 TL-004013-1	
1-11145	O-ring, -014	A-0275-014	
1-13049	Insta 2 Retainer	004096-1	
1-12129	Insta 2 Air Actuator, Normally Closed	003840-1 TL-004017-1	

Orifices

Mixing tubes

Cutting heads

Nozzle tubes

On/off valves

Pump parts








On/off valves

Mini on/off valves

Repair kits

AccuStream #	Description	Replaces	
1-12544	Mini On/off Valve Repair Kit Includes poppet, poppet seat, dynamic seal, backup ring, bushing, O-ring	711484-1	

Replacement parts

AccuStream #	Description	Replaces	
1-12538	Mini Valve Body	710866-1	
1-12539	Mini Poppet	710822-1	
1-12543	Mini Poppet Seat	710823-1	
1-12541	Mini Dynamic Seal	710820-1	
1-12540	Mini Bronze Backup Ring	710819-1	
1-12542	Mini Bronze Bushing	710821-1	
1-11145	O-ring, -014	A-0275-014	

Want to upgrade your cutting head?

The DiaLine Cutting Head takes stream alignment to the next level and backs it up with a 600-hour diamond-life warranty.

Choose a cutting head assembly from page 10 and an on/off valve from page 16. Be sure to include a thimble filter from the table on page 6 to protect your new orifice and its warranty.

Call us for assistance, we are here to help you.

Orifices

Mixing tubes

Cutting heads

Nozzle tubes


On/off valves

Pump parts

On/off valves

Universal on/off valves (60K and 94K)







Repair kits

AccuStream #	Description	Replaces	
1-13429	Universal On/off Valve Repair Kit Includes 13430 Universal On/off Valve Seal Assembly, needle guide, needle, seat, O-ring	014988-1	

Assemblies

AccuStream #	Description	Replaces	
1-14540	Universal Actuator Assembly	014559-1	

Replacement parts

AccuStream #	Description	Replaces	
1-13424	Universal On/off Valve Body	014554-1	
1-13425	Universal On/off Valve Needle Guide Backup ring	014555-1	
1-13430	Universal On/off Valve Seal Assembly (94K)	014556-1	
1-13426	Universal On/off Valve Needle Poppet	014557-1	
1-13427	Universal On/off Valve Poppet Seat	014558-1	
1-11679-014	O-ring, -014	A-0275-014	

Orifices

Mixing tubes

Cutting heads

Nozzle tubes


On/off valves

Pump parts





On/off valves

H2O high-performance on/off valve

Repair kits

AccuStream #	Description	Replaces	
1-11146	Insta 1 and H2O On/off Valve Repair Kit Includes poppet seat, seal backup ring, valve seal, on/off valve, poppet stem, O-ring	001959-1 302001-1 TL-004001-1	

Replacement parts

AccuStream #	Description	Replaces	
1-13380	H2O Pneumatic Valve Body	100048-1	
1-13685	Insta 1 High-cycle On/off Valve Repair Kit Includes poppet seat, seal backup ring, valve seal, on/off valve O-ring, high-cycle poppet stem	—	
1-14445	Insta Hybrid Air Actuator, High-performance, Normally Closed	301006-1	
1-13716	Retainer Insert Assembly, H2O High-performance	301008-1	

Orifices

Mixing tubes

Cutting heads






Nozzle tubes

On/off valves






Pump parts

Pump parts



Repair kits: Seals

AccuStream #	Description	Replaces	
1-11135	Seal Repair Kit with Bronze Backups Includes hoops, seals, bronze backups	001198-1 TL-001001-1	
1-11467	Seal Repair Kit without Backups Includes hoops, seals	—	
1-11281	Low-pressure Seal Repair Kit, ESL Includes spring-energized rod seal	010641-1 TL-001006-1	
1-11286	Low-pressure Seal Repair Kit Does not include spring-energized rod seal	B-1163-1 TL-001021-1	
1-14523	Low-pressure Seal Repair Kit (94K)	013157-1	

Repair kits: Check valves

AccuStream #	Description	Replaces	
1-11282	Check Valve Repair Kit Includes outlet poppet, inlet poppet, insert, inlet poppet housing, retaining screw, poppet spring, O-rings	015866-1 010642-1 TL-001004-1	
1-12656	Check Valve Repair Kit, Hybrid Flow®/KMT®, Calypso; includes inlet poppet, insert, inlet poppet housing, retaining screw, high-pressure poppet guide, check valve poppet, poppet compression spring, O-ring	302003-2	
1-14522	Check Valve Repair Kit (94K) Includes inlet poppet, poppet housing, retaining screw, poppet spring, high-pressure poppet, poppet seat, O-ring	012035-1	
1-14519	Inlet Repair Kit (94K) Includes inlet poppet, poppet housing, retaining screw	014884-1	
1-14521	Outlet Repair Kit (94K) Includes high-pressure poppet, poppet seat, poppet spring	014885-1	

Repair kits: Bleed-down and blow-down valves

AccuStream #	Description	Replaces	
1-11331	Bleed-down Valve Repair Kit Includes seat, needle, bushing, high-pressure seal, seal hoop, oil seal, backup, O-rings	004694-1 TL-001009-1	
1-14524	Blow-down Repair Kit, 90K Includes poppet, bearings, backup rings, seat, seal, O-rings	015084-1	

Orifices

Mixing tubes

Cutting heads





Nozzle tubes

On/off valves

Pump parts

Pump parts

Replacement parts

AccuStream #	Description	Replaces	
1-11570	Short Block Intensifier Assembly	010558-3	
1-12776	Short Block Intensifier Assembly Includes 12349 HyLoad Hydraulic Piston	—	
1-12362	Short Block Intensifier Assembly Includes 12349 HyLoad Hydraulic Piston, and Hybrid check valves	—	
1-12246	Long Block Intensifier Assembly, Performance Electronic negative-positive-negative shifting	—	
1-13846	Long Block Intensifier Assembly, Performance Electronic positive-negative-positive shifting	—	
1-11595	Attenuator Assembly, 2-liter Installation drawing available on request	—	
1-12280	Attenuator Assembly, 1-liter Installation drawing available on request	—	
1-12340	Spring-energized Rod Seal	A-11275	
1-11076	Seal Assembly Includes O-ring	004406-1 TL-001015-1	
1-11077	Hoop Use with 11076 Seal.	004407-1 TL-001014-1	
1-11134	Bronze Seal Backup	B-1465-1 TL-001019-1	
1-11365	Backup Seal Sleeve	B-1002-2 TL-001018-1	
1-11468	Spacer Oil Seal	010276-1 TL-001027-1	
1-11421	Check Valve Assembly	010559-3	
1-11115	Check Valve Body	004383-3 TL-001003-3	
1-11231	Outlet Body	C-1313-1 TL-001007-1	
1-11228	Outlet Poppet	005917-1 TL-001016-1	

Orifices

Mixing tubes

Cutting heads

















Nozzle tubes

On/off valves

Pump parts

Pump parts

Replacement parts

AccuStream #	Description	Replaces	
1-14178	Poppet Seat	—	
1-11234	Poppet Spring	A-1606	
1-11233	Retaining Screw	004380-1 TL-001026-1	
1-12363	Output Adapter, Hybrid <small>Flow®/KMT®, Calypso</small>	100022-2 TL-001024-1	
1-11229	Inlet Poppet	015384-1 010011-1	
1-11232	Inlet Poppet Housing	010564-1 TL-001022-1	
1-11230	Insert	004382-1 TL-001017-1	
1-11679-125	Check Valve O-ring, -125	A-0275-125	
1-11679-131	Check Valve O-ring (94K)	A-0275-131	
1-11480	Bleed-down Valve Assembly	C-5841-1 TL-001011-1	
1-11594	Bleed-down Valve Body	001822-1 C-1000-1 TL-001033-1	
1-11321	Bleed-down Valve Seal	—	
1-11742	Bleed-down Valve Output Adapter	B-5975-1	
1-11780	High-pressure Collar	B-5078-1	
1-11680-114	Backup Ring, -114	—	
1-11778	Bleed-down Valve Piston	B-8428-1	
1-11322	Bleed-down Valve Stem <small>Needle</small>	—	
1-11323	Bleed-down Valve Seal Hoop	—	
1-11324	Bleed-down Valve Stem Bushing	—	

Orifices

Mixing tubes

Cutting heads




















Nozzle tubes

On/off valves

Pump parts

Pump parts

Replacement parts

AccuStream #	Description	Replaces	
1-11325	Bleed-down Valve High-pressure Seat	—	
1-11359	Bleed-down Valve Oil Seal	—	
1-11679-114	O-ring, -114	—	
1-12880-908	O-ring, SAE Fitting	—	
1-12880-912	O-ring, SAE Fitting	—	
1-11394	Adapter, 3/8-in. Male to 1/4-in. Female	—	
1-11743	Bleed-down Valve Flow® Reducer	B-8426-1	
1-11779	Bleed-down Valve Housing Body	B-8427-1	
1-11796	Hydraulic Adapter, Male to Female	—	
1-11117	High-pressure Cylinder	007038-3 TL-001002-3	
1-11284	Low-pressure Cylinder with Chrome-plated ID Use with AccuStream 11438 Hydraulic Piston.	C-1000-1 TL-001012-1	
1-11438	Hydraulic Piston	007026-1 TL-001013-1	
1-12599	Low-pressure Cylinder ID is not chrome plated. Use with AccuStream 12349 HyLoad Hydraulic Piston.	—	
1-12349	HyLoad Hydraulic Piston Includes capped T piston seal, wear rings, hydraulic piston	TL-001013-1	
1-12386	Piston Seal Kit Use with 12349 HyLoad Hydraulic Piston.	B-1002-2 TL-001018-1	
1-11422	Retrofit Kit to ESL Includes 11309 Ceramic Plungers, 11135 Seal Repair Kit, 11282 Check Valve Repair Kits	010281-1	
1-11309	Ceramic Plunger, .875 in. (60K & 94K)	010253-1 TL-001005-1	
1-11446	Piston Assembly Includes piston, ceramic plungers, plunger retainers, snap rings, T-seals	010561-1	
1-11437	Plunger Retainer	007029-1	

Orifices

Mixing tubes

Cutting heads



















Nozzle tubes

On/off valves

Pump parts

Pump parts

Replacement parts

AccuStream #	Description	Replaces	
1-12364	Wear Ring	—	
1-12371	Piston Snap Ring	A-0270-250	
1-11680-240	Backup Ring, -240	—	
1-12378	Actuator Assembly, Electronic Shift	B-8346-1	
1-12357	Sensor Assembly, Electronic Shift Negative-positive-negative shifting, normally open	011275-1	
1-12821	Sensor Assembly, Electronic Shift Positive-negative-positive shifting, normally open	B-8345-2	
1-11733	Electrical Shift and Pilot Assembly 24-volt Rexroth	A-18862	
1-12684	Electrical Shift Valve and Pilot Assembly 24-volt Vickers	C-2743-1	
1-11736	Pilot Valve, 24-volt Electrical	A-10544	
1-11469	Firing Pin, Mechanical Shift	002226-1	
1-11470	Firing Pin, Electrical Shift	B-1702-1	
1-12724	Actuating Plunger	B-1007-1	
1-11420	High-pressure End Cap	321276-1 TL-001010-1	
1-11432	End Bell, Right	007303-1 TL-001008-1	
1-11433	End Bell, Left	007303-2 TL-001008-2	
1-12974	Guide Bushing, End Bell	B-1040-2	
1-11471	Tie Rod	TL-001005-1	
1-11472	Hex Nut	A-1000	
1-13006	Hydraulic Manifold, Top-mount	—	

Orifices

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Cutting heads







Nozzle tubes

On/off valves




Pump parts

Pump parts

Replacement parts

AccuStream #	Description	Replaces	
1-12177	Hydraulic Manifold, Side-mount Includes relief valve	013403-1	
1-12801	Mechanical Shift Guide Cable, Left	C-5462-1	
1-12802	Mechanical Shift Guide Cable, Right	C-5461-1	
1-12725	Shifting Split Pin	B-1611-1	
1-12791	Compression Spring, Inner	A-1713	
1-12792	Compression Spring, Outer	A-1012	

Filters

AccuStream #	Description	Replaces	
1-11402	Water Filter Cartridge, 0.45 micron, 10 in.	A-1449	
1-11390	Water Filter Cartridge, 1.0 micron, 10 in.	A-1555	
1-12738	Hydraulic Filter	A-5480	

Orifices

Mixing tubes

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On/off valves

Pump parts

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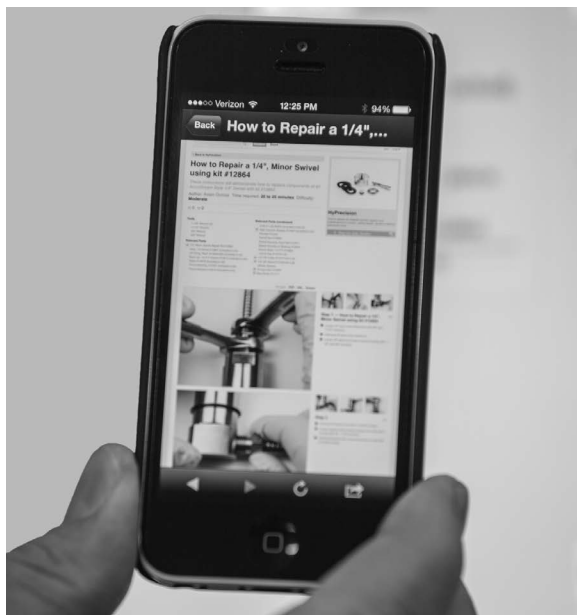
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When problems arise, the Hypertherm Waterjet Mobile Assistant (available for iOS and Android) is on the spot with the information you need to get your waterjet working as quickly as possible. Use a QR code reader or visit assist.hypertherm.com to see how the Hypertherm Waterjet Mobile Assistant makes finding the right part guide instantaneous and error proof.



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- Tools required
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- Repair instructions



We ship faster so you're back to work sooner

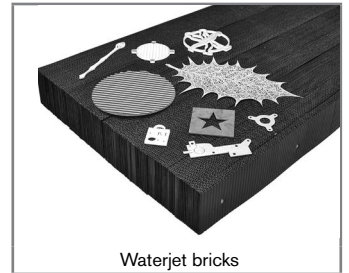
Our goal as owners is to ensure that you get what you need when you need it.

Place your order by 2:00 PM CST and we will ship it the same day.

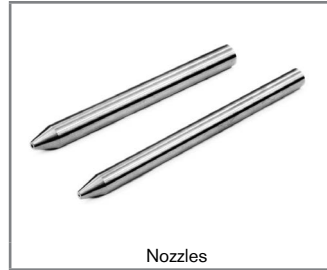
From our job shop roots, we know how it feels to be down, so we will do everything we can to keep you cutting. For orders placed after 2:00 PM CST, we will make every attempt to ship the same day, if you need it.



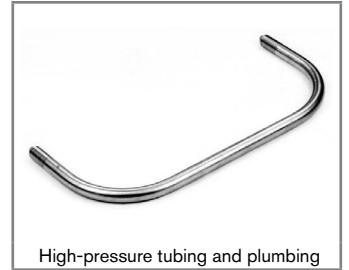
Orifices



Waterjet bricks



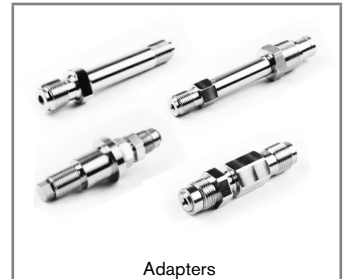
Nozzles



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