

Service Notice Number: 20191007-3**Date:** October 7, 2019**To:** Lincoln Authorized Service Facilities, End Users**Potential for Leaking Coolant in FLEXCOOL 35 and FLEXSTART****Covered Product:**

Machine	Code #	Serial Range
FLEXCOOL 35	12748	U1180204672 - U1190707352
FLEXSTART	12749	U1180201757 - U1190705899

Issue:

Potential for coolant leaking at connection points.

Recommended Action:

If the machine is in the covered product serial range perform the following:

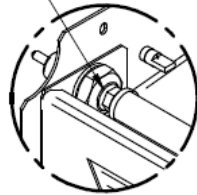
- Remove the panels from the outside of the machine.
- Check for the presence of pipe joint compound and the tightness of all fittings in all of the locations shown in the FLEXCOOL 35 INSPECTION DIAGRAMS or FLEXSTART INSPECTION DIAGRAMS below.
- Please contact Lincoln Electric at Service@LincolnElectric.com with the subject line "Flexcut Coolant 20191007-3" if you have any questions or need assistance.

Repair:

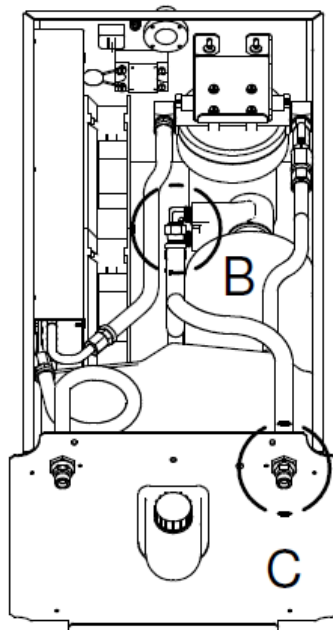
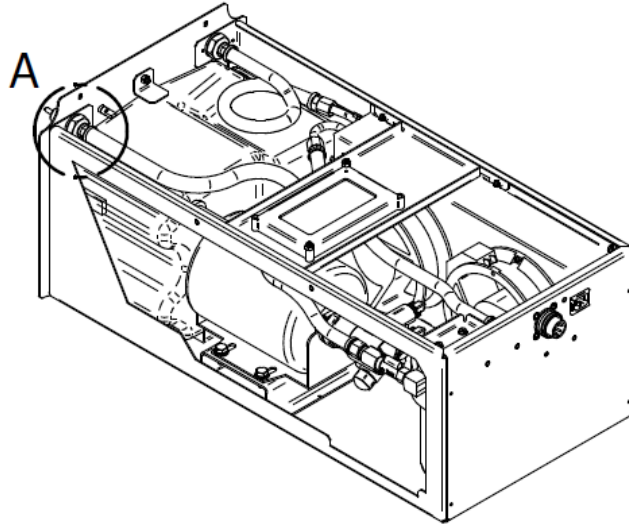
- If connections that are found to be loose or lacking sufficient pipe joint compound, drain coolant following instructions found in the the "Periodic Maintenance" section of the Instruction Manual, and then disconnect the connections.
- Apply pipe joint compound in the locations shown in the FLEXCOOL 35 INSPECTION DIAGRAMS and FLEXSTART INSPECTION DIAGRAMS below.
- The connections that were disconnected should be tightened using a wrench and then the pipe joint compound allowed to dry before adding coolant back to the system.

FLEXCOOL 35 INSPECTION DIAGRAMS

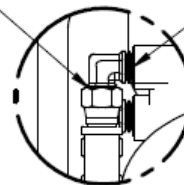
PIPE JOINT
COMPOUND



DETAIL A

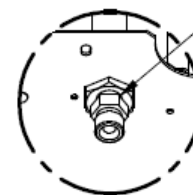


NO JOINT
COMPOUND



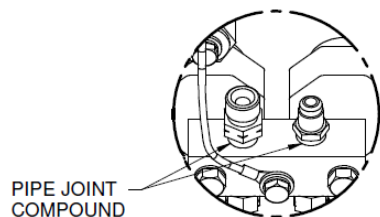
DETAIL B

PIPE JOINT
COMPOUND

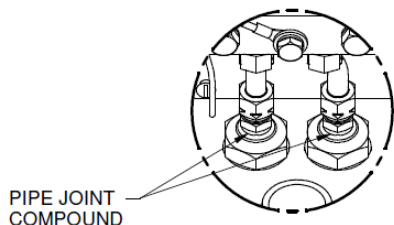


DETAIL C

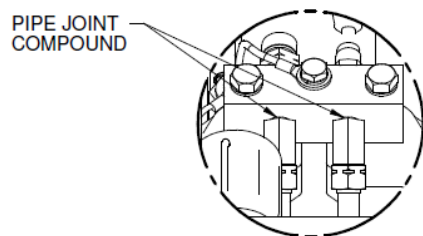
FLEXSTART INSPECTION DIAGRAMS



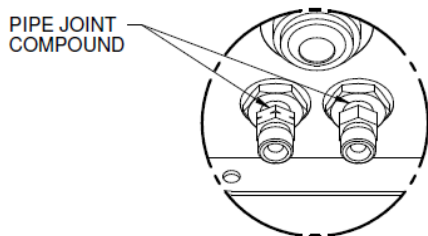
DETAIL D



DETAIL E



DETAIL F



DETAIL G

