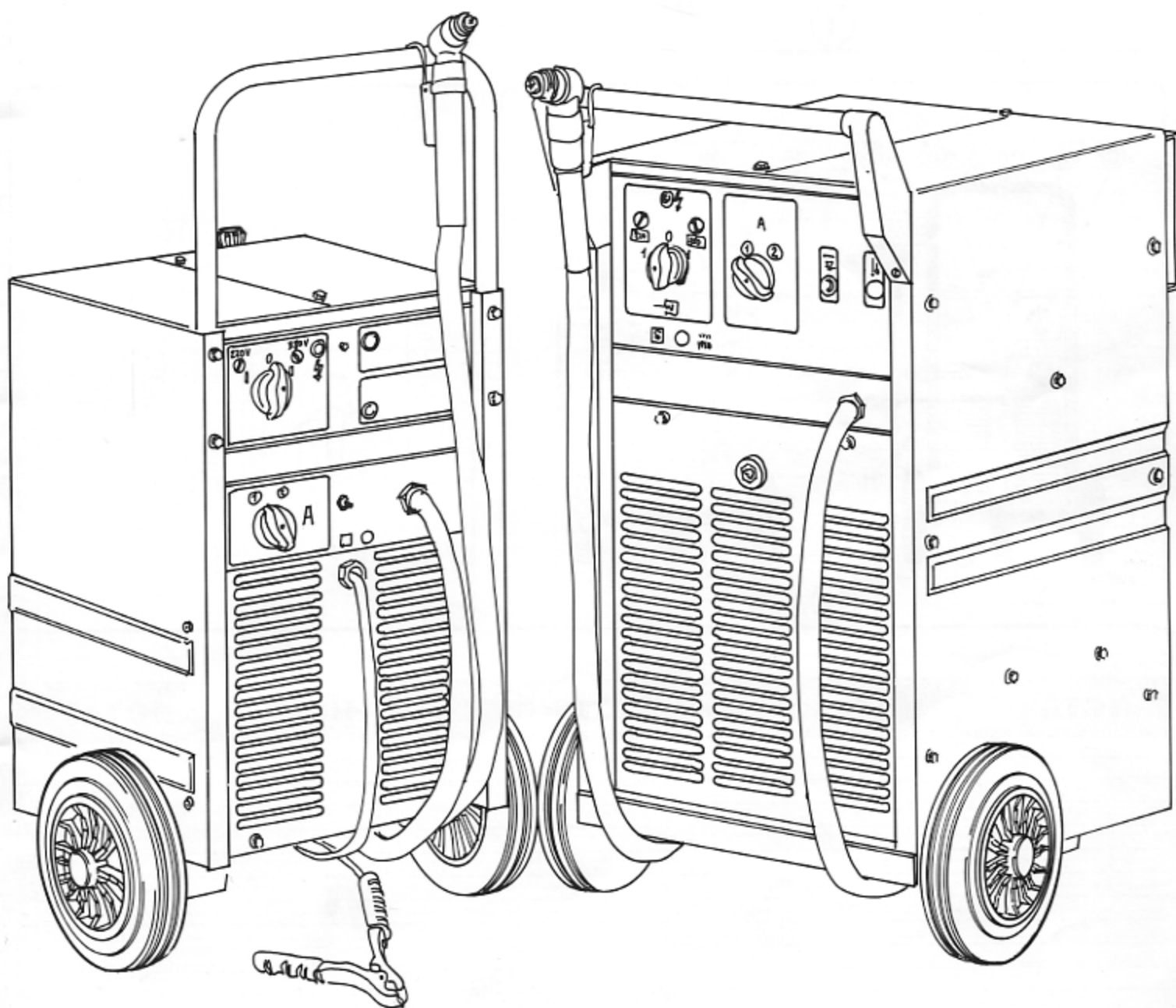
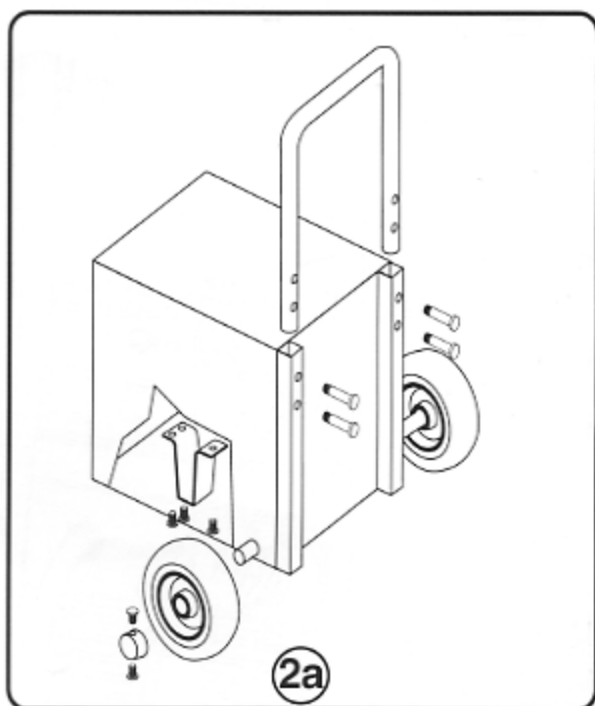
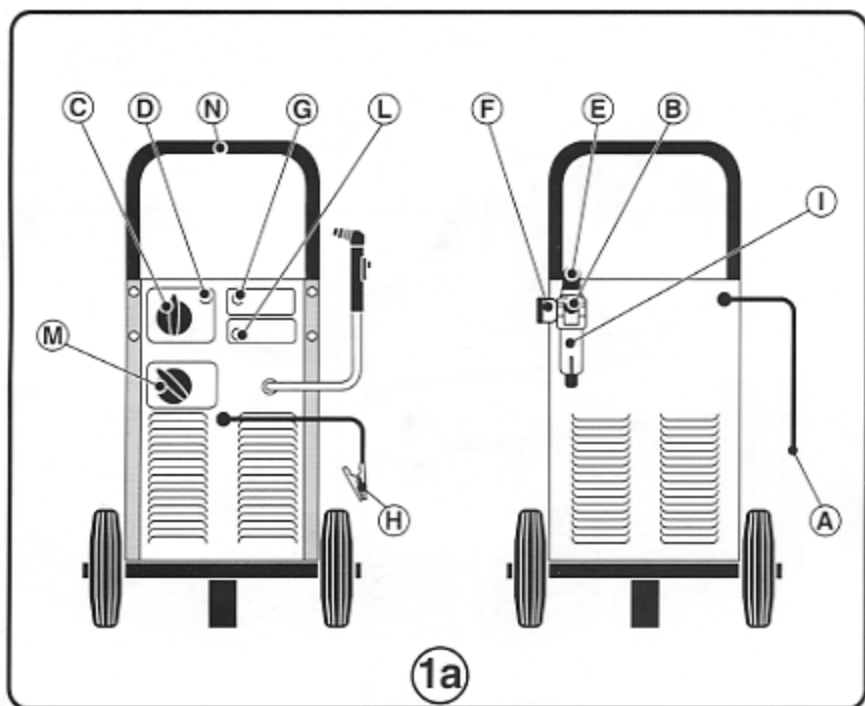
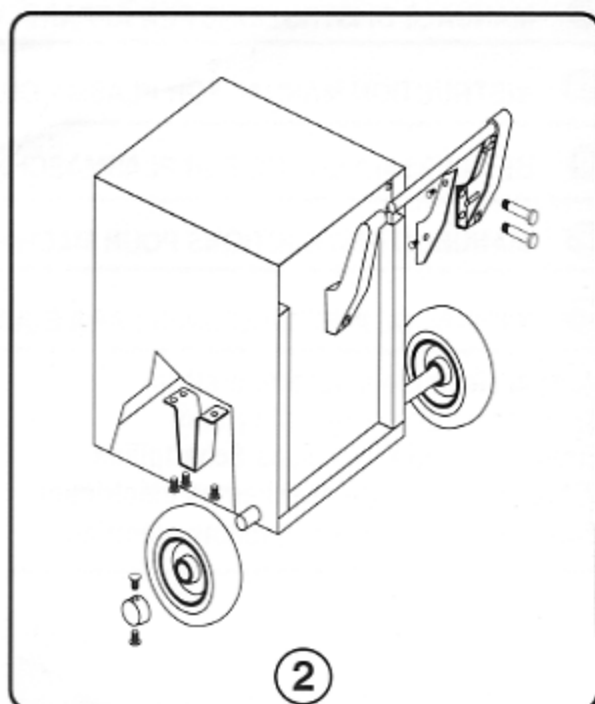
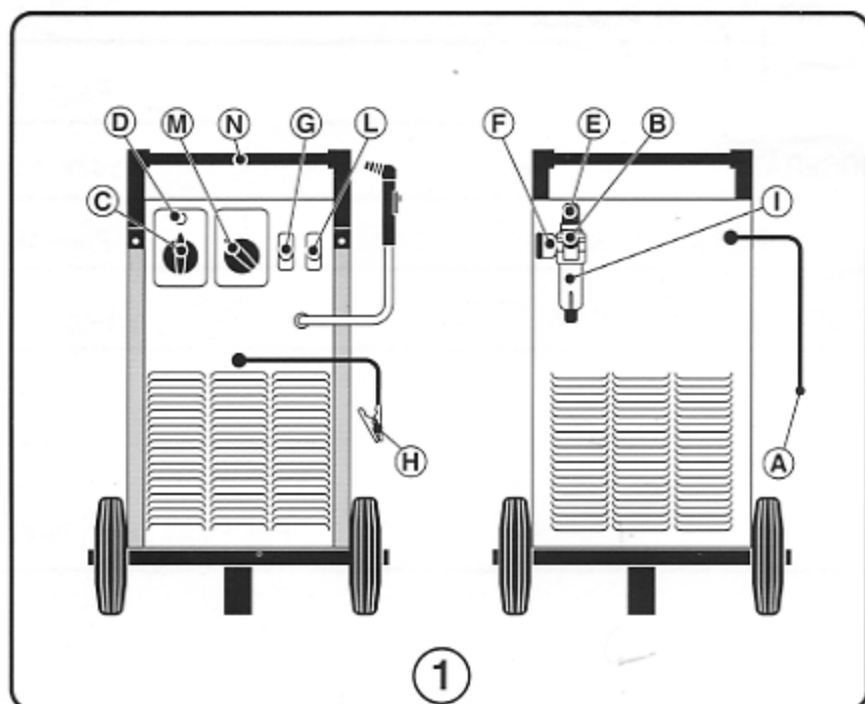


I	MANUALE DI ISTRUZIONE PER APPARECCHIO DI TAGLIO AL PLASMA	Pag. 4
GB	INSTRUCTION MANUAL FOR PLASMA CUTTER	Page 9
D	BETRIEBSANLEITUNG FÜR PLASMASCHNEIDGERÄT	Seite. 13
F	MANUEL D'INSTRUCTIONS POUR MACHINE A COUPER AU PLASMA	Page 18
E	MANUAL DE INSTRUCCIONES PARA EQUIPO DE CORTE EN PLASMA	Pag. 23

Parti di ricambio e schemi elettrici
 Spare parts and wiring diagrams
 Ersatzteile und elektrische Schaltpläne
 Pièces de rechange et schémas électriques
 Piezas de repuesto y esquemas eléctricos

Pag. Pages Seiten 28+41





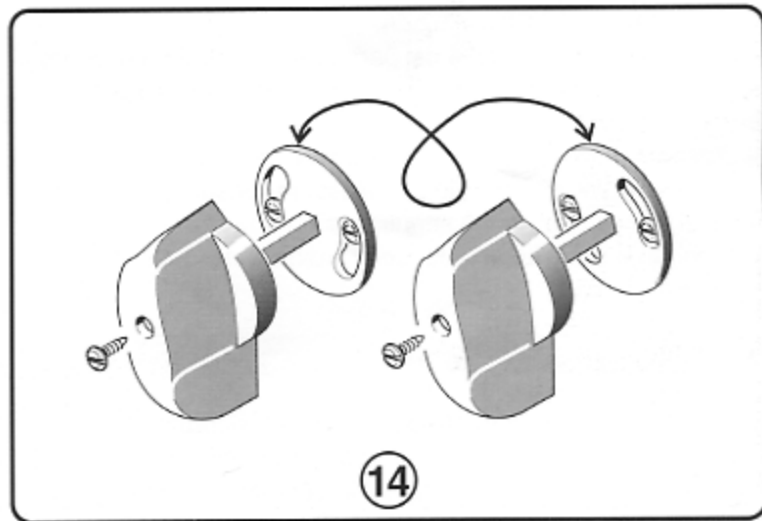
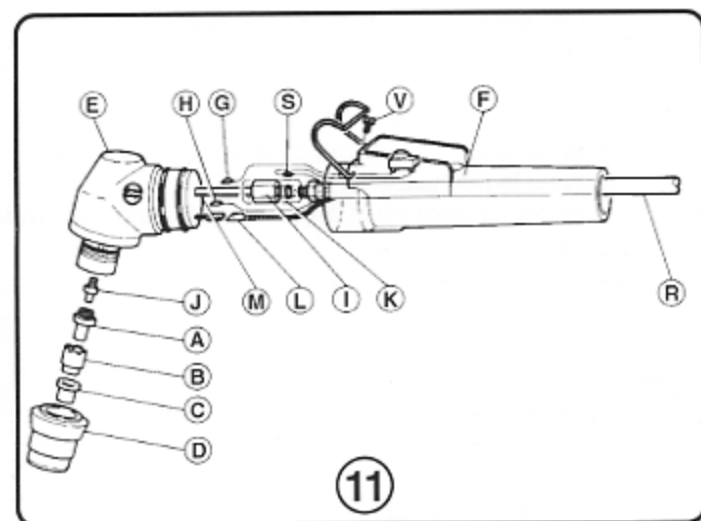
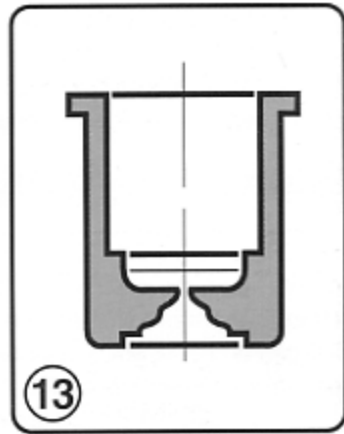
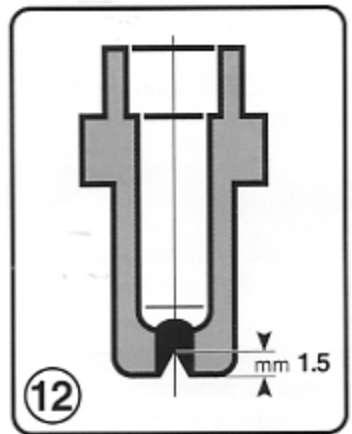
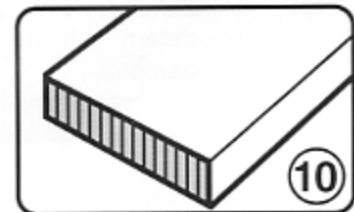
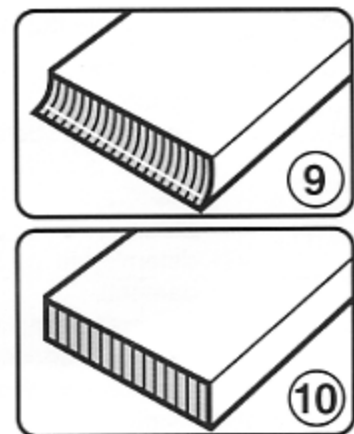
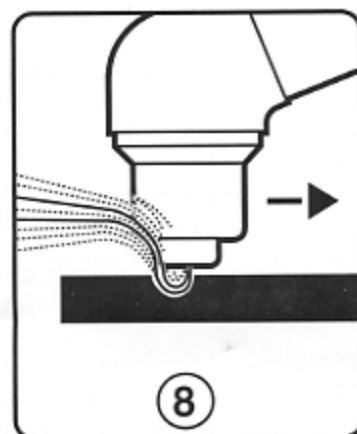
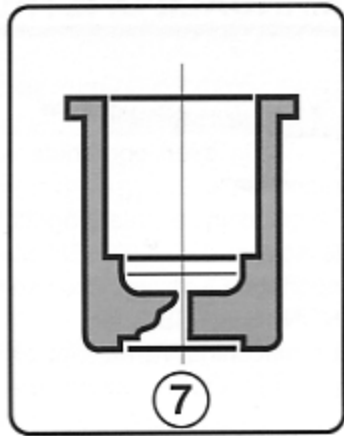
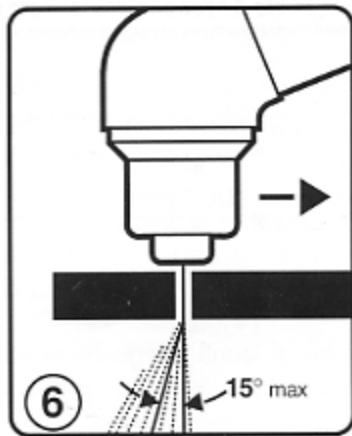
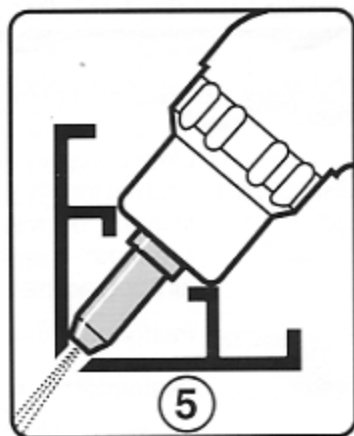
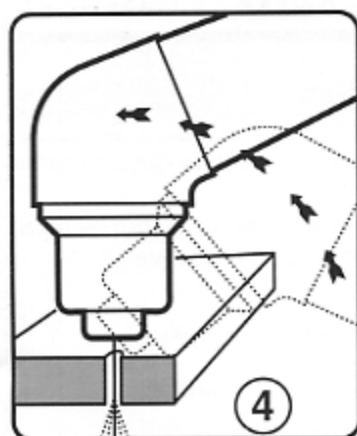
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INSTRUCTION MANUAL FOR PLASMA CUTTER



Read this manual carefully before using the machine. Failure to respect the rules described herein shall exempt the manufacturer from any liability.

The machine has been designed, built and protected (per standards: IEC 974.1 - EN 60974.1) for the functions described below. Any other use not explicitly included shall be considered FORBIDDEN.

The machine must be used in sufficiently ventilated rooms, in the absence of dust and moisture; in any case, where there is no risk of fire, explosion, or flooding.

The machine must be started, used and serviced by qualified personnel. Always follow current safety regulations.

The manufacturer shall not be held responsible for any damage caused by incorrect use of the machine.

INTRODUCTION

THIS DEVICE must be used exclusively for cutting on any electrically conductive material (metals and alloys).

PLASMA cutting takes place due to the high temperature generated by a concentrated electric arc, and thus highly dangerous situations may arise; it is therefore essential to pay the utmost attention to the chapter entitled SAFETY PRECAUTIONS.

The symbols next to certain paragraphs indicate points requiring extra attention, practical advice or simple information.

This manual must be kept carefully in a place familiar to everyone involved in using the machine. It must be consulted whenever doubts arise and be kept for the entire life-span of the machine; it will also be used for ordering replacement parts.

SAFETY DEVICES

This unit is provided with the following safety devices:

Thermic: located on the power transformer windings to avoid overloads and signalled by indicator light G on (see picture 1 or 1a).

Pneumatic: located on the torch feed line to avoid insufficient air pressure and signalled by indicator light L (see picture 1 or 1a).

Electric: located on torch body to avoid dangerous voltages while replacing nozzle, diffuser, electrode or nozzle holder.


- Do not remove or short-circuit the unit safety devices.
- Only use original spares.
- Always replace any damaged part of the unit or torch with original material.
- Do not use any torches other than the original one.
- Do not let the unit work without covers. This would be dangerous for operator and for those who are surrounding the work area and would prevent the unit from cooling efficiently.

DESCRIPTION OF TECHNICAL SPECIFICATIONS

IEC 974.1 This machine is manufactured according to these

EN 60947.1 international standards.

N°. Machine Serial Number which must appear on requests or inquiries concerning the machine.

 Three-phase transformer-rectifier or

 Single-phase transformer-rectifier



Drooping characteristic.



Plasma Arc cutting.

TORCH TYPE

U0.

X.

Type of torch that may be used with this device. Secondary no-load voltage (peak value).

Duty-Cycle Percentage

The duty-cycle is the number of minutes, expressed as a percentage, the machine can operate (arc on) within a ten minute period without overheating. The duty cycle varies according to the output current.

I2. Output cutting current

U2. Secondary voltage with cutting current I2

U1. Nominal supply voltage

3~50/60Hz Three-phase input supply at 50 or 60 Hz or

1~50/60Hz Single-phase input supply at 50 or 60 Hz

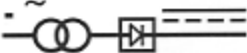





I1. Input Amps absorbed corresponding to different output levels (I2).

IP21. Machine case protection class.

The 1 in the second digit place means that this unit is not fit to work outdoors in the rain.



S

Fit to work in hazardous areas.

		N°			
		EN 60974-1			
 P.A.C. TORCH TYPE	 U₀ - V PEAK	- A / - V - - A / - V			
		X	- %	- %	
		I₂	- A	- A	
		U₂	- V	- V	
 					
- ~ 50 Hz	U₁	- V - V	I₁	- A - A	- A - A
PROTEZIONE TERMICA THERMAL PROTECTION PROTECTION THERMIQUE THERMISCH GESCHÜTZ PROTECCION TERMICA		IP 21 CL. H		VENTILAZIONE FORZATA FORCED VENTILATION VENTILE KÜHLART F VENTILACION FORZADA	

NOTE: This machine has also been designed to work in class 3 pollution areas (see IEC 664)

DESCRIPTION OF UNIT DEVICES (see picture 1)

- A) Feed cable
- B) Compressed air fitting (1/4" female gas thread)
- C) Mains switch
- D) Mains pilot light
- E) Air pressure reducing unit
- F) Gauge
- G) Light signalling thermostat is open 
- H) Work clamp
- I) Water trap
- L) Light signalling air pressure is not enough 
- M) Cutting power adjusting knob
- N) Handle (do not use for lifting up the machine)

ASSEMBLY AND ARRANGEMENT

Unpack the unit, fit wheels, stand and handle following the instructions of picture 2 or 2a. Place the unit in properly ventilated if possible undusty room making sure that the air inlet and outlet from cooling slots are not obstructed.

SETTING AT WORK

The unit must be installed by skilled personnel. All fittings must be in conformity with the existing rules and in full compliance with safety regulations.

Connect the air feed to fitting **B** making sure that pressure is 88PSI (6bar or 0.6 MPa) at least with a minimal capacity of 420 CFH (200 liters/min.).

Should air feed come from a pressure reducing unit of a compressor or of a centralized plant, the reducing unit should be adjusted at the highest output pressure which should not exceed 120 PSI (8bar or 0.8 MPa). Should air feed come from a compressed air bottle, this should be provided with a pressure regulator; **never connect compressed air bottles directly to the reducing unit! Pressure may exceed the reducing unit capacity and then explode!**

Check that the mains power supply matches that indicated on the front panel of the machine.

Select voltage by turning the disc located under the mains switch knob (see picture 14. except articles 939 and 932).

Connect supply cable **A**: the yellow-green wire of cable must be connected to an efficient earth plug of the system, the remaining wires should be connected to the feed line by means of the switch placed, if possible, close to the cutting area so as to switch the unit off quickly if necessary.

The magnetothermic switch capacity or of fuses in series with switch should be equal to the current I_1 absorbed by the unit.

Current I_1 absorbed is known by reading the technical specifications on the unit i.e. feed voltage U_1 available.

Any extensions should have adequate sections for current absorbed I_1 .

USE

Switch the unit on by turning knob **C** of the mains switch; this is shown by light **D** which is on.

By pressing for a second the torch button, the compressed air flow is opened. Check that, under this condition, the pressure shown on gauge **F** is about 75 PSI (0.45÷0.47 bar or MPa), otherwise adjust it by means of knob **E** of reducing unit, then lock this knob by pressing it down.

Connect work clamp **H** to the piece to be cut.

Welding circuit should not be deliberately placed in direct or indirect contact with protection wire if not in the workpiece.

If earthing is deliberately made on the workpiece by means of protection wire, the connection must be as direct as possible, with the wire having a section at least equal to the welding return current wire and connected to the piece being worked on, in the same place as the return wire, using the return wire terminal or a second earth terminal closeby.

All possible precautions must be taken in order to avoid stray currents.

Set the cutting current by means of the knob **M** (except art.932) Clean the work piece to ensure good electrical contact of the work clamp.

Do not connect work clamp to the material to be removed.

Press torch button to start pilot arc, if cutting does not start after 2 or 3 seconds, the pilot arc turns off and the button should

be pressed again to repeat the operation.

When possible, the torch should be pulled. Pulling is easier than pushing.

Keep torch in vertical position when cutting.

Once cutting is over and after releasing button, air continues to flow out of the torch for about 40 seconds so it enables torch to cool down. It is recommended not to turn the unit off before that time.

Should holes be drilled or should the piece be cut starting from its center, torch should be tilted and then slowly straighten to prevent molten metal from being spread on nozzle (see picture 4). This operation should be carried out with material thickness above 1/16" (2 mm). If you have to cut near angles or recesses (see picture 5) it is recommended to use extended electrodes and nozzles.

Should circular cut be done it is recommended to use caliper (supplied on request).

N.B. : Avoid keeping pilot arc uselessly on, in air to avoid electrode, diffuser and nozzle consumption.



When you have finished working, turn off the machine and hang the torch on the hook provided.

CUTTING TROUBLE

1) Insufficient penetration

This may be due to:

- high speed. Always make sure that arc thoroughly passes through the piece to be cut and that it is not tilted, when going forward, by a percentage above 10 ÷ 15° (see picture 6). It is thus avoided to wear nozzle (see picture 7) out and to burn the nozzle holder (see picture 8).

- Excessive thickness of piece (see graph of cutting speed and thickness)

- Work clamp **H** not properly in electric contact with piece

- Worn nozzle and electrode

- Too low cutting current.

N.B. : When the unit does not thoroughly pass through, nozzle is clogged by scums.

2) Cutting arc switches off

This may be due to:

- worn nozzle, electrode or diffuser

- too high air pressure

- too low feed voltage

3) Tilted cutting

When cutting is tilted (see picture 9) switch the unit off, loosen nozzle holder and turn nozzle by a quarter turn, then lock and try again.

Repeat until cutting is straight (see picture 10).

4) Excessive wear of consumable parts

This may be due to :

- a) too low air pressure with respect to the recommended one
- b) excessive burns on the end part of nozzle holder.

PRACTICAL RECOMMENDATIONS

- If the system air contains much humidity and oil it is required to use a drying filter to avoid excessive oxidation and wear of consumable parts, to avoid torch damage or to reduce speed and quality of cutting.

- Impurities of air favour oxidation of electrode and nozzle and make it difficult to start pilot arc. If this occurs, clean the end part of electrode and inside the nozzle with fine abrasive paper.

- Make sure that new electrode and nozzle to fit are clean and degreased.

- To avoid damage of torch and to prevent dangerous situations always use genuine spares.

TORCH MAINTENANCE

Always disconnect the unit before any repair of torch.

1) Replace wear parts (picture 11)

The parts subject to wear are electrode **A**, diffuser **B** and nozzle **C**.

Either part may be only replaced after loosening nozzle holder **D**. Electrode **A** should be replaced when a 1/16" (1.5 mm) deep crater is created in the middle (see picture 12).

ATTENTION! Do not make sudden stresses when unscrewing the electrode, but gradually force so as to have the thread unlocked. Lubricate the thread of the new electrode with silicone lubricant (on supply with the unit). This new electrode is required to be screwed in its housing and locked without tightening.

Nozzle **C** should be replaced when its central hole is damaged or enlarged with respect to the new part (see picture 13).

Use of worn electrode quickly wears out the nozzle.

Excessive use of electrode causes overheating and reduces the life of diffuser **B**.

Make sure that after replacing it, nozzle **D** is tight enough.

ATTENTION! Nozzle holder **D** should be only screwed on head when electrode **A** diffuser **B** and nozzle **C** are assembled.

The absence of such parts jeopardizes the machine working and particularly the operator's safety.

2) Replace torch body **E** (see picture 11).

Withdraw handle **F** from body **E** by swaying it and making sure that button wires are not torn when separating both parts.

Withdraw the **G** and **H** safety contacts wires.

Withdraw the contact **L**. Unscrew fitting **I** after cutting the insulating hose **K**.

Assemble the new body of torch making all above operations inversely.

Fitting **I** is insulated by shrink hose **K** stuck to the fitting when heated by a small source (ex. a lighter).

Before replacing handle make sure that cables are far away from each other and that fittings are tightly secured.

3) Replacement of handle with button.

To replace handle with button it is required to follow instructions as per pos. 2.

MAINTENANCE AND CONTROL

It is recommended to keep nozzle free from slag.

Avoid using sharpened bodies thus avoiding damaging the nozzle hole.

Even if the unit is provided with an automatic device for water discharge, working whenever air feed is closed, it is recommended to check from time to time that no water remains in trap **I** of reducer (picture 1).

It is required to clean from time to time the unit inside and make it free from metal dust by means of compressed air.

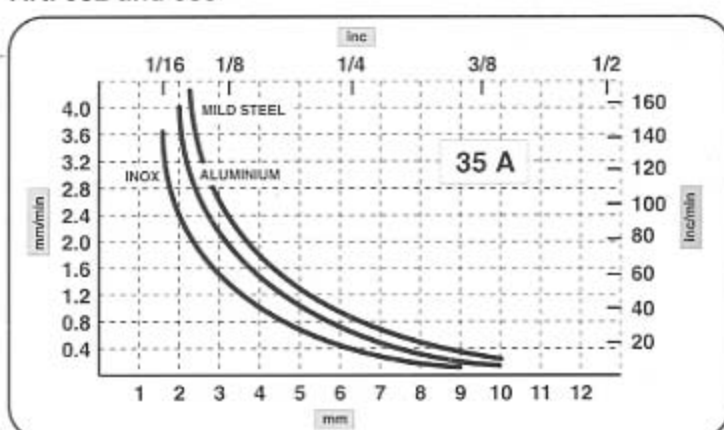
Operations to be carried out inside the unit must be effected after disconnecting feed cable.

PRECAUTIONS TO TAKE AFTER A REPAIR

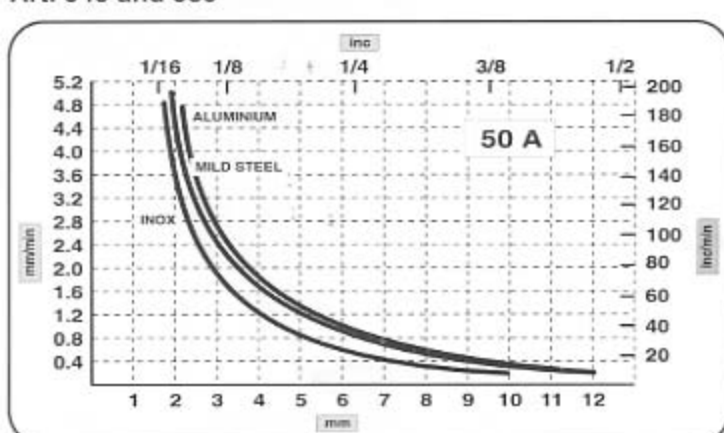
After making repairs, take care to re-order the cables so that there is sure to be insulation between the primary and secondary sides of the machine. Make sure that the wires cannot come into contact with moving parts or parts that heat during operation. Replace all clamps in their original positions on the machine, to prevent a connection between the primary and secondary circuits if a conductor accidentally breaks or disconnects.

CUTTING SPEED SCHEME

Art. 932 and 938



Art. 940 and 939



BASIC SAFETY PRECAUTIONS

ELECTRIC SHOCK



Electric shock can kill. All electric shocks are potentially fatal.

This plasma cutter requires high voltages for arc spark starting (approx. 250 ÷ 350 V). The following safety rules must be therefore observed when using the unit:

- Do not touch live parts.
- Insulate yourselves from the piece to be cut and from earth by wearing insulating gloves and clothing
- Keep your clothing (gloves, shoes, hats, dresses) and body dry
- Do not work in humid or wet areas
- Avoid touching or holding by hand the piece to be cut
- Always arrange for a proper insulation against electric shock. Should you work close to or in a dangerous area use all possible precautions.
- If you feel even the slightest electric shock sensation, stop cutting at once. Do not use the machine until the problem is identified and solved.
- Always fit an automatic wall switch with adequate power, if possible close to the machine so as to immediately switch the unit off in an emergency event.
- Check often mains cable, torch cable, earth cable and torch. Never use the unit when one of them is damaged. Replace them immediately.
- Disconnect mains cable from mains before replacing cables or before removing unit covers.
- Always switch the unit off or disconnect it before replacing nozzle, swirl ring, electrode or nozzle holder.
- Do not use the unit without protecting covers.
- Always replace any damaged parts of the unit, torch and

cables with original material.

- Never remove torch or unit safety devices.
- Make sure that the supply mains line is equipped with an efficient earth plug.
- Make sure that the work table is connected to an efficient earth plug.
- Any maintenance should be only carried out by qualified personnel aware of the risks due to dangerous voltages necessary to make the unit work.

ATTENTION: Never screw nozzle holder D (see picture 11) to torch body E without fitting consumables electrode A, diffuser B, nozzle C.

The absence of such parts jeopardizes the machine working and particularly the operator's safety.

RADIATIONS



Ultraviolet radiations created by the arc may damage your eyes and burn your skin. Then:

- Wear proper clothing and helmets.
- Do not use contact lenses!! The intense heat coming from the arc may stick them on the cornea.
- Use masks with grade DIN 10 safety lenses, at least.
- Protect people surrounding the cutting area.

FUMES



Cutting operations give off fumes and harmful metal dusts which may damage health, therefore:

- Do not work in areas without proper ventilation.
 - Keep your head out of fumes.
 - In closed rooms use suitable exhaust fans, placed under the cutting area, if possible.
 - If ventilation is not enough, use breathing sets approved for this procedure.
 - Clean the material to be cut of any solvents or halogen degreasers giving rise to toxic gases when cutting: Some chlorine solvents may decompose with radiation emitted by the arc and create phosgene gas.
 - Do not cut plated metals or metals containing lead, graphite, cadmium, zinc, chrome, quicksilver or beryllium unless you have a proper breathing set.
 - The electric arc creates ozone. After long exposure to high concentrations of ozone you may have headache, nose, throat and eyes irritation as well as serious congestion and chest pains.
- IMPORTANT: DO NOT USE OXYGEN FOR VENTILATION.**

FIRE



Avoid causing fire because of sparks, hot metal or pieces.

- Make sure that suitable fireproof devices are available close to cutting area.
- Remove from cutting area and surrounding area (33 feet at least) all inflammable and combustible material.
- Do not cut containers of combustible or lubricating material, even when empty. These should be carefully cleaned before being cut.
- Let the material cut cool down before touching it or putting it in contact with combustible or inflammable material.
- Do not cut parts with hollow spaces including inflammable material.
- Do not work under conditions of high concentration of combustible vapours, gases or inflammable dust.
- Always check the work area half an hour after cutting so as to make sure that no fire is starting to burn.

BURNS

- Wear fire-proof clothes all over your body to protect your skin against burns caused by ultraviolet radiations from the arc, from sparks and hot metal.

- Wear no turn-up trousers to prevent sparks and metal to deposit in them.
- Wait for the torch to be cooled down and then switch the unit off before touching the front side of the torch.
- **Torch is provided with a pilot arc, then as soon as you press the button, the plasma spark starts even if earth cable is not connected. Avoid directing jet towards your own body or towards other people surrounding the cutting area.**
- **To prevent spark to start by chance, always switch the unit off before putting down your torch.**
- Do not carry combustible material, such as lighters or matches in pocket.

EXPLOSIONS



- Do not cut above or near containers under pressure.
- Do not cut in environments containing explosive dusts, gases or vapours.

This plasma cutter uses compressed air to work; should you use compressed air bottles follow suitable precautions:

A) CYLINDERS

- Do not directly connect cylinders to reducing unit without a pressure regulator; pressure might exceed the reducing unit capacity making it explode.
- Feeding pressure must not exceed 120 PSI (8bar/0.8 MPa)
- Handle or use pressure cylinders in conformity with the existing rules.
- Do not use leaking or damaged cylinders.
- Do not use cylinders which are not properly secured.
- Do not carry cylinders whose content is not clearly identified.
- Never lubricate cylinder valves with oil or grease.
- Do not put electrically in contact cylinder with plasma arc.
- Do not expose cylinders to excessive heat, sparks, hot metal or flames.
- Do not tamper with cylinder valves.
- Do not try to loosen all tight valves by means of hammers, keys or something else.

B) PRESSURE REGULATORS

- Keep pressure regulators in good conditions. Damaged regulators may give rise to damage or accidents; they should only be repaired by skilled personnel.
- Do not use regulators for gases other than those they are manufactured for.
- Never use a leaking or damaged regulator.
- Never lubricate regulators with oil or grease.

C) AIR HOSES

- Replace air hoses if damaged.
- Keep hoses unwound so as to avoid bending.
- Keep excess hose wound and keep it out of the working area to avoid any damage.

NOISE



These power sources alone do not produce noise levels exceeding 80 dB. The cutting procedure, however, may produce noise levels in excess of 80 dB in which case the operator must take the necessary safety precautions as prescribed by the national safety regulations.

PACEMAKER

Magnetic fields created by the high currents in the cutting circuit can affect pacemaker operation. Persons wearing electronic life support equipment (pacemakers) should consult their doctor before going near any arc welding, gouging, cutting, or spot welding equipment in operation.