




# INSTRUCTION MANUAL FOR PLASMA CUTTER

**IMPORTANT:** BEFORE STARTING THE EQUIPMENT, READ THE CONTENTS OF THIS MANUAL, WHICH MUST BE STORED IN A PLACE FAMILIAR TO ALL USERS FOR THE ENTIRE OPERATIVE LIFE-SPAN OF THE MACHINE. THIS EQUIPMENT MUST BE USED SOLELY FOR CUTTING OPERATIONS.


## 1 SAFETY PRECAUTIONS

  **WELDING AND ARC CUTTING CAN BE HARMFUL TO YOURSELF AND OTHERS.** The user must therefore be educated against the hazards, summarized below, deriving from welding operations. For more detailed information, order the manual code 3.300.758

### NOISE.

 This machine does not directly produce noise exceeding 80dB. The plasma cutting/welding procedure may produce noise levels beyond said limit; users must therefore implement all precautions required by law.

### ELECTRIC AND MAGNETIC FIELDS - May be dangerous.

 · Electric current following through any conductor causes localized Electric and Magnetic Fields (EMF). Welding/cutting current creates EMF fields around cables and power sources.


· The magnetic fields created by high currents may affect the operation of pacemakers. Wearers of vital electronic equipment (pacemakers) shall consult their physician before beginning any arc welding, cutting, gouging or spot welding operations.

· Exposure to EMF fields in welding/cutting may have other health effects which are now not known.

· All operators should use the following procedures in order to minimize exposure to EMF fields from the welding/cutting circuit:

- Route the electrode and work cables together
- Secure them with tape when possible.
- Never coil the electrode/torch lead around your body.
- Do not place your body between the electrode/torch lead and work cables. If the electrode/torch lead cable is on your right side, the work cable should also be on your right side.
- Connect the work cable to the workpiece as close as possible to the area being welded/cut.
- Do not work next to welding/cutting power source.

### EXPLOSIONS

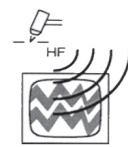
 · Do not weld in the vicinity of containers under pressure, or in the presence of explosive dust, gases or fumes. · All cylinders and pressure regulators used in welding operations should be handled with care.

### ELECTROMAGNETIC COMPATIBILITY.

This machine is manufactured in compliance with the instructions contained in the standard IEC 60974-10 (CL A), and must be used solely for professional purposes in an industrial environment. There may be potential diffi-

culties in ensuring electromagnetic compatibility in non-industrial environments.

### H.F FREQUENCY



- High frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



### DISPOSAL OF ELECTRICAL AND ELECTRONIC EQUIPMENT.

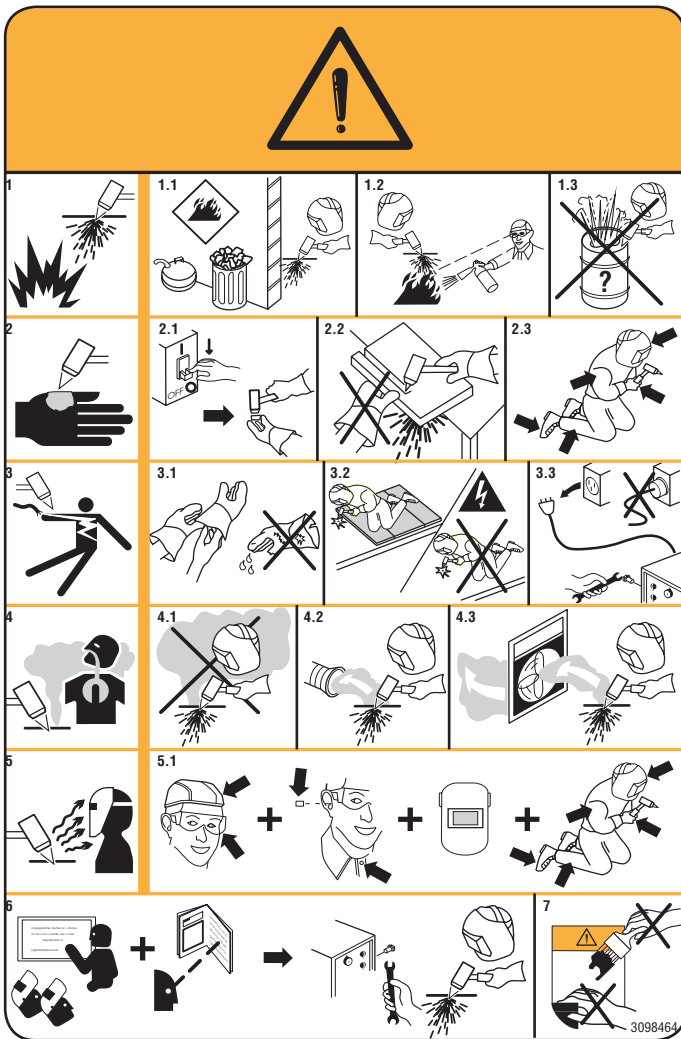
Do not dispose of electrical equipment together with normal waste! In observance of European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and returned to an environmentally compatible recycling facility. As the owner of the equipment, you should get information on approved collection systems from our local representative. By applying this European Directive you will improve the environment and human health!

IN CASE OF MALFUNCTIONS, REQUEST ASSISTANCE FROM QUALIFIED PERSONNEL.

### 1.1 WARNING LABEL

The following numbered text corresponds to the label numbered boxes.

1. Cutting sparks can cause explosion or fire.
  - 1.1 Keep flammable materials away from cutting.
  - 1.2 Cutting sparks can cause fires. Have a fire extinguisher nearby, and have a watchperson ready to use it.
  - 1.3 Do not cut on drums or any closed container.
2. The plasma arc can cause injury and burns.
  - 2.1 Turn off power before disassembling torch.
  - 2.2 Do not grip material near cutting path.
  - 2.3 Wear complete body protection.
3. Electric shock from torch or wiring can kill.
  - 3.1 Wear dry insulating gloves. Do not wear wet or damaged gloves.
  - 3.2 Protect yourself from electric shock by insulating yourself from work and ground.
  - 3.3 Disconnect input plug or power before working on machine.
4. Breathing cutting fumes can be hazardous to your health.
  - 4.1 Keep your head out of fumes.
  - 4.2 Use forced ventilation or local exhaust to remove fumes.
  - 4.3 Use ventilating fan to remove fumes.



- 5 Arc rays can burn eyes and injure skin.
- 5.1 Wear hat and safety glasses. Use ear protection and button shirt collar. Use welding helmet with correct shade of filter. Wear complete body protection.
- 6 Become trained and read the instructions before working on the machine or cutting.
- 7 Do not remove or paint over (cover) the label.

## 2 GENERAL DESCRIPTIONS

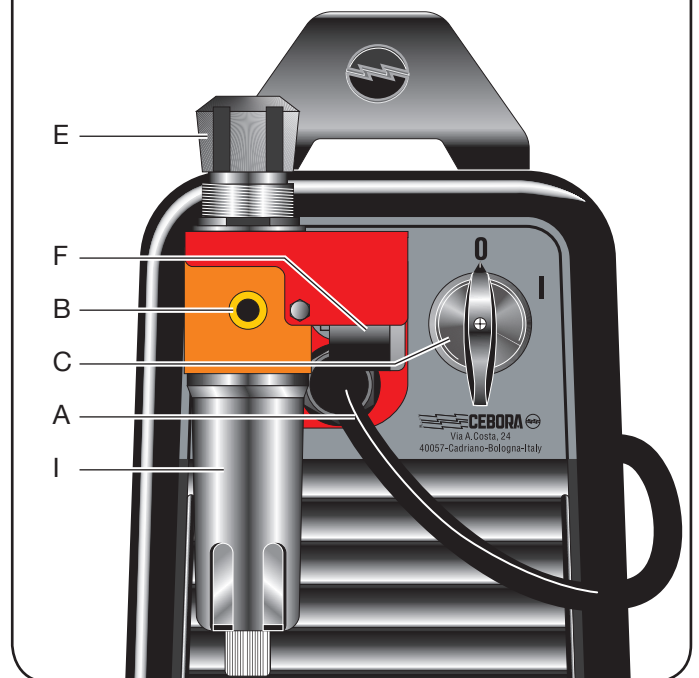
This machine is a constant direct current power source, designed for cutting electrically conductive materials (metals and alloys) using the plasma arc procedure. The plasma gas may be air or nitrogen.

### 2.1 DESCRIPTION OF DEVICES ON THE MACHINE

- A) Power cord
- B) Compressed air fitting (1/4" female gas thread)
- C) Mains power switch
- D) Mains power led
- E) Pressure regulator knob
- F) Pressure gauge
- G) Thermostat LED
- H) Grounding cord
- I) Water trap
- L) Low air pressure LED
- M) Cutting current regulator knob



Fig. 1





- N) Blocked LED; lights when hazardous conditions arise.
- O) LED that lights when the "SELF-RESTART PILOT" function is active
- P) Push-button to activate and deactivate the "SELF-RESTART PILOT" function.
- Q) Plasma torch.


## 2.2 SAFETY DEVICES

This system comes equipped with the following safety devices:

### Overload cutout:

-  To avoid overload while cutting.
-  The LED G (see fig 1) lights when active.

### Pneumatic:

-  Located on the torch inlet to prevent low air pressure. The LED L lights when tripped (see fig.1).

### Electrical:

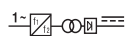
- 1) In the event of a short-circuit between the nozzle and electrode during arc striking
- 2) In the event of a short-circuit between the contacts of the reed relay on circuit 22 (see exploded drawing).
- 3) When the electrode is worn to the point it must be replaced. These conditions block the machine, and are signalled by the lit LED N.
- 4) In addition, this machine is equipped with automatic selection of the supply voltage.

- Do not remove or short-circuit the safety devices.
- Use only original spare parts.
- Always replace any damaged parts of the machine with original materials.
- Use only CEBORA torches type CP40.
- Do not run the machine without its housings. This would be dangerous to the operator and anyone else in the work area, and would prevent the machine from being cooled properly.


## 2.3 EXPLANATION OF THE TECHNICAL SPECIFICATIONS LISTED ON THE MACHINE PLATE.

This machine is manufactured according to the following international standards: IEC 60974.1 - IEC 60974.3 - IEC 60974.7 - IEC 60974.10 CL. A - IEC 61000-3-11 - IEC 61000-3-12.

N° Serial number. Always indicate this for any request regarding the machine.

 Single-phase static transformer-rectifier frequency converter.

 Drooping characteristic.

 Suitable for plasma cutting.

Torch type. Type of torch that may be used with this machine.

U0. PEAK. Secondary open-circuit voltage. Peak value.  
X Percentage duty cycle.

The duty cycle expresses the percentage of 10 minutes for which the machine may work at a certain current I2 and voltage U2 without overheating.

I2 Cutting current.

U2 Secondary voltage at cutting current I2. This voltage is measured when cutting with the gas nozzle in contact with the workpiece. **If this distance increases, the cutting voltage also increases and the duty cycle X% may drop.**


U1 Rated supply voltage.

1~50/60Hz 50- or 60-Hz single-phase power supply. The machine is equipped with automatic voltage change.

I1 Max Max. absorbed current at the corresponding current I2 and voltage U2.

I1 eff This is the maximum value of the actual current absorbed, considering the duty cycle. This value usually corresponds to the capacity of the fuse (delayed type) to be used as a protection for the equipment.

IP23S Housing protection rating. Grade 3 as the second digit means that this equipment may be stored, but it is not suitable for use outdoors in the rain, unless it is protected.

 Suitable for working in hazardous environments.

NOTE: The machine has also been designed for use in environments with a pollution rating of 3. (See IEC 664).

## 2.4 START-UP

**The machine must be installed by qualified personnel. All connections must be made in compliance with current safety standards and full observance of safety regulations (see CEI 26-23 / IEC-TS 62081).**

Connect the air supply to the fitting B.

- If the system air contains a considerable amount of moisture and oil, it is best to use a drying filter to avoid excessive oxidation and wear of the consumer parts, damaging the torch and reducing the cutting speed and quality.

If the air supply comes from a pressure regulator of a compressor or centralized system, the regulator must be set to an output pressure of no more than 8 bar (0.8 Mpa). If the air supply comes from a compressed air cylinder, the cylinder must be equipped with a pressure regulator. **Never connect a compressed air cylinder directly to the regulator on the machine! The pressure could exceed the capacity of the regulator, which might explode!**

Connect the power cord A : the yellow-green cable wire must be connected to an efficient grounding socket on the system. The remaining wires must be connected to the power supply line by means of a switch placed as close as possible to the cutting area, to allow it to be shut off quickly in case of emergency.

The capacity of the cut-out switch or fuses installed in series with the switch must be equal to the current I1 absorbed by the machine.

The absorbed current I1 may be determined by reading the technical specifications shown on the machine under the available supply voltage U1.

Any extension cords must be sized appropriately for the absorbed current I1.

### 3 USE

#### Make sure the trigger has not been pressed.

Turn the machine on using the switch **C**. The warning lamp **D** will light to indicate that the machine is on.

Press the torch trigger briefly to open the flow of compressed air. Since the arc is not lit, air leaves the torch for only 5 sec. Now adjust the pressure, shown on the pressure gauge **F**, to 3.5 bar (0.35 MPa) using the knob **E** on the regulator, then lock the knob by pressing it downward.

Connect the grounding clamp to the workpiece.

The cutting circuit must not be deliberately placed in direct or indirect contact with the protective wire except in the workpiece.

If the workpiece is deliberately grounded using the protective conductor, the connection must be as direct as possible and use a wire of at least the same size as the cutting current return wire, and connected to the workpiece at the same point as the return wire using the return wire clamp or a second grounding clamp placed in the immediate vicinity. Every precaution must be taken to avoid stray currents. Use the knob **M** to adjust the cutting current from 5 to 30 A based on the work at hand.

Make sure that the earth clamp and the workpiece are in good electrical contact, especially with painted or oxidized metal or with insulated coating; connect the clamp as close as possible to the cutting area.

Do not connect the grounding clamp to the part of the material that is to be removed.

Press the torch trigger to strike the pilot arc.

If cutting does not begin within 2 seconds, the pilot arc goes out; press the trigger again to re-strike it.

Begin cutting.

Hold the torch upright while cutting.

When you have finished cutting and released the trigger, air will continue to leave the torch for approximately 40 seconds to allow the torch to cool down.

#### It is best not to turn the machine off until this cool-down period is complete.

- To cut perforated or grid metal, activate the "Pilot self restart" function using the push-button **P** (LED **O** lit).

When you have finished cutting, holding this push-button down will cause the pilot arc to restart automatically.

#### Use this function only if necessary to avoid unnecessary wear on the electrode and nozzle.

- Should you need to make holes or begin cutting from the center of the workpiece, you must hold the torch at an angle and slowly straighten it so that the nozzle does not spray molten metal (see fig. 2). This must be done when making holes in pieces more than 3 mm thick.

- Should you need to cut several layers of metal, as are normally used in auto body work, adjust the cutting current to the minimum values.

For currents between 5 and



10 A it may be helpful to set the intake pressure to approximately 2 bar.

Turn the machine off when the task is completed.

### 3.1 REPLACING CONSUMER PARTS

#### Always shut off the machine before replacing consumer parts.

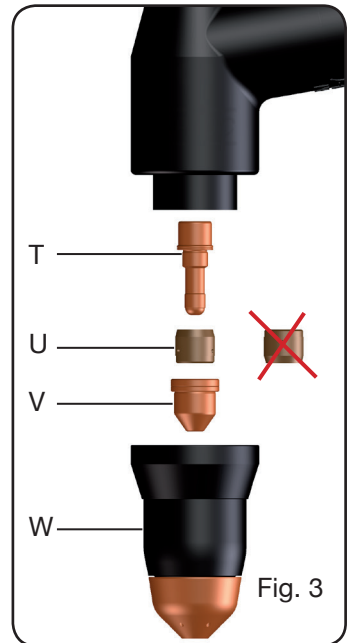
- The electrode must be replaced when it has a crater in the center approximately 1 mm deep.

- The gas nozzle must be replaced when the hole is no longer smooth and the cutting capacity is diminished.

- The diffuser must be replaced when some areas are blackened. Due to its small size, it is very important to position it correctly during assembly (see fig. 3).

- The nozzle holder must be replaced when the insulating part is deteriorated.

**Make sure that the electrode **T**, the diffuser **U** and the gas nozzle **V** are mounted correctly, and that the nozzle holder **W** is firmly tightened. If any of these parts are missing, this will interfere with smooth operation of the machine and, especially, jeopardize operator safety.=**



### 4 CUTTING ERRORS

#### 4.1 INSUFFICIENT PENETRATION

This error may be caused by the following:

- high speed. Always make sure that the arc fully penetrates the workpiece and is never held at a forward angle of more than 10 -15°. This will avoid incorrect consumption of the nozzle and burns to the nozzle holder.

- Excessively thick workpiece (see cutting charts).

- Grounding clamp not in good electrical contact with the workpiece.

- Worn nozzle and electrode.

- Cutting current too low.

NOTE: When the arc does not penetrate, the molten metal scraps obstruct the nozzle.

#### 4.2 THE CUTTING ARC GOES OFF

This error may be caused by:

- worn nozzle, electrode or swirl ring.

- air pressure too high.

- supply voltage too low.

#### 4.3 SHORTER LIFE OF CONSUMER PARTS

This error may be caused by:

- oil or dirt in the arc intake,

- unnecessarily long pilot arc,
- low arc pressure.

## 5 HELPFUL HINTS

- If the system air contains considerable amounts of moisture and oil, it is best to use a drying filter to avoid excessive oxidation and wear on consumer parts, damage to the torch and a reduction in the speed and quality of the cutting.
- Make sure that the new electrode and nozzle to be mounted are thoroughly clean and degreased.
- **Always use original spare parts to avoid damaging the torch.**

## 6 MAINTENANCE

**Any maintenance operation must be carried out by qualified personnel in compliance with standard CEI 26-29 (IEC 60974-4).**

### 6.1 GENERATOR MAINTENANCE

In the case of maintenance inside the machine, make sure that the switch **C** is in position “O” **and that the power cord is disconnected from the mains.**

Even though the machine is equipped with an automatic condensation drainage device that is tripped each time the air supply is closed, it is good practice to periodically make sure that there is no condensation accumulated in the water trap I (fig.1).

It is also necessary to periodically clean the interior of the machine from the accumulated metal dust, using compressed air.

### 6.2 PRECAUTIONS AFTER REPAIRS.

After making repairs, take care to organize the wiring so that there is secure insulation between the primary and secondary sides of the machine. In particular, make sure that the casing **50** is mounted (see exploded drawing). Do not allow the wires to come into contact with moving parts or those that heat up during operation. Reassemble all clamps as they were on the original machine, to prevent a connection from occurring between the primary and secondary circuits should a wire accidentally break or be disconnected.

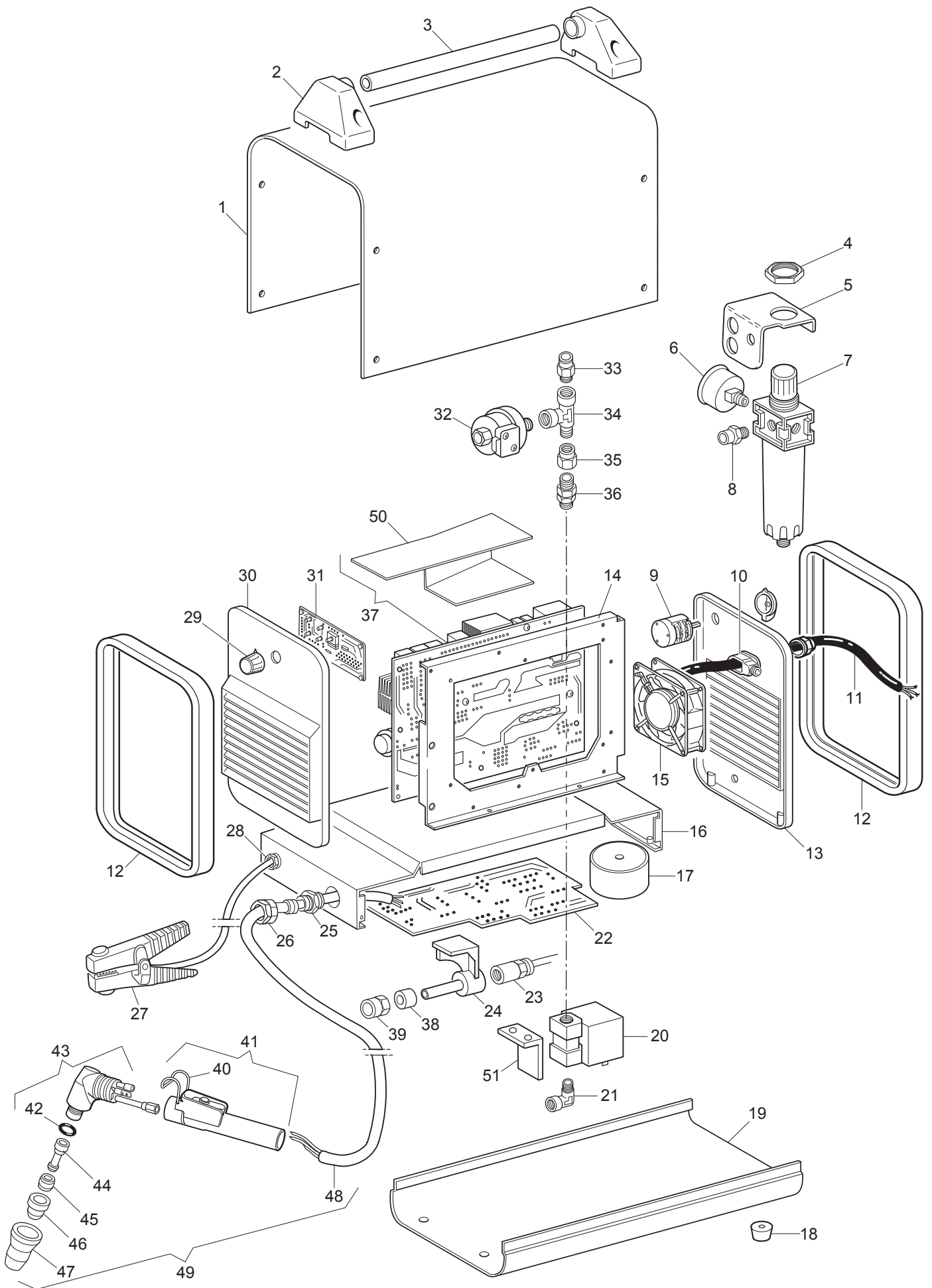
Also mount the screws with geared washers as on the original machine.

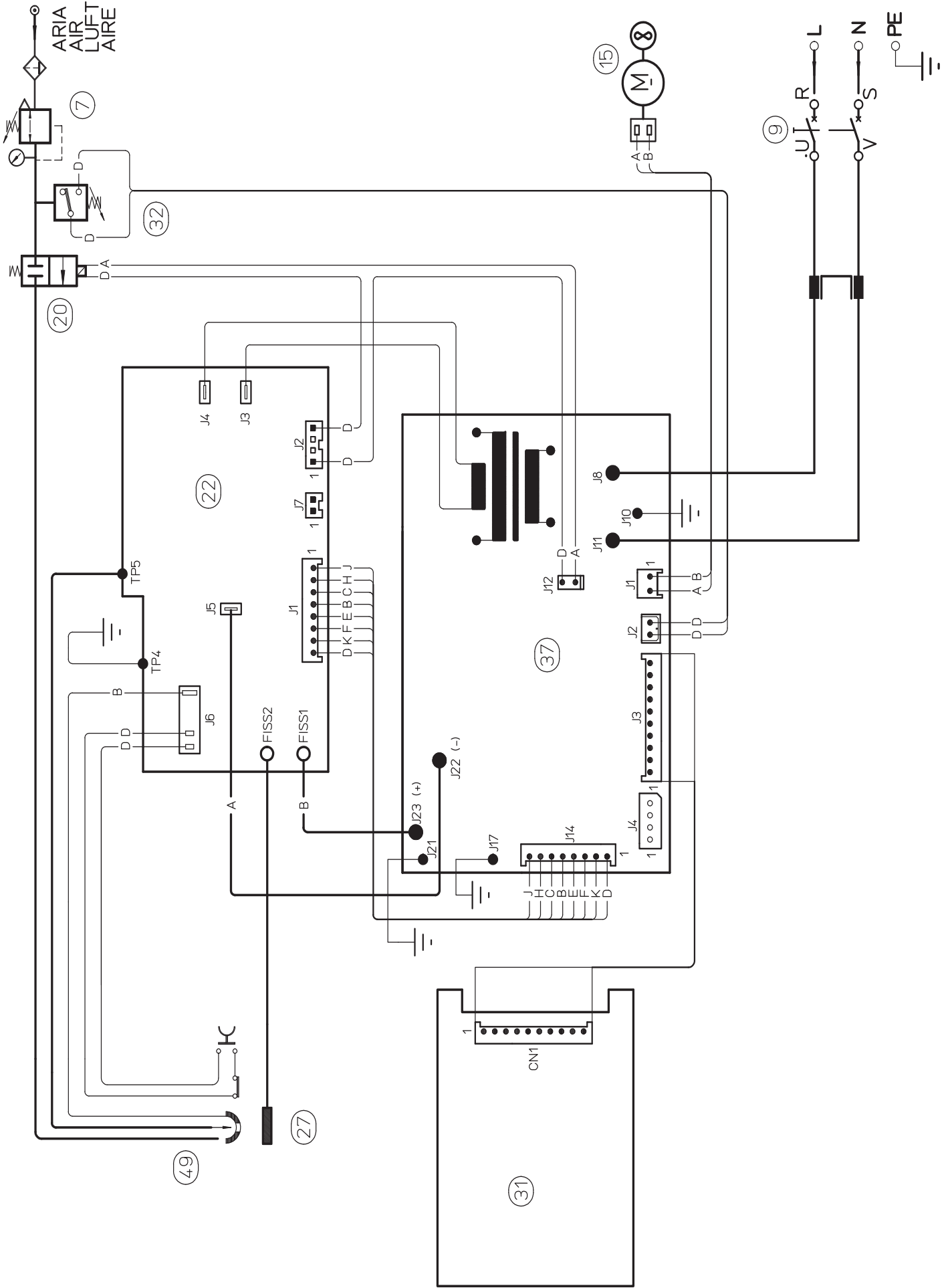
POS	DESCRIZIONE	DESCRIPTION
01	FASCIONE	HOUSING
02	SUPPORTO MANICO	HANDLE SUPPORT
03	MANICO	HANDLE
04	GHIERA	RING NUT
05	SUPPORTO	SUPPORT
06	MANOMETRO	GAUGE
07	RIDUTTORE	REGULATOR
08	RACCORDO	FITTING
09	INTERRUTTORE	SWITCH
10	PASSACAPO	CABLE OUTLET
11	CAVO RETE	POWER CORD
12	CORNICE	FRAME
13	PANNELLO POSTERIORE	BACK PANEL
14	SUPPORTO VENTOLA	FAN SUPPORT
15	MOTORE CON VENTOLA	MOTOR WITH FAN
16	PIANO INTERMEDIO	INSIDE BAFFLE
17	IMPEDENZA PFC	PFC CHOKE
18	PIEDE IN GOMMA	RUBBER FOOT
19	FONDO	BOTTOM
20	ELETTROVALVOLA	SOLENOID VALVE
21	RACCORDO A GOMITO	UNION ELBOW
22	CIRCUITO ALTA FREQUENZA	HIGH-FREQ. CIRCUIT
23	RACCORDO	FITTING
24	MORSETTIERA	TERMINAL BOARD
25	PRESSACAPO	STRAIN RELIEF
26	GHIERA	RING NUT

POS	DESCRIZIONE	DESCRIPTION
27	CAVO CON MORSETTO	CABLE WITH CLAMP
28	PRESSACAPO	STRAIN RELIEF
29	MANOPOLA	KNOB
30	PANNELLO ANTERIORE	FRONT PANEL
31	CIRCUITO PANNELLO	PANEL CIRCUIT
32	PRESSOSTATO	PRESSURE SWITCH
33	RACCORDO	FITTING
34	RACCORDO	FITTING
35	RACCORDO	FITTING
36	RACCORDO	FITTING
37	CIRCUITO DI POTENZA	POWER CIRCUIT
38	RACCORDO	FITTING
39	RACCORDO	FITTING
40	ATTACCO TORCIA	TORCH CONNECTOR
41	IMPUGNATURA CON PULSANTE	HANDGRIP WITH PUSHBUTTON
42	O.RING	O.RING
43	CORPO TORCIA (TESTINA)	TORCH BODY (HEAD)
44	ELETTRODO (CONF. DA 5 PZ.)	ELECTRODE (PACK. 5 PCS.)
45	DIFFUSORE (CONF. DA 2 PZ.)	SWIRL RING (PACK. 2 PCS.)
46	UGELLO (CONF. DA 5 PZ.)	NOZZLE (PACK. 5 PCS.)
47	PORTAUGELLO	NOZZLE HOLDER
48	CAVO TORCIA	TORCH CABLE
49	TORCIA COMPLETA	COMPLETE TORCH
50	COPERTURA	COVER
51	SUPPORTO	SUPPORT

La richiesta di pezzi di ricambio deve indicare sempre: numero di articolo, matricola e data di acquisto della macchina, posizione e quantità del ricambio.

When ordering spare parts please always state the machine item and serial number and its purchase data, the spare part position and the quantity.





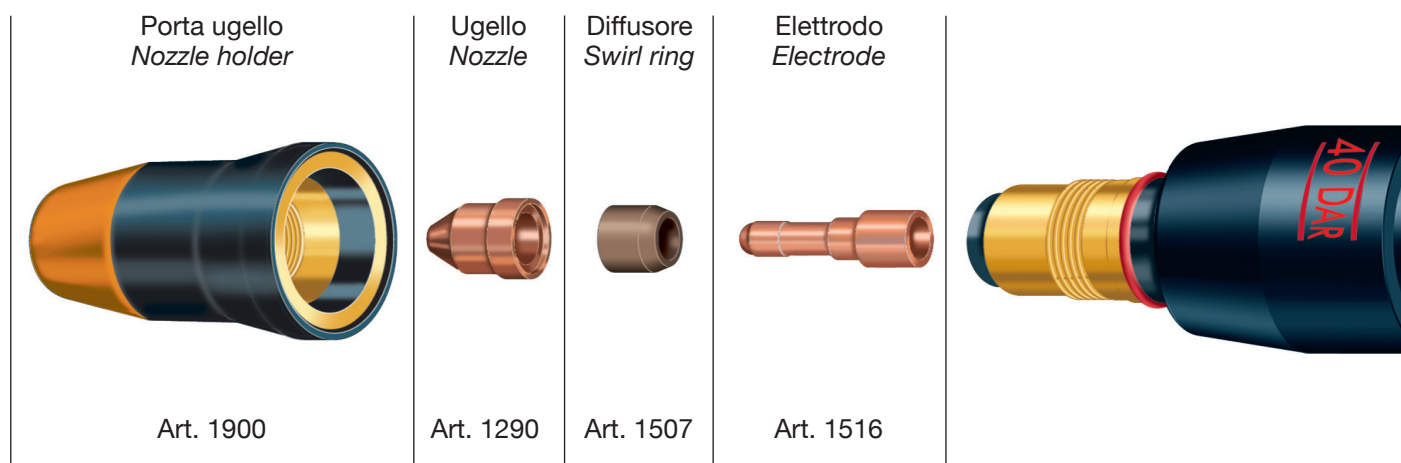


CODIFICA COLORI CABLAGGIO ELETTRICO		WIRING DIAGRAM COLOUR CODE
A	NERO	BLACK
B	ROSSO	RED
C	GRIGIO	GREY
D	BIANCO	WHITE
E	VERDE	GREEN
F	VIOLA	PURPLE
G	GIALLO	YELLOW
H	BLU	BLUE
K	MARRONE	BROWN
J	ARANCIO	ORANGE
I	ROSA	PINK

CODIFICA COLORI CABLAGGIO ELETTRICO		WIRING DIAGRAM COLOUR CODE
L	NROSA-NERO	PINK-BLACK
M	GRIGIO-VIOLA	GREY-PURPLE
N	BIANCO-VIOLA	WHITE-PURPLE
O	BIANCO-NERO	WHITE-BLACK
P	GRIGIO-BLU	GREY-BLUE
Q	BIANCO-ROSSO	WHITE-RED
R	GRIGIO-ROSSO	GREY-RED
S	BIANCO-BLU	WHITE-BLUE
T	NERO-BLU	BLACK-BLUE
U	GIALLO-VERDE	YELLOW-GREEN
V	AZZURRO	BLUE

## TABELLE DI TAGLIO CUTTING CHARTS

### Art. 279 - 30 A



Corrente di taglio Cutting current	Acciaio dolce Mild steel		Acciaio inossidabile Stainless steel		Alluminio Aluminium	
	Spessore Thickness	Velocità di taglio Cutting speed	Spessore Thickness	Velocità di taglio Cutting speed	Spessore Thickness	Velocità di taglio Cutting speed
(A)	(mm)	(m/min)	(mm)	(m/min)	(mm)	(m/min)
30	1	5,60	1	6,80	1	8,60
30	2	2,70	2	2,30	2	5,90
30	3	1,60	3	1,70	3	3,00
30	4	1,30	4	1,20	4	2,14
30	5	1,00	5	0,85	6	1,07
30	6	0,80	6	0,52	8	0,90
30	8	0,50	8	0,41	10	0,70
30	10	0,34	10	0,25	12	0,40
30	12	0,22	12	0,14	15	0,14
30	15	0,12	-	-	-	-



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