

PROCRAFT WELDING

INVERTER PLASMA CUTTER 511468

OPERATING INSTRUCTIONS



SAVE THIS MANUAL WARNING!

READ AND UNDERSTAND ALL INSTRUCTIONS

Failure to follow all instructions listed below may result in electric shock, fire, and/or serious injury.

SAVE THESE INSTRUCTIONS

Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's serial number in the back of the manual (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference.

CONSUMER SERVICE CENTRE
PO BOX 1012
HAMILTON NSW 2303 AUSTRALIA
Made in P.R.C.



SAVE THIS MANUAL

Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's serial number in the back of the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference.

IMPORTANT SAFETY INFORMATION

In this manual, on the labeling, and all other information provided with this product:

This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING: **WARNING** indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION: **CAUTION**, used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE: **NOTICE** is used to address practices not related to personal injury.

SAFETY WARNINGS AND PRECAUTIONS

WARNING: When using tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment.

Read all instructions before using this tool!

WARNING!

READ AND UNDERSTAND ALL INSTRUCTIONS

Failure to follow all instructions listed below may result in electric shock, fire, and/or serious injury.

SAVE THESE INSTRUCTIONS

ELECTRICAL SAFETY

1. Grounded tools must be plugged into an outlet properly installed and grounded in accordance with all codes and ordinances. Never remove the grounding prong or modify the plug in any way. Do not use any adapter plugs. Check with a qualified electrician if you are in doubt whether the outlet is properly grounded. If the tool should electrically malfunction or break down, grounding provides a low resistance path to carry electricity away from the user.

2. Double insulated tools are equipped with a polarized plug (one blade is wider than the other). This plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician to install a polarized outlet. Do not change the plug in any way. Double insulation eliminates the need for the three wire grounded power cord and grounded power supply system.

3. Avoid body contact with grounded surfaces such as pipes, radiators, ranges, and refrigerators. There is an increased risk of electric shock if your body is grounded.

4. Do not expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.

Do not abuse the Power Cord. Never use the Power Cord to carry the tool or pull the Plug from an outlet. Keep the Power Cord away from heat, oil, sharp edges, or

1. moving parts. Replace damaged Power Cords immediately. Damaged Power Cords increase the risk of electric shock.

1. When operating a power tool outside, use an outdoor extension cord marked "W-A" or "W". These extension cords are rated for outdoor use, and reduce the risk of electric shock.

PERSONAL SAFETY

- 1. Stay alert. Watch what you are doing, and use common sense when operating a power tool. Do not use a power tool while tired or under the influence of drugs, alcohol, or medication.** A moment of inattention while operating power tools may result in serious personal injury.
 - 2. Dress properly. Do not wear loose clothing or jewelry. Contain long hair. Keep your hair, clothing, and gloves away from moving parts.** Loose clothes, jewelry, or long hair can be caught in moving parts.
 - 3. Avoid accidental starting. Be sure the Power Switch is off before plugging in.** Carrying power tools with your finger on the Power Switch, or plugging in power tools with the Power Switch on, invites accidents.
 - 4. Remove adjusting keys or wrenches before turning the power tool on.** A wrench or a key that is left attached to a rotating part of the power tool may result in personal injury.
 - 5. Do not overreach. Keep proper footing and balance at all times.** Proper footing and balance enables better control of the power tool in unexpected situations.
- Use safety equipment. Always wear eye protection.** Dust mask, non-skid safety shoes, hard hat, or hearing protection must be used for appropriate conditions.

TOOL USE AND CARE

- 1. Use clamps (not included) or other practical ways to secure and support the work piece to a stable platform.** Holding the work piece by hand or against your body is unstable and may lead to loss of control.
 - 2. Do not force the tool. Use the correct tool for your application.** The correct tool will do the job better and safer at the rate for which it is designed.
 - 3. Do not use the power tool if the Power Switch does not turn it on or off.** Any tool that cannot be controlled with the Power Switch is dangerous and must be replaced.
 - 4. Disconnect the Power Cord Plug from the power source before making any adjustments, changing accessories, or storing the tool.** Such preventive safety measures reduce the risk of starting the tool accidentally.
 - 5. Store idle tools out of reach of children and other untrained persons.** Tools are dangerous in the hands of untrained users.
 - 6. Maintain tools with care. Keep cutting tools maintained and clean.** Properly maintained tools are less likely to bind and are easier to control. Do not use a damaged tool. Tag damaged tools "Do not use" until repaired.
- Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may**
- 1. affect the tool's operation. If damaged, have the tool serviced before using.** Many accidents are caused by poorly maintained tools.
 - 2. Use only accessories that are recommended by the manufacturer for your model.** Accessories that may be suitable for one tool may become hazardous when used on another tool.

SERVICE

- Tool service must be performed only by qualified repair personnel. Service or maintenance performed by unqualified personnel could result in a risk of injury.
- When servicing a tool, use only identical replacement parts. Use of unauthorized parts or failure to follow maintenance instructions may create a risk of electric shock or injury.

SPECIFIC SAFETY RULES

- 1. Maintain labels and nameplates on the tool.** These carry important information. If unreadable or missing, contact TOOLEX INDUSTRIAL for a replacement.
 - 2. Always wear the approved safety impact eye goggles and heavy work gloves when using the tool.** Using personal safety devices reduce the risk for injury. Safety impact eye goggles and heavy work gloves are available from Harbor Freight Tools.
- Maintain a safe working environment.** Keep the work area well lit. Make sure there is adequate surrounding workspace. Always keep the work area free of obstructions, grease, oil, trash, and other debris. Do not use a power tool in areas near flammable chemicals, dusts, and vapors.
- 1. Do not use this product in a damp or wet location.**
 - 2. Avoid unintentional starting.** Make sure you are prepared to begin work before turning on the tool.
 - 3. Never leave the tool unattended when it is plugged into an electrical outlet.** Turn off the tool, and unplug it from its electrical outlet before leaving.
 - 4. Always unplug the tool from its electrical outlet before performing and inspection, maintenance, or cleaning procedures.**
 - 5. Prevent eye injury and burns.** Wearing and using the approved personal safety clothing and safety devices reduce the risk for injury.
 - a. Wear the approved safety impact eye goggles with a welding helmet featuring at least a number 10 shade lens rating.
 - b. Leather leggings, fire resistant shoes or boots should be worn when using this product. Do not wear pants with cuffs, shirts with open pockets, or any clothing that can catch and hold molten metal or sparks.
 - c. Keep clothing free of grease, oil, solvents, or any flammable substances. Wear dry, insulating gloves and protective clothing.
 - d. Wear an approved head covering to protect the head and neck. Use aprons, cape, sleeves, shoulder covers, and bibs designed and approved for welding and cutting procedures.
 - e. When welding/cutting overhead or in confined spaces, wear flame resistant ear plugs or ear muffs to keep sparks out of ears.
- Prevent accidental fires.** Remove any combustible material from the work area.

- a. When possible, move the work to a location well away from combustible; protect the combustibles with a cover made of fire resistant material.
 - b. Remove or make safe all combustible materials for a radius of 35 feet (10 meters) around the work area. Use a fire resistant material to cover or block all open doorways, windows, cracks, and other openings.
 - c. Enclose the work area with portable fire resistant screens. Protect combustible walls, ceilings, floors, etc., from sparks and heat with fire resistant covers.
 - d. If working on a metal wall, ceiling, etc., prevent ignition of combustibles on the other side by mobbing the combustibles to a safe location. If relocation of combustibles is not possible, designate someone to serve as a fire watch, equipped with a fire extinguisher, during the cutting or welding process and for at least one half hour after the cutting or welding is completed.
 - e. Do not weld or cut on materials having a combustible coating or combustible internal structure, as in walls or ceilings, without an approved method for eliminating the hazard.
 - f. Do not dispose of hot slag in containers holding combustible materials. Keep a fire extinguisher nearby and know how to use it.
- After welding or cutting, make a thorough examination for evidence of fire. Be aware that easily visible smoke or flame may not be present for some time after the fire has started. Do not weld or cut in atmospheres containing
- h. Dangerously reactive or flammable gases, vapors, liquids, and dust.
 - i Provide adequate ventilation in work areas to prevent accumulation of flammable gases, vapors, and dust. Do not apply heat to a container that has held an unknown substance or a combustible material whose contents, when heated, can produce flammable or explosive vapors. Clean and purge containers before applying heat. Vent closed containers, including castings, before preheating, welding, or cutting.
 - j. Only use compressed air to operate the Plasma Welder/Cutter. Never use other compressed gases.

WARNING

INHALATION HAZARD: Welding and Plasma Cutting Produce

TOXIC FUMES.

Exposure to welding or cutting exhaust fumes can increase the risk of developing certain cancers, such as cancer of the larynx and lung cancer. Also, some diseases that may be linked to exposure to welding or plasma cutting exhaust fumes are:

- a. Early onset of Parkinson's Disease
- b. Heart disease
- c. Ulcers
- d. Damage to the reproductive organs
- e. Inflammation of the small intestine or stomach
- f. Kidney damage
- g. Respiratory diseases such as emphysema, bronchitis, or pneumonia

PROCRAFT

Use natural or forced air ventilation and wear a respirator approved by NIOSH to protect against the fumes produced to reduce the risk of developing the above illnesses.

1. Avoid overexposure to fumes and gases. Always keep your head out of the fumes. Do not breathe the fumes. Use enough ventilation or exhaust, or both, to keep fumes and gases from your breathing zone and general area.

- Where ventilation is questionable, have a qualified technician take an air sampling to determine the need for corrective measures. Use mechanical ventilation to improve air quality. If engineering controls are not feasible, use an approved respirator.
- Work in a confined area only if it is well ventilated, or while wearing an air-supplied respirator.
- Follow OSHA guidelines for Permissible Exposure Limits (PEL's) for various fumes and gases.
- Follow the American Conference of Governmental Industrial Hygienists recommendations for Threshold Limit Values (TLV's) for fumes and gases.
- Have a recognized specialist in Industrial Hygiene or Environmental Services check the operation and air quality and make recommendations for the specific welding or cutting situation.

2. Always keep hoses away from welding/cutting spot.

Examine all hoses and cables for cuts, burns, or worn areas before each use. If any damaged areas are found, replace the hoses or cables immediately.

1. Read and understand all instructions and safety precautions as outlined in the manufacturer's Manual for the material you will weld or cut.

1. Proper cylinder care. Secure cylinders to a cart, wall, or post, to prevent them from falling. All cylinders should be used and stored in an upright position. Never drop or strike a cylinder. Do not use cylinders that have been dented. Cylinder caps should be used when moving or storing cylinders. Empty cylinders should be kept in specified areas and clearly marked "empty."

2. Never use oil or grease on any inlet connector, outlet connector, or cylinder valves.

3. Use only supplied Torch on this Inverter Air Plasma Cutter. Using components from other systems may cause personal injury and damage components within.

4. People with pacemakers should consult their physician(s) before using this product. Electromagnetic fields in close proximity to a heart pacemaker could cause interference to, or failure of the pacemaker.

5. USE PROPER EXTENSION CORD.

Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. We recommend that a 15amp extension cord be used with the 1.5mm² cable. The following Toolex Industrial Extension Leads would be suitable 594530 10 metre, 594531 20 metre & 594532 30 metre.

SPECIFICATIONS

MODEL	511468
POWER VOLTAGE (V)	1PH ~ 220V+15%
FREQUENCY (HZ)	(50/60HZ)
RATED INPUT CURRENT (A)	15A
NO-LOAD VOLTAGE	19.8
OUTPUT CURRENT (A)	15-40
DUTY CYCLE (%)	100% @ 30A
PSI	60-80PSI@4-6kg/cm2
STEEL PLATE	12mm
ALUMINUM PLATE	8mm
EFFICIENCY	85
PROTECTION CLASS	IP 21S
DIMENSIONS	490 x 270 x 350
WEIGHT	8.5KG

DUTY CYCLE

Duty Cycle is the equipment specifications which defines the number of minutes within a 10 minute period that a piece of equipment can safely operate.

This plasma cutter 40 has a 60% duty cycle at 40 Amps, which means that it may be used only 6 minutes at 40 Amps out of any 10 minute period, and must be rested the remaining 4 minutes.

CAUTION: Failure to observe the duty cycle limitations of this Plasma Cutter can easily damage this equipment, and will void warranty.

Preparing Your Work Area

1. You must have a sturdy work table that is open below the area you are cutting. Molten slag will be blown through the work metal, and must be able to fall away freely
2. Your work table must allow the work metal to be firmly clamped to prevent it accidentally falling or moving.
3. The floor and surrounding area of your work site must not be flammable. A clean cement floor is recommended. The cutting process will eject molten metal slag onto the floor, and it will scatter for 2.3-3m or more in any direction. Have an adequate fire extinguisher available if needed.

ASSEMBLY

Grounding the tool:

Attach a ground wire of at least 14 Ga. thicknesses (not supplied) to the screw on the lower left of the back of the tool case. Connect the other end of the wire to an appropriate ground, such as a steel workbench, steel biding member or grounding electrode.

Attaching the Air Supply:

WARNING: Only use dry air as the gas in this tool. Use of any other gas, such as oxygen, acetylene, etc. may cause explosion.

Water filter

Air input coupling

1. Attach the water filter as the above photo.

2. A male quick release adapter is mounted on the rear of the tool. Attach your pressurized air supply using your female quick release adapter. Adjust your air supply deliver 60-80 PSI at 3.5 CFM.

3. During operation, you can regulate air pressure through the Plasma Cutter by adjusting the knob located on top of the tool.

4. If the tool becomes over pressurized, there is a pressure relief valve on the top of the unit.

1. Power Switch. Up is ON, down is OFF.

2. Power supply indicator.

3. Thermal Overload Indicator Lamp. This light will come on, and the device will shut down if the tool becomes overheated. Stop trying to use the cutter while leaving the power switch onto allow the cooling fan to operate, and the lamp will turn off automatically when the machine cools down. Please pay attention to the Rated Duty Cycle discussed on page 7.

4. Power Supply Controller.

OPERATION

Note: Before beginning, please read and understand all the safety precautions staring on page 1 and especially the section "Specific Safety Rules" starting on page 3.

1. Mount the metal to be cut to the metal weeding-cutting table. It should be mounted so that the cutting debris falls to the cement floor.

2. Place the Air Plasma Cutter unit no closer than six feet from the workpiece to be cut.

3. Connect an air hose and coupling (not supplied) from the air supply tank to the Air Input Coupling at the rear of the unit. See photo on page 8 right. The air supply must be regulated to between 60 and 80 PSI as read on the Air Pressure Gauge. The air supply must be dry. It is recommended to install a moisture filter (not included) on the compressor. Do not use an air oiler.

4. Connect the Torch Cable plug into the twist-lock connector on the lower left unit front. Twist to lock.

5. Plug in the Grounding Cable into the Ground Connector on the lower right of the unit front. Twist to lock.

6. Securely place the clamping end of the Grounding Cable Clamp to a part of the work piece or metal table that is clean of paint, oil, or dirt. Clamp as close as possible to the work piece without damaging the cable during cutting.

7. Verify that the Power Switch is in the Off (O) position, then plug the 240V-line cord plug into an appropriate 240V-outlet for 511468.

8. Turn the Power Supply Controller to the desired current (15 to 40 amps).

9. Adjust air pressure by turning the Pressure Regulator Knob on top of the unit (see photo on page 8). Read pressure on Pressure Gauge.

10. When everything is in place for cutting, press the Power Switch UP to the ON position. The Power Light" WILL illuminate, but the Torch is not yet energized.

11. Orient yourself to one side of the area to be cut, and move the Welding Helmet Face Shield (not included, see page 4 item 7) over your eyes.

BE CAREFUL! PILOT PLASMA ARC CAN SEVERELY INJURE.

Once the 1. trigger is squeezed, the arc will ignite. This unit provides a pilot arc, so the torch does not need to contact the work piece before the cutting arc ignites.

Caution: The Torch handle is now energized. Be careful not touch anything else with the Torch except the work piece to be cut.

Warning: Never look at the ignited arc without the approved, arc shaded, eye protection in a full face shield. Permanent eye damage or blindness can occur, also Skin burns can occur. Never breathe arc fumes.

1. Bring the Electrode (4A) of the Torch close to the staring point of the cut. The Working Indicator Light will come on.

2. Slowly move the Torch at a slight angle along the cutting line with the Torch tip trailing.

The air causes the molten metal to fall away from the work piece being cut. If proper cutting is not achieved, adjust the Power Supply Controller to a higher level, and/or increase air flow. To increase air flow, press the Power Switch to the Off (O) position, then adjust the air pressure at the Air Pressure Regulator. The air will continue for a few seconds once the trigger is released.

Note: If too much current is drawn from the Plasma Cutter (i.e., short circuit),the Thermal Switchman overload protector, will activate and the red Thermal Overload Indicator Light will light. The Plasma Cutter will turn off until it cools down. To reset you must turn the power OFF then back ON. Press the Trigger to begin cutting again.

3. When finished cutting:

a. Release the Torch handle trigger and lift the Torch handle from the work piece,

b. Press the Power Switch to the Off (O) position.

Set the Torch handle down on the a. metal workbench,

b. Turn the air supply off,

c. Unplug the line cord from the electrical outlet.

PLASMA CUTTING TECHNIQUE

Using a plasma cutter is a skill that requires time and effort to do well. Practice striking and maintaining an arc on scrap work pieces before beginning work. This will help you gauge the best settings for the plasma cutter for the material at hand.

1. You can cut metal that will conduct electricity up to approximately 1/2" thick mild steel or equivalent. Very thin or very thick metals are more difficult to cut cleanly.
2. Generally set the air pressure between 60 and 80 psi. Increased air pressure will increase plasma speed and cutting pressure. Air pressure and amperage should be adjusted in tandem.
3. Generally start with a mid-range amperage setting (32-33 amps) and adjust up or down from there. Increased amperage will increase cutting heat. This is needed with heavier and harder metals. However, increased amperage will reduce Duty Cycle time. (See page 7.)
4. Move the cutting head more slowly for thicker and harder metals, and more quickly for thin or soft metals. Keep the cutting head moving while cutting.

How do Plasma Cutters Work?

Plasma cutters work by feeding an inert gas (air) through an electric arc. The air is then heated to an extremely high temperature which converts the gas to plasma which cuts the metal.

High temperature and pressure are required to create a plasma. The electric arc provides the temperature, and by exhausting the air through a very small orifice, the pressure is increased far beyond the 60-80 PSI operating pressure of the air supply.

What is Plasma?

Materials in Nature exist in one of four different states: Solid, Liquid, Gas or Plasma. Plasma is very rare on Earth because of its very high temperature; however most of the matter in the universe is plasma. The Sun, stars and galaxies are made of plasma. On Earth, you will find plasma in lightening and a few other places. Neon tubes and florescent lights contain low-temperature plasma when lighted.

The difference between water ice, liquid water and water vapor is temperature. In each of these states, temperature energy pushes the molecules of water away from each other to change the water is in. At very high temperature and pressure the water molecules themselves break apart, and the atoms begin to ionize. Normal atoms are made up of protons and neutrons in the nucleus, surrounded by a cloud of electrons. In plasma, the electrons separate from the nucleus. The electrons are negatively charged, and they leave behind their positively charged nuclei which are known as ions. When the fast-moving electrons collide with other electrons and ions, they release vast amounts of energy. This energy is what gives plasma its unusual status and great cutting power..

How do Plasma Cutters Work?

Plasma cutters work by sending a pressurized gas through a small channel. In the centre of this channel, there is a negatively charged electrode. When power is supplied to the negative electrode, and the tip of the nozzle contacts the work metal, the connection creates a circuit. When the nozzle is lifted away, the arc will continue. As the inert gas passes through the channel, the arc heats the gas until it becomes ionized. This reaction creates a stream of directed plasma, approximately 30,000°(16,649°C) and moving at approximately 20,000 feet per second (6,096 m/sec),that reduces metal to molten slag.

The plasma itself conducts electrical current. The cycle of creating the arc is continuous as long as power is supplied to the electrode and the plasma stays in contact with the metal that is being cut. In order to ensure this contact, protect the cut from oxidation, and regulate the unpredictable nature of plasma, the cutter nozzle has a second set of channels. These channels release a constant flow of shielding gas around the cutting area. The pressure of this gas flow effectively controls the radius of the plasma beam.

MAINTENANCE

WARNING! Make sure the Power Switch of the Plasma Cutter is in its "OFF" position and that the tool is unplugged from the electrical outlet before performing any inspection, maintenance, or cleaning procedures.

Before each use, inspect the general condition of the Air Plasma Cutter. Check for loose cable connections, misalignment or binding of the fan, cracked or broken parts, damaged electrical wiring, and any other condition that may affect its safe operation. If abnormal noise or vibration occurs, have the problem

1. Corrected before further use. Do not use damaged equipment.
2. Periodically recheck all nuts, bolts, and screws for tightness.
3. Periodically blow the dust from the cooling vents with compressed air.
4. Verify that the cooling fan is operational before cutting.
5. If the unit repeatedly shuts down from thermal overload, stop all use. Have the Air Plasma Cutter inspected and repaired by a qualified service technician.
6. Store the welder and accessories in a clean and dry location.
7. Periodically disassemble and clean the Torch Head components with steel wool. Replace burnt, cracked, distorted, or coated components, Refer to the assembly drawing on page 11.
8. To gain access to the internal components of the unit, remove screws from Main Body Cover. The home user is strongly advised not to remove the tool covers and not to attempt any electronic repairs. Any repairs must be completed by a qualified technician. Opening the tool will void any warranties, and may result in damage to equipment or possible personal injury. Don't do it.
9. On a daily basis check for any of the following problems: If any are found, take the tool to a qualified repair technician.

- a. Abnormal vibration, sound or smell.
- b. Abnormal heating at any cable connection.
- c. Then fan does not work properly.
- d. Any switch or control does not work properly.
- e. Any damage to cables.

TROUBLESHOOTING IMPORTANT!

Be CERTAIN to shut off the Plasma Cutter, and disconnect it from power and air before adjusting, cleaning, or repairing the unit. A technician should discharge all capacitors before performing and internal procedures.

FAN RUN WHEN SWITCHED ON BUT ARC WILL NOT IGNITE

The Air pressure may be too high or too low. Check the Air Pressure setting on the regulator's gauge.

AIR PRESSURE TOO HIGH

Adjust the Air Regulator to deliver only 60-80 PSI to the Cutter.

AIR PRESSURE CORRECT

Make sure that all air and electrical connections are tight.

AIR PRESSURE TOO LOW

- a. Verify that the compressor is delivering at least 3.5CFM @60 PSI to the tool
- b. The Regulator on the unit must be set to at least 60 PSI

LOOSE CONNECTIONS

Shut off switch, if not off already, and tighten connections. If connections do not tighten properly, contact a qualified technician.

TIGHT CONNECTIONS

Disconnect the Torch Cables.

Disassemble the torch assembly and inspect all internal components.

Replace any damaged or missing components and reassemble carefully.

If the steps above do not solve the problem or if the repair involved are too complex, Please contact a qualified technician.

Be CERTAIN to shut off the Plasma Cutter, and disconnect it from power and air before adjusting, cleaning, or repairing the unit, A technician should discharge all capacitors before performing any internal procedures.

ARC IGNITES FOR SEVERAL SECONDS BUT THEN GOES OUT

The air pressure may be too high or too low. Check the Air Pressure setting on the regulator's gauge.

AIR PRESSURE TOO HIGH

Adjust the Air Regulator to deliver only 60-80 PSI to the Cutter.

AIR PRESSURE CORRECT

Check that the grounding point and the metal being cut are clean, dry, and free from all coatings and paint. These sections need to be able to conduct electricity efficiently

AIR PRESSURE TOO LOW

- a. Verify that the compressor is delivering at least 3.5CFM@ 80 PSI to the tool.
- b. The Regulator on the unit must be set to at least 60 PSI.

DIRTY OR COATED METAL

Use a wire wheel brush or sander (not included) to thoroughly clean both the grounding point and the area that will be cut. If any cleaners are used, allow them to dry thoroughly before

METAL IS CLEAN IN BOTH AREAS

Make sure that all air and electrical connections are tight

LOOSE CONNECTIONS

Shut off switch, if not off already, and tighten connections. If connections do not tighten properly, contact a qualified technician.

- a. Make certain that you don't lose work piece contact after an arc is struck.
- b. Make sure that the Torch can function correctly.

Disconnect the Torch Cables.

Disassemble the torch assembly and inspect all internal components.

Replace any damaged or missing components and reassemble carefully.

DO NOT OVERTIGHTEN.

- c. Nozzle is moving too slowly across the metal and cutting the material from underneath, breaking contact.

Be CERTAIN to shut off the Plasma Cutter, and disconnect it from power and air before adjusting, cleaning, or repairing the unit, A technician should discharge all capacitors before performing any internal procedures.

CUT GOES ONLY PARTIALLY THROUGH THE WORKPIECE

Material being cut is too thick. Maximum thickness for steel is 1/2".

WITHIN THICKNESS RANGE

Turn up the current adjustment knob and try again.

MATERIAL TOO THICK

You may wish to cut the object along one side and then cut along the other. If this is not practical, use a more powerful Cutter.

PROBLEM CORRECTED

You may wish to take note of the setting required for this metal thickness

PROBLEM PERSISTS AT MAXIMUM SETTING

The Air pressure may be too low. Check the Air Pressure setting on the regulator's gauge.

AIR PRESSURE CORRECT

Disassemble the torch assembly and inspect all internal components, as explained on page 11.

TROUBLESHOOTING continued..

AIR PRESSURE TOO LOW

- a. Verify that the compressor is delivering at least 6 CFM @60 PSI to the tool.
- b. The Regulator on the unit must be set to at least 60 PSI.

TORCH IN GOOD CONDITION

Try cutting at a slower pace, the arc may not have enough time to cut through the work piece.

DAMAGED COMPONENTS FOUND

Replace any damaged or missing components and reassemble carefully.

Be CERTAIN to shut off the Plasma Cutter, and disconnect it from power and air before adjusting, cleaning, or repairing the unit, A technician should discharge all capacitors before performing any internal procedures.

FAST NOZZLE WEAR OR EXCESSIVE SLAG FORMATION

These two problems have similar causes and will often appear simultaneously.

The same diagnostic procedures and remedies apply to both.

The Amperage setting may be too high; try cutting at a lowest setting possible for the metal being cut.

PROBLEMS REDUCED

Take into account the thickness and type of metal to be cut before you start. Thinner materials will typically require lower amp settings.

PROBLEMS PERSIST AT LOWEST PRACTICAL SETTING

Disconnect the Torch Cables.

Disassemble the torch assembly and inspect all internal components.

TORCH IN GOOD CONDITION

Air supply pressure may be inadequate:

- a. Verify that the compressor is delivering at least 6 CFM @ 60 PSI to the tool.
- b. The Regulator on the unit must be set to at least 60 PSI

DAMAGED COMPONENTS FOUND

Replace any damaged or missing components and reassemble carefully.

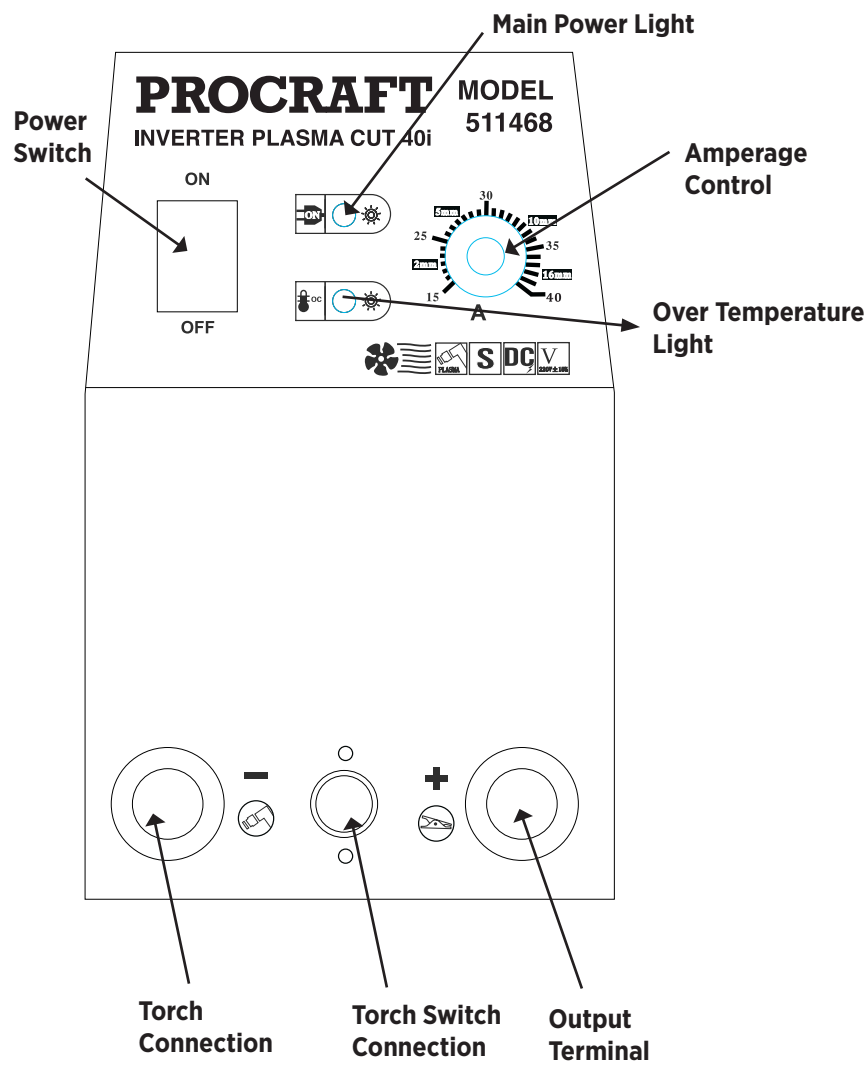
GUARANTEE PROCRAFT WARRANTY INFORMATION

Every PROCRAFT welder has been thoroughly inspected and tested before leaving the factory. In addition to any statutory regulations, TOOLEX warrants all of its products against faulty workmanship and faulty material for a twelve (12) month period from the date of purchase and undertakes, once inspected, to repair or replace, free of charge each product or part thereof that are faulty, on condition that: The complete product is returned to TOOLEX or one of its Authorised Service Centres, in person of freight pre-paid by the consumer, and the tool is found on examination, to be faulty from a manufacturing defect. The product or relevant spare parts have not been misused, neglected, or been damaged by in an accident or the repairs are required due to normal wear and tear. Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for major failure and for compensation for any reasonable foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

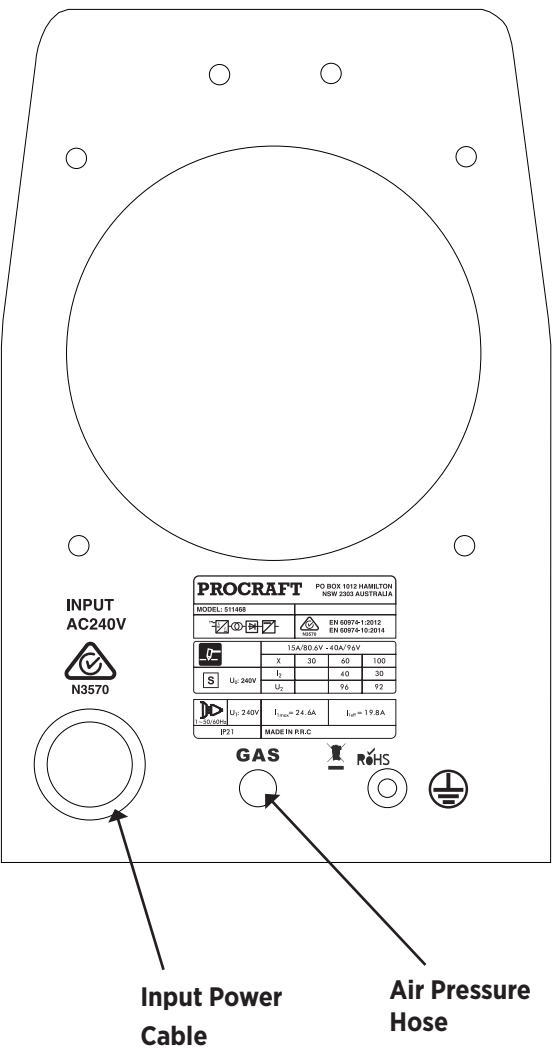
PLEASE SUPPLY A COPY OF YOUR TAX INVOICE FOR YOUR WARRANTY!

The guarantee is limited to manufacturing or machining failures, and ceases when the parts have been disassembled, manipulated or repaired out of works.

511468 Front Unit



511468 Back Unit



INCLUDED STANDARD ACCESSORIES

511468: 40i PLASMA CUTTER



INCLUDED STANDARD ACCESSORIES



**Plasma Cutting Torch
(500889)**



**Earth Clamp
(500892)**