



PR-30P Exocut™ Plasma Cutting and Gouging System

Operator Manual

86-8011 (808730) | Revision 1



Congratulations on acquiring your new Pro Spot PR-30P Exocut! Team Pro Spot looks forward to supporting you.

The following information will be needed when you call Pro Spot:

Model type: PR-30P Exocut

Serial number:

For parts or service contact your local distributor.

Local number:

In the USA call toll free 1-877-PRO SPOT or 1-760-407-1414 for a customer service representative.

Visit Pro Spot online: www.prospot.com

E-mail: info@prospot.com

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About Pro Spot

Pro Spot International, Inc., based in Carlsbad, California, manufactures resistance spot welding equipment specializing in applications for the collision repair industry. The company began in 1986. The company owns and manages an on site machine shop, research & development department, a fabrication facility and production lines for the various welders.

Pro Spot International exports its products worldwide, export sales are managed through our headquarter office. The company owns numerous patents for our ingenious application tools, machines, and procedures.

Pro Spot training and services

Pro Spot Distributors and Sub-Distributors are carefully selected and are well trained in the collision repair industry. We offer technical and service education at our world wide training facilities at regular intervals so your local distributor will always be up to date and able to pass on the latest in spot welding technology to our customers.

Customer service is an important part of any investment and our distributors and sub-distributors will be there to support your technical and service needs. We have a great customer service record, we tend to keep it that way.



Pro Spot is certified by CASE and a member of the ICAR Industry Training Alliance

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PR-30P Exocut

Operator Manual

86-8011
Revision 1

English

August 2014

Pro Spot International, Inc.
Carlsbad, CA 92010 USA



Safety information



Before operating this system, read the separate *Safety and Compliance Manual* (86-8015) included with your product for important safety information.

Electromagnetic Compatibility (EMC)	SC-13
Installation and use	SC-13
Assessment of area	SC-13
Methods of reducing emissions	SC-13
Mains supply	SC-13
Maintenance of cutting equipment	SC-14
Cutting cables	SC-14
Equipotential bonding	SC-14
Earthing of the workpiece	SC-14
Screening and shielding	SC-14
Warranty	SC-15
Attention	SC-15
General	SC-15
Patent indemnity	SC-16
Limitation of liability	SC-16
National and local codes	SC-16
Liability cap	SC-16
Insurance	SC-16
Transfer of rights	SC-16
1 Specifications	17
Safety information	17
System description	17
Power supply dimensions	18
System weights	18
Pro Spot system ratings	19
Torch dimensions	20

Contents

- Torch weight 20
- Cutting specifications 20
- Symbols and marks 21
 - Noise levels 22
 - IEC symbols 22

- 2 Power Supply Setup 23**
 - Unpack the plasma system 23
 - Claims 23
 - System contents 24
 - Position the plasma system 25
 - Prepare the electrical power 25
 - Voltage configurations 26
 - Requirements for grounding 27
 - Power cord considerations 27
 - Extension cord recommendations 28
 - Generator recommendations 28
 - Prepare the gas supply 29
 - Connect the gas supply 29
 - Additional gas filtration 30

- 3 Torch Setup 31**
 - Introduction 31
 - Hand torch components 31
 - Consumable life 32
 - Choose the consumables 32
 - Using the cut charts 34
 - General-purpose (standard) consumables 35
 - 240 V / 30 A cutting 36
 - ThinCut consumables 37
 - 120 V / 25 A cutting 38
 - 120 V / 30 A cutting 39
 - Gouging consumables 40

- 4 Operation 41**
 - Controls and indicators 41
 - Rear controls 41
 - Front controls and LEDs 42
 - Operate the plasma system 43
 - Connect the electrical power and gas supply 43
 - Install the consumables 44

- Attach the ground clamp 46
- Power ON the system 46
- Adjust the gas pressure and output current 46
 - Operating the system on a 120 V, 15 A circuit 47
 - Operating the system on a 120 V, 20 A circuit 47
 - Operating the system on a 240 V, 20 A circuit 47
- Check the indicator LEDs 48
- Verify the system is ready 48
- Understand duty-cycle limitations 48
- System operation guidelines 49
- Hand torch operation 50
 - Safety catch operation 51
 - Hand torch cutting guidelines 52
 - Recommendations for cutting at 120 V 53
 - Edge start on a workpiece 53
 - Pierce a workpiece 55
 - Gouge a workpiece 56
 - General gouging 56
 - Remove a spot weld 58
 - Varying the gouge profile 60
 - Common hand-cutting faults 61
 - Minimizing dross 61
- 5 Maintenance and Troubleshooting 63**
 - Perform routine maintenance 63
 - Inspect the consumables 65
 - Basic troubleshooting 66
 - Maintenance procedures 69
 - Replace the air filter element and air filter bowl 69
 - Remove the power supply cover and handle 69
 - Remove the old air filter element and air filter bowl 70
 - Install the new air filter element and air filter bowl 71
 - Put the power supply cover and handle back in place 72
- 6 Parts 75**
 - Power supply parts 76
 - Exterior, front 76
 - Exterior, rear 77
 - Air filter/regulator with pressure switch assembly (interior, fan side) 78
 - Hand torch consumables 79
 - General-purpose (standard) consumables 79

Contents

ThinCut consumables 79
Gouging consumables 79
Accessory parts 80
PR-30P Exocut labels 80

Installation and use

The user is responsible for installing and using the plasma equipment according to the manufacturer's instructions.

If electromagnetic disturbances are detected then it shall be the responsibility of the user to resolve the situation with the technical assistance of the manufacturer. In some cases this remedial action may be as simple as earthing the cutting circuit, see *Earthing of the work piece*. In other cases, it could involve constructing an electromagnetic screen enclosing the power source and the work complete with associated input filters. In all cases, electromagnetic disturbances must be reduced to the point where they are no longer troublesome.

Assessment of area

Before installing the equipment, the user shall make an assessment of potential electromagnetic problems in the surrounding area. The following shall be taken into account:

- a. Other supply cables, control cables, signaling and telephone cables; above, below and adjacent to the cutting equipment.
- b. Radio and television transmitters and receivers.
- c. Computer and other control equipment.
- d. Safety critical equipment, for example guarding of industrial equipment.
- e. Health of the people around, for example the use of pacemakers and hearing aids.
- f. Equipment used for calibration or measurement.
- g. Immunity of other equipment in the environment. User shall ensure that other equipment being used in the environment is compatible. This may require additional protection measures.
- h. Time of day that cutting or other activities are to be carried out.

The size of the surrounding area to be considered will depend on the structure of the building and other activities that are taking place. The surrounding area may extend beyond the boundaries of the premises.

Methods of reducing emissions

Mains supply

Cutting equipment must be connected to the mains supply according to the manufacturer's recommendations. If interference occurs, it may be necessary to take additional precautions such as filtering of the mains supply.

Consideration should be given to shielding the supply cable of permanently installed cutting equipment, in metallic conduit or equivalent. Shielding should be electrically continuous throughout its length. The shielding should be connected to the cutting mains supply so that good electrical contact is maintained between the conduit and the cutting power source enclosure.

Maintenance of cutting equipment

The cutting equipment must be routinely maintained according to the manufacturer's recommendations. All access and service doors and covers should be closed and properly fastened when the cutting equipment is in operation. The cutting equipment should not be modified in any way, except as set forth in and in accordance with the manufacturer's written instructions. For example, the spark gaps of arc striking and stabilizing devices should be adjusted and maintained according to the manufacturer's recommendations.

Cutting cables

The cutting cables should be kept as short as possible and should be positioned close together, running at or close to the floor level.

Equipotential bonding

Bonding of all metallic components in the cutting installation and adjacent to it should be considered.

However, metallic components bonded to the workpiece will increase the risk that the operator could receive a shock by touching these metallic components and the electrode (nozzle for laser heads) at the same time.

The operator should be insulated from all such bonded metallic components.

Earthing of the workpiece

Where the workpiece is not bonded to earth for electrical safety, nor connected to earth because of its size and position, for example, ship's hull, building steel work, or vehicle frame, a connection bonding the workpiece to earth may reduce emissions in some, but not all instances. Care should be taken to prevent the earthing of the workpiece increasing the risk of injury to users, or damage to other electrical equipment. Where necessary, the connection of the workpiece to earth should be made by a direct connection to the workpiece, but in some countries where direct connection is not permitted, the bonding should be achieved by suitable capacitances selected according to national regulations.

Note: The cutting circuit may or may not be earthed for safety reasons. Changing the earthing arrangements should only be authorized by a person who is competent to assess whether the changes will increase the risk of injury, for example, by allowing parallel cutting current return paths which may damage the earth circuits of other equipment. Further guidance is provided in IEC 60974-9, Arc Welding Equipment, Part 9: Installation and Use.

Screening and shielding

Selective screening and shielding of other cables and equipment in the surrounding area may alleviate problems of interference. Screening of the entire plasma cutting installation may be considered for special applications.

Attention

Genuine Pro Spot parts are the factory-recommended replacement parts for your Pro Spot system. Any damage or injury caused by the use of other than genuine Pro Spot parts may not be covered by the Pro Spot warranty, and will constitute misuse of the Pro Spot Product.

You are solely responsible for the safe use of the Product. Pro Spot does not and cannot make any guarantee or warranty regarding the safe use of the product in your environment.

General

Pro Spot International, Inc. warrants that its Products shall be free from defects in materials and workmanship for the specific periods of time set forth herein and as follows: if Pro Spot is notified of a defect (i) with respect to the plasma power supply within a period of three (3) years from the date of delivery to you, and (ii) with respect to the torch and leads within a period of one (1) year from its date of delivery to you.

This warranty shall not apply to any power supplies that have been used with phase converters. In addition, Pro Spot does not warranty systems that have been damaged as a result of poor power quality, whether from phase converters or incoming line power. This warranty shall not apply to any product which has been incorrectly installed, modified, or otherwise damaged.

Pro Spot provides repair, replacement or adjustment of the Product as the sole and exclusive remedy, if and only if the warranty set forth herein properly is invoked and applies. Pro Spot, at its sole option, shall repair, replace, or adjust, free of charge, any defective Products covered by this warranty which shall be returned with Pro Spot's prior authorization (which shall not be unreasonably withheld), properly packed, to Pro Spot's place of business in Carlsbad, CA, or to an authorized Pro Spot repair facility, all costs, insurance and freight pre paid by the customer. Pro Spot shall not be liable for any repairs, replacement, or adjustments of Products covered by this warranty, except those made pursuant to this paragraph and with Pro Spot's prior written consent.

The warranty set forth above is exclusive and is in lieu of all other warranties, express, implied, statutory, or otherwise with respect to the Products or as to the results which may be obtained therefrom, and all implied warranties or conditions of quality or of merchantability or fitness for a particular purpose or against infringement. The foregoing shall constitute the sole and exclusive remedy for any breach by Pro Spot of its warranty.

Distributors/OEMs may offer different or additional warranties, but Distributors/OEMs are not authorized to give any additional warranty protection to you or make any representation to you purporting to be binding upon Pro Spot.

Patent indemnity

Except only in cases of products not manufactured by Pro Spot or manufactured by a person other than Pro Spot not in strict conformity with Pro Spot's specifications and in cases of designs, processes, formulae, or combinations not developed or purported to be developed by Pro Spot, Pro Spot will have the right to defend or settle, at its own expense, any suit or proceeding brought against you alleging that the use of the Pro Spot product, alone and not in combination with any other product not supplied by Pro Spot, infringes any patent of any third party. You shall notify Pro Spot promptly upon learning of any action or threatened action in connection with any such alleged infringement (and in any event no longer than fourteen (14) days after learning of any action or threat of action), and Pro Spot's obligation to defend shall be conditioned upon Pro Spot's sole control of, and the indemnified party's cooperation and assistance in, the defense of the claim.

Limitation of liability

In no event shall Pro Spot be liable to any person or entity for any incidental, consequential direct, indirect, punitive or exemplary damages (including but not limited to lost profits) regardless of whether such liability is based on breach of contract, tort, strict liability, breach of warranty, failure of essential purpose, or otherwise, and even if advised of the possibility of such damages.

National and local codes

National and local codes governing plumbing and electrical installation shall take precedence over any instructions contained in this manual. In no event shall Pro Spot be liable for injury to persons or property damage by reason of any code violation or poor work practices.

Liability cap

In no event shall Pro Spot's liability, if any, whether such liability is based on breach of contract, tort, strict liability, breach of warranties, failure of essential purpose or otherwise, for any claim, action, suit or proceeding (whether in court, arbitration, regulatory proceeding or otherwise) arising out of or relating to the use of the Products exceed in the aggregate the amount paid for the Products that gave rise to such claim.

Insurance

At all times you will have and maintain insurance in such quantities and types, and with coverage sufficient and appropriate to defend and to hold Pro Spot harmless in the event of any cause of action arising from the use of the products.

Transfer of rights

You may transfer any remaining rights you may have hereunder only in connection with the sale of all or substantially all of your assets or capital stock to a successor in interest who agrees to be bound by all of the terms and conditions of this Warranty. Within thirty (30) days before any such transfer occurs, you agree to notify in writing Pro Spot, which reserves the right of approval. Should you fail timely to notify Pro Spot and seek its approval as set forth herein, the Warranty set forth herein shall be null and void and you will have no further recourse against Pro Spot under the Warranty or otherwise.

Safety information

Before operating any Pro Spot equipment, read the separate *Safety and Compliance Manual* included with your product for important safety information.

System description

The PR-30P Exocut is a highly portable, 30 A, handheld plasma cutting system appropriate for a wide range of applications. It uses air or nitrogen to cut electrically conductive metals, such as mild steel, stainless steel, or aluminum. With it you can cut thicknesses up to 15 mm (5/8 inches) and pierce thicknesses up to 6 mm (1/4 inch).

Typically all configurations include:

- 1 complete set of general-purpose (standard) consumables (preinstalled on the Pro-30T hand torch) for standard cutting:
 - 1 electrode
 - 1 swirl ring
 - 1 nozzle
 - 1 retaining cap
 - 1 shield
- 1 extra general-purpose nozzle
- 1 extra electrode
- Gouging consumables for gouging:
 - 1 gouging nozzle
 - 1 gouging shield
- ThinCut consumables for detailed cutting:
 - 1 ThinCut nozzle
 - 1 ThinCut deflector

1 – Specifications

- 1 region-specific air fitting:
 - Industrial interchange quick-disconnect nipple with 1/4 NPT threads
- External regulator for gouging
- Carrying strap
- Operator Manual
- Safety and Compliance Manual

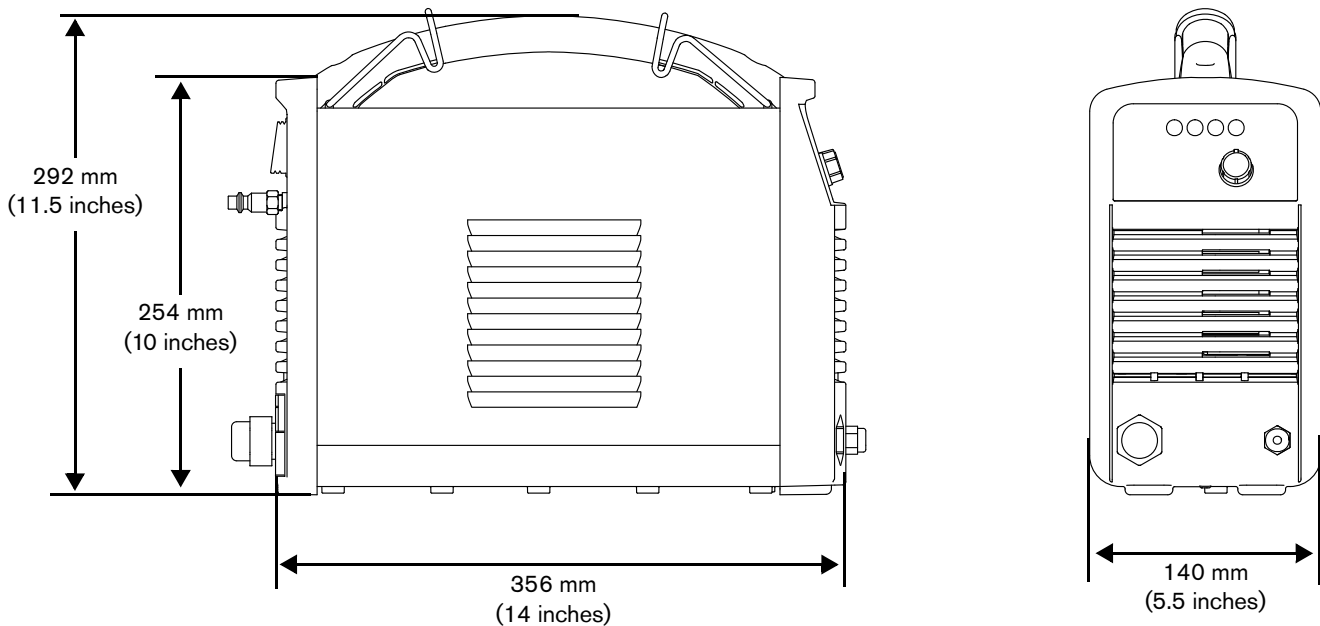


For details on how to select the right set of consumables for a given cutting job, see *Choose the consumables* on page 32.

Additional items may also ship with your system depending on the configuration that you ordered, such as instructional setup materials, a carrying case, leather cutting gloves, or protective glasses.

Units ship with a 120 V/15 A (NEMA 5-15P) adapter and a 240 V/20 A (NEMA 6-50P) adapter that connect to the NEMA twist lock-style 240 V/20 A (NEMA L6-20P) plug wired to the power supply. See *Power cord considerations* on page 27 for more information.

Power supply dimensions



System weights

The following system weights include the hand torch with 4.6 m (15 foot) torch lead, a 4.6 m (15 foot) work lead with ground clamp, and a 3.0 m (10 foot) power cord:

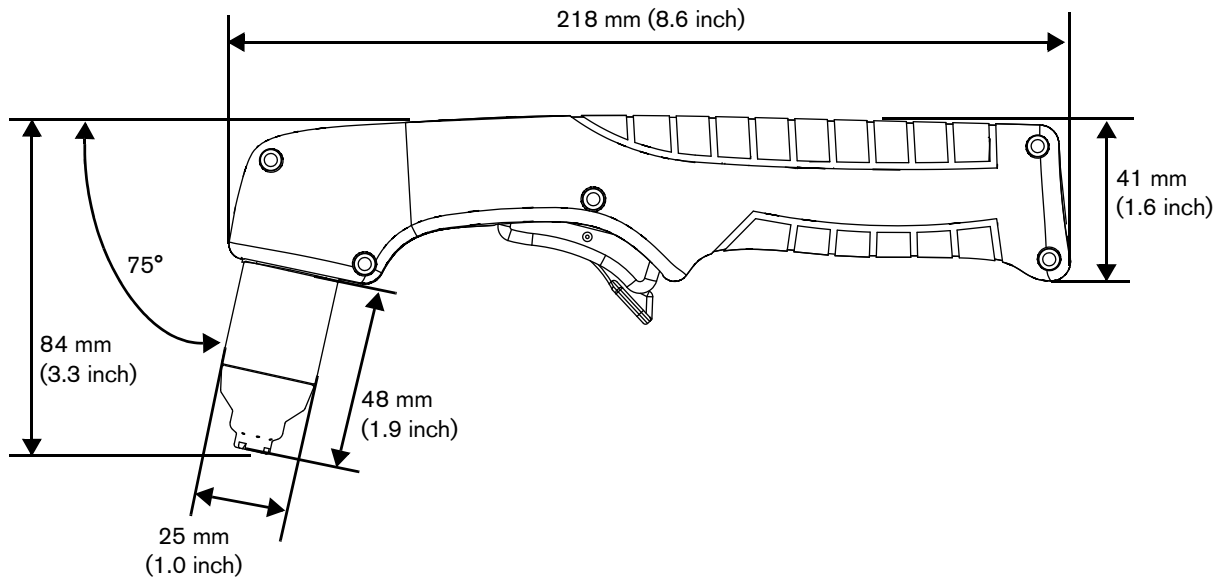
- 9.7 kg (21.4 pounds)

Pro Spot system ratings

Rated open circuit voltage (U_0)	256 VDC	
Rated output current (I_2)	15 A to 30 A	
Rated output voltage (U_2) at $U_1 = 120$ VAC	83 VDC	
Rated output voltage (U_2) at $U_1 = 200 - 240$ VAC	125 VDC	
Duty cycle at 40°C, $U_1 = 120$ VAC (See data plate on power supply for more information on duty cycle and for IEC ratings.)	20% ($I_2 = 30$ A, $U_2 = 83$ V) 60% ($I_2 = 17$ A, $U_2 = 83$ V) 100% ($I_2 = 15$ A, $U_2 = 83$ V)	
Duty cycle at 40°C, $U_1 = 200 - 240$ VAC (See data plate on power supply for more information on duty cycle and for IEC ratings.)	35% ($I_2 = 30$ A, $U_2 = 125$ V) 60% ($I_2 = 23$ A, $U_2 = 125$ V) 100% ($I_2 = 18$ A, $U_2 = 125$ V)	
Operating temperature	-10° to 40° C (14° to 104° F)	
Storage temperature	-25° to 55° C (-13° to 131° F)	
Power factor (120 V – 240 V)	0.99 – 0.97	
Input voltage (U_1)/ Input current (I_1) at rated output ($U_{2\text{ MAX}}$, $I_{2\text{ MAX}}$) (See <i>Voltage configurations</i> on page 26 for more information.)	120 V, 1-phase, 50/60 Hz, 25 A 200 – 240 V, 1-phase, 50/60 Hz, 22.5 – 18.8 A	
Gas type	Air	Nitrogen
Gas quality	Clean, dry, oil-free	99.995% pure
Minimum required gas inlet flow and pressure	99.1 L/min at 4.7 bar (3.5 scfm at 68 psi)	
Recommended gas inlet flow and pressure	113.3 L/min at 5.5 bar (4.0 scfm at 80 psi)	
Maximum gas inlet pressure	9.3 bar (135 psi)	

1 – Specifications

Torch dimensions



Torch weight

Hand torch with general-purpose (standard) consumables only	0.3 kg (0.75 pounds)
Hand torch with general-purpose (standard) consumables and 4.6 m (15 foot) lead (with strain relief)	1.1 kg (2.35 pounds)

Cutting specifications

240 V (with general-purpose [standard] consumables)	
Recommended cut capacity	9 mm (3/8 inch) at 500 mm/minute (20 inches/minute) 12 mm (1/2 inch) at 250 mm/minute (10 inches/minute)
Severance cut capacity	15 mm (5/8 inch) at 125 mm/minute (5 inches/minute)

120 V: Use the ThinCut nozzle and deflector for cutting on 120 V input circuits. When you operate the system at the maximum recommended output of 25 A, the cut capacities are:

- ❑ 6 mm (1/4 inch) at 480 mm/minute (19 inches/minute)
- ❑ 9 mm (3/8 inch) at 200 mm/minute (8 inches/minute)
- ❑ 12 mm (1/2 inch) at 75 mm/minute (3 inches/minute)



To understand the differences between the general-purpose, ThinCut, and gouging consumables, and for guidelines on selecting the right set for your cutting applications, see *Choose the consumables* on page 32.

Symbols and marks

Your product may have one or more of the following markings on or near the data plate. Due to differences and conflicts in national regulations, not all marks are applied to every version of a product.



S mark

The S mark indicates that the power supply and torch are suitable for operations carried out in environments with increased hazard of electrical shock according to IEC 60974-1.



CSA mark

Products with a CSA mark meet the United States and Canadian regulations for product safety. The products were evaluated, tested, and certified by CSA-International. Alternatively, the product may have a mark by one of the other Nationally Recognized Testing Laboratories (NRTL) accredited in both the United States and Canada, such as Underwriters Laboratories, Incorporated (UL) or TÜV.



CE mark

The CE marking signifies the manufacturer's declaration of conformity to applicable European directives and standards. Only those versions of products with a CE marking located on or near the data plate have been tested for compliance with the European Low Voltage Directive and the European Electromagnetic Compatibility (EMC) Directive. EMC filters needed to comply with the European EMC Directive are incorporated within versions of the product with a CE marking.



Eurasian Customs Union (CU) mark

CE versions of products that include an EAC mark of conformity meet the product safety and EMC requirements for export to Russia, Belarus, and Kazakhstan.



GOST-TR mark

CE versions of products that include a GOST-TR mark of conformity meet the product safety and EMC requirements for export to the Russian Federation.



C-Tick mark

CE versions of products with a C-Tick mark comply with the EMC regulations required for sale in Australia and New Zealand.



CCC mark

The China Compulsory Certification (CCC) mark indicates that the product has been tested and found compliant with product safety regulations required for sale in China.



UkrSEPRO mark

The CE versions of products that include a UkrSEPRO mark of conformity meet the product safety and EMC requirements for export to the Ukraine.



Serbian AAA mark

CE versions of products that include a AAA Serbian mark meet the product safety and EMC requirements for export to Serbia.

1 – Specifications

Noise levels

This plasma system may exceed acceptable noise levels as defined by national and local codes. Always wear proper ear protection when cutting. Any noise measurements taken depend on the specific environment in which the system is used. Refer to *Noise can damage hearing* in the *Safety and Compliance Manual* included with your system.

IEC symbols

The following symbols may appear on the power supply data plate, control labels, switches, and LEDs.



Direct current (DC)



An inverter-based power source



Alternating current (AC)



Volt/amp curve, “drooping” characteristic



Plasma torch cutting



Power is ON (LED)



AC input power connection



Inlet gas pressure fault (LED)



The terminal for the external protective (earth) conductor



Missing or loose consumables (LED)



Power is ON



Power supply is overheated (LED)



Power is OFF

Section 2

Power Supply Setup

Unpack the plasma system

1. Verify that you received all items on your order in good condition. Contact your distributor if any parts are damaged or missing. (See *System contents* on page 24.)
2. Inspect the system for damage that may have occurred during shipment. If you find evidence of damage, refer to *Claims*. All communications regarding this equipment must include the model number and the serial number located on the bottom of the power supply.
3. Before you set up and operate this system, read the separate *Safety and Compliance Manual* included with your system for important safety information.

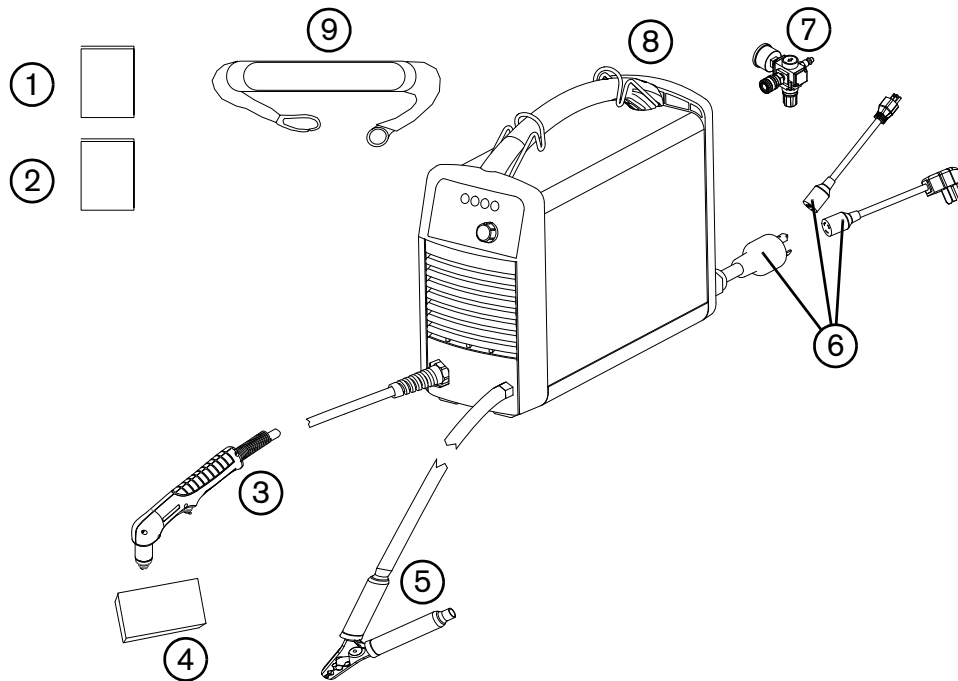
Claims

- **Claims for damage during shipment** – If your unit was damaged during shipment, file a claim with the carrier. You can contact Pro Spot for a copy of the bill of lading. If you need additional assistance, call the Pro Spot office listed in the front of this manual.
- **Claims for defective or missing merchandise** – If any component is missing or defective, contact your Pro Spot distributor. If you need additional assistance, call the Pro Spot office listed in the front of this manual.

System contents

The following illustration shows the components typically included with all system configurations. Additional components – such as setup instructions, a carrying case and protective glasses and gloves – may also be included with your system, depending on the configuration you ordered.

Figure 1



- | | |
|--------------------------------|---------------------------------------|
| 1 Operator Manual | 6 Power cord with power plug adapters |
| 2 Safety and Compliance Manual | 7 External regulator |
| 3 Hand torch with lead | 8 Power supply |
| 4 Consumable kit | 9 Carrying strap |
| 5 Ground clamp and work lead | |



The specific components included with the system are subject to change over time.

Position the plasma system

- Position the plasma system near an appropriate power receptacle. The system has a 3.0 m (10 foot) power cord.
- Allow at least 0.25 m (10 inches) of space around the power supply for proper ventilation.
- Place the power supply on a stable, level surface before using. To avoid toppling, do not set the power supply on an incline greater than 10 degrees.
- Do not use the system in rain or snow.

Prepare the electrical power

The system's maximum output voltage varies based on the input voltage and the circuit's amperage.

Additional factors must be considered when you are operating the system at an input power of 120 V, as tripped circuit breakers can result under some conditions. For more information, see *System operation guidelines* on page 49 and *Basic troubleshooting* on page 66.

2 – Power Supply Setup

Voltage configurations

The system automatically adjusts for proper operation at the current input voltage without requiring you to perform any switching or rewiring. However, you must set the amperage adjustment knob to an appropriate output current and verify that an appropriate set of consumables is properly installed in the torch. For more information, see *Adjust the gas pressure and output current* on page 46 and *Install the consumables* on page 44.

The following table shows the maximum rated output for typical combinations of input voltage and amperage. The output setting you need to use depends on the thickness of the metal and is limited by the input power to your system.

Input voltage circuit*	Rated output	Input current at rated output	kVA	Recommended consumables†
120 V, 15 A	20 A, 83 V	16.4 A	2.0	ThinCut
120 V, 15 A	20 A, 83 V	13 A	1.6	Gouging
120 V, 20 A	25 A, 83 V	20.5 A	2.5	ThinCut
120 V, 30 A	30 A, 83 V	25 A	3.0	ThinCut
200 V – 240 V, 20 A	15 A, 125 V	11 A – 9 A	2.2	Gouging
200 V – 240 V, 20 A	30 A, 125 V	22.5 A – 18.8 A	4.5	General-purpose or ThinCut

* Input voltages can be $\pm 10\%$ of the values in this table.

† See *Choose the consumables* on page 32 for an explanation of general-purpose (standard), ThinCut, and gouging consumables.



CAUTION!

A circuit capable of 20 A/120 V or 20 A/240 V is required for proper operation. Protect the circuit with appropriately sized slow-blow (time-delay) fuses or circuit breakers.

Requirements for grounding

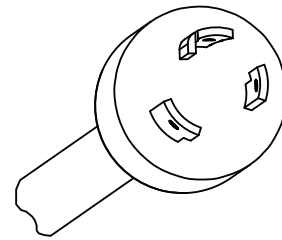
Properly ground the system as follows to ensure personal safety, proper operation, and to reduce electromagnetic interference (EMI):

- The system must be grounded through the power cord according to national and local electrical codes.
- Single-phase service must be of the three-wire type with a green wire for the protective earth ground and must comply with national and local requirements. **Do not use a two-wire service.**
- Refer to the *Safety and Compliance Manual* for more information.

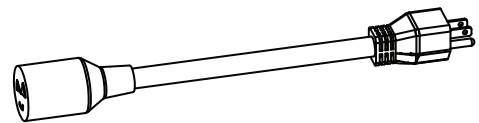
Power cord considerations

Configurations include the following plug and adapters.

- The power cord is equipped with a NEMA twist lock-style plug (NEMA L6-20P) appropriate for use on a 240 V/20 A circuit with a NEMA twist lock-style outlet.

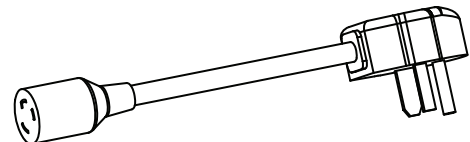


- To operate the system on a lower amperage circuit, attach the female end of the 120 V/15 A (NEMA 5-15P) plug adapter to the power supply's NEMA twist lock-style plug.



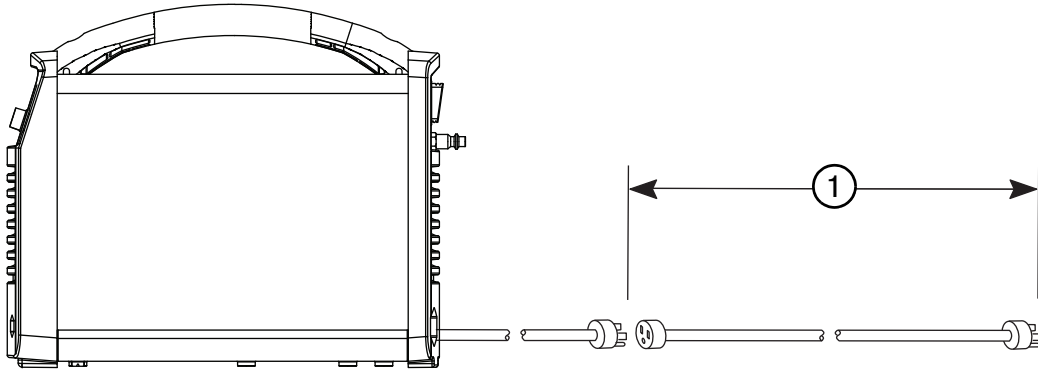
- Do not set the amperage adjustment knob above 20 A, or you may trip the circuit breaker. See *Adjust the gas pressure and output current* on page 46.

- To operate the system on a 240 V/20 A circuit, attach the female end of the 240 V/20 A (NEMA 6-50P) plug to the power supply's NEMA twist lock-style plug.




2 – Power Supply Setup

Extension cord recommendations



Use an extension cord of an appropriate wire gauge for the cord length and system voltage. Use a cord that meets national and local codes.


Input voltage	Phase	①	
		Recommended cord gauge size	Length
120 VAC	1	4 mm ² (12 AWG)	Up to 16 m (53 feet)
240 VAC	1	2 mm ² (14 AWG)	Up to 40.5 m (133 feet)


 Extension cords can cause the machine to receive less input voltage than the output of the circuit. This can limit the operation of your system.

Generator recommendations

Generators used with this system should produce 240 VAC.

Engine drive rating	Engine drive output current 1-phase	Performance (arc stretch)
5.5 kW	30 A	Full
4 kW	25 A	Limited

 Adjust the cutting current as needed based on the generator rating, age, and condition.

 If a fault occurs while using a generator, turn OFF the system and wait approximately 60 seconds before turning it ON again. Turning the power switch quickly to OFF and ON again (called a "quick reset") may not clear the fault.

Prepare the gas supply

The gas supply can be shop-compressed or cylinder-compressed. You must regulate the gas so that the gas reaches the filter on the power supply at 99.1 L/min at 4.7 bar (3.5 scfm at 68 psi). This system comes with a regulator that attaches to the air fitting on the back of the system. To make sure there is adequate pressure to the power supply, set the regulator between 5.5 bar and 6.9 bar (80 psi and 100 psi) for cutting and to 3.4 bar (50 psi) for gouging applications.

The system contains an internal filter element, but additional filtration may be required depending on the quality of the gas supply. If gas supply quality is poor, cut speeds decrease, cut quality deteriorates, cutting thickness capability decreases, and the life of the consumables shortens. For optimal performance, the gas should have a maximum:

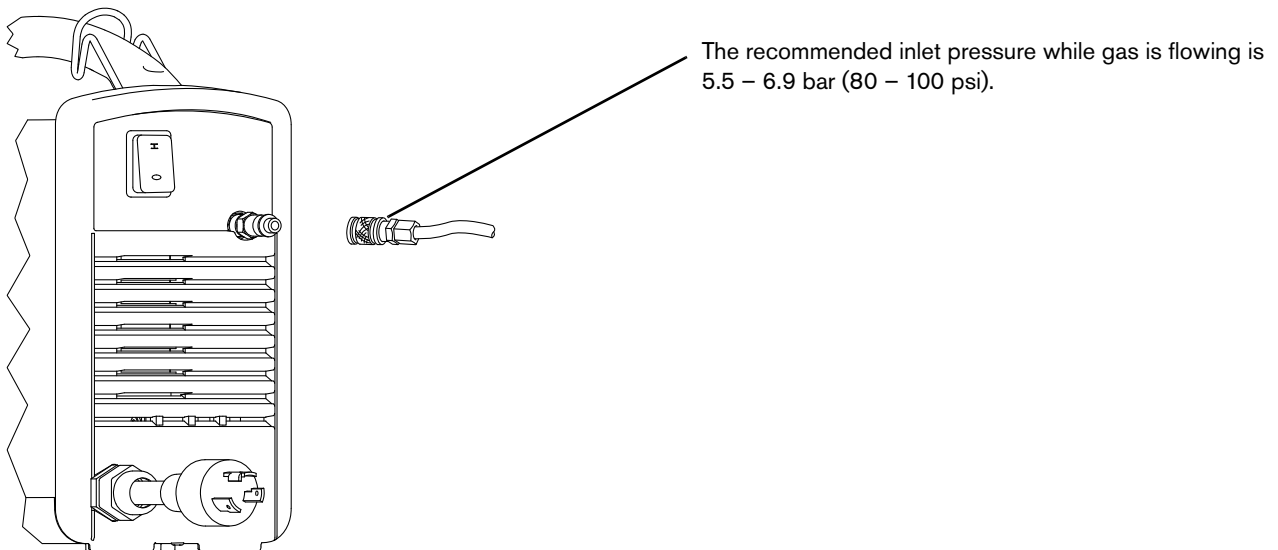
- Particle size of 0.1 micron at a maximum concentration of 0.1 mg/m³
- Dew point of -40° C (-40° F)
- Oil concentration of 0.1 mg/m³ (per ISO 8573-1 Class 1.2.2)



Connect the gas supply

Connect the gas supply to the regulator using an inert gas hose with a 6.3 mm (1/4 inch) or greater internal diameter and an industrial interchange quick-disconnect coupler.

	CAUTION!
Some air compressors use synthetic lubricants containing esters that damage the polycarbonates used in the air filter bowl.	

Figure 2

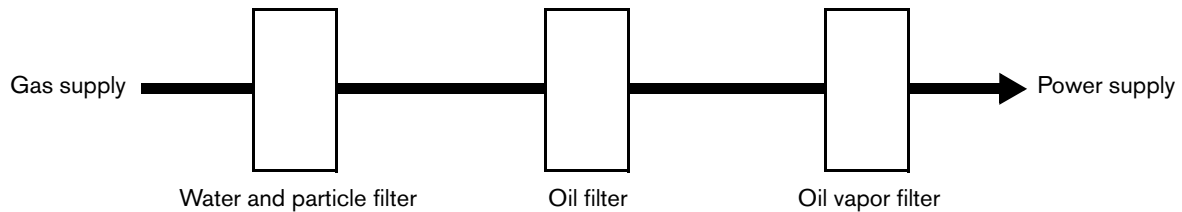


	WARNING!
	The air filter bowl may explode if the gas supply pressure exceeds 9.3 bar (135 psi).

Additional gas filtration

When site conditions introduce moisture, oil, or other contaminants into the gas line, use a three-stage coalescing filtration system. A three-stage filtering system works as follows to clean contaminants from the gas supply.

Figure 3

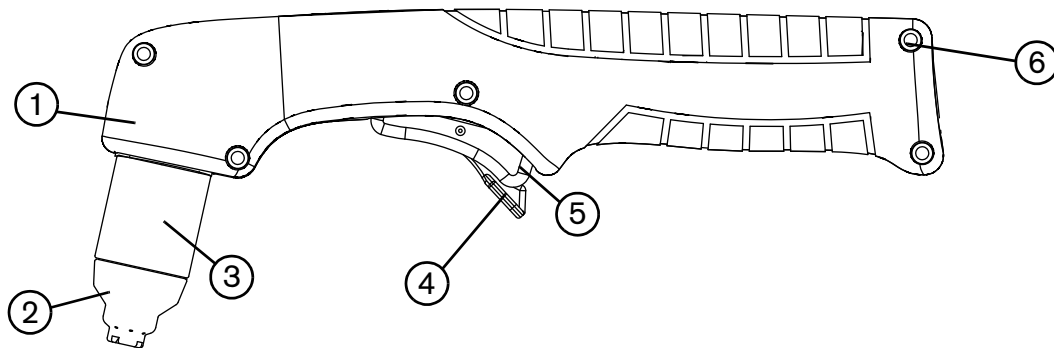


Install the filtering system between the quick-disconnect coupler and the power supply.

Introduction

The PR-30P Exocut includes the Pro-30T hand torch. This section explains how to set up and operate your torch. To achieve optimal consumable life and cut quality, follow the instructions in this manual.

Hand torch components



- | | | | |
|---|-----------------------------|---|---------------|
| 1 | Handle | 4 | Safety catch |
| 2 | Shield (shown) or deflector | 5 | Trigger (red) |
| 3 | Retaining cap | 6 | Screws (5) |

Consumable life

Consumable life varies based on the following factors:

- Thickness of the metal
- Length of the average cut
- Gas supply quality (presence of oil, moisture, or other contaminants)
- Type of cutting (piercing decreases life when compared to edge cutting)
- Pierce height
- Consumables (general-purpose, ThinCut, or gouging)



Pro Spot does not recommend the use of any other consumables in this hand torch except for those listed in this section, which are designed specifically for this system. The use of any other consumables could adversely affect system performance.

Although largely dependent on the factors listed above, as a general rule, the consumables last approximately 1 to 2 hours of actual “arc on” time. See *Inspect the consumables* on page 65 for information on the signs of wear to look for in consumables.



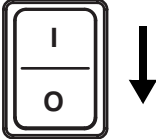
If the consumables’ life is shorter than expected or the cut quality is poor, verify that you are using the correct combination of consumables. (See the following topic, *Choose the consumables*.) Under normal conditions, the nozzle wears out first.



For optimal cutting performance, always replace the nozzle and the electrode together.

See *Hand torch operation* on page 50 for more information about proper cutting techniques.

Choose the consumables

		WARNING! INSTANT-ON TORCHES PLASMA ARC CAN CAUSE INJURY AND BURNS
	The plasma arc ignites immediately when you press the torch trigger. Make sure the power is OFF before changing consumables.	

The hand torch ships with general-purpose (standard) consumables installed. The general-purpose consumables are designed for a broad range of cutting applications.

Also included with your system is at least one ThinCut nozzle and deflector. The ThinCut consumables are designed to achieve more finely detailed results on thin gauge metal.

Also included with your system is one gouging nozzle and shield. The gouging consumables are designed specifically for the gouging process. You can use these consumables to remove welds or other unwanted metal without cutting completely through the workpiece.



The retaining cap, swirl ring, and electrode are the same for all sets of consumables.

The consumables that you choose should be determined by the:

- Input power
- Amperage output setting
- Thickness of the metal you plan to cut or gouge

The amperage output setting you need to use depends on the thickness of the metal you are planning to cut or gouge and is limited by the input power to your system. See *Voltage configurations* on page 26.

Although the visual differences between the general-purpose (standard) and ThinCut consumable parts are minor, installing the wrong combination of consumables will affect the life of the parts as well as the cut quality.


 Pro Spot does not recommend the use of any other consumables in this hand torch except for those listed in this section, which are designed specifically for this system. The use of any other consumables could adversely affect system performance.

Figure 4, Figure 5, and Figure 6 illustrate the differences between the general-purpose, ThinCut, and gouging nozzles and between the deflector and the shields. The ThinCut consumables have rings or grooves etched onto them (as shown in Figure 5) to help you distinguish them from the general-purpose consumables.

Figure 4 – General-purpose (standard)



Figure 5 – ThinCut



Figure 6 – Gouging



Using the cut charts

The following topics provide cut charts for each set of consumables. Use these cut charts to guide you in selecting the consumables and cutting current based on the thickness and type of the metal you need to cut.

The maximum cut speeds listed in the cut charts are the fastest possible speeds to cut metal without regard to cut quality. Recommended cut speeds are a starting point for finding the best quality cut (best angle, least dross, and best cut surface finish). Adjust the cutting speed for your application to obtain the desired cut quality.

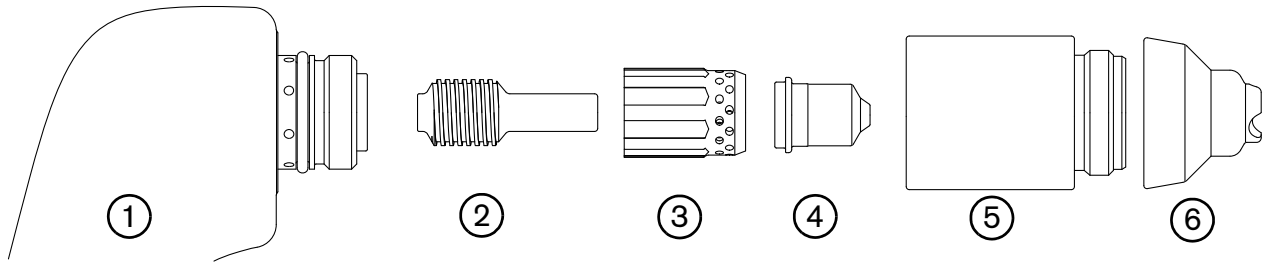
When cutting thin metal – 3 mm (10 gauge) or thinner – you may achieve a higher cut quality by using the ThinCut consumables and cut charts.

General-purpose (standard) consumables

Use the general-purpose (or standard) consumables to cut thicker metals that do not require cuts that are as finely detailed. (See *Voltage configurations* on page 26 and *System operation guidelines* on page 49.) This set includes an electrode, swirl ring, general-purpose nozzle, retaining cap, and shield. The general-purpose nozzle must be installed only with the general-purpose shield, not the deflector.

Cutting at 120 V with the general-purpose consumables is not recommended.

Figure 7 – General-purpose (standard) consumable set



1 Torch

2 Electrode

3 Swirl ring

4 Nozzle

5 Retaining cap

6 Shield

3 – Torch Setup

240 V / 30 A cutting

General-purpose (standard) consumables

Metric

Material thickness (mm)	Material	Arc current (A)	Maximum cut speed (mm/minute)
1	Mild steel	30	10160 [†]
2			7530
3			4185
5			1835
8*			780
12*			320
16*			175
1	Stainless steel	30	8355
2			5635
3			2910
5			1245
8*			575
10*			360
13*			215
3	Aluminum	30	3555
5			2115
8*			785
10*			425
13*			205

English

Material thickness (gauge/inches)	Material	Arc current (A)	Maximum cut speed (inches/minute)
18 GA	Mild steel	30	400 [†]
10 GA			110
1/4			40
3/8*			22
1/2*			10
5/8*			7
18 GA	Stainless steel	30	306
10 GA			70
1/4			31
3/8*			15
1/2*			9
1/8	Aluminum	30	135
1/4			45
3/8*			18
1/2*			9

* To cut material thicker than 6 mm (1/4 inch), start the torch at the edge of the workpiece.

† Maximum cut speed is limited by the test table's maximum speed (10160 mm/minute or 400 inches/minute).

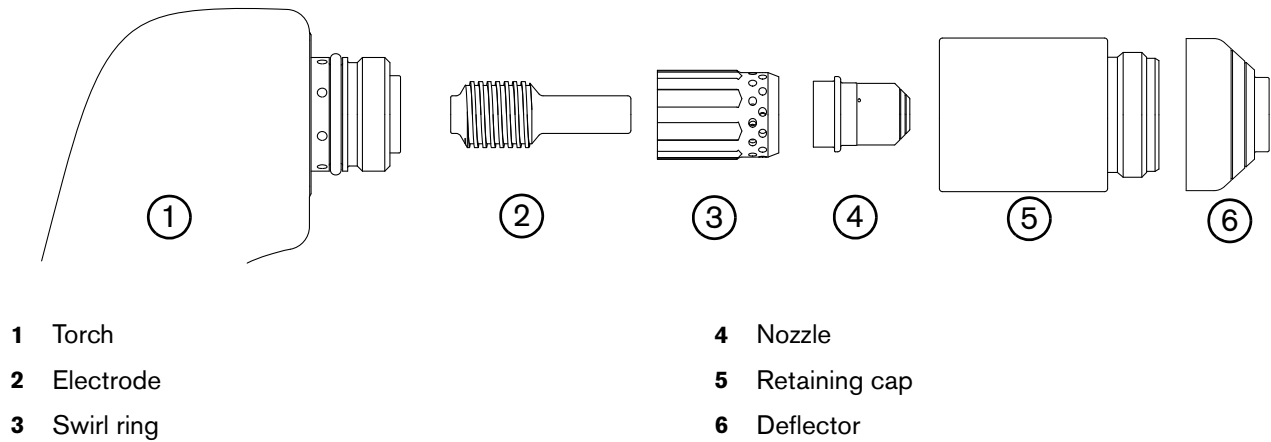
ThinCut consumables

Use the ThinCut consumables for detailed cutting on thin gauge metal. The ThinCut consumable set uses a ThinCut nozzle and a deflector with the same electrode, swirl ring, and retaining cap used in the general-purpose consumable set.

The ThinCut nozzle must be installed only with the deflector, not the shield. Using the shield results in poor cut quality and increased power demand because the torch-to-work distance is too great.

For guidelines on cutting with 120 V input, see *Recommendations for cutting at 120 V* on page 53.

Figure 8 – ThinCut consumable set



3 – Torch Setup

120 V / 25 A cutting

ThinCut consumables

Metric

Material thickness (mm)	Material	Arc current (A)	Maximum cut speed (mm/minute)
1	Mild steel	25	10160 [†]
2			3570
3			1745
5			905
6			590
7*			280
1			Stainless steel
2	2860		
3	1500		
5	825		
6	515		
7*	205		
1	Aluminum	25	
2			5130
3			2170
5			920
7*			120

English

Material thickness (gauge/inches)	Material	Arc current (A)	Maximum cut speed (inches/minute)
18 GA	Mild steel	25	330
16 GA			205
14 GA			150
12 GA			80
10 GA			55
1/4			19
18 GA			Stainless steel
16 GA	160		
14 GA	120		
12 GA	65		
10 GA	52		
1/4	16		
1/25	Aluminum	25	
1/16			250
1/8			65
1/4			15

* To cut material thicker than 6 mm (1/4 inch), start the torch at the edge of the workpiece.

† Maximum cut speed is limited by the test table's maximum speed (10160 mm/minute or 400 inches/minute).

120 V / 30 A cutting

ThinCut consumables

Metric

Material thickness (mm)	Material	Arc current (A)	Maximum cut speed (mm/minute)
1	Mild steel	30	10160 [†]
2			6175
3			2420
5			1300
8*			535
10*			280
13*			110
1	Stainless steel	30	10025
2			5755
3			2045
5			1135
8*			410
10*			170
1	Aluminum	30	10160 [†]
2			6805
3			3285
5			1455
8*			375
10*			150

English

Material thickness (gauge/inches)	Material	Arc current (A)	Maximum cut speed (inches/minute)
22 GA	Mild steel	30	400 [†]
18 GA			400 [†]
12 GA			112
10 GA			75
1/4			31
3/8*			12
1/2*			5
22 GA	Stainless steel	30	400 [†]
18 GA			390
12 GA			90
10 GA			69
1/4			24
3/8*			9
1/25	Aluminum	30	400 [†]
1/16			325
1/8			105
1/4			22
3/8*			8

* To cut material thicker than 6 mm (1/4 inch), start the torch at the edge of the workpiece.

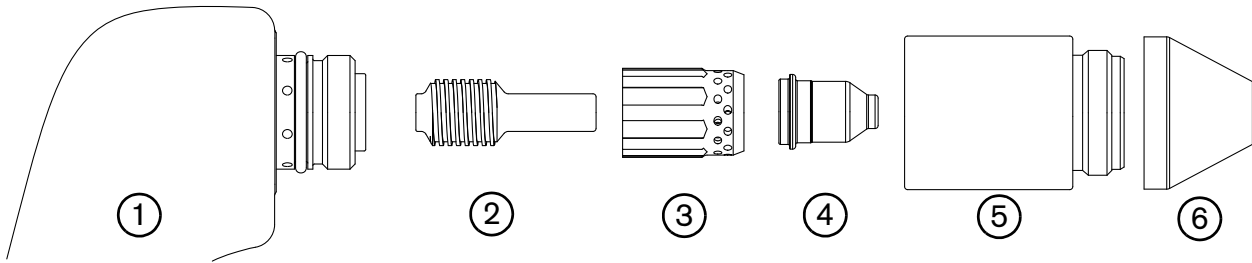
† Maximum cut speed is limited by the test table's maximum speed (10160 mm/minute or 400 inches/minute).

Gouging consumables

Use the gouging consumables to remove welds or other unwanted metal. (See *Voltage configurations* on page 26 and *System operation guidelines* on page 49.) This set includes an electrode, swirl ring, gouging nozzle, retaining cap, and gouging shield. The gouging nozzle must be installed only with the gouging shield, not the deflector or general-purpose (standard) shield.

Gouging at 120 V with the gouging consumables is not recommended.

Figure 9 – Gouging consumable set



1 Torch

2 Electrode

3 Swirl ring

4 Nozzle

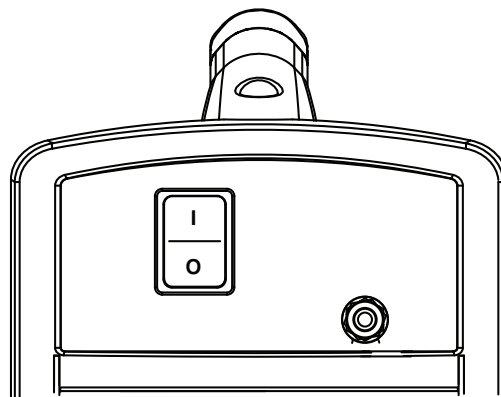
5 Retaining cap

6 Shield

Controls and indicators

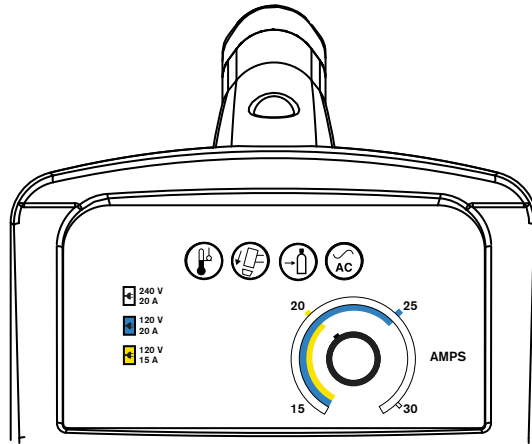
Refer to the following topics to become familiar with the controls and LED indicators on the system before you begin cutting.

Rear controls



ON (I) / OFF (O) power switch – Activates the system and its control circuits.

Front controls and LEDs



Power ON LED (green) – When illuminated, this LED indicates that the power switch has been set to ON (I) and that the safety interlocks are satisfied.



Gas pressure LED (yellow) – When illuminated, this LED indicates that the inlet gas pressure is below 2.8 bar (40 psi).



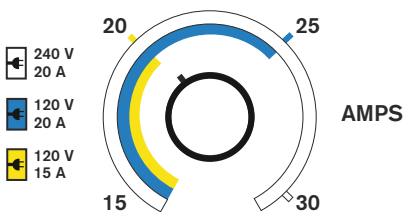
Torch cap LED (yellow) – When illuminated, this LED indicates that the consumables are loose, improperly installed, or missing.



Temperature LED (yellow) – When illuminated, this LED indicates that the system's temperature is outside the acceptable operating range.



Some fault conditions cause one or more of the LEDs to blink. For information on what these fault conditions are and how to clear them, see *Basic troubleshooting* on page 66.



Amperage adjustment knob – Use this knob to set the output current between 15 A and 30 A.

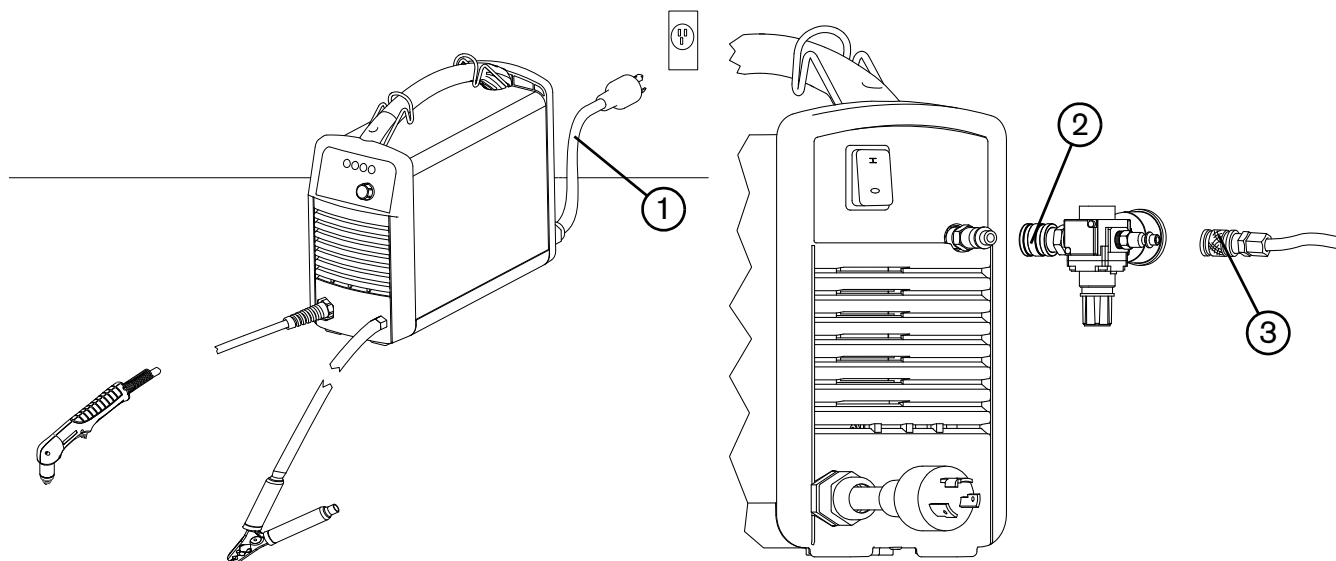
Operate the plasma system

The following topics explain how to begin cutting with the plasma system.

Connect the electrical power and gas supply



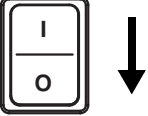
Plug in the power cord ①, connect the external regulator ②, and connect the gas supply line ③.

Figure 10



- For information on connecting the gas supply to the power supply, see *Prepare the gas supply* on page 29.
- For information on connecting the proper plug to the power cord, see *Power cord considerations* on page 27.
- To understand which consumables to use and what cutting capacity to expect based on input voltage, see *Choose the consumables* on page 32.
- For information on electrical requirements and gas supply requirements for this system, see *Power Supply Setup* on page 23.

Install the consumables

		<p style="text-align: center;">WARNING! INSTANT-ON TORCHES PLASMA ARC CAN CAUSE INJURY AND BURNS</p>
		<p>The plasma arc ignites immediately when you press the torch trigger. Make sure the power is OFF before changing consumables.</p>

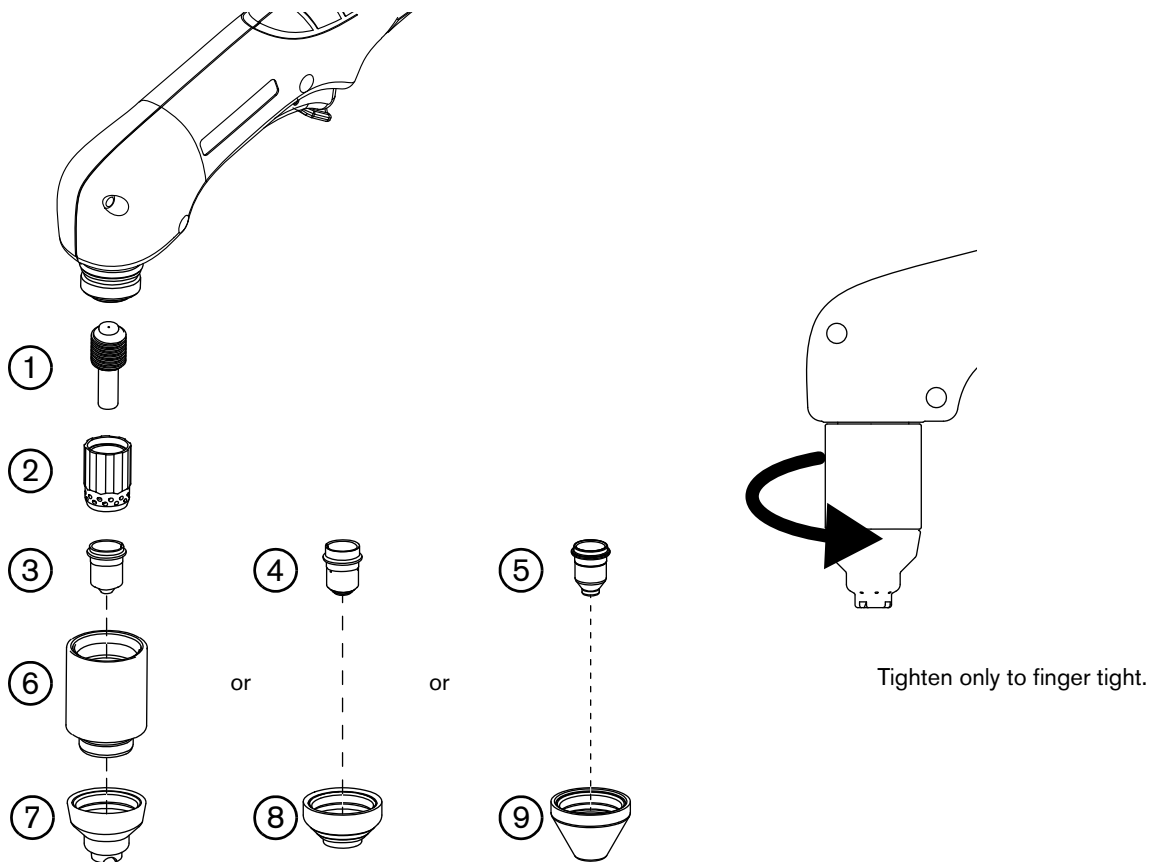
To operate the Pro-30T torch, first verify:

1. The power switch is in the OFF (●) position.
2. A complete set of consumables is installed as shown in Figure 11.
3. You use only the general-purpose shield with the general-purpose (standard) nozzle.



To understand the differences between the general-purpose, ThinCut, and gouging consumables, and for guidelines on selecting the right set for your cutting applications, see *Choose the consumables* on page 32.

Figure 11



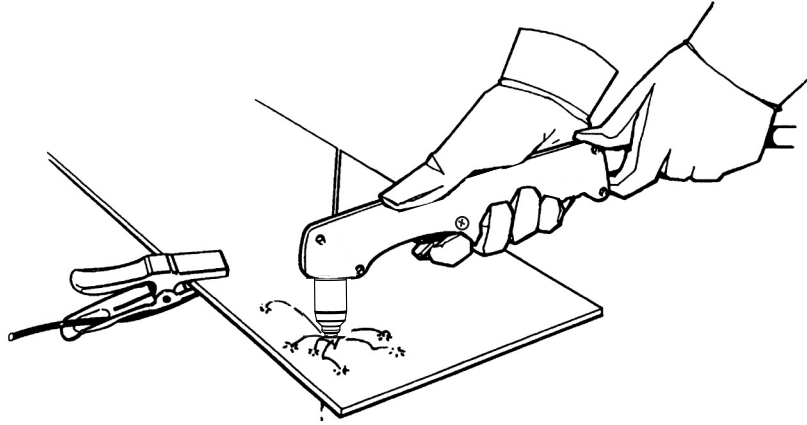
- | | |
|---|--|
| <ul style="list-style-type: none"> 1 Electrode 2 Swirl ring 3 Nozzle (general-purpose) 4 Nozzle (ThinCut) 5 Nozzle (gouging) | <ul style="list-style-type: none"> 6 Retaining cap 7 Shield (general-purpose) 8 Deflector (ThinCut) 9 Shield (gouging) |
|---|--|

Attach the ground clamp

Attach the ground clamp to the workpiece.

- Verify that the ground clamp and the workpiece make good metal-to-metal contact.
- Attach the ground clamp as close as possible to the area being cut to reduce exposure to electric and magnetic fields (EMF) and to achieve the best possible cut quality.
- **Do not attach the ground clamp to the portion of the workpiece that you are cutting away.**

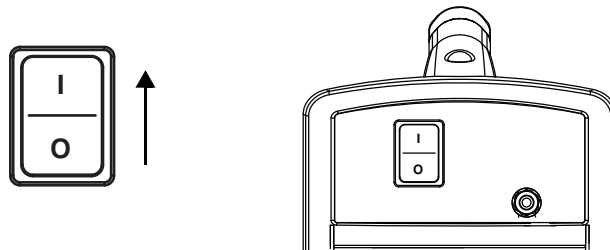
Figure 12



Power ON the system

Set the ON/OFF switch to the ON (I) position.

Figure 13

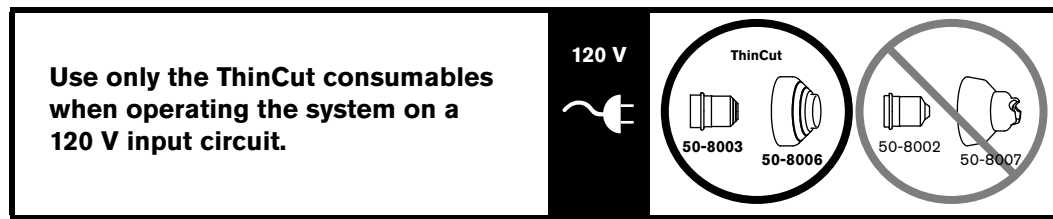


Adjust the gas pressure and output current

The power ON LED and the gas pressure LED illuminate when there is insufficient gas pressure to the system. Use a high-pressure regulator that is capable of delivering gas to the filter on the power supply at 99.1 L/min at 4.7 bar (3.5 scfm at 68 psi). For more information on attaching the gas supply, see *Prepare the gas supply* on page 29.

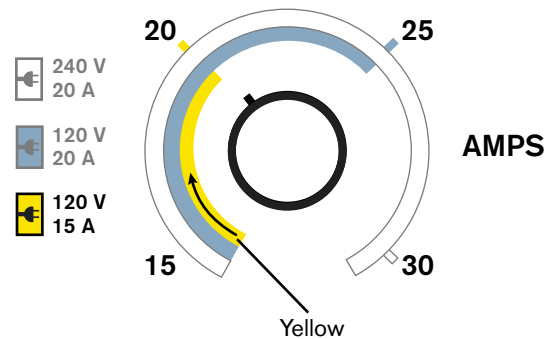
1. For cutting, set the regulator between 5.5 and 6.9 bar (80 and 100 psi). For gouging, set the external regulator to 3.4 bar (50 psi).
2. Turn the amperage knob to the desired output current based on the input voltage, circuit size, and consumables.

Figure 14



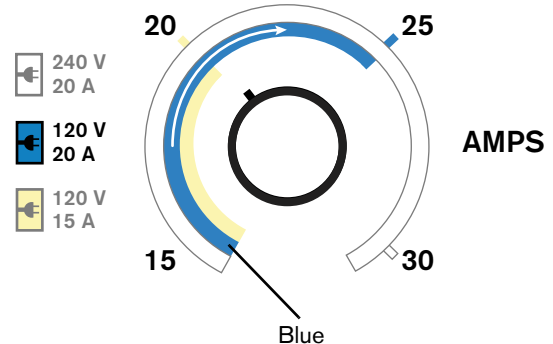
Operating the system on a 120 V, 15 A circuit

- Set the amperage below 20 A, as indicated by the gray shading around the knob (the inner ring).
- Use only the ThinCut nozzle and deflector.
- Do not use the general-purpose (standard) nozzle or shield.
- Do not use the gouging nozzle or shield.
- Verify that nothing else is drawing power from the circuit.




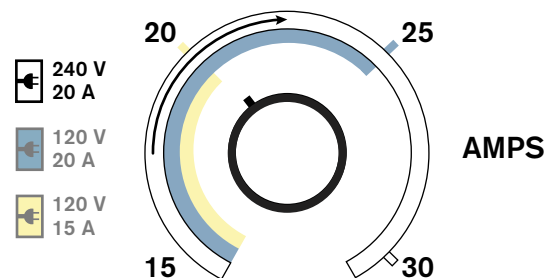
Operating the system on a 120 V, 20 A circuit

- Set the amperage below 25 A, as indicated by the blue shading around the knob (the middle ring).
- Use only the ThinCut nozzle and deflector.
- Do not use the general-purpose (standard) nozzle or shield.
- Do not use the gouging nozzle or shield.
- Verify that nothing else is drawing power from the circuit.



Operating the system on a 240 V, 20 A circuit

- Set the amperage between 15 – 30 A.
 - Use the general-purpose (standard), ThinCut, or gouging consumables.
-  Do not mix the general-purpose, ThinCut, and gouging consumables. Use one complete set.



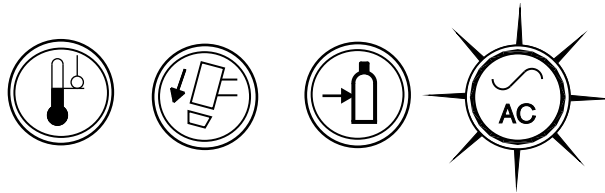
See *Voltage configurations* on page 26 for more information.

Check the indicator LEDs

Verify that the green power ON LED on the front of the power supply is illuminated and that none of the other LEDs are illuminated or blinking.

If the temperature, torch cap sensor, or gas pressure LEDs illuminate or blink, or if the power ON LED blinks, correct the fault condition before continuing. See *Basic troubleshooting* on page 66 for more information.

Figure 15



Verify the system is ready

When the power ON LED illuminates, none of the other LEDs illuminate or blink, and the amperage knob is set, the system is ready for use.

Understand duty-cycle limitations

The duty cycle is the percentage of time out of 10 minutes that a plasma arc can remain on when operating at an ambient temperature of 40° C (104° F).

With input power of 120 V:

- At 30 A, the arc can remain on for 2.0 minutes out of 10 minutes without causing the unit to overheat (20% duty cycle).
- At 17 A, the arc can remain on for 6 minutes out of 10 (60%).
- At 15 A, the arc can remain on for 10 minutes out of 10 (100%).

With input power of 240 V:


- At 30 A, the arc can remain on for 3.5 minutes out of 10 (35% duty cycle).
- At 23 A, the arc can remain on for 6 minutes out of 10 (60%).
- At 18 A, the arc can remain on for 10 minutes out of 10 (100%).

When the duty cycle is exceeded, the system overheats, the temperature LED illuminates, the arc shuts off, and the cooling fan continues to run. To resume cutting, wait for the temperature LED to extinguish.






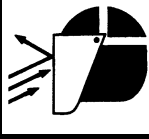
The fan may run during normal operation of the system.

System operation guidelines

- To achieve the highest level of performance:
 - Operate the system at an input power of 240 VAC whenever possible.
 - Avoid using an extension cord whenever possible.
-  If you must use an extension cord, use a heavy conductor cord of the shortest possible length. See *Extension cord recommendations* on page 28.
- If you are operating your system on a 120 V, 15 A circuit, do not set the amperage higher than 20 A. See *Voltage configurations* on page 26.
- For best results when operating your system on a 120 V, 15 A circuit:
 - Do not connect anything else that will draw power from the same circuit.
 - Be aware that extension cords can reduce the voltage to the machine from what is output by the circuit. This reduction in power can impair cutting performance and increase the probability of tripping the circuit breaker.
- Cutting a thicker workpiece with the general-purpose (standard) consumables requires a higher amperage setting. It is preferable to operate on a higher rated circuit (240 V / 30 A) when cutting thicker metal. See *Voltage configurations* on page 26.
- Additional techniques to reduce the frequency of tripped circuit breakers include:
 - Turn down the amperage adjustment knob.
 - Avoid stretching the arc. Instead, drag the torch on the workpiece as explained in *Edge start on a workpiece* on page 53.

Hand torch operation

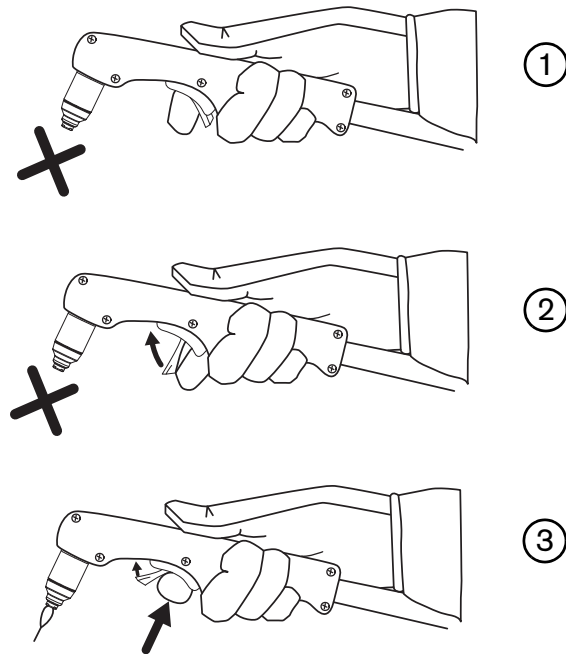
		<p style="text-align: center;">WARNING! INSTANT-ON TORCHES PLASMA ARC CAN CAUSE INJURY AND BURNS</p>
<p>Plasma arc ignites immediately when you press the torch trigger. The plasma arc cuts quickly through gloves and skin.</p> <p>Keep hands, clothes, and objects away from the torch tip.</p> <p>Do not hold the workpiece, and keep your hands clear of the cutting path.</p> <p>Never point the torch toward yourself or others.</p>		

		<p style="text-align: center;">WARNING! SPARKS AND HOT METAL CAN INJURE EYES AND BURN SKIN</p>
<p>Always wear proper protective equipment including gloves and eye protection, and point the torch away from yourself and others. Sparks and hot molten metal spray out from the nozzle.</p>		

Safety catch operation

The hand torch is equipped with a safety catch to prevent accidental firings. When you are ready to cut with the torch, flip the safety catch forward (toward the torch head) and press the red torch trigger.

Figure 16



Hand torch cutting guidelines

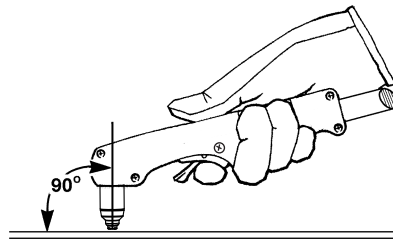
- With any set of consumables, drag the torch tip lightly on the workpiece to maintain a steady cut speed.



Sometimes the torch sticks slightly to the workpiece when you cut with the ThinCut consumables.

- While cutting, make sure that sparks exit from the bottom of the workpiece. The sparks should lag slightly behind the torch as you cut (15° – 30° angle from vertical).
- If sparks spray up, you are not cutting all the way through the workpiece. Move the torch more slowly, or, if possible, increase the output current.
- Hold the torch nozzle perpendicular to the workpiece so that the nozzle is at a 90° angle to the cutting surface, and watch the arc as it cuts along the line.

Figure 17



- Pulling the torch toward you along the cut is easier than pushing it or moving from side-to-side.
- For straight-line cuts, use a straight edge as a guide. To cut circles, use a template or a radius cutter attachment (a circle cutting guide).
- If you fire the torch unnecessarily, you shorten the life of the nozzle and electrode.

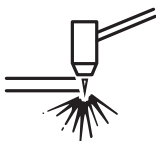
Figure 18



- For cutting, set the external regulator between 5.5 bar and 6.9 bar (80 psi and 100 psi).
- For gouging, set the external regulator to 3.4 bar (50 psi).

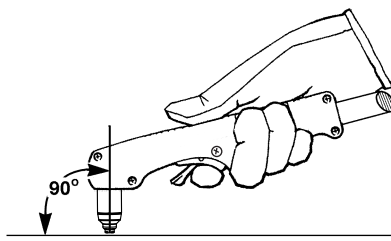
Recommendations for cutting at 120 V

- Use only the ThinCut consumables.
- Do not use an extension cord.
- Verify nothing else is drawing power from the circuit.
- Turn down the current adjustment knob to avoid tripping the breaker.

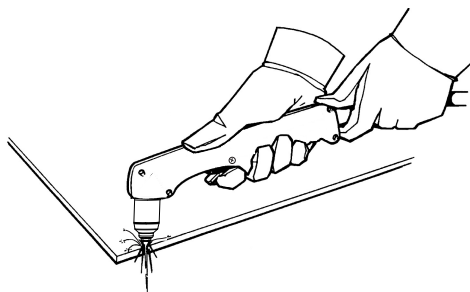
Edge start on a workpiece

When cutting material thicker than 6 mm (1/4 inch), start the torch at the edge of the workpiece to prolong consumable life.

1. With the ground clamp attached to the workpiece, hold the torch perpendicular (90°) to the workpiece and on the edge.

Figure 19

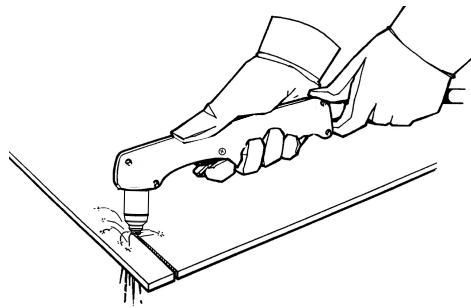
2. Press the torch trigger to start the arc. You may need to pause at the edge until the arc has cut completely through the workpiece.

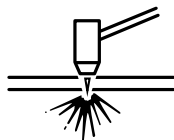
Figure 20

4 – Operation

3. Drag the torch lightly across the workpiece to proceed with the cut. Maintain a steady, even pace.

Figure 21



Pierce a workpiece

If the metal is thinner than 6 mm (1/4 inch), use piercing to cut an interior feature. Piercing shortens the life of the consumables.

The type of pierce to perform depends on the thickness of the metal.

■ **Straight pierce** – For cutting metal that is thinner than 3 mm (1/8 inch).

■ **Rolling pierce** – For cutting metal that is 3 mm (1/8 inch) or thicker.

1. Attach the ground clamp to the workpiece.

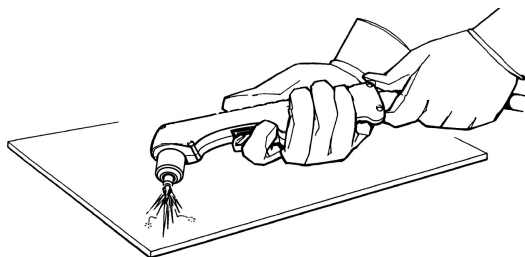
2. **Straight pierce:** Hold the torch perpendicular (90°) to the workpiece.

Rolling pierce: Hold the torch at an approximate 30° angle to the workpiece with the torch tip within 1.5 mm (1/16 inch) of it before firing the torch.

3. **Straight pierce:** Press the torch trigger to start the arc.

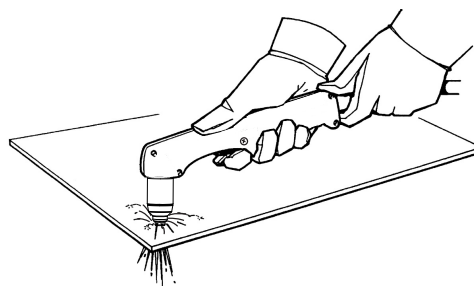
Rolling pierce: Press the torch trigger to start the arc while still at an angle to the workpiece, then slowly rotate the torch to the perpendicular (90°) position.

Figure 22



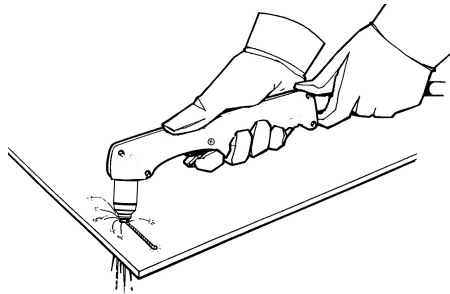
4. Hold the torch in place while continuing to press the trigger. When sparks exit from the bottom of the workpiece, the arc has pierced the metal.

Figure 23



5. When the pierce is complete, drag the torch lightly along the workpiece to proceed with the cut.

Figure 24



Gouge a workpiece



Use this system with the gouging consumables for light gouging applications, such as the removal of spot welds and tack welds. For spot-weld information, see *Remove a spot weld* on page 58. The system comes with an external regulator for gouging. Before gouging, make sure that the external regulator is installed. (See *Connect the gas supply* on page 29.)



Do not use the ThinCut consumables for gouging applications.



To reduce the frequency of tripped circuit breakers, when gouging, limit the output current to 15 A.

General gouging

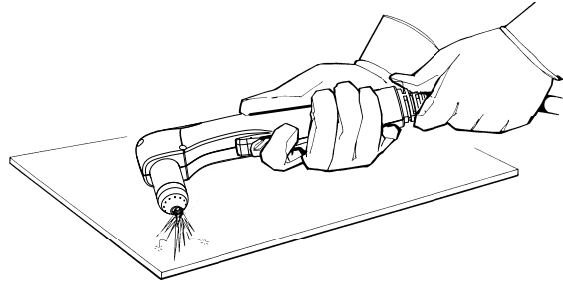
1. Set the external regulator to 3.4 bar (50 psi) for gouging.



Set the output current to 15 A or lower.

2. Hold the torch so that the torch tip is slightly above the workpiece before firing the torch.

3. Hold the torch at a 45° angle to the workpiece with a small gap between the torch tip and the workpiece. Press the trigger to obtain a pilot arc. Transfer the arc to the workpiece.

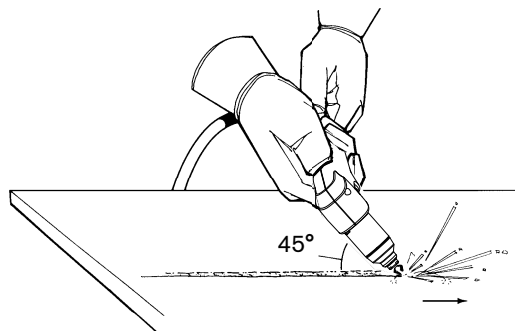
Figure 25

4. Maintain an approximate 45° angle to the workpiece as you feed into the gouge.

Push the plasma arc in the direction of the gouge you want to create. Keep a small distance between the torch tip and the molten metal to avoid reducing consumable life or damaging the torch.

You can vary the gouge profile by varying the:

- Speed of the torch over the workpiece
- Torch-to-work standoff distance
- Angle of the torch to the workpiece

Figure 26

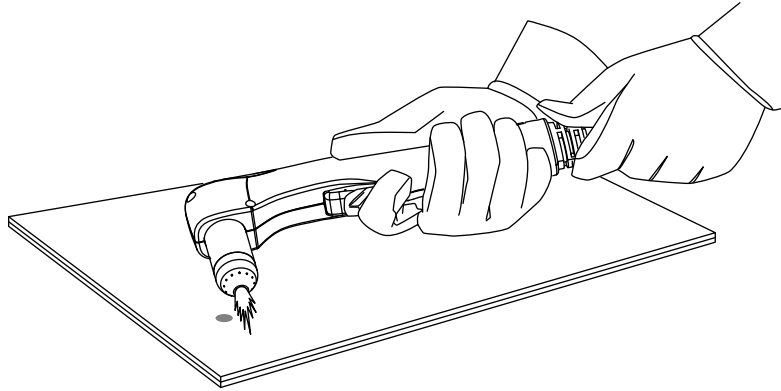
4 – Operation

Remove a spot weld

To remove a spot weld, gouge around the weld and cut completely through the top layer of metal without damaging the layer underneath.

1. Set the external regulator to 3.4 bar (50 psi) for gouging.
2. Hold the torch so that the torch tip is slightly above the workpiece next to the spot weld before firing the torch.

Figure 27

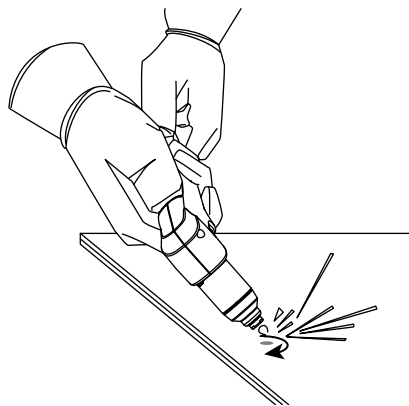


3. Hold the torch at a 45° angle to the workpiece. Press the trigger to obtain a pilot arc. Transfer the arc to the workpiece.



You may need to adjust the angle for the thickness of your workpiece. If the angle is too large, you will cut through both layers of metal. If the angle is too small, you will lose contact with the workpiece and the arc will go out.

Figure 28

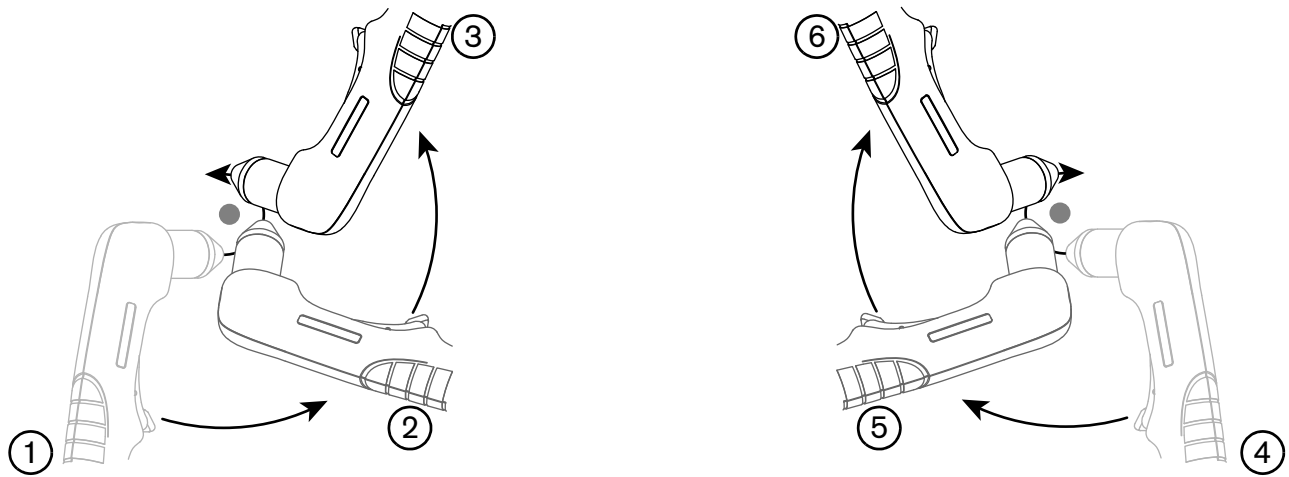


4. Maintain the angle and distance to the workpiece as you move the torch around the spot weld.



It is helpful to gouge one side of the weld, reposition the torch, and then gouge the other side of the weld as shown in Figure 29.

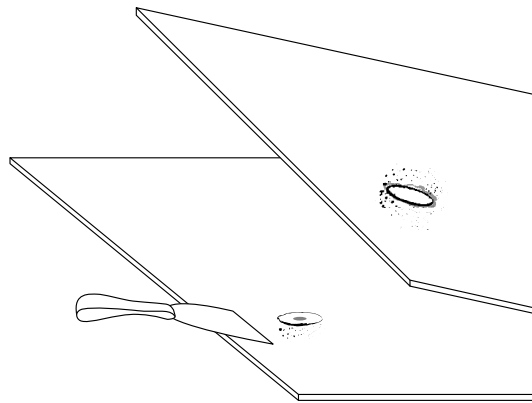
Figure 29



5. If the gouge did not cut through the top layer of metal completely, repeat the process until you can remove the top layer of metal.

6. If necessary, scrape away any dross or metal left on the bottom layer of metal.

Figure 30



Varying the gouge profile

Follow these recommendations to change the gouge profile as needed:

- **Increasing the speed** of the torch will **decrease width** and **decrease depth**.
- **Decreasing the speed** of the torch will **increase width** and **increase depth**.
- **Increasing the standoff** of the torch will **increase width** and **decrease depth**.
- **Decreasing the standoff** of the torch will **decrease width** and **increase depth**.
- **Increasing the angle** of the torch (more vertical) will **decrease width** and **increase depth**.
- **Decreasing the angle** of the torch (less vertical) will **increase width** and **decrease depth**.

Common hand-cutting faults

For more information on faults, see *Basic troubleshooting* on page 66.


- The torch sputters and hisses, but does not produce an arc. The cause can be:
 - Overtightened consumables
- The torch does not cut completely through the workpiece. The causes can be:
 - Cut speed is too fast
 - Worn consumables
 - Metal being cut is too thick for the selected amperage
 - Installation of the wrong consumables
 - Poor electrical contact between the ground clamp and the workpiece
 - Low gas pressure or low gas flow rate
- Cut quality is poor. The causes can be:
 - Metal being cut is too thick for the selected amperage
 - Installation of the wrong consumables
 - Cut speed is too fast or too slow
 - Worn or damaged consumables
- The arc sputters and consumables life is shorter than expected. The causes can be:
 - Moisture in the gas supply
 - Low gas pressure
 - Incorrect installation of the consumables
 - Installation of the wrong consumables


Minimizing dross

Dross is the molten metal that solidifies on the workpiece. Some amount of dross is always present when cutting with air plasma. However, you can control the amount and type of dross by adjusting your system correctly for your application.

Low-speed dross forms when the torch's cutting speed is too slow and the arc shoots ahead. It forms as a heavy, bubbly deposit at the bottom of the cut and is usually easy to remove. Increase your speed to reduce this type of dross.

High-speed dross forms when the cutting speed is too fast and the arc lags behind. It forms as a thin, linear bead of solid metal attached very close to the cut. It forms to the bottom of the cut and is often more difficult to remove. Decrease your speed to reduce this type of dross.



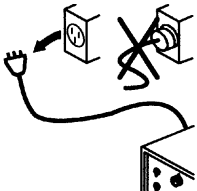
 Dross is more likely to form on warm or hot metal than on cool metal. For example, the first cut in a series of cuts is likely to produce the least dross. As the workpiece heats up, more dross may form on subsequent cuts.

 Worn or damaged consumables may produce intermittent dross.

Section 5

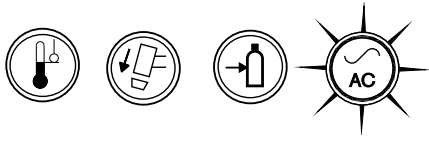
Maintenance and Troubleshooting

Perform routine maintenance

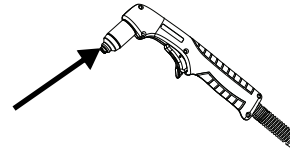
		WARNING! ELECTRIC SHOCK CAN KILL
		<p>Disconnect electrical power before performing any maintenance that involves removing the cover from the power supply or the consumables from the torch.</p> <p>All work requiring removal of the power supply cover must be performed by a qualified technician.</p> <p>See the <i>Safety and Compliance Manual</i> for more safety precautions.</p>

5 – Maintenance and Troubleshooting

Every use:



Check the indicator lights and correct any fault conditions.

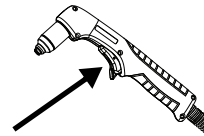


Inspect the consumables for proper installation and wear.

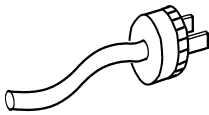
Every 3 months:



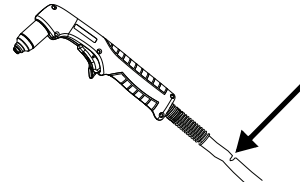
Replace any damaged labels.



Inspect the trigger for damage. Inspect the torch body for cracks and exposed wires. Replace any damaged parts.

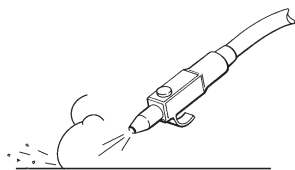


Inspect the power cord and plug. Replace if damaged.

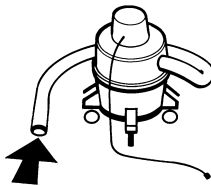


Inspect the torch lead. Replace if damaged.

Every 6 months:



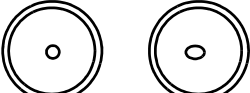
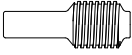
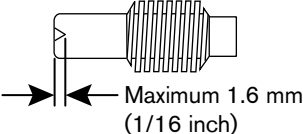

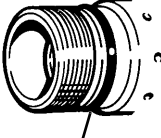


or



Clean the inside of the power supply with moisture-free compressed air or a vacuum.

Inspect the consumables



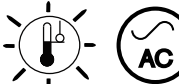
Part	Inspect	Action
 <p>Shield Deflector</p>	<p>The center hole for roundness.</p> <p>The gap between the nozzle and the shield or deflector for accumulated debris.</p>	<p>Replace the shield or deflector if the hole is no longer round.</p> <p>Remove the shield or deflector and clean any material away.</p>
 <p>Nozzle</p>	<p>The center hole for roundness.</p>  <p>Good Worn</p>	<p>Replace if the center hole is not round. Replace the nozzle and the electrode together.</p>
 <p>Electrode</p>	<p>The center surface for wear and verify the pit depth.</p>  <p>Maximum 1.6 mm (1/16 inch)</p>	<p>Replace if the surface is severely worn or the pit depth is greater than 1.6 mm (1/16 inch) deep. Replace the nozzle and the electrode together.</p>
 <p>Swirl ring</p>	<p>The internal surface for damage or wear and the gas holes for blockages.</p>	<p>Replace if the surface is damaged or worn or any of the gas holes are blocked.</p>
	<p>Whether the electrode can still slide freely through the swirl ring.</p>	<p>If the electrode cannot slide freely through the swirl ring, replace the swirl ring.</p>
 <p>Torch O-ring</p>	<p>The surface for damage, wear, or a lack of lubrication.</p>	<p>If the O-ring is dry, apply a thin film of silicone lubricant on the O-ring and the threads. The O-ring should look shiny, but there should not be any excess or built-up lubricant.</p> <p>If the O-ring is cracked or worn, replace it.</p>


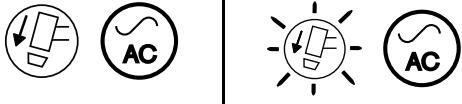
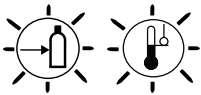
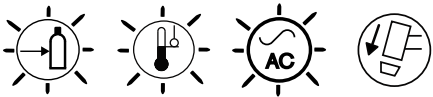
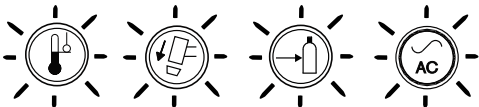
Basic troubleshooting

The following table provides an overview of the most common problems that may arise when using this system and explains how to solve them.

If you are unable to fix the problem by following this basic troubleshooting guide or if you need further assistance:

1. Call your distributor or authorized repair facility.
2. Call the office listed in the front of this manual.



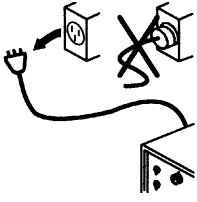
Problem	Solution
<p>The ON/OFF power switch is set to ON (I), but the power ON LED does not illuminate.</p>	<ul style="list-style-type: none"> ▪ Verify that the power cord is plugged into the receptacle. ▪ Verify that the power is on at the main power panel or at the disconnect-power switch box. ▪ Verify that the line voltage is not too low (more than 15% below the rated voltage).
<p>The power ON LED and the gas pressure LED illuminate.</p> 	<ul style="list-style-type: none"> ▪ Verify that the gas supply line is connected to the power supply and the gas is turned on. ▪ Inspect the gas supply line for leaks, and verify the incoming gas pressure.
<p>The power ON LED and the temperature LED illuminate.</p> 	<ul style="list-style-type: none"> ▪ Leave the system on to allow the fan to cool the power supply. ▪ If the system's internal temperature approaches -30° C (-22° F), the temperature LED may illuminate. Move the system to a warmer location.
<p>The power ON LED illuminates and the temperature LED blinks.</p> 	<p>Leave the system on to allow the fan to cool the power supply. The temperature LED blinks when the system continuously draws too much input current for too long. Try the following to prevent this condition:</p> <ul style="list-style-type: none"> ▪ Turn down the cutting current. See <i>Adjust the gas pressure and output current</i> on page 46. ▪ Use only the ThinCut consumables when operating the system on a 120 VAC input circuit. See <i>Choose the consumables</i> on page 32. ▪ Operate the system on a 240 VAC input circuit whenever possible. ▪ Avoid stretching the arc. Drag the torch on the workpiece. See <i>Edge start on a workpiece</i> on page 53. ▪ Operate the system without using an extension cord. If you must use an extension cord, use a heavy conductor cord of the shortest possible length. See <i>Extension cord recommendations</i> on page 28. ▪ Verify nothing else is drawing power on the same circuit.

Problem	Solution
<p>The power ON LED blinks.</p> 	<ul style="list-style-type: none"> Have an electrical technician check the incoming power. The input line voltage is either too high or too low (a variance greater than $\pm 15\%$ of the rated voltage). See <i>Pro Spot system ratings</i> on page 19 and <i>Prepare the electrical power</i> on page 25.
<p>The power ON LED illuminates and the torch cap LED illuminates or blinks.</p> 	<ul style="list-style-type: none"> Turn OFF the power supply. Verify that the consumables are properly installed and tightened. See <i>Install the consumables</i> on page 44. If the consumables became loose or were removed while the power supply was ON, turn OFF the power supply, correct the problem, and then turn ON the power supply to clear the fault. If the consumables appear to be installed correctly, the torch may be damaged. Contact your distributor or authorized repair facility.
<p>The gas pressure and temperature LEDs blink when the machine is powered ON.</p> 	<ul style="list-style-type: none"> Release the trigger and restart the power supply. The system automatically disables itself when the power supply is turned on while the torch trigger is pressed.
<p>The temperature, gas pressure, and power ON LEDs blink, and the torch cap LED illuminates.</p> 	<ul style="list-style-type: none"> Install new consumables in the torch (they may be corroded or approaching end of life). If you continue to see this error, contact your distributor or authorized repair facility.
<p>All four LEDs blink when the system is powered ON.</p> 	<ul style="list-style-type: none"> A qualified service technician must service the system. Contact your distributor or use the information in the front of this manual to contact technical service.
<p>The arc does not transfer to the workpiece.</p>	<ul style="list-style-type: none"> Clean the area where the ground clamp contacts the workpiece to ensure a good metal-to-metal contact. Inspect the ground clamp for damage and repair it if necessary. Move the torch closer to the workpiece and fire the torch again. See <i>Hand torch operation</i> on page 50.
<p>The torch does not cut completely through the workpiece.</p>	<ul style="list-style-type: none"> Verify that the torch is being used correctly. See <i>Hand torch operation</i> on page 50. Inspect the consumables and replace as necessary. See <i>Inspect the consumables</i> on page 65.

5 – Maintenance and Troubleshooting


Problem	Solution
The arc blows out but re-ignites when the torch trigger is pressed again.	<ul style="list-style-type: none">▪ Inspect and replace the consumable parts if they are worn or damaged. See <i>Inspect the consumables</i> on page 65.▪ Replace the air filter element if it is contaminated. See <i>Replace the air filter element and air filter bowl</i> on page 69.▪ Make sure the air pressure is at the proper level.
The arc sputters and hisses.	<ul style="list-style-type: none">▪ Replace the air filter element. See <i>Replace the air filter element and air filter bowl</i> on page 69.▪ Inspect the gas line for moisture. If necessary, install or replace the gas filtration to the power supply. See <i>Prepare the gas supply</i> on page 29.
The cut quality is poor.	<ul style="list-style-type: none">▪ Verify that the torch is being used correctly. See <i>Hand torch operation</i> on page 50.▪ Verify the correct consumables are installed. See <i>Choose the consumables</i> on page 32.▪ Inspect the consumables and replace as necessary. See <i>Inspect the consumables</i> on page 65.▪ Loosen the consumables about 1/8th of a turn and try again.▪ Check the air pressure and air quality.▪ Verify the work lead connection is secure and there is no damage to the work lead.▪ Operate the system without using an extension cord. If you must use an extension cord, use a heavy conductor cord of the shortest possible length. See <i>Extension cord recommendations</i> on page 28.
The circuit breaker trips while you are cutting.	<ul style="list-style-type: none">▪ Turn down the cutting current. See <i>Adjust the gas pressure and output current</i> on page 46.▪ Use only the ThinCut consumables when operating the system on a 120 VAC input circuit. See <i>Choose the consumables</i> on page 32.▪ Operate the system on a 240 VAC input circuit whenever possible.▪ Avoid stretching the arc. Drag the torch on the workpiece. See <i>Edge start on a workpiece</i> on page 53.▪ Operate the system without using an extension cord. If you must use an extension cord, use a heavy conductor cord of the shortest possible length. See <i>Extension cord recommendations</i> on page 28.▪ Verify nothing else is drawing power on the same circuit.

Maintenance procedures

		<p>WARNING! ELECTRIC SHOCK CAN KILL</p>
		<p>Disconnect electrical power before performing any maintenance that involves removing the cover from the power supply or the consumables from the torch.</p> <p>All work requiring removal of the power supply cover must be performed by a qualified technician.</p> <p>See the <i>Safety and Compliance Manual</i> for more safety precautions.</p>

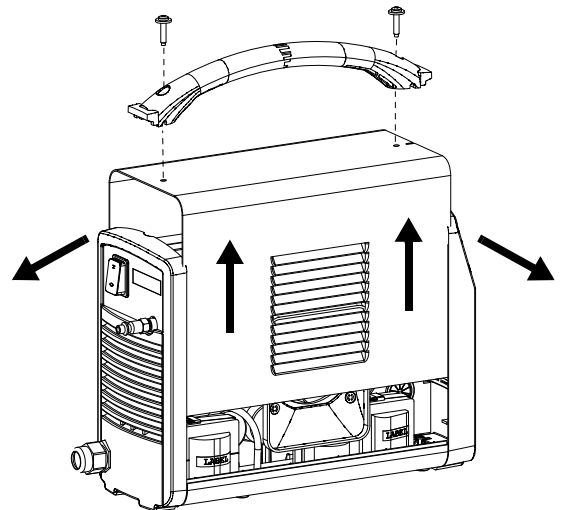
Replace the air filter element and air filter bowl

The following procedure explains how to remove the air filter element and air filter bowl inside the power supply and replace them with new ones.

 You can also use this procedure to replace the plastic retaining nut on the air filter/regulator assembly. For ordering information, see *Parts* on page 75.

Remove the power supply cover and handle

1. Set the power switch to OFF (O). Disconnect the power cord, and disconnect the gas supply.
2. Remove the two screws from the handle on the top of the power supply. Gently pull on the panel nearest the screw you are removing to keep pressure on the screw. When the screw is almost out, tilt the screwdriver slightly to help pull the screw out of the recessed hole.
3. Slightly tip the front and rear panels away from the power supply so that you can get the edges of the handle out from underneath them. Remove the handle, and set it and the two screws aside.
4. Continue to tilt the panels outward to release the sides of the cover from their tracks. Then lift the cover off the power supply.

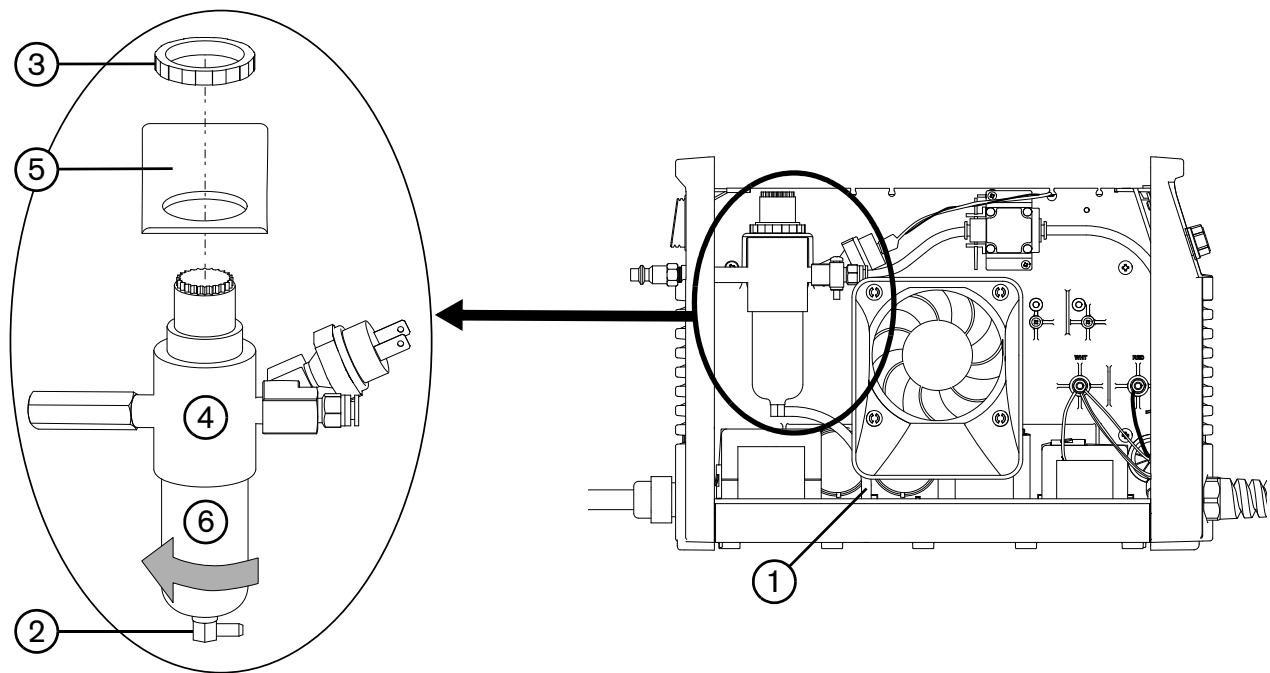


5 – Maintenance and Troubleshooting

Remove the old air filter element and air filter bowl

1. From the fan side of the power supply, disconnect the drain hose ① from the hole in the bottom of the base.
2. Remove the other end of the drain hose from the brass fitting ② at the bottom of the air filter bowl. Set the drain hose aside.
3. Unscrew the plastic retainer nut ③ that holds the air filter/regulator ④ in the bracket ⑤ on the center panel.
4. Tilt the bottom of the air filter/regulator assembly towards you with one hand.
5. With your other hand, unscrew the air filter bowl ⑥ to remove it from the air filter/regulator assembly.

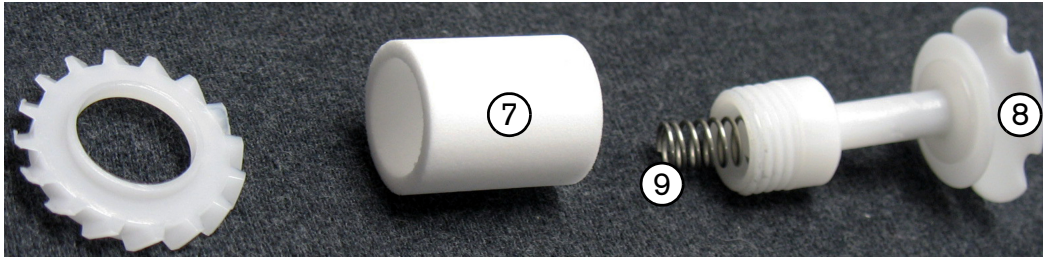
Figure 31



6. Does the air filter element ⑦ need to be replaced?

- ❑ If yes, unscrew the plastic retaining nut ⑧ that secures the air filter element, being careful not to lose the spring ⑨ that is compressed between the retaining nut and the air filter/regulator. Do not allow the air filter element to rotate as you remove the nut. Remove the air filter element from the plastic retaining nut.
- ❑ If no, continue with Step 3 on page 71.

Figure 32



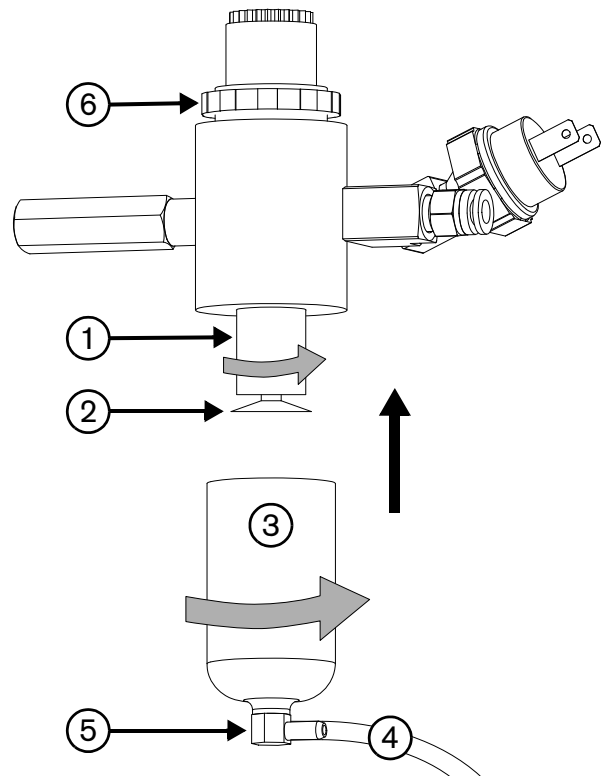
Install the new air filter element and air filter bowl

1. Place the new air filter element ① on the plastic retaining nut. Verify that the spring is in place.
2. Install the new air filter element. Tighten the retaining nut ② to finger-tight.
3. Does the air filter bowl ③ need to be replaced?
 - ❑ If yes, install the new filter bowl.
 - ❑ If no, clean the bowl before reinstalling it by wiping away any oil, dirt, or other contaminants.
 Tighten the filter bowl to finger-tight.
4. Connect the drain hose ④ to the fitting ⑤ at the bottom of the filter bowl. Verify the drain hose extends towards the front of the power supply.
5. Position the air filter/regulator assembly in the bracket on the center panel of the power supply, and secure it using the plastic retainer nut ⑥. Hand-tighten the retainer nut plus a quarter turn.



Do not overtighten the retainer nut.

6. Route the drain hose through the hole in the base of the power supply.



5 – Maintenance and Troubleshooting

7. Reconnect the gas supply, and check for leaks at each fitting and hose connection point on the air filter/regulator assembly.



CAUTION!

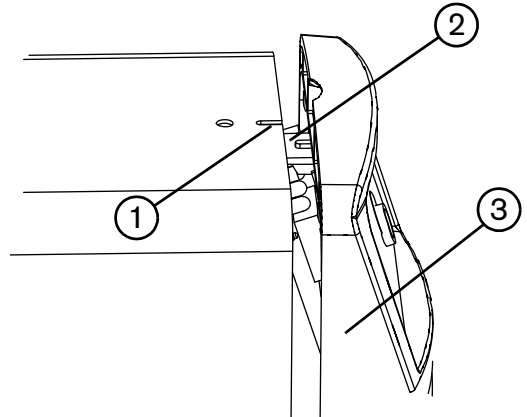
Gas supply pressures not within the specifications in the *Specifications* section of this manual can cause poor cut quality, poor consumable life, and operational problems.

If the purity level of the gas is too low, or if there are leaks in the supply hoses or connections:

- Cut speeds can decrease.
- Cut quality can deteriorate.
- Cutting thickness capability can decrease.
- Parts life can shorten.

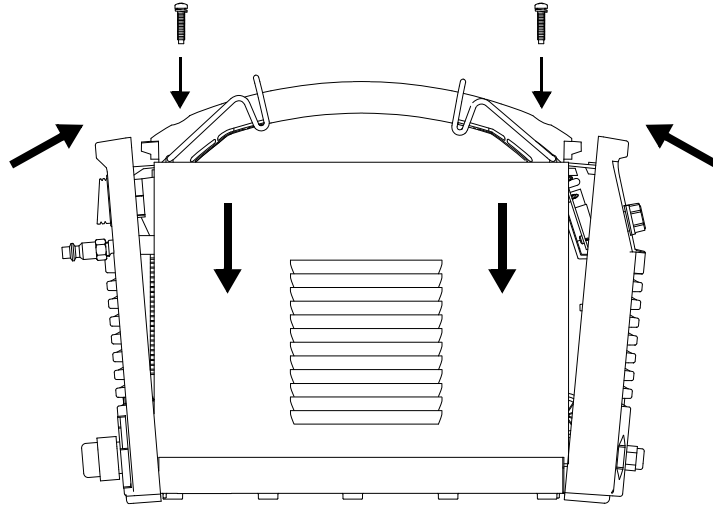
Put the power supply cover and handle back in place

1. Being careful not to pinch any wires, slide the cover onto the power supply. Align the bottom edges with the tracks, and align the slot in the top of the cover ① with the tab ② on the front panel ③ so that the louvers in the cover are in front of the fan.
2. Realign the front panel with the power supply.
3. Realign the rear panel with the power supply, making sure that the hole in the ground clip is aligned with the screw holes in both the panel and the power supply.
4. Position the handle over the holes in the top of the cover, and position the ends of the handle underneath the edges of the panels.



5. Reinstall the two screws that secure the cover and handle with a torque setting of 23.0 kg-cm (20 inch-pounds).
6. Reconnect the electrical power, and turn ON the power supply.

Figure 33



Section 6

Parts

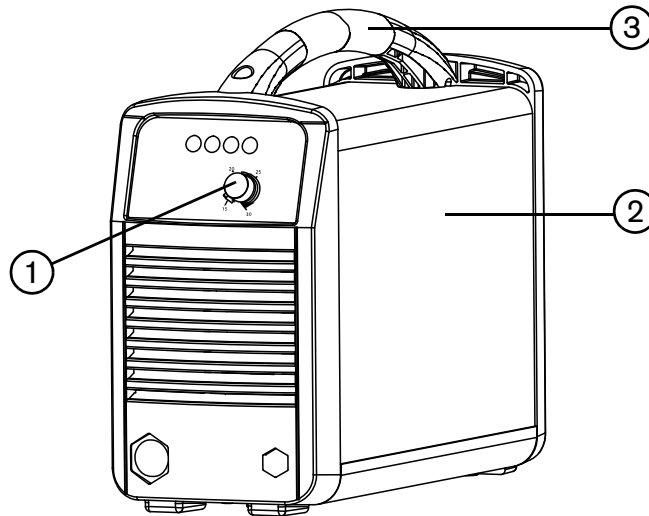
Use the kit numbers in this section to order operator replaceable parts, consumables, and accessories for your power supply and hand torch.

See *Maintenance procedures* on page 69 for applicable installation procedures.

For instructions on installing the consumables in the hand torch, see *Install the consumables* on page 44.

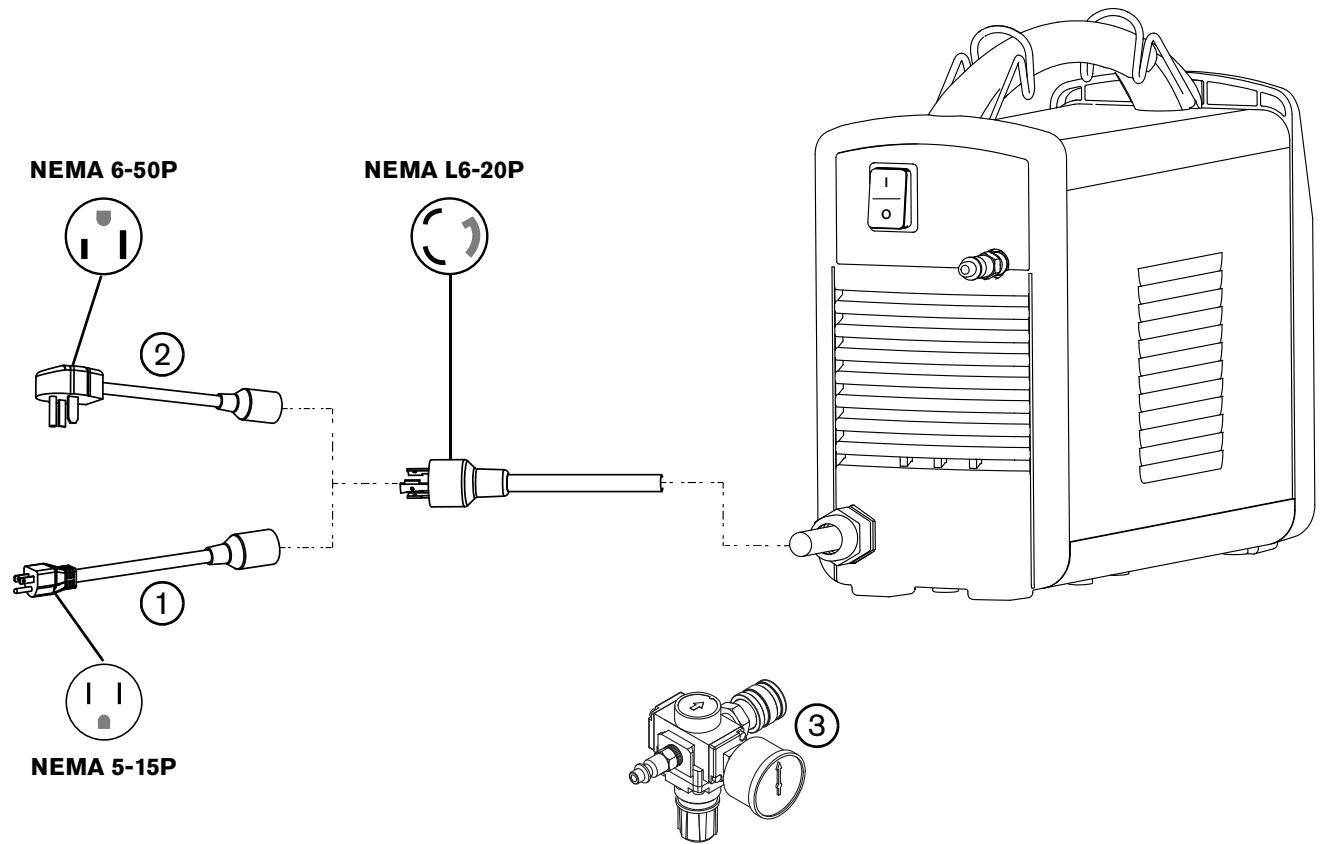
Power supply parts

Exterior, front



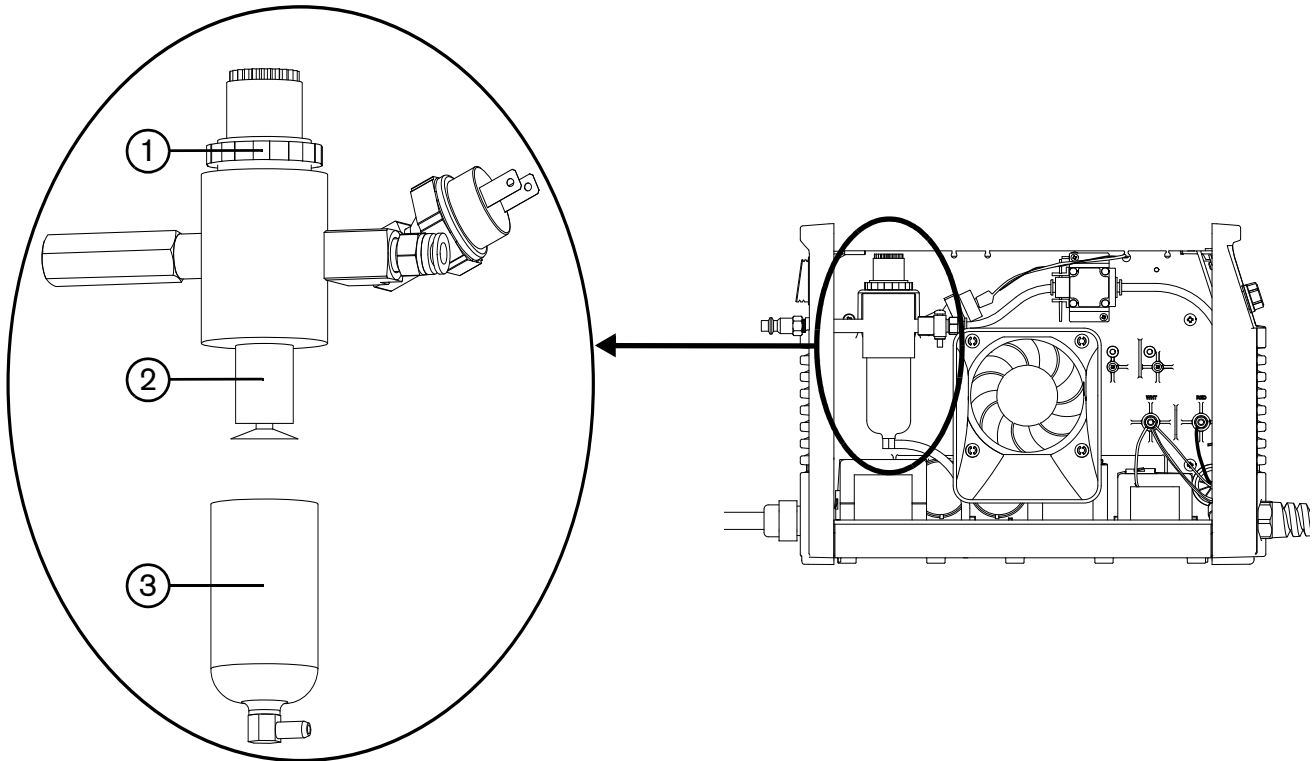
Item	Kit number	Description
	86-8030	Kit: Screws for the power supply cover and handle (not shown)
1	86-8031	Kit: Current adjustment knob
2	86-8020	Kit: Power supply cover with labels
3	86-8032	Kit: Handle with screws

Exterior, rear



Item	Kit number	Description
1	86-8036	Power cord extension: 120 V/15 A plug adapter
2	86-8037	Power cord extension: 240 V/20 A plug adapter
3	86-8029	Kit: External regulator



Air filter/regulator with pressure switch assembly (interior, fan side)



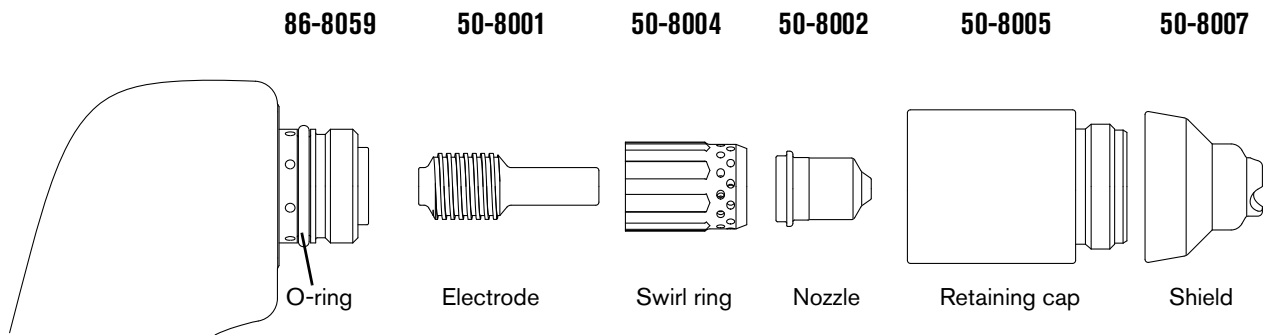
Item	Kit number	Description
1	86-8039	Kit: Air filter retaining nut
2	86-8040	Kit: Air filter element
3	86-8041	Kit: Air filter bowl

Hand torch consumables

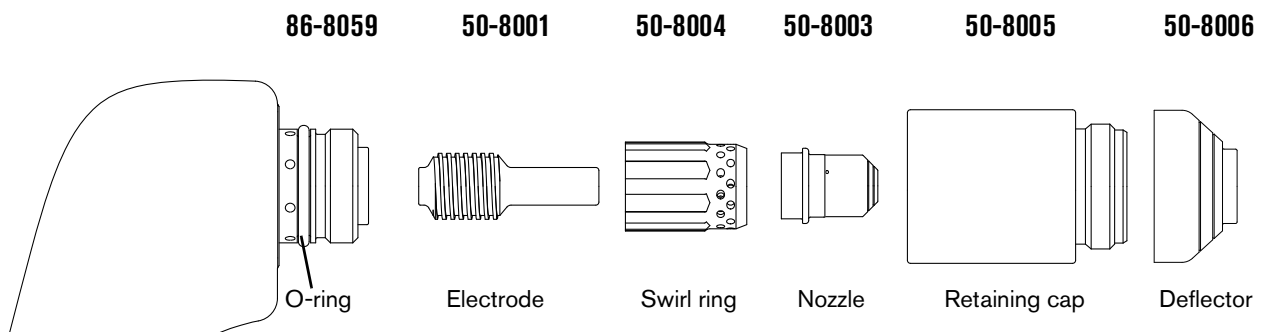
To order consumables for your torch, use the following part numbers.

-  Replace the nozzle and electrode at the same time.
-  Use the same electrode, swirl ring, and retaining cap for all applications. Do not use the general-purpose or gouging nozzle with the deflector. Do not use the ThinCut nozzle with either shield.

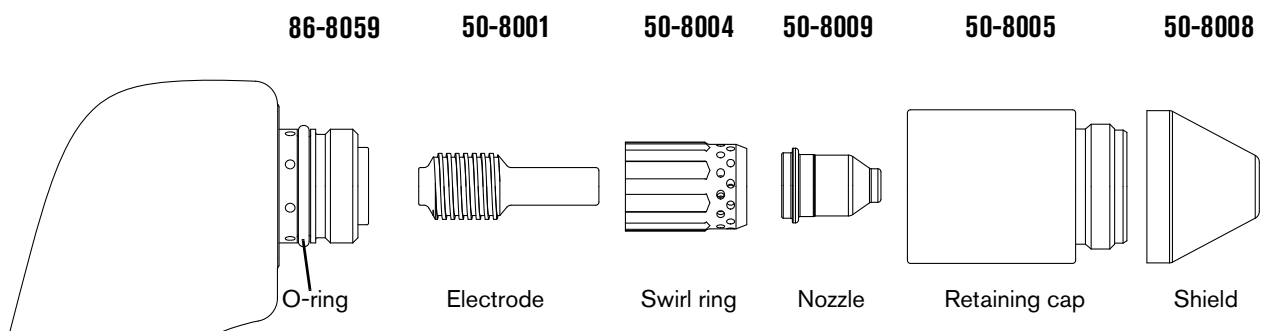
General-purpose (standard) consumables



ThinCut consumables



Gouging consumables



Accessory parts

Part number	Description
86-0002	Shoulder strap
86-8017	Leather cutting gloves
86-8018	Protective glasses, shade 5 lens

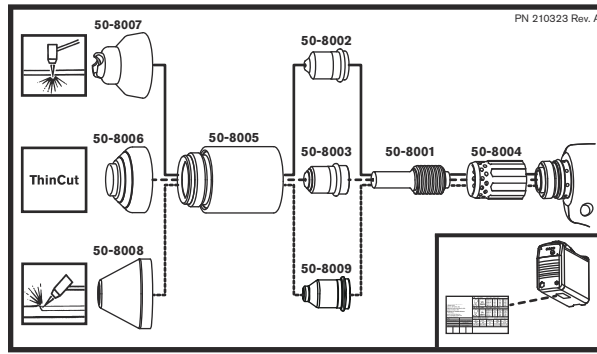
PR-30P Exocut labels

Kit number	Description
86-8019	Kit: PR-30P Exocut labels

The label kits include:

- Consumables label
- Appropriate safety labels
- Front and side decals

The following illustration shows the consumables label and warning label.



Consumables label

Read and follow these instructions, employer safety practices, and material safety data sheets. Refer to ANS Z49.1, "Safety in Welding, Cutting and Allied Processes" from American Welding Society (http://www.aws.org) and OSHA Safety and Health Standards, 29 CFR 1910 (http://www.osha.gov).		WARNING	AVERTISSEMENT
		Plasma cutting can be injurious to operator and persons in the work area. Consult manual before operating. Failure to follow all these safety instructions can result in death.	Le coupage plasma peut être préjudiciable pour l'opérateur et les personnes qui se trouvent sur les lieux de travail. Consulter le manuel avant de faire fonctionner. Le non respect des ces instructions de sécurité peut entraîner la mort.
1. Cutting sparks can cause explosion or fire. 1.1 Do not cut near flammables. 1.2 Have a fire extinguisher nearby and ready to use. 1.3 Do not use a drum or other closed container as a cutting table.		1. Les étincelles de coupage peuvent provoquer une explosion ou un incendie. 1.1 Ne pas couper près des matières inflammables. 1.2 Un extincteur doit être à proximité et prêt à être utilisé. 1.3 Ne pas utiliser un fût ou un autre contenant fermé comme table de coupage.	1. Les étincelles de coupage peuvent provoquer une explosion ou un incendie. 1.1 Ne pas couper près des matières inflammables. 1.2 Un extincteur doit être à proximité et prêt à être utilisé. 1.3 Ne pas utiliser un fût ou un autre contenant fermé comme table de coupage.
2. Plasma arc can injure and burn; point the nozzle away from yourself. Arc starts instantly when triggered. 2.1 Turn off power before disassembling torch. 2.2 Do not grip the workpiece near the cutting path. 2.3 Wear complete body protection.		2. Plasma arc can injure and burn; point the nozzle away from yourself. Arc starts instantly when triggered. 2.1 Turn off power before disassembling torch. 2.2 Do not grip the workpiece near the cutting path. 2.3 Wear complete body protection.	2. L'arc plasma peut blesser et brûler; éloigner la buse de soi. Il s'allume instantanément quand on l'amorce; 2.1 Couper l'alimentation avant de démonter la torche. 2.2 Ne pas saisir la pièce à couper de la trajectoire de coupage. 2.3 Se protéger entièrement le corps.
3. Hazardous voltage. Risk of electric shock or burn. 3.1 Wear insulating gloves. Replace gloves when wet or damaged. 3.2 Protect from shock by insulating yourself from work and ground. 3.3 Disconnect power before servicing. Do not touch live parts.		3. Hazardous voltage. Risk of electric shock or burn. 3.1 Wear insulating gloves. Replace gloves when wet or damaged. 3.2 Protect from shock by insulating yourself from work and ground. 3.3 Disconnect power before servicing. Do not touch live parts.	3. Tension dangereuse. Risque de choc électrique ou de brûlure. 3.1 Porter des gants isolants. Remplacer les gants quand ils sont humides ou endommagés. 3.2 Se protéger contre les chocs en s'isolant de la pièce et de la terre. 3.3 Couper l'alimentation avant l'entretien. Ne pas toucher les pièces sous tension.
4. Plasma fumes can be hazardous. 4.1 Do not inhale fumes. 4.2 Use forced ventilation or local exhaust to remove the fumes. 4.3 Do not operate in closed spaces. Remove fumes with ventilation.		4. Plasma fumes can be hazardous. 4.1 Do not inhale fumes. 4.2 Use forced ventilation or local exhaust to remove the fumes. 4.3 Do not operate in closed spaces. Remove fumes with ventilation.	4. Les fumées plasma peuvent être dangereuses. 4.1 Ne pas inhaler les fumées. 4.2 Utiliser une ventilation forcée ou un extracteur local pour dissiper les fumées. 4.3 Ne pas couper dans des espaces clos. Chasser les fumées par ventilation.
5. Arc rays can burn eyes and injure skin. 5.1 Wear correct and appropriate protective equipment to protect head, eyes, ears, hands, and body. Button shirt collar. Protect ears from noise. Use welding helmet with the correct shade of filter.		5. Arc rays can burn eyes and injure skin. 5.1 Wear correct and appropriate protective equipment to protect head, eyes, ears, hands, and body. Button shirt collar. Protect ears from noise. Use welding helmet with the correct shade of filter.	5. Les rayons d'arc peuvent brûler les yeux et blesser la peau. 5.1 Porter un bon équipement de protection pour se protéger la tête, les yeux, les oreilles, les mains et le corps. Boutonner le col de la chemise. Protéger les oreilles contre le bruit. Utiliser un masque de soudeur avec un filtre de teinte appropriée.
6. Become trained. Only qualified personnel should operate this equipment. Use torches specified in the manual. Keep non-qualified personnel and children away. 7. Do not remove, destroy, or cover this label. Replace if it is missing, damaged, or worn (PN 110584 Rev D).		6. Become trained. Only qualified personnel should operate this equipment. Use torches specified in the manual. Keep non-qualified personnel and children away. 7. Do not remove, destroy, or cover this label. Replace if it is missing, damaged, or worn (PN 110584 Rev D).	6. Suivre une formation. Seul le personnel qualifié a le droit de faire fonctionner cet équipement. Utiliser exclusivement les torches indiquées dans le manuel. Le personnel non qualifié et les enfants doivent se tenir à l'écart. 7. Ne pas enlever, détruire ni couvrir cette étiquette. La remplacer si elle est absente, endommagée ou usée (PN 110584 Rev D).

Warning label

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