



COOLCUT40air
OWNER'S
MANUAL



PLASMA CUTTING

Arc Plasma cutting Power Source

Manufactured at



Certified Facility

Serial Number:

Where Purchase:


Date of purchased:




READ INSTRUCTIONS!

- ✓ Consult the Owner's Manual for welding safety precautions.
- ✓ Use only genuine replacement parts
- ✓ While the information contained in this Manual represents the Manufacturer's best judgment, the Manufacturer assumes no liability for its use.

Owner's Record


Register your product
Active your warranty

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Model Name: _____

Date of purchased: _____

Serial Number: _____

Where Purchase: _____

- ✓ Proof of ownership
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- ✓ Track repair history
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SECTION 1 SAFETY PRECAUTIONS

SECTION 1 CONSIGNES DE SÉCURITÉ

1-1. Symbol Usage Symboles utilisés



Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.

Symbole graphique d'avertissement ! Attention !

Cette procédure comporte des risques possibles ! Les dangers éventuels sont représentés par les symboles graphiques joints.

- ▲ **Marks a special safety message.**
Indique un message de sécurité particulier
- ☞ **Means "Note"; not safety related.**
Signifie **NOTE** ; n'est pas relatif à la sécurité.



This group of symbols means Warning! Watch Out possible ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards

Ce groupe de symboles signifie Avertissement! Attention! Risques d'ÉLECTROCUTION, ORGANES MOBILES et PARTIES CHAUDES. Consulter les symboles et les instructions afférents ci-dessous concernant les mesures à prendre pour supprimer les dangers.

1-2. Arc welding Hazards Dangers relatifs au soudage à l'arc

- ★ **The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard.**
- ★ **Only qualified persons should service, test, maintain, and re- pair this unit.**
- ★ **During servicing, keep everybody, especially children, away**
- ★ **Les symboles représentés ci-dessous sont utilisés dans ce manuel pour attirer l'attention et identifier les dangers possibles. En présence de l'un de ces symboles, prendre garde et suivre les instructions afférentes pour éviter tout risque. Les instructions en matière de sécurité indiquées ci-dessous ne constituent qu'un sommaire des instructions de sécurité plus complètes fournies dans les normes de sécurité énumérées dans la Section 2-5. Lire et observer toutes les normes de sécurité.**
- ★ **Seul un personnel qualifié est autorisé à installer, faire fonctionner, entretenir et réparer cet appareil.**
- ★ **Pendant le fonctionnement, maintenir à distance toutes les personnes, notamment les enfants de l'appareil.**



ELECTRIC SHOCK can kill.
UNE DÉCHARGE ÉLECTRIQUE entraîner la mort.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is

- confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings, or scaffolds; when in cramped positions such as sitting, kneeling, or lying; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, use the following equipment in order presented: 1) a semiautomatic DC constant voltage (wire) welder, 2) a DC manual (stick) welder, or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone!
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first – double-check connections.
- Frequently inspect input power cord for damage or bare wiring – replace cord immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.
- If earth grounding of the workpiece is required, ground it directly with a separate cable.

- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Do not touch electrode holders connected to two welding machines at the same time since double open-circuit voltage will be present.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

SIGNIFICANT DC VOLTAGE exists after removal of input power on inverters.

Il reste une TENSION DC NON NÉGLIGEABLE dans les sources de soudage onduleur quand on a coupé l'alimentation.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.
- Ne pas toucher aux pièces électriques sous tension.
- Porter des gants isolants et des vêtements de protection secs et sans trous.
- S'isoler de la pièce à couper et du sol en utilisant des housses ou des tapis assez grands afin d'éviter tout contact physique avec la pièce à couper ou le sol.
- Ne pas se servir de source électrique à courant électrique dans les zones humides, dans les endroits confinés ou là où on risque de tomber.
- Se servir d'une source électrique à courant électrique UNIQUEMENT si le procédé de soudage le demande.
- Si l'utilisation d'une source électrique à courant électrique s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.
- D'autres consignes de sécurité sont nécessaires dans les conditions suivantes : risques électriques dans un environnement humide ou si l'on porte des vêtements mouillés ; sur des structures métalliques telles que sols, grilles ou échafaudages ; en position coincée comme assise, à genoux ou couchée ; ou s'il y a un risque élevé de contact inévitable ou accidentel avec la pièce à souder ou le sol. Dans ces conditions, utiliser les équipements suivants, dans l'ordre indiqué : 1) un poste à souder DC à tension constante (à fil), 2) un poste à souder DC manuel (électrode) ou 3) un poste à souder AC à tension à vide réduite. Dans la plupart des situations, l'utilisation d'un poste à souder DC à fil à tension constante est recommandée. En outre, ne pas travailler seul !
- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Installer le poste correctement et le mettre à la terre convenablement selon les consignes du manuel de l'opérateur et les normes nationales, provinciales et locales.
- Toujours vérifier la terre du cordon d'alimentation. Vérifier

et s'assurer que le fil de terre du cordon d'alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.

- En effectuant les raccordements d'entrée, fixer d'abord le conducteur de mise à la terre approprié et contre-vérifier les connexions.
- Vérifier fréquemment le cordon d'alimentation afin de s'assurer qu'il n'est pas altéré ou à nu, le remplacer immédiatement s'il l'est. Un fil à nu peut entraîner la mort.
- L'équipement doit être hors tension lorsqu'il n'est pas utilisé.
- Ne pas utiliser des câbles usés, endommagés, de grosseur insuffisante ou mal épissés.
- Ne pas enrouler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode provenant d'une autre machine.
- Ne pas toucher des porte électrodes connectés à deux machines en même temps à cause de la présence d'une tension à vide doublée.
- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretien l'appareil conformément à ce manuel.
- Porter un harnais de sécurité si l'on doit travailler au-dessus du sol.
- S'assurer que tous les panneaux et couvercles sont correctement en place.
- Fixer le câble de retour de façon à obtenir un bon contact métal-métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Isoler la pince de masse quand pas mis à la pièce pour éviter le contact avec tout objet métallique.
- Ne pas raccorder plus d'une électrode ou plus d'un câble de masse à une même borne de sortie de soudage.
- Arrêter les convertisseurs, débrancher le courant électrique et décharger les condensateurs d'alimentation selon les instructions indiquées dans la partie Entretien avant de toucher les pièces.



STATIC (ESD) can damage PC boards.

LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.
- Établir la connexion avec la arrette de terre avant de manipuler des cartes ou des pièces.
- Utiliser des pochettes et des boîtes antistatiques pour stocker, déplacer ou expédier des cartes PC.



FIRE OR EXPLOSION hazard. Risque D'INCENDIE OU

D'EXPLOSION.

- Do not place unit on, over, or near combustible surfaces.
- Do not service unit near flammables
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.
- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
- Ne pas installer l'appareil à proximité de produits inflammables.
- Ne pas surcharger l'installation électrique – s'assurer que l'alimentation est correctement dimensionnée et protégée avant de mettre l'appareil en service.



**FLYING METAL can injure eyes.
DES PARTICULES VOLANTES
peuvent blesser les yeux.**

- Wear safety glasses with side shields or face shield during servicing.
- Be careful not to short metal tools, parts, or wires together during testing and servicing.
- Le soudage, l'écaillage, le passage de la pièce à la brosse en fil de fer, et le meulage génèrent des étincelles et des particules métalliques volantes. Pendant la période de refroidissement des soudures, elles risquent de projeter du laitier.
- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.



**HOT PARTS can cause severe burns.
DES PIÈCES CHAUDES peuvent
provoquer des brûlures graves.**

- Do not touch hot parts bare handed.
- Allow cooling period before working on welding gun or torch
- Ne pas toucher des parties chaudes à mains nues.
- Prévoir une période de refroidissement avant d'utiliser le pistolet ou la torche.



**MAGNETIC FIELDS can affect pacemakers.
LES CHAMPS MAGNÉTIQUES
peuvent affecter les stimulateurs
cardiaques.**

- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near arc welding, gouging, or spot welding operations.
- Porteurs de stimulateur cardiaque, rester à distance.

- Les porteurs d'un stimulateur cardiaque doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de gougeage ou de soudage par points.



**CYLINDERS can explode if damaged.
LES BOUTEILLES peuvent
exploser si elles sont
endommagées.**

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the right equipment, correct procedures, and sufficient number of persons to lift and move cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.

Des bouteilles de gaz protecteur contiennent du gaz sous haute pression. Si une bouteille est endommagée, elle peut exploser. Du fait que les bouteilles de gaz font normalement partie du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, des dommages physiques, du laitier, des flammes ouvertes, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber ou de se renverser.
- Tenir les bouteilles éloignées des circuits de soudage ou autres circuits électriques.
- Ne jamais placer une torche de soudage sur une bouteille à gaz.
- Une électrode de soudage ne doit jamais entrer en contact avec une bouteille.
- Ne jamais souder une bouteille pressurisée – risque d'explosion.
- Utiliser seulement des bouteilles de gaz protecteur, régulateurs, tuyaux et raccords convenables pour cette application spécifique ; les maintenir ainsi que les éléments associés en bon état.
- Détourner votre visage du détendeur-régulateur lorsque vous ouvrez la soupape de la bouteille.

- Le couvercle du détendeur doit toujours être en place, sauf lorsque la bouteille est utilisée ou qu'elle est reliée pour usage ultérieur.
- Utiliser les équipements corrects, les bonnes procédures et suffisamment de personnes pour soulever et déplacer les bouteilles.
- Lire et suivre les instructions sur les bouteilles de gaz comprimé, l'équipement connexe et le dépliant P-1 de la CGA (Compressed Gas Association) mentionné dans les principales normes de sécurité.



FALLING UNIT can cause injury.
LA CHUTE DE L'APPAREIL peut blesser.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit
- Utiliser l'anneau de levage uniquement pour soulever l'appareil, NON PAS les chariots, les bouteilles de gaz ou tout autre accessoire.
- Utiliser un équipement de levage de capacité suffisante pour lever l'appareil.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.



MOVING PARTS can cause injury.
DES ORGANES MOBILES peuvent provoquer des blessures.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before reconnecting input power.
- S'abstenir de toucher des organes mobiles tels que des ventilateurs.
- Maintenir fermés et verrouillés les portes, panneaux, recouvrements et dispositifs de protection.
- Seules des personnes qualifiées sont autorisées à enlever les portes, panneaux, recouvrements ou dispositifs de protection pour l'entretien.
- Remettre les portes, panneaux, recouvrements ou dispositifs de protection quand l'entretien est terminé et avant de rebrancher l'alimentation électrique.



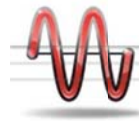
MOVING PARTS can cause injury.
DES ORGANES MOBILES peuvent provoquer des blessures.

- Keep away from moving parts
- Keep away from pinch points such as drive rolls
- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.



OVERUSE can cause OVERHEATING. L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit
- Prévoir une période de refroidissement ; respecter le cycle opératoire nominal.
- Réduire le courant ou le facteur de marche avant de poursuivre le soudage.
- Ne pas obstruer les passages d'air du poste.



H.F. RADIATION can cause interference.
LE SOUDAGE À L'ARC risque de provoquer des interférences.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.
- Le rayonnement haute fréquence (HF) peut provoquer des interférences avec les équipements de radio-navigation et de communication, les services de sécurité et les ordinateurs.
- Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un electricien qualifié les interférences résultant de l'installation.
- Si le FCC signale des interférences, arrêter immédiatement l'appareil.
- Effectuer régulièrement le contrôle et l'entretien de l'installation.
- Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence, maintenir les éclateurs à une distance correcte et utiliser une terre

et un blindage pour réduire les interférences éventuelles.



READ INSTRUCTIONS. LIRE LES INSTRUCTIONS.

- Consult the Owner's Manual for welding safety precautions.

- Use only genuine replacement parts

- Lire le manuel d'utilisation avant d'utiliser ou d'intervenir sur l'appareil.
- Utiliser uniquement des pièces de rechange.

1-3. Safety Standards Normes de sécurité

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3 (phone: 800-463-6727 or in Toronto 416-747-4044, website: www.csa-international.org).

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, de Global Engineering Documents (téléphone : 1-877-413-5184, site Internet : www.global.ihs.com).

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1-4. EMF Information EMF Information

Considerations About Welding And The Effects Of Low Frequency Electric And Magnetic Fields

Welding current, as it flows through welding cables, will cause electro- magnetic fields. There has been and still is some concern about such fields. However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: "The body of evidence, in the committee's judgment, has not demonstrated that exposure to power- frequency electric and magnetic fields is a human-health hazard." However, studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

To reduce magnetic fields in the workplace, use the following procedures:

Considérations sur le soudage et les effets de basse fréquence et des champs magnétiques et électriques.

Le courant de soudage, pendant son passage dans les câbles de soudage, causera des champs électromagnétiques. Il y a eu et il y a encore un certain souci à propos de tels champs. Cependant, après avoir examiné plus de 500 études qui ont été faites pendant une période de recherche de 17 ans, un comité spécial ruban bleu du National Research Council a conclu : « L'accumulation de preuves, suivant le jugement du comité, n'a pas démontré que l'exposition aux champs magnétiques et champs électriques à haute fréquence représente un risque à la santé humaine ». Toutefois, des études sont toujours en cours et les preuves continuent à être examinées. En attendant que les conclusions finales de la recherche soient établies, il vous serait souhaitable de réduire votre exposition aux champs électromagnétiques pendant le soudage ou le coupage.

Pour réduire les champs magnétiques sur le poste de travail, appliquer les procédures suivantes :

1. Maintenir les câbles ensemble en les tordant ou en les enveloppant.

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.
4. Keep welding power source and cables as far away from operator as practical.
5. Connect work clamp to work piece as close to the weld as possible.

About Pacemakers:

Pacemaker wearers consult your doctor first. If cleared by your doctor, then following the above procedures is recommended

2. Disposer les câbles d'un côté et à distance de l'opérateur.
3. Ne pas courber pas et ne pas entourer pas les câbles autour de votre corps.
4. Garder le poste de soudage et les câbles le plus loin possible de vous.
5. Connecter la pince sur la pièce aussi près que possible de la soudure.

En ce qui concerne les stimulateurs cardiaques

Les porteurs de stimulateur cardiaque doivent consulter leur médecin avant de souder ou d'approcher des opérations de soudage. Si le médecin approuve, il est recommandé de suivre les procédures précédente

SECTION 2 PACKING LIST

CoolCut40-air package (Part No: 07001900)		
Description	Part no	Quantity
CoolCut40-air Power source come with build-in air compressor and water trap, 10 ft. (3 M) Power cord and molded NEMA 6-50P 230V AC Plug		1
SG55 industrial plasma cutting torch with 16 ft (6 M) #4 lead	07001812	1
200A ground clamp with 16ft (5 M) lead and 25 mm male Dinse plug	07000464	1
Owner' manual	07000419	1

Table 2.1

SECTION 3 BASIC INFORMATION

3-1. Plasma cutting power source specifications

CoolCut40air package (Part No: 07003700)		
Power supply	AC (208)V/230V,60Hz,1 phase	
Input Amps @ Maximum output(A)	33	
Rated input (KW)	4.8	
Open circuit voltage(V)	450	
Amperage range(A)	20-40A	
Duty cycle (%) @ 40 °C	31A/92.4V/100% Duty cycle 40A/96V/60% Duty cycle	
Compress air Pressure(Psi)	44-73(3-5Bar), recommend 65(4.5Bar)	
Gas Type	Air: Clean, dry, oil free Nitrogen: 99.995% pure	
Cutting capacity	External compress air	Internal compress air
	Rated 3/8 in @ 10 ipm, 1/2 in @ 7 ipm Severance 5/8 in @4 ipm	Rated 1/4 in @ 12 ipm, 3/8 in @ 7 ipm Severance 1/2 in @3 ipm
Protection class	IP23	
Insulation class	H	
Operating temperature (°C)	-20 to +40 (-4°F to 104°F)	

Storage temperature (°C)	-40 to +85 (-40°F to 185°F)
Machine dimension (HxWxD) (CM)	52x21x40(20.4x8.3x15.7in)
Power source weight (KG)	18(40lbs)
Packing dimension (HxWxD)(CM)	63x38x52(24.8x15x20.5in)
Packing weight(KG)	23(51lbs)

Table 3.1

SG55 Plasma cutting gun	
Rated current(A)	60
Rated Duty cycle (%)	60% at 60A, 100% at 40A
Cool style	Air cooled
Maximum Air pressure(Bar)	4-6(57-85psi)
Air consumption(l/min)	160
Cable length(M)	6(16FT)
Connection	Quick Connection

Table 3.2

Detailed gun specification please see separate gun manual

3-2. Duty cycle & Over heating

Duty Cycle is percentage of 10 minutes that unit can cut at rated load without overheating.

If unit overheats, output stops, over-heat protection lamp will illuminate. Wait 15 minutes for unit to cool. Reduce amperage, before resume plasma cutting.

CAUTION! EXCEEDING DUTY CYCLE CAN DAMAGE UNIT AND VOID WARRANTY.

SECTION 4 INSTALLATIONS

4-1. Connection diagram when use built-in air compressor

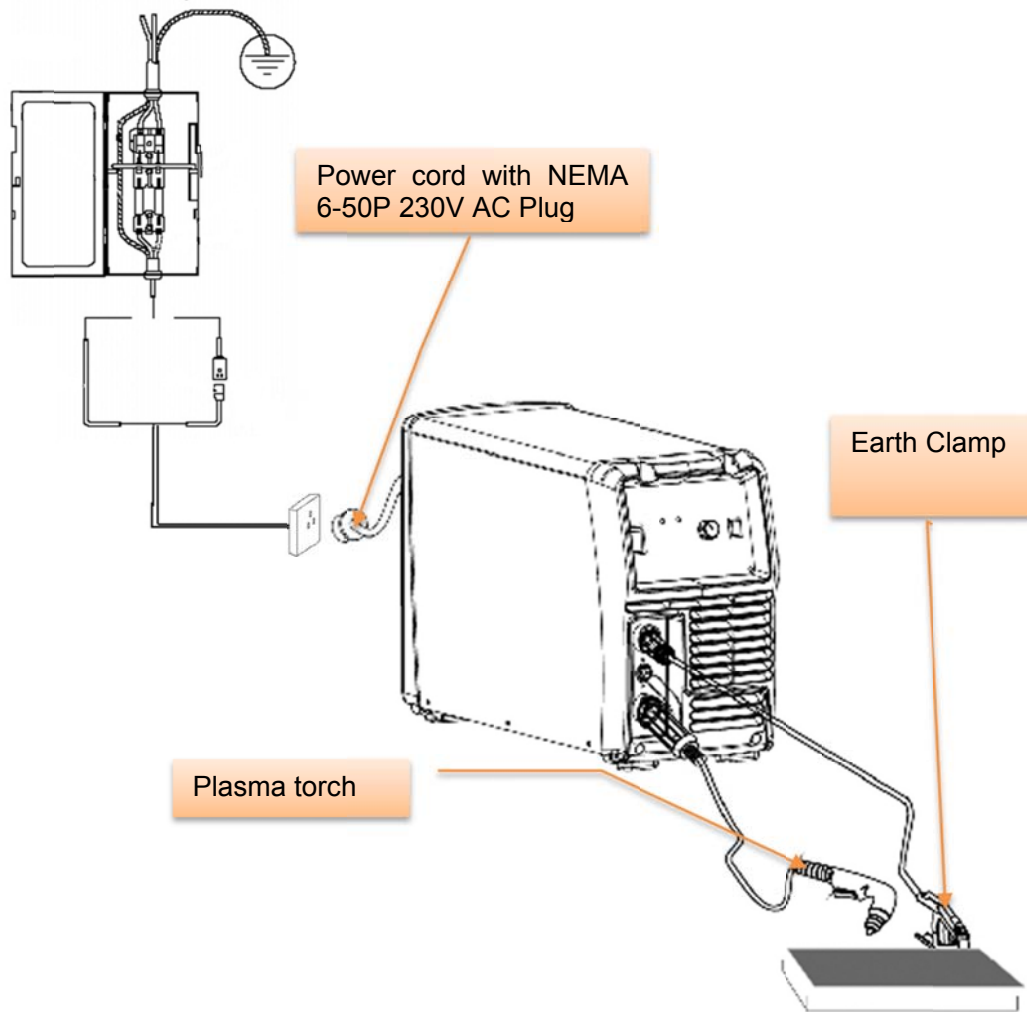


Figure 4.1

4-2. Installation procedure

4-2.1. Plasma cutting machine should be installed in a stable position and with good ventilation. Avoid direct sun outdoors or rain. Place at a distance of 12" (300mm) or more from walls or similar that could restrict natural air flow for cooling. Avoid transport in invert or side position.

4-2.2. Switch the ON/OFF Switch to OFF.

4-2.3. Connect the work lead cable to the negative output terminal, Insert earth clamp quick connector into receptacle and turn 90° clockwise. Refer to Figure 4.1.

4-2.4. Connect the SG55 plasma cutting torch to the positive output terminal. Attached the 2 pin control cable to control receptacle and tight with hand. Refer to Figure 4.1.

4-2.5. **Using built-in air compressor:** switch air source selection knob to "Internal Air".

4-2.6. **Using external air compressor:**



WARNING!

A high precision oil/air filter/separator must be applied when connected to external air supply. Failed to do it will not only deteriorates the cutting capacity, reduces the life of the consumables, the accumulated water inside the machine may cause damage which is not covered by warranty!

Optional: WeldKing® high precision, high efficiency two-stage oil/air filter/separator with built-in regulator and reducer kit, model AF433, Part no: 07001920. AF433 filter kit removes moisture and contaminants to at least 5 microns and is recommended for improved filtering with compressed air, to keep moisture and debris out of the torch.

Use AF433: switch air source selection knob to "External Air". Attach AF433 to the mounting bracket supplied with the machine. Connect air supply line to the Ø8 barb inlet port of AF433 according to Figure 4.2. Air supply can be either air or Nitrogen.

Use user supplied oil/air filter/separator: an high pressure regulator must be used on either type of gas and must be capable of delivering 155 l/min at a pressure of 5 bar (72psi) to the filter.

NOTE! For a secure seal, apply thread sealant to the fitting threads, according to the maker's instructions. Do not use Teflon tape as a thread sealer, as small particles of the tape may break off and block the small air passages in the torch.

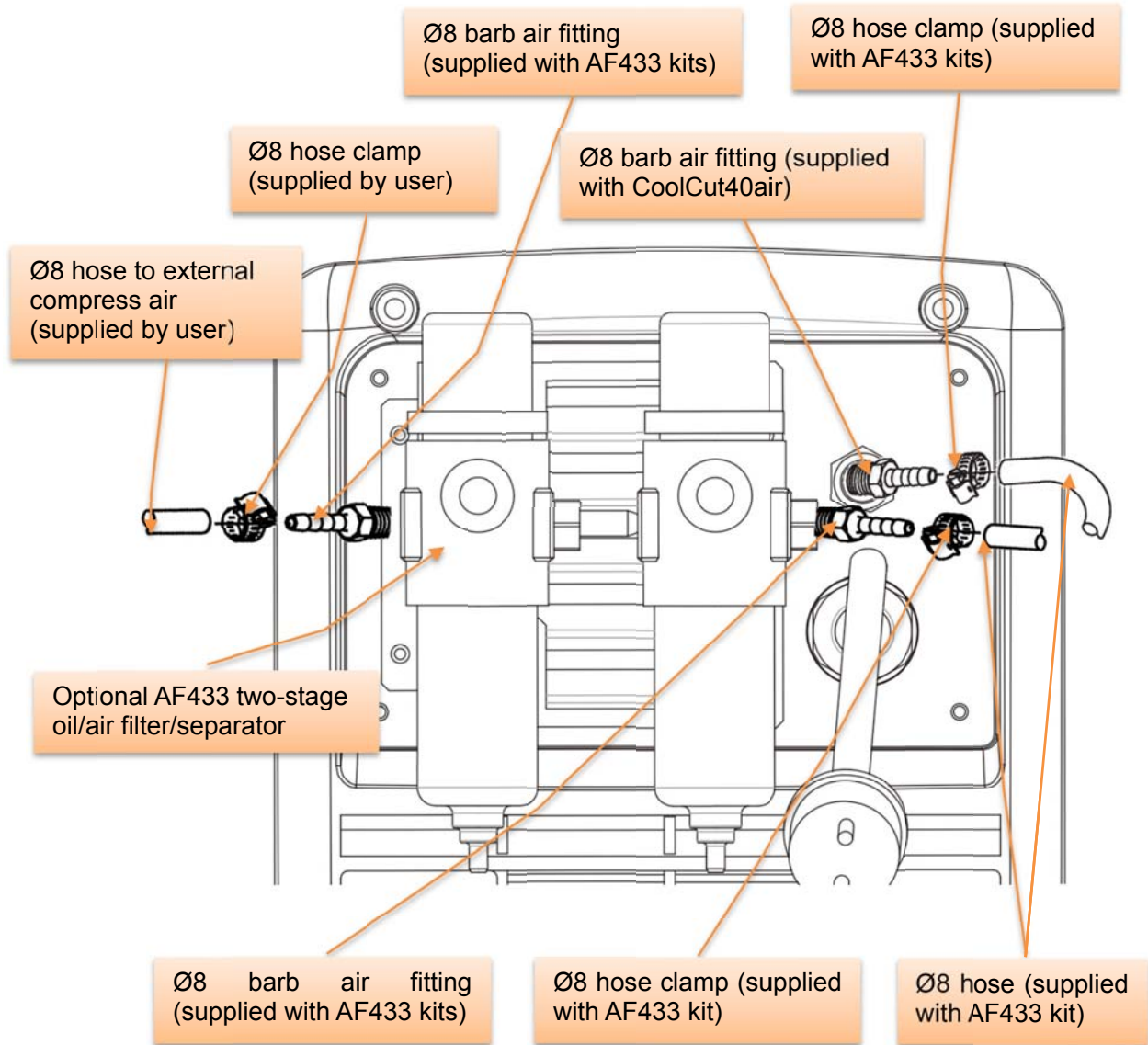


Figure 4.2

4-2.7. Connect the work lead clamp to your work piece.

4-2.8. Connect machine with 208/230V single phase power supplies.

4-3. Electric service guide

CAUTION!

WARNING: THIS PLASMA CUTTING MACHINE MUST BE CONNECTED TO POWER SOURCE IN ACCORDANCE WITH APPLICABLE ELECTRICAL CODES

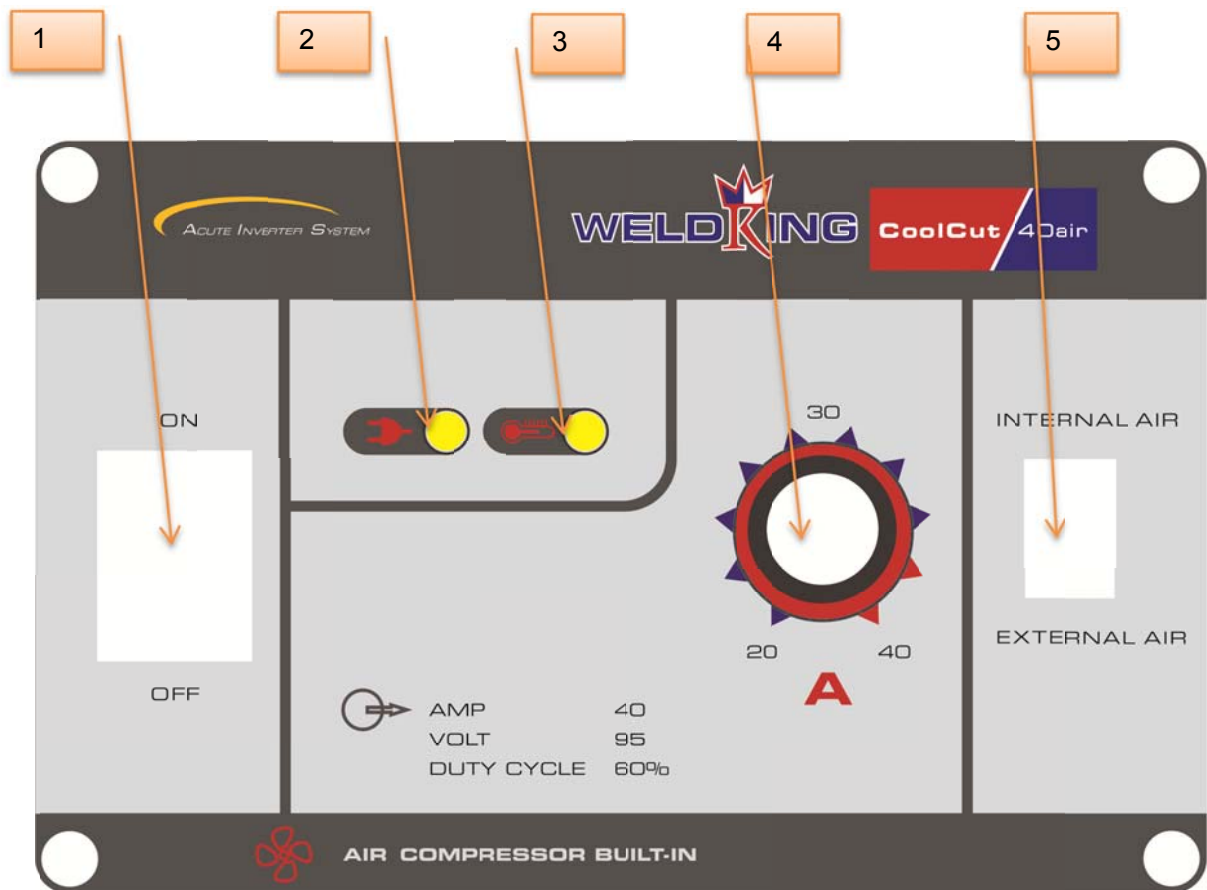
AVERTISSEMENT: LE RACCORDEMENT DE CETTE MACHINE DE SOUDAGE Á L'ALIMENTATION DOIT ÉTRE CONFORME AUX CODES D' ÉLECTRICITÉ PERTINENTS

Input voltage(V)	208/230
Frequency(Hz)	60
Input Amperes at rated output(A)	33
Max recommended standard fuse Rating in Amp	
Circuit breaker, time delay	35
Normal operation	45
Min input conductor size in AWG	10
Min Grounding conductor Size in AWG	10

Table 4.1

SECTION 5 OPERATION

5-1. Power source panel layout and description



1. Main power switch

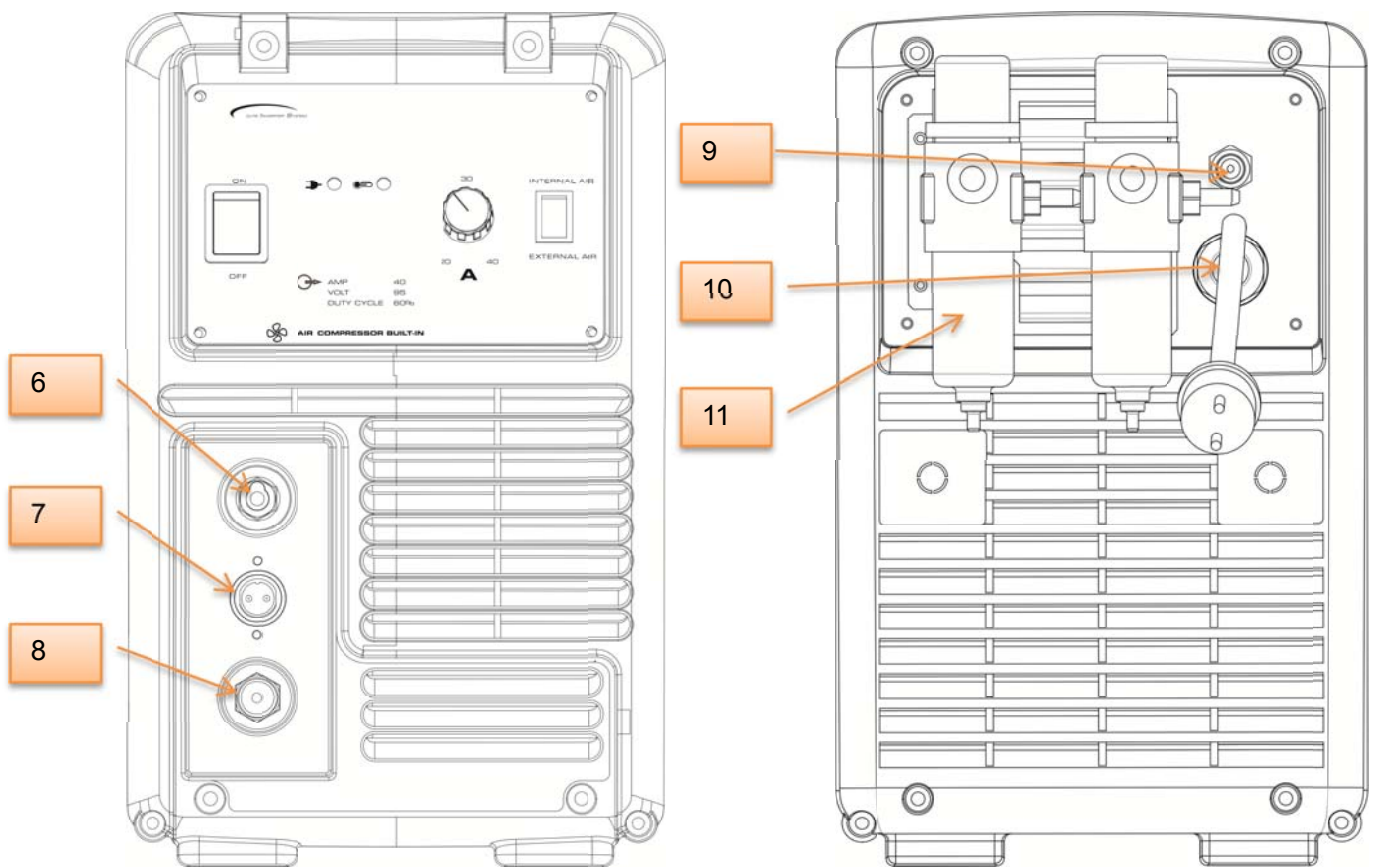
4. Current adjustment knob

2. Power indication light

5. Internal/External air selection switch

3. Protection indication light

Figure 5.1



6. Positive output connect to earth clamp

7. 2 pin on-off switch control port

8. Negative output connect to torch

9. External gas inlet (8mm barb fitting)

10. Power cord

11. **Optional** two stage water/oil filter/separator with built-in pressure reducer and regulator/gauge

Figure 5.2

5-2. Operation



USE SINGLE PHASE 208V/230V POWER SUPPLY.

5-2.1. Switch on the power source. Check the connection of work piece, earth cable, plasma cutting torch; make sure they are firm and reliable. Do not attach earth cable to the portion that will fall away.

5-2.2. If external air is used, pull the regulator cap out, gradually turn regulator cap to adjust gas pressure to 65psi (4.5 bar) and push the regulator cap back in.

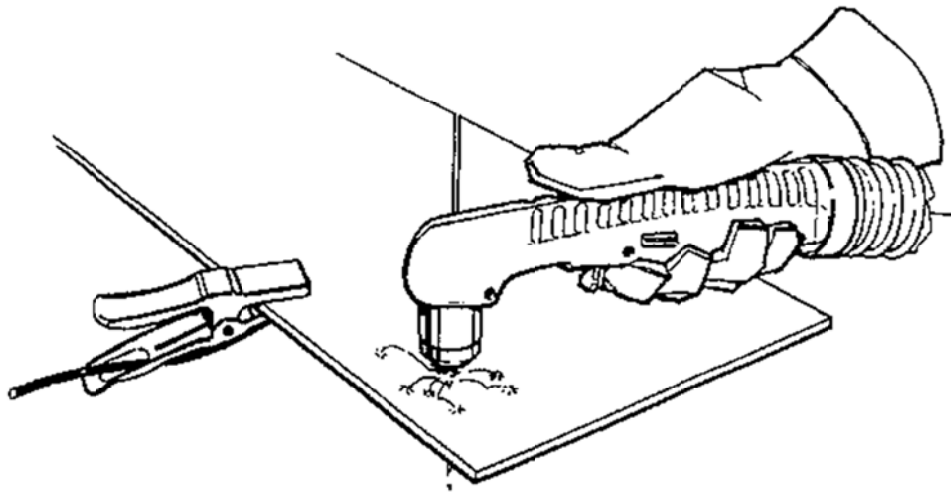


Figure 5.3

5-2.3. Switch on the power source. The power light (white) should illuminate. Adjust the cutting current knob to desired setting.

5-2.4. Place the tip of the torch at the edge of the work piece makes sure the tip is vertical to the work piece. When piercing, the tip should have an angle away from yourself, after arc starts, slowly rotate the torch to upright position. This is to blow the melted metal away and is particularly important when cutting thicker material. Make sure that the torch is pointed away from you and the people near you to avoid any danger from sparks and hot metal.

5-2.5. After arc starts, hold the torch nozzle at vertical position and watch the arc as it cut

along the line. By lightly dragging the shield on the workpiece, you can maintain a steady cut. For straight-line cutting, use any straight edge as a guide.

5-2.6. Evenly move the torch in the desired direction, at a speed which will ensure good cut quality. Pulling the torch through the cut is easier than push it.

5-2.7. When cutting, make sure that the sparks are coming out of the bottom of the metal. If they are spraying on top of the workpiece, you are moving the torch too fast, or you do not have sufficient power to fully penetrate the workpiece.

5-2.8. When the cut is finished, release the torch switch to extinguish the arc.

5-2.9. Grate Cutting - For rapid restarts, such as grate or heavy mesh cutting, do not release the torch switch. This avoids the 10 seconds post flow portion of the cutting cycle.

5-2.10. After finish operation, turn off the air supply. In the end, turn off plasma cutting power source and wall switch.

5-3. Recommend Cutting parameter

The settings listed below are just for initial commission of the machine. The parameters can be refined in actual cutting.

The cutting speed is for using external air supply. When use internal air supply, the cutting speed is 60% of using external air.

Material	Thickness (inches) (mm)		Current (amps)	Maximum travel speed	
				(ipm)	(mm/min)
Mild steel	26 GA	0.5	20	87	2209
	10 GA	3.4	25	63	1600
	1/4	6.4	40	32	812
	3/8	10	40	22	558
	1/2	12	40	12	304
Aluminum	1/32	0.8	20	60	1524
	1/8	3.2	25	55	1397

	1/4	6.4	40	30	762
	3/8	10	40	20	508
	1/2	12	40	10	256
Stainless steel	26 GA.	0.5	20	60	1524
	14 GA.	1.9	30	43	1092
	1/4	6.4	40	25	635
	3/8	10	40	14	355
	1/2	12	40	8	203

Table 5.1

SECTION 6 TROUBLE SHOOTING

6-1. General trouble shooting

No	Problem		Cause	Solution
1	Power Indication lamp does not on after switch on the main switch		Loose contact at input lead	Check contact situation
			Lamp malfunction, poor contact	Check contact situation. Replace lamp
			Main switch malfunction	Check switch, replace if necessary
2	Cooling fan stops to rotate after machine has worked a period	Power indication lamp on	Cooling fan blade blocked by obstacle.	Clear
			Cool fan failure	Check fan, replace if necessary
		Power indication lamp off	See No. 1	
3	Overheat light on		Work excess the rate duty circle	Use under rate duty circle
			Input voltage is too high	Use under rate input voltage

4	The mains power circuit breaker or fuse nuisance trip	High ambient temperature	Use machine under rated ambient temperature
		Using an extension cable	Use extension cable
		Low line mains power voltage	Use input voltage according to specification
		Rectifier short circuit	Check and replace
		Main transformer short circuit	Check and replace
		Control transformer short circuit	Check and replace
		Cooling fan short circuit	Check and replace
5	Electric leak at the case	Power cord leak	Insulate power cord
		Transformer contact with case	Insulate transformer
		Not grounding properly	Check and redo the grounding
6	No OCV	Problem main circuit	Check control PCB, Power PCB and IGBT module
7	Machine does not response after push the	Trigger shortcut or control cable broken	Replace/re-connect

	start trigger	Control transformer failure	Replace
		Input voltage is too low	Use rated Input voltage
8	Cutting current cannot be adjusted	cutting current adjustment potentiometer is loose or damage	Check and repair
9	Wall circuit breaker jump	Control transformer short circuit	Check and replace
		Solenoid valve short circuit	Check and replace
		Cooling fan short circuit	Check and replace
		Work excess the rated duty circle	Use under rated duty circle
		Input voltage is too high	Use proper voltage

Table 6.1

6-2. Plasma cutting trouble shooting

No.	Problem	Cause	Solution
10	Erratic or improper cutting output.	Wrong cable size	Choose the right cable size
11	Cable or receptacle too hot.	Poor contact between cutting torch or earth cable and receptacle at machine	Clean and tighten all plasma cutting connections

		Poor connection between torch and torch cable	Clean and tighten
12	Poor penetration during cutting	Work piece thickness excess the capacity of the machine	Use higher capacity cutter
		Cutting speed is too fast	Slow down
		Torch tilt to much	Adjust angle to vertical
		Air pressure is too low or too high	Adjust the pressure
		Consumables are worn	Change consumables
		Line voltage is not stable	Use Voltage stabilizer
13	Arc fail to ignite or does not ignite properly	The torch cable open circuit	Re-connect
		Control circuit board failure	Check and repair the circuit board
		Poor contact at earth lead and gun cable	Check and re-connect
		Loose or poor connection with the main power supply link	Check the connection
		Water in the air compressor or filter	Drain water or Change filter
14	The arc extinguish suddenly during plasma cutting	The cutting speed is too slow	Adjust the speed
		Electrode too far away from work piece surface	Reduce the torch or put torch on the workpiece
		The Nozzle or electrode are	Replace

		faulty	
15	Torch sputters and hisses	The gas filter at the rear of the machine contains excessive moisture	Drain the filter bowl and clean the filter. See MAINTENANCE SECTION.

Table 6.2

SECTION 7 MAINTENANCE

7-1. Maintenance

Periodic maintenance is necessary for keeping the machine work properly.



CAUTION! DISCONNECT POWER INPUT AND SWITCH OFF THE MAIN POWER SWITCH BEFORE START OF MAINTENANCE.

Regular Check and Inspection	Bowl Draining and Filter Element Cleaning
<ul style="list-style-type: none"> • Check and change broken electrode and nozzle to avoid damage to the torch and machine. • Replace unreadable labels. • Check the function of all switches. • Check if the fan rotates properly and if there is air venting out from back of the machine. • Pay Attention to the abnormal vibration, noise, smell and gas leakage during operation. • Check if the cutting cables are over heated. • Check if the cable connections are over heated. • Check if the cable is connected firmly and properly, if it is broken and cause bad insulation. 	<p>Moisture in the torch can cause the torch to sputter and hiss. If moisture is present, purge the gas lines. If moisture builds up in the bowl of the filter, drain the bowl and clean the filter element:</p> <ul style="list-style-type: none"> • Shut off the gas supply and disconnect the gas supply hose from the filter assembly before proceeding. • Remove the cap at the bottom of the filter bowl and turn the knurled drain valve to the right to release water from the bowl. • Unscrew the filter bowl. • Unscrew the filter element. • Clean the filter element with alcohol, and then blow it out with air. Clean the bowl with household soap only. • Replace the filter element and filter bowl.

- | | |
|--------------------------------------|----------------------------------|
| • Check the cover grounded properly. | • Reconnect the gas supply hose. |
|--------------------------------------|----------------------------------|

Table 7.1

7-2. Safety precaution



Refer to the American National Standard Z49.1 entitled: SAFETY IN WELDING AND CUTTING. **ALL INSTALLATION, OPERATION, MAINTENANCE, AND REPAIR WORK MUST BE PERFORMED BY QUALIFIED PERSONAL.**

- 7-2.1. Welders must be equipped with welding mask, gloves and tie the sleeves and collar properly. Use Table 6.4 to choose proper glass shade, also can reference to ANSI Z49.1 listed in Safety Standards. There should be an arc shield around plasma cutting field to protect others from arc shock.
- 7-2.2. Do not perform plasma cutting near flammable, explosive materials or gases.
- 7-2.3. Gas cylinder must be located at a safe and steady place to avoid injury others.
- 7-2.4. Keep finger, hair and clothing away from the rotating fan.
- 7-2.5. The power source must be grounded when plasma cutting.
- 7-2.6. When yellow protection light is enlightened during plasma cutting, it is indicating that the plasma cutter is over current or over heat, and automatic protection will be triggered. Stop plasma cutting immediately and wait until plasma cutter cool down.
- 7-2.7. Plasma cutting machine should not work in a flammable and toxic environment, avoid moisture, rain, and do not directly expose to sun.
- 7-2.8. Do not switch off the plasma cutter during plasma cutting!
- 7-2.9. Periodically maintain the machine and clean the dust inside.

SECTION 8 PARTS LIST

Item	Order No.	Description	Note	Qty
1	8.253RM.003-B	Handle	arc style black 301*90*66	1
2	8.301RM.659	Cover	use with S.008RM.659 CUT 40COM HZ Panel	1
3	8.123RM.414	internal air filter bracket	use with S.008RM.660 CUT 40 HF COM HZ panel	1
4	8.307RM.660	rear plate	use with S.008RM.660 CUT 40 HF COM HZ panel	1
5	8.462RM.041	gas inlet	¼" NPT fitting to φ8 barb connector. M12 installation thread.	1
6	7.154.415-C	Power cord	3M/2.5MM2	1
7	7.155.021	strain relief	M2012B6-12 beisit	1
8	8.068RM.932	rear frame	FLAMA MULTIMIG 200 rear plate	1
9	8.122RM.659	fan support	use with S.008RM.659 CUT 40COM HZ Panel	1
10	7.720.053	fan	MODEL 3610VL-05W-B70 24VDC 0.49A	1
	7.723.002	fan screen	φ88	1
11	W.496RM.414-A	MUR PCB	Base board B.067RM.414-A	1
12	W.496RM.332-A	EMC PCB	Base board B.067RM.332-A	1
13	8.423RM.078	MUR heat sink #4	CUT 40E HF use with S.008RM.612-RG	1
14	8.423RM.079	MUR heat sink #5	CUT 40E HF use with S.008RM.612-RG	1

15	8.423RM.077	MUR heat sink #3	CUT 40E HF use with S.008RM.612-RG	1
16	8.423RM.075	MUR heat sink #1	CUT 40E HF use with S.008RM.612-RG	1
17	8.423RM.076	MUR heat sink #2	CUT 40E HF use with S.008RM.612-RG	1
18	7.421.541	Fast recovery diode	IDP45E60(D45E60)	6
	8.713.182	Insolation plate(2 holes)	polycarbonate(2 hole 10mm)	6
19	8.123RM.919	middle plate	reinforced nylon	1
20	8.123RM.343	compressor mount	use with S.008RM.659 CUT 40COM HZ Panel	2
21	7.721.060	compressor	280A-75L 220V 360W	1
22	7.253.013	solenoid valve 2/2 way	YG2T-2,work pressure 0-0.8MPa/24VDC,φ6 inlet	2
23	8.123RM.411	Mount bracket	use with S.008RM.660 CUT 40 HF COM HZ panel	1
24	W.496RM.417-A	compressor control PCB	base board B.067RM.417-A	1
25	8.055RM.660	bottom plate	use with S.008RM.660 CUT 40 HF COM HZ panel	1
26	7.122.020	control connector mount	use with 7.132RM.001	1
27	8.462RM.002-A	gas outlet	zhengyuan M16*1.5 60.5MM length	1
28	8.123RM.415	front output plate	use with S.008RM.660 CUT 40 HF COM HZ panel	1
29	7.132RM.001	Amphenol socket	GX16 2 pin	1

30	7.152.001-B	quick connection	10-25SQ M6 extra-long 2.5mm Essen	1
31	7.232.738	toggle switch(red)	LIGHT COUNTRY 25A/250V	1
32	8.306RM.660	front plate	use with S.008RM.660 CUT 40 HF COM HZ panel	1
33	7.458.430	knob	Omter \varnothing 21*16 black/grey with black line	1
34	7.227.017	toggle switch	R9-32B/2A250V 1×2	1
35	W.496RM.410-C	control PCB	base board B.067RM.410-C	1
36	8.069RM.997	Front frame	345.2*217.7*88.5 reinforce nylon	1
37	7.253.466	internal air filter	SYMC MODEL:SAF2000-02 MAX1	1
38	8.123RM.413	internal air filter bracket	use with S.008RM.660 CUT 40 HF COM HZ panel	1
39	L.271RM.601-A	inductance		
40	W.496RM.418-B	HF PCB		
41	L.185RM.608	transformer	use with S.008RM.608 CUT 40E	1
42	8.123RM.412	transformer mount	use with S.008RM.660 CUT 40 HF COM HZ panel	1
43	8.123RM.917	Main PCB seal	ABS	1
44	W.496RM.419-C	Main PCB	base board B.067RM.419-C	1
45	7.411.250	rectifier	BR6010(32*32)	1
	8.212.020	rectifier position stopper	\varnothing 13.5*7.3 DMC	1

46	7.425.555	single tube IGBT module	STGW60V60DF	4
	8.713.184	insulation block	polycarbonate 3 holes 12.5mm	4
47	7.467.608	capacitor	2 pc 7.467.597,1pc 7.463.010,4.5cm1SQ black wire 2pc,20cm1SQ yellow/green wire 1pc MKP3C-224+103*2	1
48	8.422RM.294	IGBT heat sink #1	CUT 40E HF use with S.008RM.612-RG	1
49	8.422RM.295	IGBT heat sink #2	CUT 40E HF use with S.008RM.612-RG	1
50	8.422RM.296	IGBT heat sink #3	CUT 40E HF use with S.008RM.612-RG	1
51	7.624.281	Y type 3 way bypass	OD Φ 8,ID Φ 5	1

Table 8.1

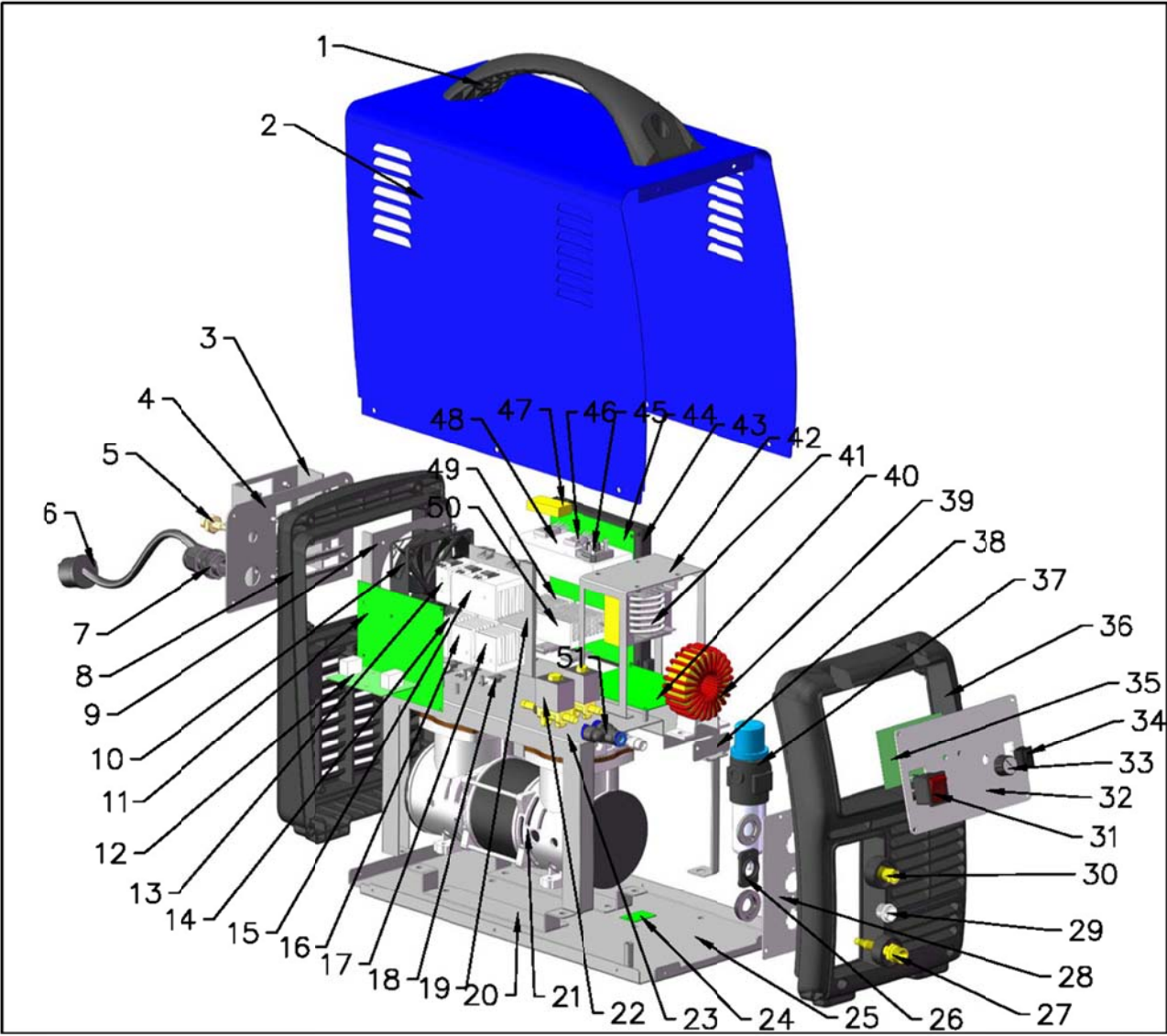


Figure 8.1

SG55 industrial plasma cutting torch with 16 ft (6 M) #4 lead (Part No.07001810)

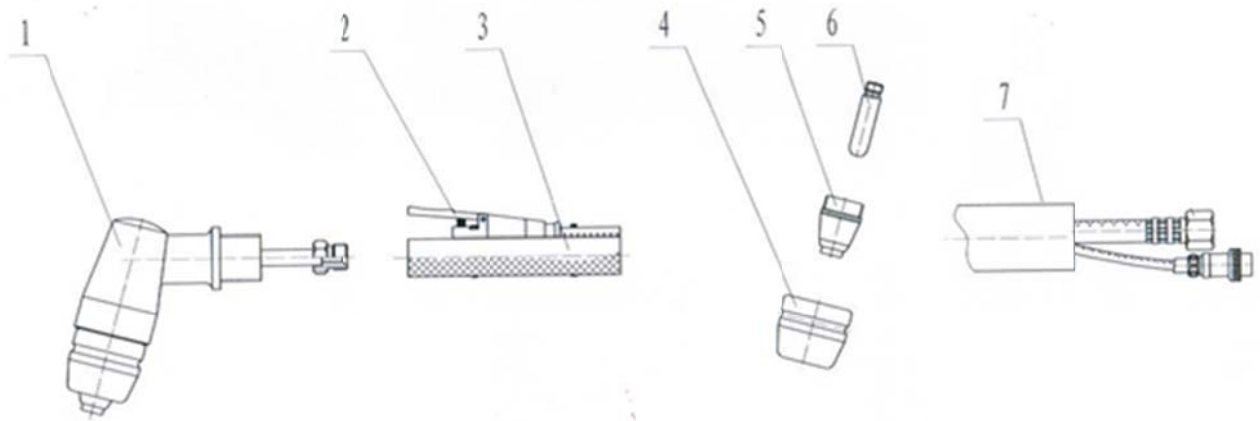


Figure 8.2

Item	Order No.	Description
1	SG5501	Torch head
2	SG5517	Micro switch
3	SG5511	Handle A type
4	07Y2517004	Nozzle outside SG55
5	07Y2517005	TIP,SG55
6	07Y2517003	Electrode,SG55
7	SG5530	Cable assembly 5M

Table 8.2

NOTES

WELDKING® CoolCut40-air power source

SECTION 9 ELECTRIC DIAGRAM

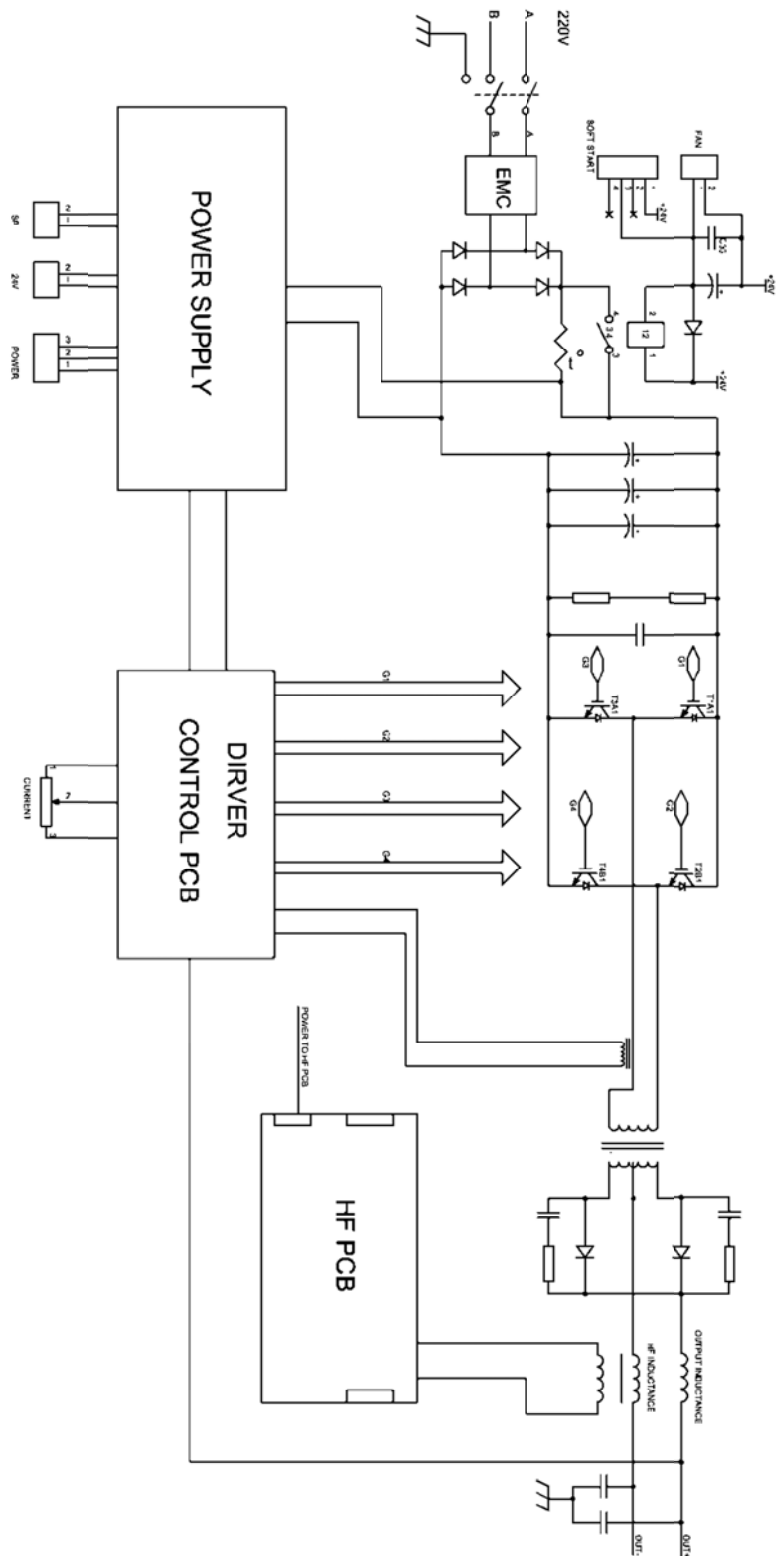


Figure 9.1

SECTION 10 WARRANTY POLICY

Malo Welding Products Ltd., Warranty Policy

Effective August 1st, 2004, revision at April 1st, 2011

LIMITED WARRANTY - Subject to the terms and conditions below, Malo Welding Products Ltd.(WELDKING®) endeavors to provide high quality products and product support to its customers and therefore backs up all of its new products purchased from Malo Welding Products Ltd.(WELDKING®) or any authorized Malo Welding Products Ltd.(WELDKING®) distributor/service center after the effective date of this limited warranty and is free of defects in material and workmanship at the time it is shipped. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE FACE OF THE MALO WELDING PRODUCTS LTD.(WELDKING®) WARRANTY. MALO WELDING PRODUCTS LTD.(WELDKING®) DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, REGARDING THE PRODUCTS, INCLUDING ANY IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE OR NONINFRINGEMENT. IN THE UNITED STATES, SOME STATES DO NOT ALLOW THE EXCLUSION OF THE IMPLIED WARRANTIES, SO THE ABOVE EXCLUSION MAY NOT APPLY TO YOU.

Malo Welding Products Ltd.(WELDKING®) shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the date that the equipment was delivered to the original retail purchaser, or one year after the equipment is sent to a North American distributor.

(1) 3 Years - Parts and Labor

Power Sources

Wire Feeders

(2) 90 Days - Parts (No Labor)

Guns

Remote Controls

Accessory Kits

Replacement Parts (No labor)

Malo Welding Products Ltd.(WELDKING®)'s limited Warranty shall not apply to:

(1) Consumable components; such as contact tips, cutting nozzles, contactors, brushes, slip rings, relays or parts that fail due to normal wear.

(2) All limited warranties are void for, and Malo Welding Products Ltd.(WeldKing®) does not warrant in any way, any product that evidences misapplication, improper installation, abuse, lack of maintenance, negligence in use or care, abnormal use, alteration of design, use of incompatible or corrosive chemicals, and/or servicing, installation of parts, or repairs by anyone other than Malo Welding Products Ltd.(WELDKING®) or a Malo Welding Products Ltd.(WELDKING®) authorized distributor or service center. Malo Welding Products Ltd.(WELDKING®) may make changes in products it manufactures and markets at any time; these changes are made without obligation to change, retrofit, or upgrade any product previously sold or manufactured.

MALO WELDING PRODUCTS LTD.(WELDKING®) 'S PRODUCTS ARE FOR COMMERCIAL/INDUSTRIAL USE AND PERSONS TRAINED AND EXPERIENCED IN THE USE

AND MAINTENANCE OF WELDING/PLASMA CUTTING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Malo Welding Products Ltd.(WELDKING®)'s option: (1) repair; or (2) replacement; or, where authorized in writing by Malo Welding Products Ltd.(WELDKING®), in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense. No compensation or reimbursement for transportation costs of any kind will be allowed.

LIMITATION OF DAMAGES: THE REMEDY OF REPLACEMENT OR REPAIR OF ANY DEFECTIVE GOODS SHALL BE THE EXCLUSIVE REMEDY UNDER ANY WARRANTY MADE BY MALO WELDING PRODUCTS LTD.(WELDKING®), WHETHER EXPRESS OR IMPLIED. IN NO EVENT SHALL MALO WELDING PRODUCTS LTD.(WELDKING®) BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES, PROPERTY DAMAGES, OR PERSONAL INJURIES.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY OR REPRESENTATION AS TO PERFORMANCE, AND ANY REMEDY FOR BREACH OF CONTRACT TORT OR ANY OTHER LEGAL THEORY WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY MALO WELDING PRODUCTS LTD.(WELDKING®), IS EXCLUDED AND DISCLAIMED BY MALO WELDING PRODUCTS LTD.(WELDKING®).

If any provision or portion of this limited warranty policy is found to be unenforceable, then the remaining provisions and portions shall remain valid and enforceable. If any provision or portion of this limited warranty policy is found to be limited by law, then that provision or portion shall be construed to make it effective within the bounds of law.

To obtain warranty service you must active your product(s)'s warranty online at weldking.com or mail the product registration card included in the package to Malo Welding Products Ltd.(WELDKING®) right after the purchase. When there is a warranty issue, return the defective welding machine or plasma cutting machine along with proof of purchase to any WeldKing® Authorized Warranty Depot. For the location of the nearest WeldKing® Authorized Warranty depot or for service information in the United States or Canada, please telephone toll free: 1-866-686-5088 or visit www.weldking.com (USA & Canada).available, but may vary from province to province.

SECTION 11 AUTHORIZED SERVICE CENTER

Please go to our website www.weldking.com to fill the warranty registration form. Malo Welding Products Ltd. will not distribute or disclose customer's private information to any third party and will not send promotion material to the customer.

Find your nearest warranty center at:

www.weldking.com/servicelocations.aspx

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