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YESWELDER CUT-65DS PRO

YESWELDER Plasma Cutter CUT-65DS PRO Instruction Manual

Model: CUT-65DS PRO | Brand: YESWELDER

1. Safety Information

Operating plasma cutting equipment requires strict adherence to safety protocols to prevent injury and equipment damage. Always read and understand all safety warnings and instructions before use.



Image: The YESWELDER CUT-65DS PRO plasma cutter highlighting its safety features, including protection against overheating, overload, IP21 water rating, and electrostatic shock prevention.

General Safety Precautions:

- **Electric Shock:** Plasma cutting involves high voltage. Ensure proper grounding and never operate in wet conditions. Wear dry gloves and protective clothing.
- **Fumes and Gases:** Ensure adequate ventilation to avoid inhaling hazardous fumes. Use a fume extractor if necessary.
- **Arc Rays:** The plasma arc produces intense visible and invisible (UV/IR) rays that can burn eyes and skin. Always wear a welding helmet with appropriate shade, protective clothing, and gloves.
- **Fire and Explosion:** Sparks and hot metal can cause fires. Keep flammable materials away from the cutting area. Have a fire extinguisher readily available.
- **Noise:** Plasma cutting can be noisy. Wear hearing protection.
- **Hot Parts:** The torch and workpiece will be hot after cutting. Allow them to cool before handling.

Product Specific Safety Features:

- **Non-High Frequency Start:** The 'blow-back' start system minimizes electrical interference with surrounding machinery and reduces risk to operators.
- **IP21 Water Rating:** Provides protection against vertically falling water drops.
- **Overload Protection:** Automatic shutdown system activates in case of overload.
- **Overheating Protection:** Automatic shutdown system activates if the machine overheats.
- **Electrostatic Protection:** Features a unique coating to prevent shock transfer.

2. Product Overview

The YESWELDER CUT-65DS PRO is a 65Amp non-high frequency, non-touch pilot arc plasma cutting machine designed for various metal cutting applications. It features a digital display, dual voltage (110/220V) capability, and advanced IGBT inverter technology.



Image: The YESWELDER CUT-65DS PRO plasma cutter shown with its included accessories: plasma torch, ground clamp, air hose, and power adapter.

Key Features:

- **Non-High Frequency Start:** Provides a smooth, interference-free arc initiation.
- **Non-Touch Pilot Arc:** Allows cutting without direct contact, extending consumable life and improving cut quality.
- **Digital Display:** Real-time display of air pressure, voltage, and current for precise control.
- **Dual Voltage:** Operates on both 110V and 220V power supplies.
- **65A Output:** Powerful cutting capacity for various metal thicknesses.
- **2T/4T Function:** Offers semi-automatic (2T) and automatic (4T) cutting control for reduced operator fatigue.
- **Built-in Air Pressure Regulator:** Simplifies setup and ensures consistent air flow.

Package Contents:

- YESWELDER CUT-65DS PRO Plasma Cutter
- Earth Leakage Protection
- Air Filter Regulator
- Air Hose
- Ground Clamp
- Power Adapter
- Plasma Torch (IPT40)
- User Manual



Image: An illustration detailing the various accessories included with the YESWELDER CUT-65DS PRO, such as the gas hose, ground clamp, cutting gun accessories, 1/4" NPT air connector, Teflon sealing tape, adapter, IPT40 cutting torch, and air compressor filter.

3. Setup

Proper setup is essential for safe and efficient operation. Follow these steps carefully.

3.1 Power Connection:

- Ensure the plasma cutter is switched OFF before connecting to power.
- Connect the power adapter to the machine. The CUT-65DS PRO supports dual voltage (110V/220V) and will auto-sense the input voltage.

- Plug the power cord into a suitable, grounded electrical outlet. Ensure the circuit can handle the required amperage (e.g., 48A for 110V, 32A for 220V at 60% duty cycle).

3.2 Air Supply Connection:

The CUT-65DS PRO features a built-in air pressure regulator for convenience.



Image: A visual guide demonstrating how to connect the air hose to the plasma cutter's integrated air pressure regulator using a 10mm quick connector and 1/4" NPT air connector.

1. Connect your air compressor hose to the 1/4" NPT air connector on the back of the machine.
2. Ensure the air supply is clean, dry, and free of oil. An external air filter/dryer is recommended for optimal performance and consumable life.
3. Adjust the air pressure using the knob on the built-in regulator. The recommended operating pressure will be displayed on the digital screen.

3.3 Torch and Ground Clamp Connection:

1. Connect the IPT40 plasma torch to the designated port on the front panel of the machine. Ensure it is securely fastened.
2. Connect the ground clamp cable to the ground terminal on the front panel.
3. Attach the ground clamp securely to the workpiece or work table, ensuring good electrical contact.

4. Operating Instructions

Familiarize yourself with the control panel and operating modes before beginning any cutting tasks.



Image: A detailed view of the CUT-65DS PRO control panel, indicating the functions of each display and control: Gas Pressure, Current Value Post-Flow Time, Voltage, 2T/4T Display, 2T/4T Change, Center Knob, Unit Change, and Post Time Set.

4.1 Powering On and Digital Display:

1. Turn the power switch to the ON position.
2. The digital display will illuminate, showing real-time parameters such as air pressure (PSI/MPa), voltage (V), and current (A).
3. The display also indicates the selected 2T/4T mode and post-flow time.

4.2 Adjusting Cutting Parameters:

- **Current Adjustment:** Use the main control knob to adjust the cutting amperage (A) according to the material thickness and type.
- **Air Pressure Adjustment:** Adjust the air pressure regulator knob until the desired PSI/MPa is shown on the display. Refer to the specifications for recommended pressures for different materials.
- **Post-Flow Time:** The post-flow function cools the torch after the arc is extinguished, extending consumable life. Adjust this time (5-20 seconds) using the dedicated button and knob. A typical range is 5-8 seconds.

4.3 2T/4T Function:

The 2T/4T function allows for different torch trigger control methods.



Image: An illustration demonstrating the 2T/4T function selection on the plasma cutter's control panel, explaining their suitability for different

cutting durations and operator comfort.

- **2T (Two-Touch) Mode:** Press and hold the torch trigger to start the arc and cut. Release the trigger to stop. This mode is suitable for short cuts or tacking.
- **4T (Four-Touch) Mode:** Press and release the trigger to start the arc and cut. Press and release again to stop. This mode is ideal for long, continuous cuts as it reduces finger fatigue.

4.4 Non-Touch Pilot Arc Operation:

The non-touch pilot arc allows for cutting without the torch tip contacting the workpiece, which is beneficial for cutting rusty, painted, or uneven surfaces.



Image: A close-up view of the IPT40 plasma cutting torch in action, demonstrating its non-touch pilot arc capability for efficient and precise metal cutting.

1. Ensure all connections are secure and safety gear is worn.
2. Set the desired amperage and air pressure.
3. Position the torch approximately 1/8" to 1/4" above the workpiece.
4. Activate the torch trigger (2T or 4T mode). The pilot arc will initiate, followed by the main cutting arc.
5. Maintain a consistent travel speed and torch height for optimal cut quality.

4.5 Cutting Capacity Guidelines:

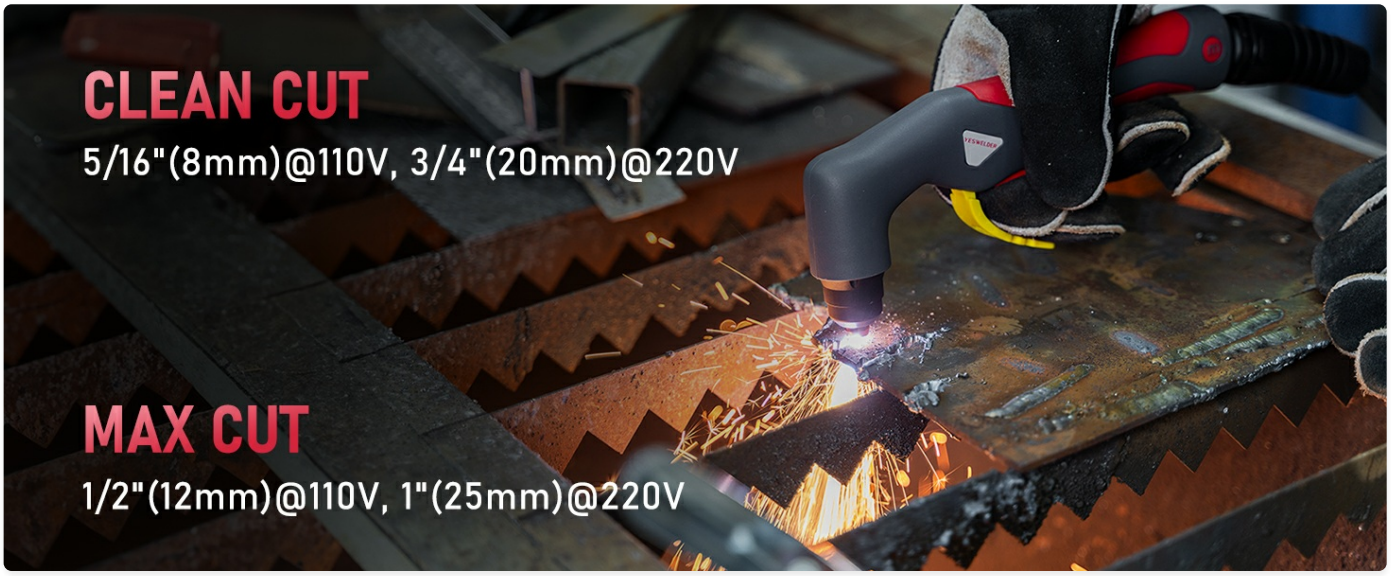


Image: A graphic illustrating the cutting capabilities of the plasma cutter, specifying clean cut and maximum cut thicknesses for both 110V

and 220V operations.

- **Ideal Clean Cut:** 5/16" (8mm) @ 110V, 3/4" (20mm) @ 220V
- **Maximum Sever Cut:** 1/2" (12mm) @ 110V, 1" (25mm) @ 220V

5. Maintenance

Regular maintenance ensures the longevity and optimal performance of your plasma cutter.

5.1 Daily Maintenance:

- Inspect all cables and connections for damage or wear.
- Check the torch consumables (electrode, nozzle, shield cup) for wear and replace if necessary.
- Empty any water from the air filter regulator bowl.
- Clean the exterior of the machine to prevent dust buildup.

5.2 Periodic Maintenance:

- **Air Filter:** Periodically inspect and clean or replace the air filter element in the regulator to ensure clean air supply.
- **Internal Cleaning:** If operating in a dusty environment, periodically open the machine (after disconnecting power) and use compressed air to blow out any accumulated dust from internal components. This should be done by qualified personnel.

6. Troubleshooting

This section addresses common issues you might encounter and their potential solutions.

Problem	Possible Cause	Solution
No power/Display off	Power switch off, loose power connection, circuit breaker tripped.	Ensure power switch is ON. Check power cord and outlet. Reset circuit breaker.
No arc when trigger pressed	No air supply, low air pressure, worn consumables, poor ground connection, machine error.	Check air compressor and pressure. Replace torch consumables. Ensure ground clamp is secure. Check digital display for error codes.
Poor cut quality	Incorrect amperage/air pressure, worn consumables, incorrect travel speed/torch height.	Adjust settings according to material. Replace consumables. Optimize travel speed and torch height.
Machine overheats/shuts down	Exceeded duty cycle, blocked ventilation, high ambient temperature.	Allow machine to cool down. Ensure adequate ventilation. Reduce cutting time or amperage.
Error Code on Display	Internal fault or specific operational issue.	Refer to the specific error code in the full user manual for detailed diagnostics and solutions. Contact customer support if the issue persists.

7. Specifications

Detailed technical specifications for the YESWELDER CUT-65DS PRO plasma cutter.

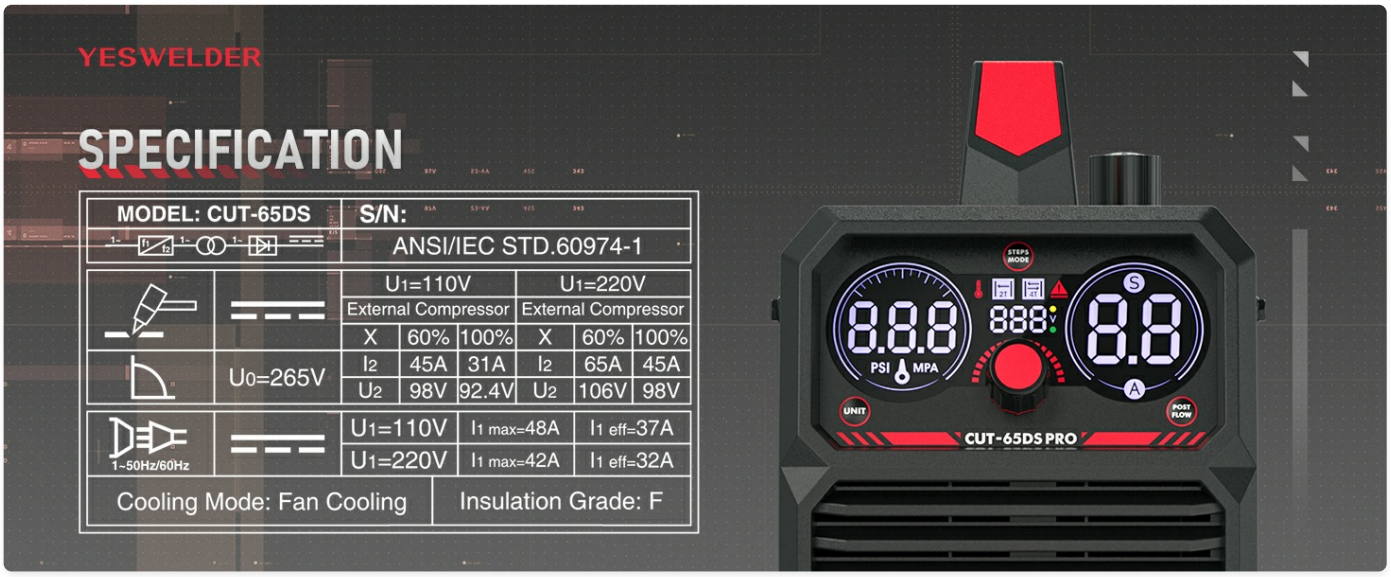


Image: A comprehensive table outlining the technical specifications of the YESWELDER CUT-65DS PRO, including electrical parameters for both 110V and 220V operation, duty cycle, and safety standards.

Feature	Specification
Model	YESWELDER CUT-65DS PRO
Input Voltage	110V/220V Dual Voltage (Auto-sensing)
Output Current (110V)	60% @ 45A, 100% @ 31A
Output Current (220V)	60% @ 65A, 100% @ 45A
Open Circuit Voltage (U0)	265V
Rated Output Voltage (U2)	92.4V (110V), 106V (220V)
Frequency	50/60Hz
Cooling Mode	Fan Cooling
Insulation Grade	F
Protection Class	IP21
Product Dimensions	15.75 x 5.91 x 11.81 inches
Item Weight	21.4 Pounds

8. Warranty and Support

YESWELDER provides support for its products.

- **Warranty:** This product typically comes with a 1-year warranty. Please refer to your purchase documentation for specific warranty terms and conditions.
- **Customer Support:** For technical assistance, troubleshooting beyond this manual, or warranty claims, please contact YESWELDER customer support. Contact information can usually be found on the official YESWELDER website or your product packaging.

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