

## 24Pcs Plasma Cutter Set

# Instruction Manual

## GENERIC 24-PIECE PLASMA CUTTER CONSUMABLE SET

For Chicago Electric Models 95539, 95413, 60767, 95136 and Razorweld CUT 45

### 1. Introduction

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This manual provides essential information for the proper installation, operation, and maintenance of your Generic 24-Piece Plasma Cutter Consumable Set. This set is designed to be compatible with specific plasma cutter models, ensuring optimal performance and durability. Please read these instructions carefully before use to ensure safety and extend the lifespan of your consumables.



Image 1.1: Complete 24-piece plasma cutter consumable set.

## 2. Package Contents

The 24-piece plasma cutter consumable set includes the following components:

- 10 x Plasma Torch Ref: PD-116-8 (WSP-08002)
- 10 x Plasma Torch Electrode Ref: PR-110 (WSP-08001)
- 1 x Plasma Torch Guard Ref: PC0116 (WSP-08014)
- 1 x Swirl Ring for Plasma Torch Ref: PE0106 (WSP-08005)
- 2 x Plasma Torch Spring Guide Ref: CV0010 (WSP-08050)



1. **Safety First:** Disconnect the plasma cutter from the power source before attempting any installation or maintenance. Wear appropriate personal protective equipment (PPE), including gloves and eye protection.
2. **Disassemble Torch Head:** Carefully unscrew and remove the existing consumables from the plasma torch head. Note the order of components for reassembly.
3. **Inspect Components:** Before installing new consumables, inspect the torch head for any damage or debris. Clean if necessary.
4. **Install New Consumables:** Insert the new electrode (PR-110) into the torch body. Follow with the swirl ring (PE0106), ensuring it is seated correctly. Then, place the plasma torch spring guide (CV0010) if applicable. Finally, screw on the plasma torch guard (PC0116) and the plasma torch ref (PD-116-8) securely. Ensure all components are hand-tightened to prevent gas leaks and ensure proper electrical contact.
5. **Verify Assembly:** Double-check that all consumables are correctly installed and tightened.



Image 4.1: Consumable set with detailed views of key components for installation.

## 5. Operating Guidelines

Once the consumables are correctly installed, you can operate your plasma cutter according to its manufacturer's instructions. Here are some general tips for optimal performance with these consumables:

- **Air Pressure:** Ensure the air pressure is set correctly for your plasma cutter and the material thickness you are cutting. Incorrect pressure can lead to poor cut quality and premature consumable wear.
- **Cutting Speed:** Adjust your cutting speed to match the material and thickness. Too fast or too slow can affect cut quality and consumable life.
- **Torch Standoff:** Maintain the recommended standoff distance between the torch tip and the workpiece. This is critical for arc stability and consumable longevity.
- **Cleanliness:** Keep the workpiece and torch components clean from oil, grease, and rust to ensure a stable arc and clean cuts.

## 6. Maintenance

Regular maintenance of your plasma cutter consumables will ensure consistent performance and extend their operational life.

- **Daily Inspection:** Before each use, inspect the electrode tip and nozzle for signs of wear, such as pitting, discoloration, or excessive orifice enlargement. Replace worn parts promptly.
- **Cleaning:** Periodically clean the torch head and consumable components. Use a soft cloth and avoid abrasive materials that could damage the surfaces. Ensure no metal shavings or debris are present.
- **Storage:** Store unused consumables in a clean, dry environment to prevent contamination and corrosion.
- **Replacement:** Consumables are designed to wear out. Replace them as soon as you notice a decrease in cut quality, arc instability, or difficulty in starting the arc.

## 7. Troubleshooting

If you encounter issues during plasma cutting, consider the following common troubleshooting steps related to consumables:

| Problem                         | Possible Cause   | Solution   |
|---------------------------------|--|--|
| Poor Cut Quality / Rough Edges  | Worn electrode or nozzle, incorrect air pressure, improper cutting speed.                            | Replace worn consumables. Adjust air pressure and cutting speed according to material.                   |
| Short Consumable Life           | Incorrect air pressure, excessive arc starting, improper standoff distance, contaminated air supply. | Verify air pressure. Minimize unnecessary arc starts. Maintain correct standoff. Check air filter/dryer. |
| Arc Not Starting / Unstable Arc | Loose or incorrect consumable installation, worn electrode, insufficient ground connection.          | Re-install consumables securely. Replace electrode. Check workpiece ground clamp.                        |
| Excessive Dross                 | Too slow cutting speed, incorrect amperage, worn nozzle.   | Increase cutting speed. Adjust amperage. Replace nozzle.   |

If problems persist, consult your plasma cutter's specific troubleshooting guide or contact a qualified technician.

## 8. Specifications

- **Product Dimensions:** 3.54 x 3.15 x 0.79 inches
- **Item Weight:** 5.2 ounces
- **Manufacturer:** FANG
- **ASIN:** B0DMT5DFWC
- **Item Model Number:** 8070JXTN46YA26EKERKLQ39D
- **Date First Available:** November 12, 2024
- **Tip Size:** 0.8mm (as indicated in product title)

## 9. Warranty and Support

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This consumable set is designed for durability and performance. As consumables are wear items, their lifespan depends heavily on usage conditions and maintenance practices. For specific warranty information or technical support regarding this product, please contact the seller or manufacturer directly through your purchase platform.

Always ensure you are using genuine or compatible replacement parts to maintain the integrity and safety of your plasma cutting equipment.

