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› FEIFANKE Plasma Cutter FKC-550H User Manual

## FEIFANKE FKC-550H

# FEIFANKE Plasma Cutter FKC-550H User Manual

Comprehensive instructions for safe and effective use of your plasma cutting equipment.

## 1. SAFETY INSTRUCTIONS

Read and understand all safety warnings and instructions before operating the FEIFANKE FKC-550H Plasma Cutter. Failure to follow these instructions may result in electric shock, fire, serious injury, or death.

- **Electric Shock:** Plasma cutting involves high voltage. Ensure proper grounding. Do not operate in wet conditions. Wear dry gloves.
- **Fumes and Gases:** Plasma cutting produces fumes and gases that can be hazardous to health. Operate in a well-ventilated area or use a fume extractor.
- **Fire and Explosions:** Sparks and hot metal can cause fires. Keep flammable materials away from the cutting area. Do not cut near explosive materials.
- **Burns:** The plasma arc and cut material are extremely hot. Wear appropriate personal protective equipment (PPE), including welding gloves, a welding helmet with a suitable shade, and protective clothing.
- **Eye and Skin Protection:** The plasma arc emits intense UV and IR radiation. Always use a welding helmet with a proper shade filter to protect your eyes and face. Protect exposed skin from the arc.
- **Compressed Air:** Ensure the air compressor is properly maintained and regulated to the specified pressure. Never direct compressed air at yourself or others.
- **Maintenance:** Disconnect power before performing any maintenance or changing consumables.

## 2. PRODUCT OVERVIEW

The FEIFANKE FKC-550H is a versatile 55A plasma cutter designed for efficient cutting of various metals. It supports both 110V and 220V input power, offering flexibility for different work environments.

### Included Components:

- 1 x FEIFANKE FKC-550H Plasma Cutter Unit
- Plasma Cutting Torch
- Ground Clamp
- Air Regulator
- Air Hose

### 3. SETUP

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Follow these steps to set up your plasma cutter before operation.

1. **Unpacking and Inspection:** Carefully remove the plasma cutter and all accessories from the packaging. Inspect for any shipping damage. Report any damage to the supplier immediately.
2. **Power Connection:** Connect the power cord to a suitable power outlet. The FKC-550H supports both 110V and 220V. Ensure the correct voltage is selected or automatically detected by the unit, and that the circuit can handle the required amperage (55A).
3. **Air Compressor Connection:** Connect the air hose from your air compressor to the air inlet on the plasma cutter. Install the provided air regulator and set the air pressure according to the specifications (typically 60-70 PSI for cutting). Ensure the air supply is clean and dry.
4. **Torch Connection:** Connect the plasma cutting torch to the designated port on the front panel of the plasma cutter. Ensure it is securely fastened.
5. **Ground Clamp Connection:** Attach the ground clamp cable to the ground terminal on the plasma cutter. Securely attach the ground clamp to the workpiece or the cutting table, ensuring good electrical contact.

### 4. OPERATING INSTRUCTIONS

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Once the unit is set up, follow these steps for safe and effective cutting.

1. **Power On:** Turn on the main power switch on the plasma cutter. The display should illuminate.
2. **Adjust Cutting Current:** Use the control knob to set the desired cutting current (amperage) based on the material type and thickness. Refer to a cutting chart for recommended settings.
3. **Prepare Workpiece:** Ensure the workpiece is clean and free of rust, paint, or other contaminants that could interfere with the arc. Secure the workpiece firmly.
4. **Initiate Arc:** Position the torch nozzle approximately 1/16 to 1/8 inch (1.5-3 mm) from the edge of the workpiece. Press the torch trigger to initiate the pilot arc.
5. **Begin Cutting:** Once the pilot arc transfers to the workpiece, move the torch steadily along the desired cut line. Maintain a consistent standoff distance and travel speed for optimal cut quality.
6. **Observe Cut:** Look for sparks exiting from the bottom of the workpiece, indicating a full penetration cut. Adjust travel speed if necessary.
7. **Finish Cut:** Release the torch trigger once the cut is complete. Allow the material to cool before handling.
8. **Power Off:** After use, turn off the plasma cutter and disconnect the power supply.

### 5. MAINTENANCE

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

- **Consumable Replacement:** Regularly inspect the torch consumables (electrode, nozzle, swirl ring, shield cup). Replace them when they show signs of wear or damage to maintain cut quality.
- **Air Filter/Regulator:** Check and drain the moisture trap on the air regulator daily or as needed. Clean or replace the air filter element if it becomes clogged.
- **General Cleaning:** Keep the plasma cutter unit clean and free of dust and metal particles. Use compressed air to blow out internal components periodically, ensuring the power is disconnected.
- **Cable Inspection:** Inspect all cables (power, torch, ground) for cuts, abrasions, or loose connections. Repair or replace damaged cables immediately.

## 6. TROUBLESHOOTING

Refer to this table for common issues and their solutions.

| Problem            | Possible Cause                                                                               | Solution                                                                                           |
|--------------------|----------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------|
| No Arc / Pilot Arc | No power, poor ground connection, worn consumables, insufficient air pressure.               | Check power supply, ensure ground clamp is secure, replace torch consumables, verify air pressure. |
| Poor Cut Quality   | Worn consumables, incorrect air pressure, incorrect cutting speed/amperage, dirty workpiece. | Replace consumables, adjust air pressure, optimize cutting speed and amperage, clean workpiece.    |
| Unit Overheats     | Exceeding duty cycle, poor ventilation.                                                      | Allow the unit to cool down. Ensure adequate airflow around the machine. Reduce cutting time.      |
| Air Leaks          | Loose connections, damaged hose.                                                             | Tighten all air connections. Inspect air hose for damage and replace if necessary.                 |

## 7. SPECIFICATIONS

Technical specifications for the FEIFANKE FKC-550H Plasma Cutter.

| Specification       | Value                    |
|---------------------|--------------------------|
| Manufacturer        | FEIFANKE                 |
| Model Number        | FKC-550H                 |
| Power Source        | AC/DC                    |
| Input Voltage       | 110V/220V (Dual Voltage) |
| Output Current      | 55A                      |
| Included Components | 1 x plasma cutter        |

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