

Cutting Guide

1. Rest assured, 95% of all issues with the operation of the machine can be resolved by following the steps below.

2. Three key points for using a cutting machine. Beginners are advised to start with cutting thin sheets and practice more.

Before cutting:

1. Ensure the torch head is perpendicular to the workpiece.
2. Position the midpoint of the holes in the nozzle in line with the edge of the workpiece.
3. Start the arc by pressing the torch trigger and move slowly forward, stopping the torch head until the cutting arc is as vertical as possible before proceeding.
4. If the cut isn't penetrating, slow down the torch movement and try cutting again elsewhere.
5. It's normal for beginners to struggle at first, so start with thinner plates, around 3mm.



During cutting:

1. Keep the torch head perpendicular to the workpiece throughout the cutting process.
2. Ensure the angle of the downward spark spray is no more than 30 degrees from vertical.
3. Slow down the torch movement if the angle is too large until it's less than 30 degrees.
4. If there's a spark sprayback, stop cutting and restart from a new point.



Ending Cutting:

1. Pause the torch momentarily when reaching the end of the workpiece, waiting for the cutting arc to become as vertical as possible and the edge of the workpiece to turn red before slowly moving the torch forward to complete the cut.
2. If there's a spark sprayback, pause cutting immediately to avoid damaging the torch parts.
3. It's normal for beginners to experience spark sprayback, so prepare extra parts and practice more.



3. Pay attention to timely replacement of vulnerable parts.

① Fitting

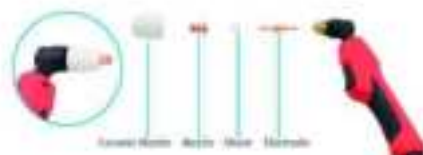


If the Hfium wire at the electrode tip is recessed by 2mm, replace the electrode; Electrode both ends can be used.

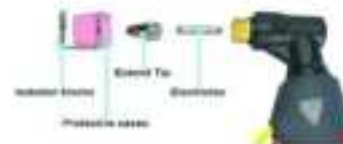
Deformed nozzles must be replaced.

If the hole deformed a little can cut thin workpiece less 4mm, please change it if need to cut thick workpiece or quality cutting.

② Cutting torch setup



© PT31 Setup



© AG60 Setup

③ Compressed air parameters

A	15A	30A	40A	50A
Press	40Psi	45Psi	50Psi	60Psi
	0.25Mpa	0.3Mpa	0.35Mpa	0.4Mpa