



MODEL T33938
60A PLASMA CUTTER
OWNER'S MANUAL

(For models manufactured since 08/23)





WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.



MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL T33938 60A PLASMA CUTTER

Product Dimensions:

Weight 38 lbs.
Width (side-to-side) x Depth (front-to-back) x Height 8 x 20-1/2 x 14-1/2 in.

Shipping Dimensions:

Type Cardboard
Content..... Machine
Weight..... 42 lbs.
Length x Width x Height..... 24 x 13 x 18 in.

Electrical:

Power Requirement 220V, Single-Phase, 60 Hz
Minimum Circuit Size 50A
Output Current Range..... 20 - 60A
Duty Cycle..... 60% @ 60A
Power Cord Length 84 in.
Power Cord Gauge 12 AWG
Included Plug Type 6-50P
Switch Type ON/OFF Rocker

Operation Information:

Maximum Material Thickness (Mild Steel) 3/4 in.
Torch Cable Length 13 ft.
Ground Cable Length..... 8 ft.
Air Requirement 60 - 65 PSI

Other Specifications:

Country of Origin..... China
Warranty..... 1 Year
Approximate Assembly & Setup Time 15 Minutes
Serial Number Location Machine ID Label
Housing Protection Class..... IP21S
ISO 9001 Factory..... Yes

Features:

High Frequency Start
Adjustable Amperage Setting
Capable of Cutting Stainless Steel, Copper, Iron, and Aluminum
Built-in Pressure Regulator with Gauge

Accessories:

Brush/Chipping Hammer
2 Ceramic Covers, Nozzles, and Electrodes
Welding Safety Shield

SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

Alerts the user to useful information about proper operation of the machine to avoid machine damage.

Safety Instructions for Machinery

WARNING

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS.

You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are **NOT** approved safety glasses.

WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly **BEFORE** operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace **BEFORE** operating machine. For your own safety, **DO NOT** operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—**NOT** the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

Additional Safety for Plasma Cutters and Welders

WARNING

WELDING FUMES. Breathing welding fumes can cause suffocation or poisoning without warning. Keep your head out of welding fumes. Use adequate ventilation at the arc to safely remove the fumes from your breathing zone and the general area. Use ANSI approved respirators for the type of welding operation. Protect others from these fumes.

WELDING IN A CONFINED SPACE CAN BE HAZARDOUS. Always open all covers, sustain forced ventilation, remove toxic and hazardous materials, and provide a power disconnect to the welder inside the work space. Always work with someone who can give you help from outside the space. Welding can displace oxygen. Always check for safe breathing atmosphere and provide air-supplied respirators if necessary. Keep in mind that all normal welding hazards are intensified in a confined space.

ELECTRIC SHOCK. DO NOT touch live electrical parts. Connect welder to power source with approved earth ground. Make sure all electrical connections are tight, clean, and dry. Connect workpiece to approved earth ground. The work lead is NOT a ground connection and is to be used only to complete the working welding circuit.

PREVENT FIRES. Welding work zones must be kept clear of flammable liquids, such as gasoline and solvents; combustible solids, such as paper and wood; and flammable gases, such as acetylene and hydrogen. Provide approved fire barriers and fire extinguishing equipment for the welding zone. Stay alert for sparks and spatter thrown into cracks and crevices that can start a smoldering fire. Inspect the work area again one hour after welding for any potential fire hazards.

WORKING AREA. Keep working area clear of any material not involved in the welding operation. Keep all equipment, workpieces, and work surfaces clean, dry, and free of entanglements. Keep lead cables organized and away from your body.

PROTECT BODY FROM ARC BURNS, SPARKS, AND SPATTER. Wear correct and approved eye, ear, and body protection. Wear complete body protection, such as clean and oil-free protective clothing, leather gloves, protective cap, heavy long-sleeve shirt, cuffless pants, and high leather boots. DO NOT wear jewelry or frayed clothing. Use a welding helmet with the correct shade of filter for the operation. Protect other people and property in your working zone from exposure to arc radiation, sparks, and spatter.

HANDLING GAS CYLINDERS. Regardless of content, pressurized gas cylinders can explode. Always secure a protector cap in place over the outlet valve assembly when moving the cylinder. A broken off valve could release the pressurized contents and cause the cylinder to be hurled about at dangerously high speeds, causing serious property damage, personal injury, or death. Always use safe methods when moving gas cylinders. Always secure a gas cylinder to a wall or approved cylinder cart with a chain before using or storing.

PROTECT GAS CYLINDERS FROM HEAT OR DAMAGE. An excess of heat can cause the pressurized gas to expand and explode the cylinder. Never weld on the gas cylinder. Damaging the outside of the cylinder can cause the cylinder to crack and explode. Exploding pressurized gas cylinders can cause serious property damage, personal injury, or death.

ELECTRIC AND MAGNETIC FIELDS (EMF). Welding operations create EMF around the welding equipment and workpieces. Workers who have pacemakers must consult with their physician before using this equipment or being within 50 feet of welding operations.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties performing the intended operation, stop using the equipment. Contact our Technical Support Department at (570) 546-9663.

Additional Sources for Welding Codes and Standards

American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126, (305) 443-9353, Website: www.aws.org.

- Safety in welding, Cutting, and Allied Processes, ANSI Standard Z49.1
- Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping, AWS F4.1

National Fire Protection Association, P. O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101, (617) 770-3000, Website: www.nfpa.org and www.sparky.org.

- National Electrical Code, NFPA Standard 70
- Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B

Compressed Gas Association, 1735 Jefferson Davis Highway, Suite 1004, Arlington, VA 22202-4102, (703) 412-0900, Website: www.cganet.com.

- Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1

Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3, (800) 463-6727, Website: www.csa-international.org.

- Code for Safety in Welding and Cutting, CSA Standard W117.2

American National Standards Institute (ANSI), 11 West 42nd Street, New York, NY 10036-8002, (212) 642-4900, Website: www.ansi.org.

- Practice for Occupational and Educational Eye and Face Protection, ANSI Standard Z87.1

U. S. Government Printing Office, Superintendent of Documents, P. O. Box 371954, Pittsburgh, PA 15250 (312) 353-2220, Website: www.osha.gov.

- OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1929, Subpart J

American Conference of Government Industrial Hygienists (ACGIH), 1330 Kemper Meadow Drive, Suite 600, Cincinnati, OH 45240-1634, (513) 742-2020, Website: www.acgih.org.

- Threshold Limit Values (Booklet)

WARNING

Like all equipment there is potential danger when operating this welder. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this welder with respect and caution to reduce the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

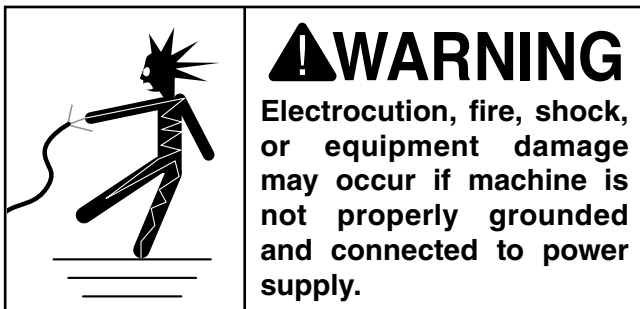
CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other equipment with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V 50 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

Circuit Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

! CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*

Circuit Requirements

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 208V, 220V, 230V, 240V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 50 Amps
Plug/Receptacle NEMA 6-50

Grounding Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!

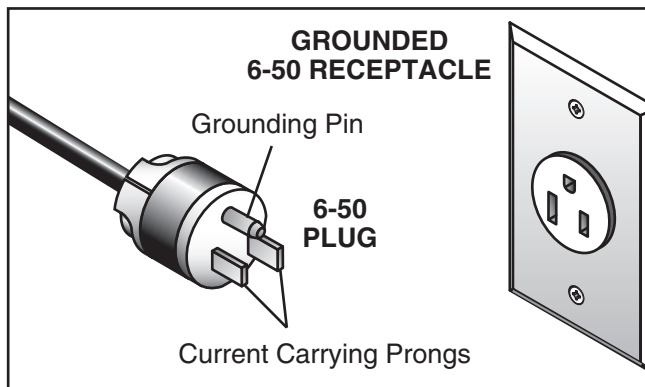
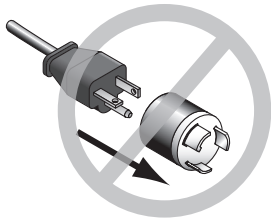


Figure 1. Typical 6-50 plug and receptacle.

! CAUTION



No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

! WARNING

Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

Due to the current draw of this machine, we do not recommend the use of an extension cord.

FOR YOUR SAFETY

Read and understand this manual before use. Keep this manual for future reference.

PRODUCTS INTRODUCTION

This plasma cutter is made using advanced inverter technology. The 50Hz/60Hz frequency is inverted to high frequency. The step- down voltage, rectification current, and inverter power supply generate a powerful DC welding current through PWM technology. The dimensions and weight of the machine have been reduced substantially and efficiency has been increased 30%.

The machine has the following attributes:

1. Stable
2. Reliable
3. Lightweight
4. Quiet and energy efficient
5. High cutting speed
6. Smooth cutting; no need to polish

This machine can cut stainless steel, alloy, steel, mild steel, copper, and other colored metals.

SAFETY CAUTION



**When welding or cutting, there is the possibility of injury.
Please take your personal protection seriously during operations.**

Electric shock——may lead to death !!

- Set the earth fitting according to applying standard.
- Do not touch electrical parts or the electrode with bare skin or when wearing wet gloves or clothes.
- Make sure you are insulated from the ground in the workshop.
- Perform all operations from a stable position.

Gas——may be harmful to health!

- Wear a respirator during operations. Breathing welding/cutting fumes is dangerous.
- When working with an arc welder, wear a respirator or use an air extractor.
- Using compressed air is the most economical choice of gasses.

Arc radiation——is harmful to your eyes and can burn your skin.

- Use a suitable helmet and light filter; wear leather gloves, a leather apron, and leather boots.

Fire

- Welding sparks may cause fire. Make sure there are no flammable materials in the welding area.

Noise——can be harmful to your hearing.

- Wear ear protection during operations.
- Warn bystanders if noise will be extreme.

Malfunction——when trouble happens, contact the professionals.

- If trouble occurs during installation or operations, please review the directions provided in this manual.
- If you do not understand the manual, or the trouble cannot be solved, seek professional help.



CAUTION !

Creepage-protecting switch should be added when you are using the machine !!!

CUT-60
DC INVERTER PLASMA CUTTER

1. POWER switch
2. O.C. (Over Current) switch
3. Amperage selector dial with settings: 20, 26, 36, 44, 52, 60
4. Top circular indicator
5. Bottom circular indicator with polarity symbols (- and +)
6. Gas control knob
7. Gas flow rate control knob
8. Gas flow rate control knob

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- Diagram of the rear panel of the CUT-60 device, showing various components and their labels:
- 9**: ON/OFF switch.
 - 10**: INPUT 1-AC220V terminal.
 - 11**: Large circular ventilation grille.
 - 12**: GAS terminal.
 - 13**: Grounding symbol (⊕).
- Technical specifications and labels on the rear panel:
- TYPE CUT-60** Serial Number: **EN 60974-1**
- UT** **IP20** **IP20** **IP20**
- | | | | |
|----------------------|-------|-------|-----|
| U _N | 230V~ | 250V~ | 100 |
| I _N | 60 | 60 | 100 |
| I _{th} | 60 | 60 | 60 |
| U ₀ -250V | 100 | 100 | 60 |
- DC** **1-60V** **U=220V** **Inmax 40A** **High 37A**
- IP20** **IP20** **IP20** **IP20**

8. Ground clamp connector
9. ON/OFF switch
10. Input power cable
11. Fan
12. Air supply connector
13. Ground connector

INSTALLATION

(Reference Panel Illustration on Prior Page)

Input cable connection

1. Connect machine to power source. Ensure correct voltage.
2. Make sure power cord is reliably connected to power outlet.

Output cable connection

1. To prevent leaks, ensure air line connection to GAS IN port (12) on back of machine is tight.
2. Ensure torch is connected to electrify integrated terminal (6), and tighten securely to prevent gas leaking.
3. Ensure ground cable clamp is connected to terminal (8) on front panel.
4. Ensure air plug on torch is connected to 2-pin connector (7) on front panel.

CHECK

1. Check if machine is grounded reliably on a bare (unpainted) metal surface.
2. Check if all connectors are connected firmly.
3. Check if power voltage is correct.

OPERATION

1. Move power switch to ON position. Indicator light will illuminate, and gas pressure gauge will show current volume.
2. Adjust gas pressure for operation, then open gas valve.
3. Press control knob on torch. Electromagnetic valve will open, sound of HF arc-tricking will be heard, and gas will begin to flow from torch.
4. Make sure cutting current is adequate for thickness of workpiece.
5. When torch nozzle touches workpiece, press torch switch to start arc, then raise nozzle a little to prevent it getting burned and begin cutting.

INSTRUCTION NOTES

Operating environment

1. The machine can safely be operated at temperatures between 14° and 104° Fahrenheit.
2. Avoid using machine in direct sunlight.
3. Keep machine dry.
4. Do not use machine in dusty environments or expose to corrosive fumes.

SAFETY

1. Make sure work area is adequately ventilated.

To prevent overheating, this machine is equipped with two internal fans. Ensure that the fan vent on the back of the machine is never covered up. Periodically, check for dust build-up on the ventilation cover.

2. Do not overload

Do not attempt to exceed the duty cycles or the machine can be badly damaged, shortening its overall working life.

3. Use correct voltage

Use the voltage marked on the machine. The automatic compensation circuit will act as a safeguard to prevent excessive voltage, but if power voltage is too high, internal components will be damaged.

4. There is a grounding screw on the back of the machine. Ensure the mantle is grounded reliably in order to prevent electrostatic shock.

5. If the duty cycle is exceeded, the machine will automatically stop, the red indicator light will illuminate, and the fans will continue to function to cool the machine down. Once machine temperature is reduced, operation may continue.

CUTTING NOTES

1. While cutting, do not allow the copper tip on the torch to touch the workpiece. To protect the copper tip, the torch should be held at a slight incline and kept approximately 1/8" from the workpiece surface.
2. As an arc-supporting machine, if arc-supporting frequency is down or there is no arc support, the user should remove oxidation on the electrode using sand-paper. The machine will then operate normally.

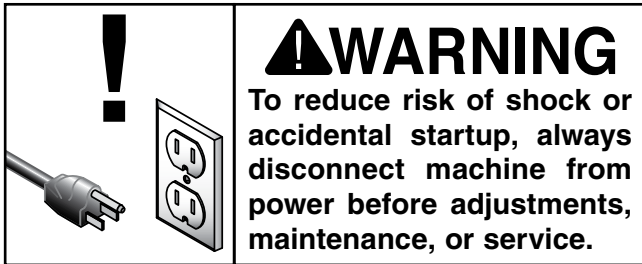
MAINTENANCE

1. Vacuum dust off of machine regularly. If machine exposed to heavy amounts of smoke and dust, then it should be cleaned daily.
2. Ensure pressure is adequate for cutting in order to protect small components.
3. Check that all electrical connections are tight.
4. Avoid using the machine in the rain or damp environments. If it gets wet, unplug machine and allow to dry.
5. If the machine will not be used for a long time, place it in the original packing box and store it in dry environment.

Check Fault

Faults	Solutions
1. Switch indicator is on, but fan and control knob are not working.	1. Over voltage protection is working. Shut down machine for a few minutes, then restart.
2. Switch indicator is lit and fan is working, but when torch control knob is pressed, there is no arc striking sound and electromagnetic valve is not working.	1. Check if torch has an open circuit. 2. Check if control knob of torch is damaged. 3. Part of assistant power of top board is damaged and there is no DC 24V output. Repair/replace.
3. Switch indicator is lit and fan is working, but when torch control knob is pressed, there is no arc striking sound, and the O.C light is illuminated.	1. Check if transistor on top board is damaged (driver module is damaged). 2. Rising transformer on bottom board is damaged. 3. Control module is damaged.
4. Switch indicator is lit, and fan and electromagnetic valve are working. However, there is no arc striking sound, and the O.C light is not illuminated.	There is some trouble in part of arc-striking, such as: 1. It is too far between discharge tip or there is adhesion in discharge tip. 2. Primary coil of arc-striking transformer is damaged or there is poor contact. 3. Check if four times voltage rectifier diode is damaged. 4. Check if HF electric capacity 102/10 KV is leaking. Relay is damaged.
5. Machine is operating normally, but arc is not striking.	1. Input voltage is too low. 2. Air pressure is too high or too low.

MAINTENANCE



Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose cables.
- Damaged torch tip.
- Worn or damaged wires.
- Any other unsafe condition.

Daily Maintenance

- Drain water in moisture separator.

Draining Moisture Separator

It is extremely important that the air supply be clean and dry. A separate moisture trap, water/oil separator, or desiccant system should be used. The plasma cutter has a built-in moisture separator that requires draining each time you have completed working with the unit. This feature is located on the underside rear corner and is drained by keeping the unit level and gently pulling down on the drain fitting.

Constantly inspect the torch tip for excessive erosion, molten metal accumulation, or burning. If damaged, it must be replaced.

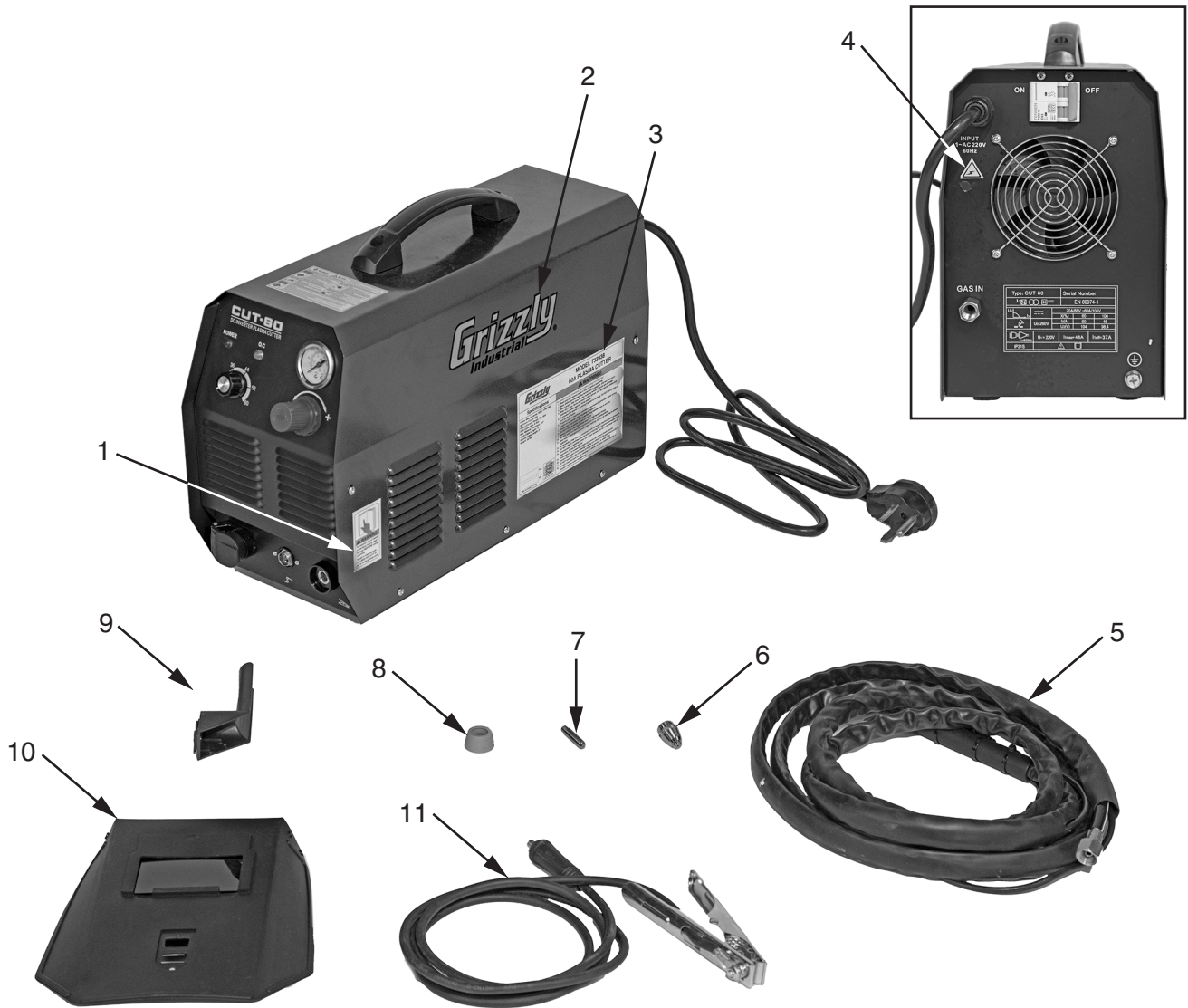
Before each use, inspect all electrical connections, cables, supply line, torch, air supply, housing and controls for damage. If any damage or wear is noted, DO NOT USE THE UNIT.

Always store the unit in a safe, clean, dry environment.

PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call (800) 523-4777 or visit www.grizzly.com/parts to check for availability.

Main



REF	PART #	DESCRIPTION
1	PT33938001	READ MANUAL LABEL
2	PT33938002	GRIZZLY LOGO
3	PT33938003	MACHINE ID LABEL
4	PT33938004	ELECTRICITY LABEL
5	PT33938005	PLASMA CUTTER
6	PT33938006	NOZZLE

REF	PART #	DESCRIPTION
7	PT33938007	ELECTRODE
8	PT33938008	CUP
9	PT33938009	WELDING MASK HANDLE
10	PT33938010	WELDING MASK
11	PT33938011	GROUND CABLE

WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

In the event you need to use this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

To take advantage of this warranty, you must register it at <https://www.grizzly.com/forms/warranty>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.





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~Since 1983~

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Current Specials!*

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