

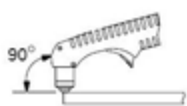
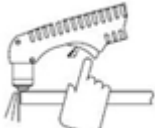
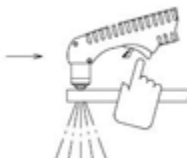


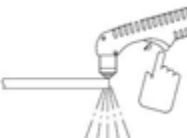
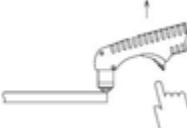


# Plasma Cutting Tips

Always read and follow the safety precautions and operational instructions in your owner's manual.

	<b>1.</b> Connect work clamp to a clean, paint free location on the metal workpiece, as close to the cutting area as possible.
	<b>2.</b> If your plasma system includes adjustable air, set the air pressure to the factory recommended pressure (psi) for cutting.
	<b>3.</b> For standard (shielded) cutting, place the drag shield on the edge of the metal. For non-shielded cutting, use 1/8 in (3.2mm) standoff distance (dragging a non shielded tip on the metal will reduce tip life)
	<b>4.</b> Raise trigger lock and press the trigger. The pilot arc will start. The pilot arc starts immediately when trigger is pressed
	<b>5.</b> Move the pilot arc into the metal being cut.
	<b>6.</b> After the cutting arc starts, slowly start moving the torch across the metal.
	<b>7.</b> Adjust the torch speed so sparks go thru the metal and out the bottom of the cut.
	<b>8.</b> If sparks are being blown upward and back at the torch head, your speed is too excessive.
	<b>9.</b> At the end of the cut, pause briefly before releasing the trigger to sever the work piece.
	<b>10.</b> Postflow continues for approximately 15 to 20 seconds after releasing the trigger. The cutting arc can be instantly restarted during postflow by raising the trigger lock and pressing the trigger.