

# User Manual

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# FERREX® PLASMA CUTTER



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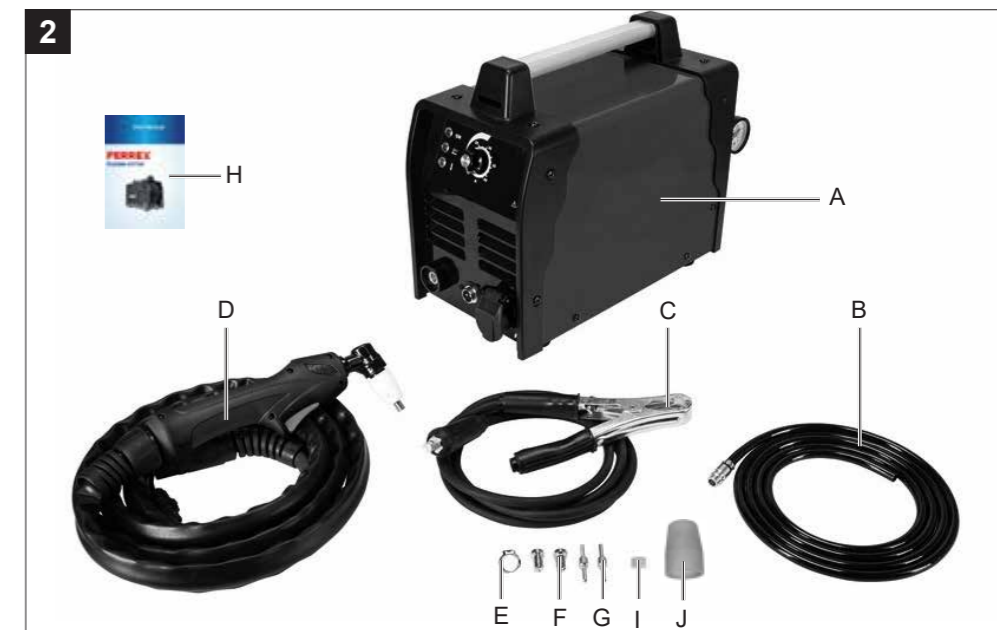
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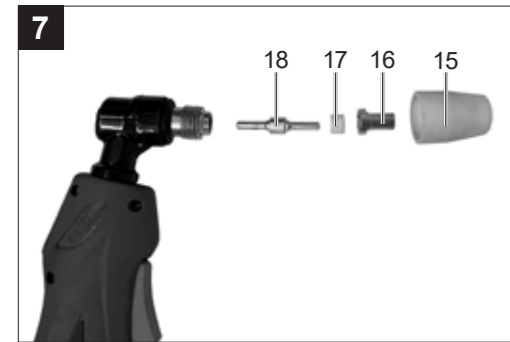
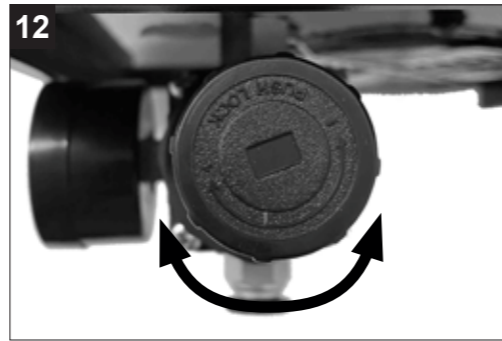
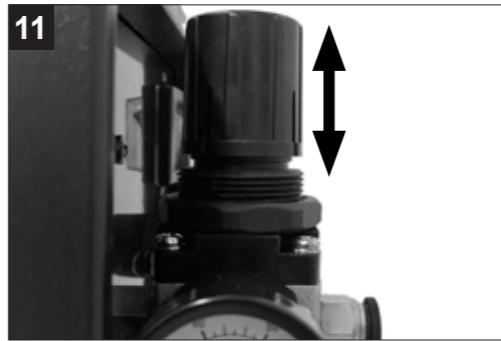
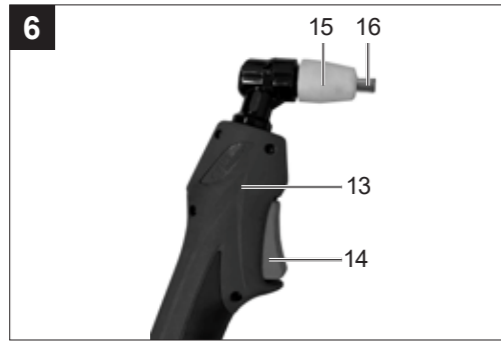
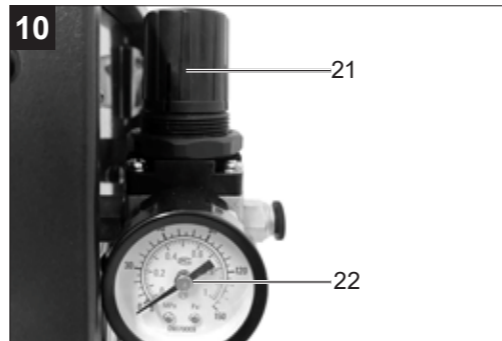
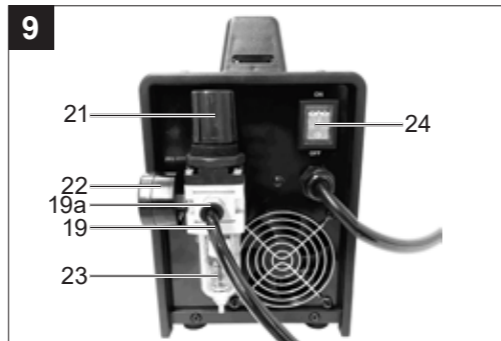
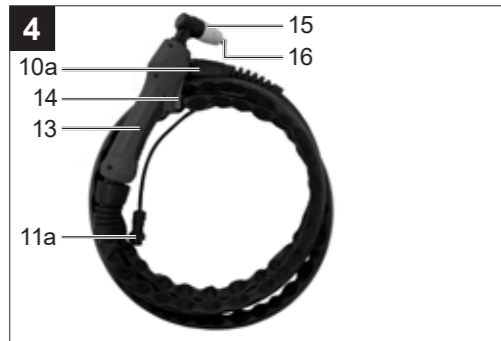
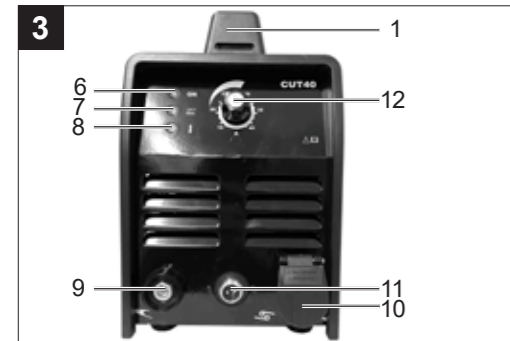
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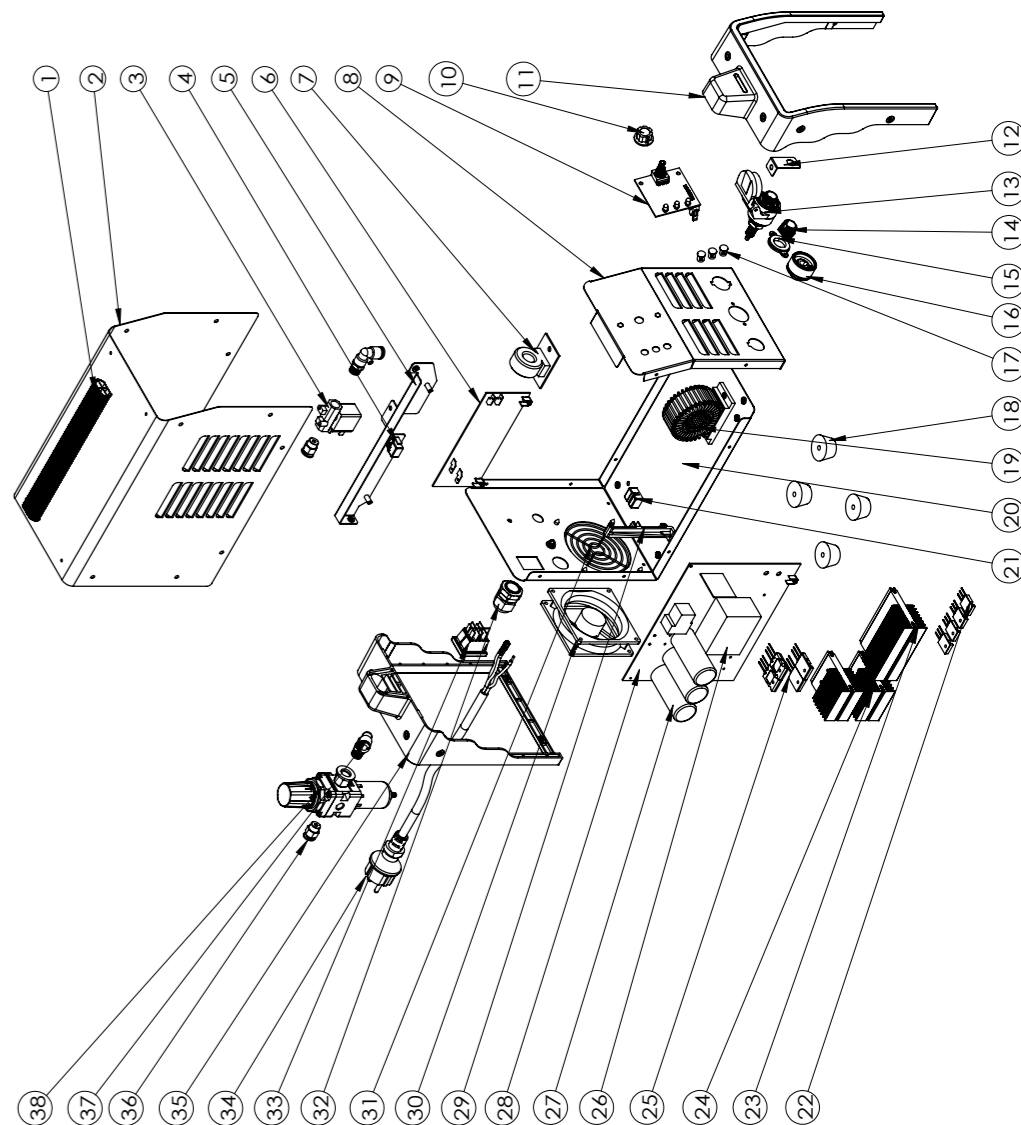


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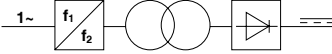






### Package contents/part list

- 1 Plasmas cutter, 1x
- 2 Compressed air hose, 1x
- 3 Ground cable with terminal, 1x
- 4 Plasma hose package, 1x
- 5 Hose clamp, 1x
- 6 Nozzle, 3x (1x pre-assembled)
- 7 Electrodes, 3x (1x pre-assembled)
- 8 Diffuser, 2x
- 9 Ceramic cap, 2x
- 10 Warranty card
- 11 Operating instructions
















## Explanation of Symbols

The use of symbols in this manual is intended to draw your attention to possible risks. The safety symbols and the explanations that accompany them must be perfectly understood. The warnings in themselves do not remove the risks and cannot replace correct actions for preventing accidents.

	Caution - Read the operating instructions to reduce the risk of injury
	Single-phase static frequency converter transformer rectifier
	Direct current
	Power input; phase number, as well as Alternating current symbol and rated value of the frequency
$U_0$	Rated idling voltage
$U_1$	Mains voltage
$X$	Duty cycle
$I_2$	Cutting current
$U_2$	Operating voltage [V]
$I_{max}$	Rated maximum mains current
$I_{eff}$	Effective value of the highest line current [A]
<b>IP21S</b>	Protection type
<b>H</b>	Insulation class
	Caution! Risk of electric shock!
	Electric shock from the welding electrode can be fatal
	Inhaling welding smoke can be hazardous to your health.
	Electromagnetic fields can interfere with the functionality of pacemakers.

Explanation of symbols

	<p>Welding sparks can cause an explosion or fire.</p>
	<p>Arc rays can damage the eyes and injure the skin.</p>
	<p>Electromagnetic compatibility is not guaranteed in residential areas. Therefore, the device can only be used for occasional, smaller welding work!</p>
	<p>Do not use the device outdoors and never in rain!</p>
	<p>Cutting with the plasma cutter.</p>
	<p>Suitable for welding with an increased electric risk.</p>
	<p>Connection – Ground terminal plug</p>
	<p>Connection – plasma burner - Power plug</p>
	<p>Connection – plasma burner</p>
	<p>Work light</p>
	<p>Overheat protection indicator lamp</p>
	<p>Warranty period</p>
	<p>Warranty class</p>
<p><b>⚠ Attention!</b></p>	<p>In this operating manual, we have used this sign to mark all sections that concern your safety.</p>

# Introduction

Congratulations on choosing to buy a FERREX® product.

All products brought to you by FERREX® are manufactured to the highest standards of performance and safety, and as part of our philosophy of customer service and satisfaction, are backed by our comprehensive 1 Year Warranty.

We hope you will enjoy using your purchase for many years to come.

## **Note:**

According to the applicable product liability law the manufacturer of this device is not liable for damages which arise on or in connection with this device in case of:

- improper handling,
- non-compliance with the instructions for use,
- repairs by third party, non-authorized skilled workers,
- installation and replacement of non-original spare parts,
- improper use.

## **Recommendations:**

Read the entire text of the operating instructions prior to the assembly and operation of the device.

These operating instructions are intended to make it easier for you to get familiar with your device and utilise its intended possibilities of use.

The operating instructions contain important notes on how to work safely, properly and economically with your machine and how to avoid dangers, save repair costs, reduce downtime, and increase the reliability and working life of the machine.

In addition to the safety regulations contained herein, you must in any case comply with the applicable regulations of your country with respect to the operation of the machine.

Keep the operating instructions in a clear plastic folder to protect them from dirt and humidity; store them near the machine. The instructions should be read and carefully understood by each operator prior to using the machine. Only persons who have been trained in the use of the machine and are aware of the related dangers and risks should be allowed to use the machine. The local required minimum age must be met.

In addition to the safety notes contained in these operating instructions and any specific regulations in your country, the generally recognised technical rules for the operation of identically constructed machines must be observed.

---

## **Layout (Fig. 1, 3, 4, 5, 7, 8, 9)**

1. Handle
2. Plasma cutter
3. Mains plug
4. Plasma hose package
5. Ground terminal clamp
6. Mains indicator lamp
7. Work light
8. Overheat protection indicator lamp
9. Ground terminal connection socket
- 9a. Ground terminal plug
10. Plasma burner connection socket
- 10a. Plasma burner plug
11. Plasma burner power socket
- 11a. Plasma burner power plug
12. Current controller
13. Plasma burner
14. Plasma burner trigger
15. Ceramic cap
16. Nozzle
17. Diffuser
18. Electrode
19. Compressed air hose
- 19a. Compressed air connection
20. Quick connector compressed air hose
21. Rotary knob to regulate the pressure
22. Manometer
23. Condensation water tank
24. On/off switch

## Scope of delivery (Fig. 2)

Position	Part	Quantity
A	Plasma cutter	1x
B	Compressed air hose	1x
C	Ground cable with terminal	1x
D	Plasma hose package	1x
E	Hose clamp	1x
F	Nozzle	3x (1x pre-assembled)
G	Electrodes	3x (1x pre-assembled)
H	Operating instructions	1x
I	Diffuser	2x
J	Ceramic cap	2x

- Open the packaging and take out the equipment with care.
- Remove the packaging material.
- Check that all listed contents are present.
- Inspect the equipment and parts for any damage. Please contact the helpline if anything is missing.
- If possible, keep the packaging until the end of the guarantee period.
- Read the operating instructions fully to familiarise yourself with the tool prior to using it.
- Only use original accessories and spare parts. Spare parts are available by contacting the helpline.
- Specify the part numbers when you contact the helpline.

### **⚠ ATTENTION!**

**The device and packaging materials are not toys!**

**Children must not be allowed to play with plastic bags, film and small parts!**

**There is a risk of swallowing and suffocation!**

## Intended use

The device is intended for compressed-air plasma cutting of all electrically conductive metals. Observing the safety instructions and assembly instructions and operating information in the instructions for use is also a component of the intended use. This device is designed for domestic DIY use only and is not designed for commercial, trade or industrial use

It is imperative to adhere to the applicable accident prevention regulations. The device must not be used:

- in insufficiently ventilated rooms,
- in moist or wet environments,
- in explosive environments,
- to defrost pipes,
- in close proximity to people with cardiac pacemakers and
- in close proximity to easily flammable materials.

Use the product only as described and only for the specific applications as stated. Keep these instructions in a safe place. Ensure you hand over all documentation when passing the product on to anyone else. Any use that differs to the intended use as stated above is prohibited and potentially dangerous.

Damage or injury caused by misuse or disregarding the above warning is not covered by the warranty or any liability on the part of the manufacturer. The device is not intended for commercial use. Commercial use will void the guarantee.

## Safety regulations

**⚠ WARNING!** Please read through the operating instructions carefully before use. Familiarise yourself with the device, its proper use and the safety notes based on these operating instructions. These form part of the product and must be available at all times.

**⚠ WARNING! RISK OF SERIOUS INJURY OR DEATH FOR INFANTS AND CHILDREN!** Never leave children unsupervised near packaging material. There is a risk of suffocation.

- This device may be used by children aged 16 years and older, and by



persons with reduced physical, sensory or mental capacities, or a lack of experience and knowledge, if they are supervised or have been instructed in how to use the device safely and understand the dangers that may arise when using it. Do not allow children to play with the device. Cleaning and day-today maintenance must not be performed by children without supervision.

- Repairs or/and maintenance work must only be carried out by qualified electricians.
- Only use the cutting cable provided in the scope of delivery.
- During operation, the device should not be positioned directly on the wall, covered or jammed between other devices so that sufficient air can be absorbed through the ventilation slats. Makes sure that the device is correctly connected to the supply voltage. Avoid any form of tensile stress of the power cable. Disconnect the plug from the socket prior to setting up the device in another location.
- If the device is not in operation, always switch it off by pressing the ON/OFF switch. Place the electrode holder on an insulated surface and only remove it from the holder after allowing it to cool down for 15 minutes.
- Hot metal and sparks are blown off from the cutting arch. The flying sparks, hot metal as well as hot objects and hot device equipment can cause fires or burns. Check the working environment and make sure the workplace is suitable prior to using the device.
- Remove all flammable material within 10 m of the plasma cutter. If this is not possible, cover the objects meticulously using suitable covers.
- Do not make cuts in places where flying sparks could come into contact with flammable material.
- Protect yourself and others from flying sparks and hot metal.
- Please be careful because sparks and hot materials can easily fall through small gaps and openings while cutting and land on adjacent areas.
- Please be aware that cutting on a ceiling, floor or a partition can cause a fire on the opposite side that is not visible.
- Connect the power cable using the shortest route with a socket situated close to the workplace to prevent the power cable from being spread across the whole room and located on a surface which could cause an electric shock, sparks or fire outbreak.

- Do not use the plasma cutter to defrost frozen tubes.

### **Risk of electric shock**

#### **⚠ WARNING! Electric shock from the cutting electrode can be fatal.**

- Do not use the plasma cutter when it is raining or snowing.
- Wear dry insulating gloves.
- Do not touch the electrodes with bare hands.
- Do not wear wet or damaged gloves.
- Protect yourself from electric shock with insulation against the work-piece.
- Do not open the device housing.
- Additional protection against a shock from the mains power in the event a fault can be provided by using a fault-circuit interrupter, which is operated with a leakage current of no more than 30 mA and covers all mains-powered devices in close proximity. The fault-circuit interrupter must be suitable for all types of current.
- There must be means of rapid electrical isolation of the cutting power source or the cutting circuit (e.g. emergency stop device) which are easily accessible.

### **Danger from smoke emission when plasma cutting:**

- Inhalation of fumes which result from plasma cutting can endanger health.
- Do not keep your head in the fumes.
- Use the device in open areas.
- Only use the device in well-ventilated spaces.

### **Danger from flying sparks when plasma cutting:**

- Cutting sparks can cause an explosion or fire.
- Keep flammable substances away from the cutting location.
- Do not use the plasma cutter near flammable substances.
- Cutting sparks can cause fires.
- Keep a fire extinguisher close by and an observer should be present to be able to use it immediately.
- Do not carry out plasma cutting on drums or any other closed containers. Danger from arc beams:
- Arc beams can damage your eyes and injure your skin.

- Wear a hat and safety goggles.
- Wear hearing protection and high, closed shirt collars.
- Use a welding safety helmet and make sure that the filter setting is correct.
- Wear complete body protection. Danger from electromagnetic fields:
- Cutting current generates electromagnetic fields.
- Do not use if you have a medical implant.
- Never wrap the cutting cable around your body.
- Guide cutting cables together. Welding shield-specific safety instructions
- With the help of a bright light source (e.g. lighter) examine the proper functioning of the welding shield prior to starting with any cutting work.
- Cut spatters can damage the protective screen. Immediately replace damaged or scratched protective screens.
- Immediately replace damaged or highly contaminated or splattered components.
- The device must only be operated by people over the age of 16.
- Please familiarise yourself with the cutting safety instructions. To that end, you must also observe the safety instructions of your plasma cutter.
- Always wear a welding helmet while welding and plasma cutting. If it is not used, you could sustain severe lesions to the retina.
- Always wear protective clothing during welding and plasma cutting operations.
- Never use the welding shield without the protective screen because this could damage the optical unit. There is a risk of damage to the eyes!
- Regularly replace the protective screen to ensure good visibility and fatigue proof work.

### **Environment with increased electrical hazard**

Environments with increased electrical hazard may be encountered, for example:

- In workplaces where the space for movement is restricted, such that the operator is working in a forced posture (e.g.: kneeling, sitting, lying) and is touching electrically conductive parts;

- In workplaces which are restricted completely or in part in terms of electrical conductivity and where there is a high risk through avoidable or accidental touching by the operator;
- In wet, humid or hot workplaces where the air humidity or weld significantly reduces the resistance of human skin and the insulating properties or effect of protective equipment.
- Even a metal conductor or scaffolding can create an environment with increased electrical hazard.
- When using plasma cutters under electrically dangerous conditions, the output voltage of the plasma cutter must be greater than 48 volt when idling (effective value).
- The plasma cutter may not be used in these cases due to the output voltage.

### **Plasma cutting in tight spaces**

- When welding and plasma cutting in tight spaces this may pose a hazard through toxic gases (risk of suffocation). In tight spaces the device may only be operated if there are trained individuals in the immediate vicinity who can intervene if necessary. In this case, before starting to use the plasma cutter, an expert must carry out an assessment in order to determine what steps are necessary, in order to guarantee safety at work and which precautionary measures should be taken during the actual cutting procedure.

### **Total of open circuit voltages**

- When more than one plasma power source is operated at the same time, their open circuit voltages may add up and lead to an increased electrical hazard. The plasma power sources must be clearly marked with their individual control units and connections, in order to be able to identify which device belongs to which circuit.

### **Using shoulder straps**

- The plasma cutter must not be used if the device is being carried e.g. with a shoulder strap (not included).

### **This is intended to prevent:**

- The risk of losing your balance if the lines or hoses which are connected are pulled.

- The increased risk of an electric shock as the operator comes into contact with the earth if he/she is using a Class I plasma cutter, the housing of which is earthed through its conductor.

### **Protective clothing**

- At work, the operator must protect his/her whole body by using appropriate clothing and face protection against radiations and burns. The following steps must be observed:
  - Wear protective clothing prior to cutting work.
  - Wear gloves.
  - Open windows to guarantee air supply.
  - Wear protective goggles.
- Gauntlet gloves made of a suitable material (leather) must be worn on both hands. They must be in perfect condition.
- A suitable apron must be worn to protect clothing from flying sparks and burns. When specific work, e.g. overhead cutting, is required, a protective suit must be worn and, if necessary, even head protection.

### **Protection against rays and burns**

- Warn of the danger to the eyes by hanging up a sign saying “Caution! Do not look into flames!”. The workplaces must be shielded so that the persons in the vicinity are protected. Unauthorised persons must be kept away from cutting work.
- The walls in the immediate vicinity of fixed workplaces should neither be bright coloured or shiny. Windows up to head height must be protected to prevent rays being transmitted or reflecting through them, e.g. by using suitable paint.

### **EMC Device Classification**

- According to standard IEC 60974-10, it has to do with a plasma cutter with class A electromagnetic compatibility. Thus, it meets the appropriate requirements in the industrial and residential area. In residential areas, it can be connected to the public low-voltage supply network. Even if the plasma cutter complies with the emission level as per the standard, the plasma cutter can still result in electromagnetic disturbances in sensitive systems and devices. The operator is responsible for malfunctions that occur through the arc while plasma

cutting and must take suitable protective measures. In doing so, the operator must consider the following:

- Power cables, control, signal and telecommunication lines
- Computer and other microprocessor controlled devices.
- Television, radio and other playback devices
- Electronic and electrical safety equipment
- Persons with cardiac pacemakers or hearing aids
- Measurement and calibration devices
- Noise immunity of other devices in the vicinity
- The time of day at which the cutting work is performed.

**The following is recommended to reduce possible interference radiation:**

- The plasma cutter must be regularly maintained and kept in a good condition
- Cutting cables should be completely unwound and installed parallel on the floor, if possible
- Devices and systems at risk of interference radiation must be removed from the cutting area if possible, or shielded.

**General plasma explanations**

- Plasma cutters are operated by pushing pressurised gas, e.g. air, through a small pipe. In the centre of the pipe, there is a negatively charged electrode that is directly above the nozzle. The vortex ring causes the plasma to rotate quickly. If you supply the negative electrode with current and make the tip of the nozzle touch the metal, this connection creates a closed, electrical circuit.

A powerful spark occurs between the electrode and the metal. While the gas flows into the pipe, the spark heats up the gas until it has reached the plasma condition. This reaction causes a current from the controlled plasma with a temperature of 17.000 °C or more that moves at speed of 6.096 m/sec and the metal transforms into steam and molten discharge. The plasma itself conducts electrical current. The working circuit that allows the arc to occur remains as long as current is supplied to the electrode and the plasma remains in contact with the metal to be processed. The cutting nozzle has a range of further channels. These channels generate a constant flow of protective

gas around the cutting area. The pressure of the gas flow controls the radius of the plasma jet.

**Please note!**

This machine is only designed to use compressed air as “gas”.

**Installation environment**

Make sure that working area is sufficiently ventilated. If the device is used without sufficient cooling, the power-on time reduces and it can result in overheating. Additional protection can be required for this purpose:

- The device must be free-standing with a distance of at least 0.5 m all around.
- Ventilation slots must not be blocked or covered.
- The device must not be used a storage place and tools or other items must not be placed on the device. It must be operated in a dry and well ventilated working environment.

**Remaining hazards**

The machine has been built using modern technology in accordance with recognized safety rules. Some remaining hazards, however, may still exist.

- Injury through electric current if incorrect electric connection leads are used.
- Even when all safety measures are taken, some remaining hazards which are not yet evident may still be present.
- Remaining hazards can be minimized by following the safety instructions as well as the instructions in the chapter Authorized use and in the entire operating manual.
- Health hazard due to electrical power, with the use of improper electrical connection cables.
- Release the handle button and switch off the machine prior to any operations.
- Avoid accidental starts of the machine: Do not press the start button while inserting the plug into the socket.
- Use the tools recommended in this manual to obtain the best results from your machine.

- Always keep hands away from the work area when the machine is running.
- Eye injuries due to glare,
- Touching hot parts of the device or workpiece (burn injury),
- In case of improper protection risk of accident and fire through sparks and slag particles,
- Harmful emissions from smoke and gases if there is a lack of air or if closed rooms are insufficiently extracted.

**Warning!** This electric tool generates an electromagnetic field during operation. This field can impair active or passive medical implants under certain conditions. In order to prevent the risk of serious or deadly injuries, we recommend that persons with medical implants consult with their physician and the manufacturer of the medical implant prior to operating the electric tool.

## **Attachment / Before starting the equipment**

### **Connecting the cutting torch**

- Insert the plasma burner plug (10a) into the plasma burner connection socket (10) and tighten the union nut hand-tight (see Fig. 1,3 + 4).
- Insert the plasma burner power plug (11a) into the plasma burner power socket (11) and tighten the union nut hand-tight (see Fig. 1,3 + 4).

### **Connecting the ground cable**

- Connect the ground terminal plug (9a) with the ground terminal connection socket (9). Make sure that the connecting shaft is first connected and then turned. The connecting shaft must face upwards when plugging in the ground terminal plug (9a). After plugging in, the connecting shaft must be rotated in a clockwise direction until it reaches the stop, in order to lock it in place (see Fig. 1,3 + 5). This does not require force!

### **Connect the compressed air hose**

- Connect the compressed air hose (19) on the back of the plasma cutter to the compressed air connection (19a). To do so, insert the side of the compressed air hose into the compressed air connection (19a) of the plasma cutter without a quick connector (see Fig. 9).



- The pressure can be set via the rotary knob to regulate the pressure (21) on the condensate separator (see Fig. 9 - 12). Select a pressure of 4–4.5 bar.
- In order to release the compressed air hose (19), you must press the locking mechanism of the compressed air connection (19a) and pull out the compressed air hose (19) at the same time.

The compressed air source (not included) must have a filter and regulator.

**⚠ IMPORTANT!**

You must fully assemble the appliance before using it for the first time!

**⚠ ATTENTION!**

**The ceramic cap (15) must only be screwed on to the plasma burner (13) once it has been equipped with the electrode (18), the diffuser (17) and the nozzle (16). If these parts are missing, the device may malfunction and it may create a hazard for the operating personnel.**

## Operation

1. Set the plasma cutter up in a dry and well ventilated area in the vicinity of the workpiece.
2. Clamp the ground terminal clamp (5) to the workpiece to be cut and make sure that there is a good electrical contact.
3. Turn the compressed air supply on.
4. Press the On/off switch (24) to position I.
5. Set the cutting current on the current controller (12). If the arc beam is interrupted, the cutting current must be set higher if necessary. If the electrode burns through frequently, then the cutting current must be set lower.
6. To cut in the manual cutting mode, pull the plasma burner (13) across the workpiece while maintaining a constant speed.
7. To achieve the perfect cut, it is important for the material thickness to comply with the correct cutting speed. If the cutting speed is too low, the cutting edge will be blunt due to the severe heat input. The optimal cutting speed is achieved once the cutting jet is slightly inclined towards the rear while cutting.
8. If the plasma burner trigger(14) is released, the plasma jet goes out and the power source switches off. The gas continues to flow for approx. 5 seconds in order to cool the burner. The same process is followed when the workpiece is pulled out with a pressed plasma burner trigger (14). During the gas post-flow time, the

plasma cutter must not be switched off to avoid damaging the plasma burner (13) as a result of overheating.

### **Electrical connection**

The electrical motor installed is connected and ready for operation. The connection complies with the applicable VDE and DIN provisions.

The customer's mains connection as well as the extension cable used must also comply with these regulations.

### **Damaged electrical connection cable**

The insulation on electrical connection cables is often damaged.

This may have the following causes:

- Passage points, where connection cables are passed through windows or doors.
- Kinks where the connection cable has been improperly fastened or routed.
- Places where the connection cables have been cut due to being driven over.
- Insulation damage due to being ripped out of the wall outlet.
- Cracks due to the insulation ageing.

Such damaged electrical connection cables must not be used and are life-threatening due to the insulation damage.

Check the electrical connection cables for damage regularly. Make sure that the connection cable does not hang on the power network during the inspection.

Electrical connection cables must comply with the applicable VDE and DIN provisions. Only use connection cables with the marking „H07RN“.

The printing of the type designation on the connection cable is mandatory.

For single-phase AC motors, we recommend a fuse rating of 16A (C) or 16A (K) for machines with a high starting current (starting from 3000 watts)!

# Cleaning and maintenance

## Cleaning:

- Switch off the main power supply and the main switch of the device prior to carrying out maintenance or repair work on the plasma cutter.
- Regularly clean the outside of the plasma cutter and its accessories. Use compressed air, cotton waste or a brush to remove dirt and dust.
- In case of a defect or a necessary replacement of equipment parts, please contact the appropriate qualified personnel.

## Maintenance:

### **⚠ ATTENTION!**

Pull out the power plug before carrying out any maintenance work on the equipment.

Let hot parts cool down before touching.

- The parts displayed in Figure 7 are the electrode (18), the diffuser (17) and the nozzle (16). They can be replaced once the ceramic cap (15) has been unscrewed.
- The electrode (18) must be replaced if there is a crater of approximately 1.5 mm depth in the centre.
- The nozzle (16) must be replaced if the central bore is damaged or if it has expanded in comparison to a drilling of a new nozzle. If the electrode (18) or the nozzle (16) are replaced too late, this can result in an overheating of the parts. This can reduce the lift cycle of the diffuser (17).

### **⚠ ATTENTION!**

- The ceramic cap (15) must only be screwed on to the plasma burner (13) once it has been equipped with the electrode (18), the diffuser (17) and the nozzle (16).

**If these parts are missing, the device may malfunction and it may create a hazard for the operating personnel.**

The plasma cutter must be regularly maintained for perfect function and to comply with the safety requirements. Improper and wrong operation may cause failures and damage to the device. Have repairs only conducted by qualified specialists.

## **Connections and repairs**

Connections and repairs of electrical equipment may only be carried out by an electrician.

Please provide the following information in the event of any enquiries:

- Machine data - type plate

### Service information

Please note that the following parts of this product are subject to normal or natural wear and that the following parts are therefore also required for use as consumables.

Wear parts\*: electrode, diffuser, nozzle

\* Not necessarily included in the scope of delivery!

## Technical data

Mains connection	230 V~ / 50/60 Hz
Output	15 - 40 A
On-load factor*	35% at 40A (25°C) 20% at 40A (40°C)
Working pressure	4 - 4.5 bar / 58 - 65 PSI
Insulation class	H
Cutting capacity	0.1 mm - 12 mm ( depending on the material)
Material	Copper: 1 - 4 mm Stainless steel: 1 - 8 mm Aluminium: 1 - 8 mm Iron: 1 - 10 mm Steel: 1 - 12 mm
Dimensions L x W x H	375 x 169 x 250 mm
Weight	6 kg

Subject to technical changes!

On-load factor\* = is the percentage of the operating time, in which the machine can be used continuously under normal temperature conditions. In relation to a 10-minute time period this means, for example, that with a duty cycle of 20%, that it can be used for 2 minutes and then there should be a break of 8 minutes. If you exceed the duty cycle values then this will trigger the overheating protection which will bring the device to a stop until it has cooled down to the normal working temperature. Exceeding the duty cycle values continuously can damage the device.

## **Storage and transport**

### **Storage:**

Store the device and its accessories in a dark, dry and frost-proof place that is inaccessible to children. The optimum storage temperature is between 5 and 30°C.

Cover the electrical tool in order to protect it from dust and moisture. Store the operating manual with the electrical tool.

### **Transport:**

Switch off the device before transporting it.

Lift the plasma cutter using the carrying handle (1).

## **Disposal and recycling**

The equipment is supplied in packaging to prevent it from being damaged in transit. The raw materials in this packaging can be reused or recycled. The equipment and its accessories are made of various types of material, such as metal and plastic. Never place defective equipment in your household refuse. The equipment should be taken to a suitable collection center for proper disposal. If you do not know the whereabouts of such a collection point, you should ask in your local council offices.

## Troubleshooting

The table below contains a list of error symptoms and explains what you can do to solve the problem if your tool fails to work properly. If the problem persists after working through the list, please contact your nearest service workshop.

<b>Problem</b>	<b>Possible Cause</b>	<b>Remedy</b>
Indicator lamp does not lit up?	No electrical connection.	Check whether the device is connected to the socket.
	ON/OFF switch set to off.	
Ventilator does not work?	Power line interrupted.	Check whether the device is connected to the socket.
	Power line ventilator faulty.	
	Ventilator faulty.	
Warning lamp switches on?	Overheating protection switched on.	Allow device to cool down.
	Input voltage too high.	Input voltage according to type plate.
No output current?	Machine faulty.	Machine must be repaired.
	Overvoltage protection activated.	Allow device to cool down.
Output current does not decrease?	Input voltage too low.	Observe input voltage according to type plate.
	Connection cable cross-section too low.	
Air current cannot be regulated?	Compressed air hose damaged or faulty.	New connection of the hose.
	Valve/manometer fails.	
HF-arc is not created?	The burner switch is faulty.	Renew electrode.
	Soldering point on the burner switch or plug loosened.	
	Valve/manometer fails.	
Bad ignition?	Burner wear parts damaged or worn.	Change wear parts.
	Check HF spark gap.	Set spark gap.

Plasma burner (13) is not ready for operation?	Current switch is switched off.	Switch the current switch to “on”.
	Air transmission is restricted.	Another indication of this is a green flame. Check the air supply.
	Workpiece is not connected to the ground terminal clamp.	Check the connections.
Sparks fly upwards, instead of down through the material?	Burner sleeve does not penetrate the material.	Increase the current.
	Burner sleeve is too far away from the material.	Reduce the distance between the burner sleeve and material.
	Apparently material was not grounded properly.	Check the connection for correct grounding.
	Lifting speed is too quick.	Reduce the speed.
Initial cut but not completely drilled through?	Potential connection problem.	Check all connections.
Slag formation on interfaces?	Tool/material creates heat.	Allow the material to cool down and then continue cutting
	Cutting speed too low or current too high.	Increase the speed and/or reduce the current until the slag has been reduced to a minimum.
	Plasma burner component parts are worn	Check and replace worn parts.
Arc stops during cutting?	Cutting speed too low.	Increase the cutting speed until the problem no longer exists.
	Plasma burner is held too high and too far away from the material.	Lower the plasma burner to the recommended height.
	Plasma burner component parts are worn	Check and replace worn parts.
	Workpiece no longer connected to the grounding cable.	Check the connections.
Insufficient Penetration?	Cutting speed too fast.	Slow down the working speed
	Burner sleeve is not straight	Adjust the inclination.
	Metal is too thick.	Several cycles necessary.
	Plasma burner component parts are worn	Check and replace worn parts.

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# FERREX®

PLASMA CUTTER

## Warranty Details

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REGISTER YOUR PURCHASE AT [www.aldi.com.au/en/about-aldi/product-registration/](http://www.aldi.com.au/en/about-aldi/product-registration/)  
TO KEEP UP-TO-DATE WITH IMPORTANT PRODUCT INFORMATION

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The product is guaranteed to be free from defects in workmanship and parts for a period of 12 months from the date of purchase. Defects that occur within this warranty period, under normal use and care, will be repaired, replaced or refunded at our discretion. The benefits conferred by this warranty are in addition to all rights and remedies in respect of the product that the consumer has under the Competition and Consumer Act 2010 and similar state and territory laws.

Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and for compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

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#### AFTER SALES SUPPORT

 1300 855 831

 [support@schepach.com.au](mailto:support@schepach.com.au)

AU Hotline Costs: Local rate for landline calls\*

\*Charges may vary dependent upon network operator or mobile network provider.





# FERREX®

## PLASMA CUTTER

# Repair and Refurbished Goods or Parts Notice

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REGISTER YOUR PURCHASE AT [www.aldi.com.au/en/about-aldi/product-registration/](http://www.aldi.com.au/en/about-aldi/product-registration/)  
TO KEEP UP-TO-DATE WITH IMPORTANT PRODUCT INFORMATION

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Unfortunately, from time to time, faulty products are manufactured which need to be returned to the Supplier for repair.

Please be aware that if your product is capable of retaining user-generated data (such as files stored on a computer hard drive, telephone numbers stored on a mobile telephone, songs stored on a portable media player, games saved on a games console or files stored on a USB memory stick) during the process of repair, some or all of your stored data may be lost.

**We recommend you save this data elsewhere prior to sending the product for repair.**

You should also be aware that rather than repairing goods, we may replace them with refurbished goods of the same type or use refurbished parts in the repair process.

**Please be assured though, refurbished parts or replacements are only used where they meet ALDI's stringent quality specifications.**

If at any time you feel your repair is being handled unsatisfactorily, you may escalate your complaint. Please telephone us on "1300 855 831" or write to us at:

RossMac Pty. Ltd.

P.O. Box 261, Essendon North, Victoria, 3041

Telephone: 1300 855 831 (Monday - Friday 8:30am-6:00pm)

Email: [support@schepach.com.au](mailto:support@schepach.com.au)

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