



HandyPlasma[®] 550 **PLASMARC CUTTING PACKAGE**



Installation, Operation and Service Manual

This manual provides complete instructions for the following HandyPlasma[®] 550 cutting packages starting with Serial No. PPOR144027:

ESAB P/N 0558002612 - 230 V, 1-Phase, 50/60 Hz - North America

**BE SURE THIS INFORMATION REACHES THE OPERATOR.
YOU CAN GET EXTRA COPIES THROUGH YOUR SUPPLIER.**

CAUTION

These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for arc welding and cutting equipment, we urge you to read our booklet, "Precautions and Safe Practices for Arc Welding, Cutting, and Gouging," Form 52-529. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information. Be sure to read the Safety Precautions before installing or operating this equipment.

USER RESPONSIBILITY

This equipment will perform in conformity with the description thereof contained in this manual and accompanying labels and/or inserts when installed, operated, maintained and repaired in accordance with the instructions provided. This equipment must be checked periodically. Malfunctioning or poorly maintained equipment should not be used. Parts that are broken, missing, worn, distorted or contaminated should be replaced immediately. Should such repair or replacement become necessary, the manufacturer recommends that a telephone or written request for service advice be made to the Authorized Distributor from whom it was purchased.

This equipment or any of its parts should not be altered without the prior written approval of the manufacturer. The user of this equipment shall have the sole responsibility for any malfunction which results from improper use, faulty maintenance, damage, improper repair or alteration by anyone other than the manufacturer or a service facility designated by the manufacturer.

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1.0 Safety Precautions



WARNING: These Safety Precautions are for your protection. They summarize precautionary information from the references listed in Additional Safety Information section. Before performing any installation or operating procedures, be sure to read and follow the safety precautions listed below as well as all other manuals, material safety data sheets, labels, etc. Failure to observe Safety Precautions can result in injury or death.



PROTECT YOURSELF AND OTHERS -- Some welding, cutting, and gouging processes are noisy and require ear protection. The arc, like the sun, emits ultraviolet (UV) and other radiation and can injure skin and eyes. Hot metal can cause burns. Training in the proper use of the processes and equipment is essential to prevent accidents. Therefore:

1. Always wear safety glasses with side shields in any work area, even if welding helmets, face shields, and goggles are also required.
2. Use a face shield fitted with the correct filter and cover plates to protect your eyes, face, neck, and ears from sparks and rays of the arc when operating or observing operations. Warn bystanders not to watch the arc and not to expose themselves to the rays of the electric-arc or hot metal.
3. Wear flameproof gauntlet type gloves, heavy long-sleeve shirt, cuffless trousers, high-topped shoes, and a welding helmet or cap for hair protection, to protect against arc rays and hot sparks or hot metal. A flameproof apron may also be desirable as protection against radiated heat and sparks.
4. Hot sparks or metal can lodge in rolled up sleeves, trouser cuffs, or pockets. Sleeves and collars should be kept buttoned, and open pockets eliminated from the front of clothing.
5. Protect other personnel from arc rays and hot sparks with a suitable non-flammable partition or curtains.
6. Use goggles over safety glasses when chipping slag or grinding. Chipped slag may be hot and can fly far. Bystanders should also wear goggles over safety glasses.

1.1 Safety - English



FIRES AND EXPLOSIONS -- Heat from flames and arcs can start fires. Hot slag or sparks can also cause fires and explosions. Therefore:

1. Remove all combustible materials well away from the work area or cover the materials with a protective non-flammable covering. Combustible materials include wood, cloth, sawdust, liquid and gas fuels, solvents, paints and coatings, paper, etc.
2. Hot sparks or hot metal can fall through cracks or crevices in floors or wall openings and cause a hidden smoldering fire or fires on the floor below. Make certain that such openings are protected from hot sparks and metal."
3. Do not weld, cut or perform other hot work until the workpiece has been completely cleaned so that there are no substances on the workpiece which might produce flammable or toxic vapors. Do not do hot work on closed containers. They may explode.
4. Have fire extinguishing equipment handy for instant use, such as a garden hose, water pail, sand bucket, or portable fire extinguisher. Be sure you are trained in its use.
5. Do not use equipment beyond its ratings. For example, overloaded welding cable can overheat and create a fire hazard.
6. After completing operations, inspect the work area to make certain there are no hot sparks or hot metal which could cause a later fire. Use fire watchers when necessary.
7. For additional information, refer to NFPA Standard 51B, "Fire Prevention in Use of Cutting and Welding Processes", available from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.



ELECTRICAL SHOCK -- Contact with live electrical parts and ground can cause severe injury or death. DO NOT use AC welding current in damp areas, if movement is confined, or if there is danger of falling.

1. Be sure the power source frame (chassis) is connected to the ground system of the input power.
 2. Connect the workpiece to a good electrical ground.
 3. Connect the work cable to the workpiece. A poor or missing connection can expose you or others to a fatal shock.
 4. Use well-maintained equipment. Replace worn or damaged cables.
 5. Keep everything dry, including clothing, work area, cables, torch/electrode holder, and power source.
 6. Make sure that all parts of your body are insulated from work and from ground.
 7. Do not stand directly on metal or the earth while working in tight quarters or a damp area; stand on dry boards or an insulating platform and wear rubber-soled shoes.
 8. Put on dry, hole-free gloves before turning on the power.
 9. Turn off the power before removing your gloves.
 10. Refer to ANSI/ASC Standard Z49.1 (listed on next page) for specific grounding recommendations. Do not mistake the work lead for a ground cable.
3. Welders should use the following procedures to minimize exposure to EMF:
 - A. Route the electrode and work cables together. Secure them with tape when possible.
 - B. Never coil the torch or work cable around your body.
 - C. Do not place your body between the torch and work cables. Route cables on the same side of your body.
 - D. Connect the work cable to the workpiece as close as possible to the area being welded.
 - E. Keep welding power source and cables as far away from your body as possible.



FUMES AND GASES -- Fumes and gases, can cause discomfort or harm, particularly in confined spaces. Do not breathe fumes and gases. Shielding gases can cause asphyxiation.

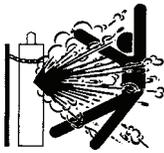
Therefore:



ELECTRIC AND MAGNETIC FIELDS — May be dangerous. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding and cutting current creates EMF around welding cables and welding machines. Therefore:

1. Welders having pacemakers should consult their physician before welding. EMF may interfere with some pacemakers.
2. Exposure to EMF may have other health effects which are unknown.
1. Always provide adequate ventilation in the work area by natural or mechanical means. Do not weld, cut, or gouge on materials such as galvanized steel, stainless steel, copper, zinc, lead, beryllium, or cadmium unless positive mechanical ventilation is provided. Do not breathe fumes from these materials.
2. Do not operate near degreasing and spraying operations. The heat or arc rays can react with chlorinated hydrocarbon vapors to form phosgene, a highly toxic gas, and other irritant gases.
3. If you develop momentary eye, nose, or throat irritation while operating, this is an indication that ventilation is not adequate. Stop work and take necessary steps to improve ventilation in the work area. Do not continue to operate if physical discomfort persists.
4. Refer to ANSI/ASC Standard Z49.1 (see listing below) for specific ventilation recommendations.

5. WARNING: This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code §25249.5 et seq.)



CYLINDER HANDLING -- Cylinders, if mishandled, can rupture and violently release gas. Sudden rupture of cylinder, valve, or relief device can injure or kill. Therefore:

1. Use the proper gas for the process and use the proper pressure reducing regulator designed to operate from the compressed gas cylinder. Do not use adaptors. Maintain hoses and fittings in good condition. Follow manufacturer's operating instructions for mounting regulator to a compressed gas cylinder.
2. Always secure cylinders in an upright position by chain or strap to suitable hand trucks, undercarriages, benches, walls, post, or racks. Never secure cylinders to work tables or fixtures where they may become part of an electrical circuit.
3. When not in use, keep cylinder valves closed. Have valve protection cap in place if regulator is not connected. Secure and move cylinders by using suitable hand trucks. Avoid rough handling of cylinders.
4. Locate cylinders away from heat, sparks, and flames. Never strike an arc on a cylinder.
5. For additional information, refer to CGA Standard P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders", which is available from Compressed Gas Association, 1235 Jefferson Davis Highway, Arlington, VA 22202.



EQUIPMENT MAINTENANCE -- Faulty or improperly maintained equipment can cause injury or death. Therefore:

1. Always have qualified personnel perform the installation, troubleshooting, and maintenance work. Do not perform any electrical work unless you are qualified to perform such work.
2. Before performing any maintenance work inside a power source, disconnect the power source from the incoming electrical power.
3. Maintain cables, grounding wire, connections, power cord, and power supply in safe working order. Do not operate any equipment in faulty condition.
4. Do not abuse any equipment or accessories. Keep equipment away from heat sources such as furnaces, wet conditions such as water puddles, oil or grease, corrosive atmospheres and inclement weather.
5. Keep all safety devices and cabinet covers in position and in good repair.
6. Use equipment only for its intended purpose. Do not modify it in any manner.



ADDITIONAL SAFETY INFORMATION -- For more information on safe practices for electric arc welding and cutting equipment, ask your supplier for a copy of "Precautions and Safe Practices for Arc Welding, Cutting and Gouging", Form 52-529.

The following publications, which are available from the American Welding Society, 550 N.W. LeJuene Road, Miami, FL 33126, are recommended to you:

1. ANSI/ASC Z49.1 - "Safety in Welding and Cutting"
2. AWS C5.1 - "Recommended Practices for Plasma Arc Welding"
3. AWS C5.2 - "Recommended Practices for Plasma Arc Cutting"
4. AWS C5.3 - "Recommended Practices for Air Carbon Arc Gouging and Cutting"

5. AWS C5.5 - "Recommended Practices for Gas Tungsten Arc Welding"
6. AWS C5.6 - "Recommended Practices for Gas Metal Arc Welding"
7. AWS SP - "Safe Practices" - Reprint, Welding Handbook.
8. ANSI/AWS F4.1, "Recommended Safe Practices for Welding and Cutting of Containers That Have Held Hazardous Substances."



MEANING OF SYMBOLS - As used throughout this manual: Means Attention! Be Alert! Your safety is involved.



Means immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.



Means potential hazards which could result in personal injury or loss of life.



Means hazards which could result in minor personal injury.

2.1 GENERAL

The HandyPlasma[®] 550 is a compact, completely self-contained plasma cutting system. As shipped, the system is fully assembled and ready to cut after being connected to input power and a source of prefiltered compressed air (90-150 psi). The HandyPlasma[®] 550 package uses the PT-31XL torch to deliver cutting power for materials up to 1/2 inch thick or for severing up to 5/8 inch thick. Refer to the following paragraphs for descriptions of the HandyPlasma[®] 550 packages available as well as performance specifications.

2.2 SCOPE

The purpose of this manual is to provide the operator with all the information required to install and operate the HandyPlasma[®] 550 plasmarc cutting package. Technical reference material is also provided to assist in troubleshooting the cutting package.



Do not use any torch with this power source other than the ESAB brand PT-31XL torch. Serious injury may occur if used with any other torch.

2.3 PACKAGE AVAILABLE

HandyPlasma[®] 550 - North America (see Note 1 below) P/N 0558002612 includes:

- Console with Regulator and Work Cable
- Torch
- Spare Parts Kit

Table 2-1. PT-31XL Spare Parts Kit Contents

Description	Part Number	Quantity
Spare Parts Kit P/N 0558003301 includes:		
30/40 A Nozzle	20860	3
Electrode	20862	2
Swirl Baffle	20463	1
Heat Shield	20282	1

NOTE:

- 1.) PT-31XL Torch Assembly P/N 0558004498, on North American machine 0558002612, is supplied with the nozzle, electrode, swirl baffle, and heat shield assembled.
- 2.) PT-31XL Torch Assembly P/N 21985, on Asian machine 0558003178, is supplied with the nozzle, electrode, swirl baffle, and heat shield assembled.

1.4 SPECIFICATIONS

Refer to Tables 2-2, 2-3, and Figures 2-1 and 2-2 for HandyPlasma® 550 technical specifications.

Table 2-2. HandyPlasma® 550 Specifications

Rated Output	40% Duty Cycle*	35 A @ 120 V dc
	60% Duty Cycle*	30 A @ 120 V dc
	100% Duty Cycle*	22 A @ 120 V dc
Output Current Range		15 to 35 Amperes
Open Circuit Voltage		230 V dc Nominal
Rated Primary Input @ 35 A @ 120 VDC Output	230 VAC, 50/60 Hz, 1-Phase	27 A
Power Factor @ 35 Amperes Output		81% (1-Phase)
Current Capacity	PT-31XL	50 A DCSP
Air Requirements	PT-31XL	250 cfh @ 80 psi
Dimensions of Handy Plasma® 550	Length	14.25-in. (362 mm)
	Height	12.7-in. (322 mm)
	Width	6.2-in. (156 mm)
Weight (less torch)		35 lbs (16 kg)

* Duty cycle is based on a 10-minute period; therefore, a 40% duty cycle means the machine may operate for 4 minutes with a cool down period of 6 minutes; a 60% duty cycle means the machine may operate for 6 minutes with a cool down period of 4 minutes; a 100% duty cycle means the machine may operate continuously.

Table 2-3. PT-31XL Torch Specifications

PT-31XL Torch	
Current Capacity	50A DCSP
Shipping Wgt.	2 lbs (1 kg)
Length of Service Lines	25-ft. (7.6 m)

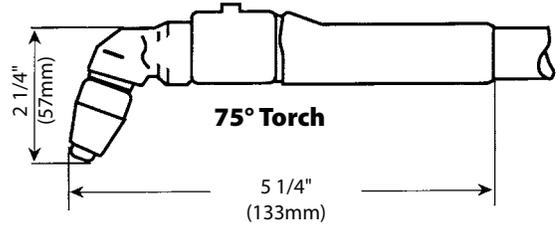


Figure 2-1. PT-31XL Dimensions

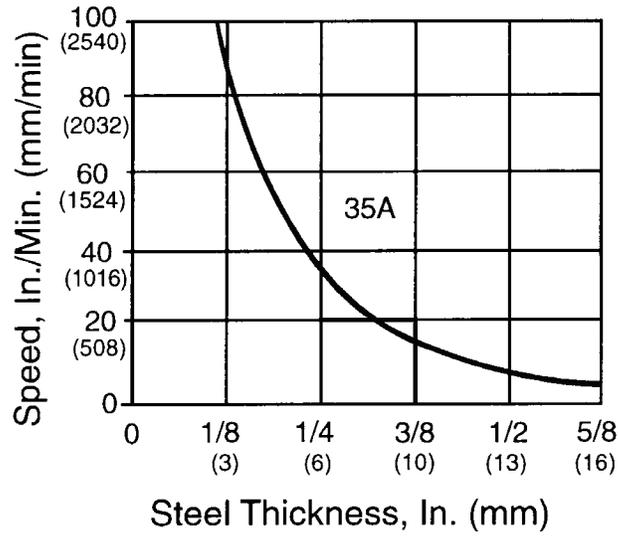


Figure 2-2. PT-31XL Cutting Performance

3.1 GENERAL

Proper installation can contribute materially to the satisfactory and trouble-free operation of the HandyPlasma® 550 cutting package. It is suggested that each step in this section be studied carefully and followed as closely as possible.

3.2 EQUIPMENT REQUIRED

A source of clean, prefiltered dry air that supplies 250 cfh at 80 psig is required for the cutting operation. The air supply should not exceed 150 psig (the maximum inlet pressure rating of the air filter-regulator supplied with the package).

3.3 LOCATION

Adequate ventilation is necessary to provide proper cooling of the HandyPlasma® 550 and the amount of dirt, dust, and excessive heat to which the equipment is exposed, should be minimized. There should be at least one foot of clearance between the HandyPlasma® 550 power source and wall or any other obstruction to allow freedom of air movement through the power source.

Installing or placing any type of filtering device will restrict the volume of intake air, thereby subjecting the power source internal components to overheating. The warranty is void if any type of filter device is used.

3.4 INSPECTION

- A. Remove the shipping container and all packing material and inspect for evidence of concealed damage which may not have been apparent upon receipt of the HandyPlasma® 550. Notify the carrier of any defects or damage at once.
- B. Check container for any loose parts prior to disposing of shipping materials.
- C. Check air louvers and any other openings to ensure that any obstruction is removed.

3.5 PRIMARY ELECTRICAL INPUT CONNECTIONS (FIGURE 3-1)



ELECTRIC SHOCK CAN KILL! Precautionary measures should be taken to provide maximum protection against electrical shock. Be sure that all power is off by opening the line (wall) disconnect switch and by unplugging the power cord to the unit when connections are made inside of the power source.

CAUTION

Be sure that the power source is properly configured for your input power supply. Damage to the machine may occur otherwise.

The HandyPlasma® 550 power source operating on 230 V, 1-phase input power is equipped with a 8-ft, 3-conductor cable with plug. An optional mating receptacle (P/N 674540) is available. A line (wall) disconnect switch with a 40-ampere fuse or circuit breaker should be provided at the main power panel. The cable connecting the disconnect switch to the receptacle should include three (two power and one ground) No. 10 AWG insulated conductors.



The chassis must be connected to an approved electrical ground. Failure to do so may result in electrical shock, severe burns or death.

A line (wall) disconnect switch, with proper sized fuse or circuit breaker (see Table 3.1), should be provided at the main power panel.

3.6 SECONDARY (OUTPUT) CONNECTIONS (REFER TO FIG. 3-1)

Torch comes factory installed. These instructions are for torch replacement.



Before making any connections to the power source output terminals, make sure that all primary input power to the power source is deenergized (off) at the main disconnect switch and that the input power cable is unplugged. For operator safety, the torch connections are loaded.

1. The torch connections are located at the flowswitch on upper left side of machine.
2. Thread the power cable and switch lead of the PT-31XL through the right side (above pressure gauge) bushing of the front panel. Connect power cable to the torch fitting (left-hand threads) and connect torch switch leads to pins 1 and 2 of M₂ located in the upper right hand corner of machine (viewing from rear of machine) of the control P.C. Board. Make sure the power cable connection is wrench-tight.
3. Replace the machine cover panel.
4. Connect your air supply to the inlet connection of the filter-regulator.
5. Clamp the work cable to the workpiece. Be sure the workpiece is connected to an approved earth ground with a properly sized ground cable.

Table 3-1. Recommended Sizes for Input Conductors and Line Fuses

Rated Input			Input & GND Conductor CU/AWG*	Fuse Size Amps
Volts	Amp	Phases		
230	27	1	No. 10	40

* Sized per National Code for 80°C rated copper conductors @ 30°C ambient. Not more than three conductors in raceway or cable. Local codes should be followed if they specify sizes other than those listed above.

3.7 CONNECTING HANDYPLASMA® 550 FOR 230 Vac INPUT

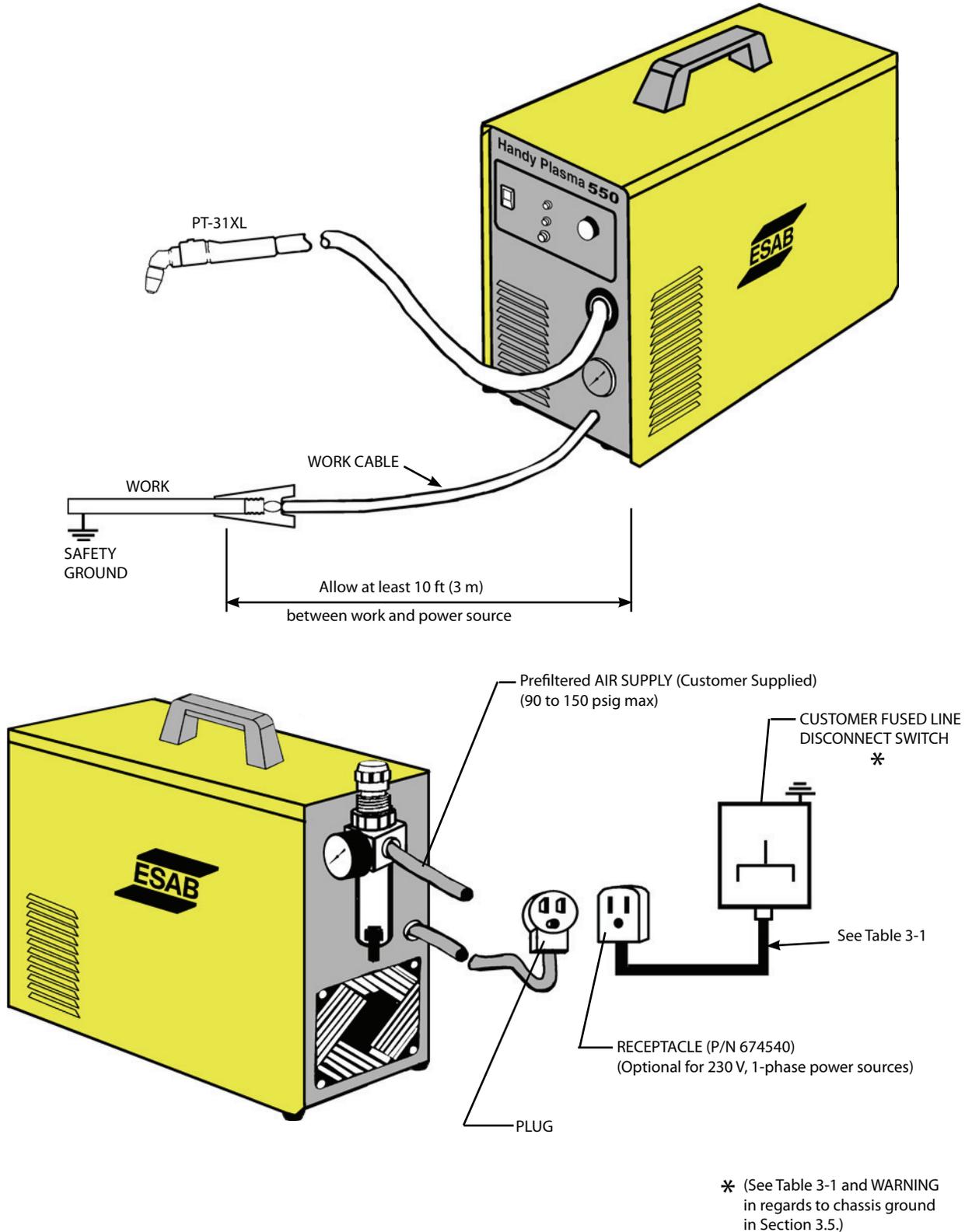
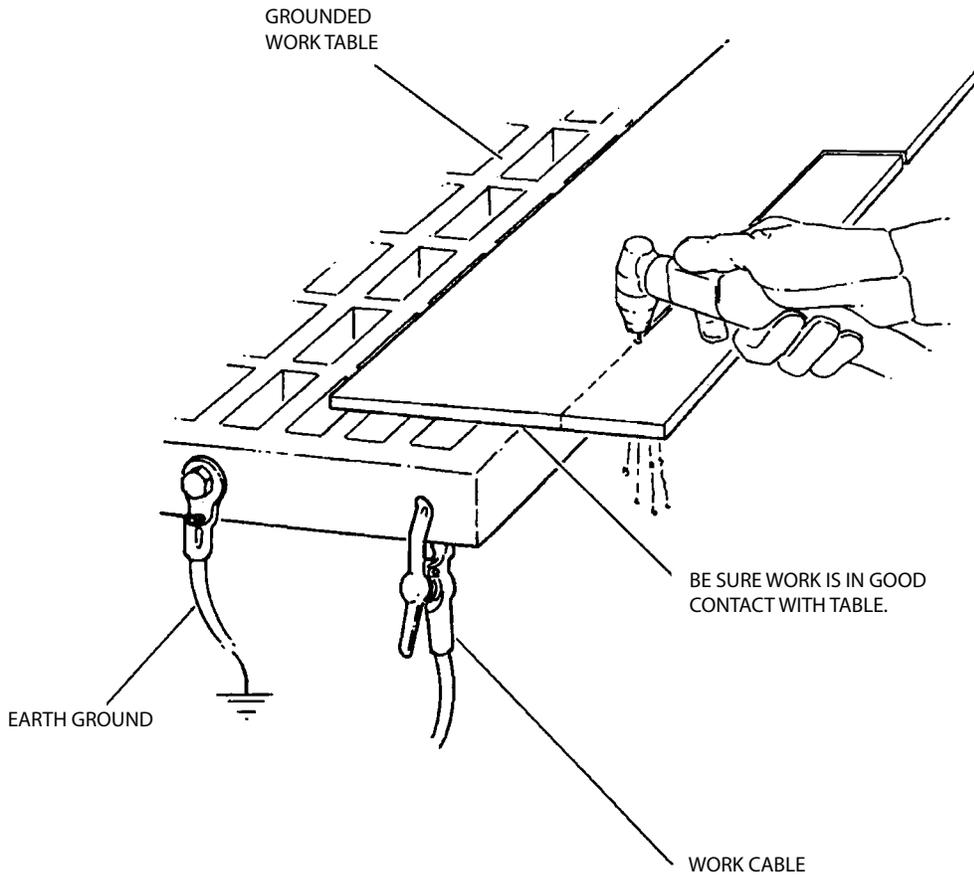
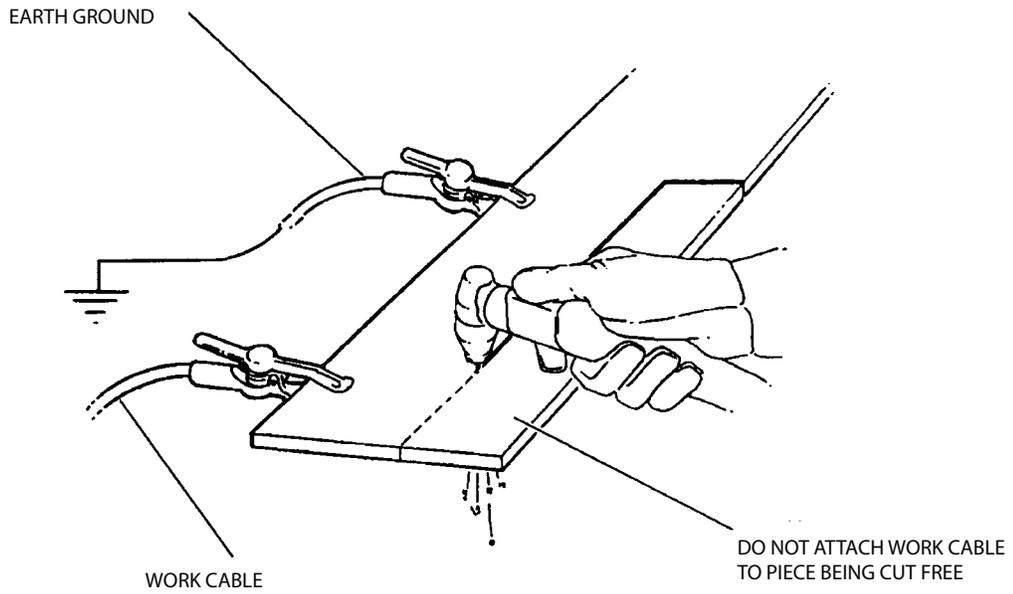


Figure 3-1. HandyPlasma® 550 Interconnection Diagram



4.1 OPERATION



ELECTRIC SHOCK can kill.

- Do NOT operate the unit with the cover removed.
- Do NOT apply power to the unit while holding or carrying the unit.
- Do NOT touch any torch parts forward of the torch handle (nozzle, heat shield, electrode, etc.) with power switch on.



**ARC RAYS can burn eyes and skin;
NOISE can damage hearing.**

- Wear welding helmet with No. 6 or 7 lens shade.
- Wear eye, ear, and body protection.

CAUTION

Position the HandyPlasma[®] 550 at least 10 feet (3 meters) from the cutting area. Sparks and hot slag from the cutting operation can damage the unit.

4.2 HANDYPLASMA[®] 550 CONTROLS
(FIGURE 4-1)

- A. **Power Switch (located on front panel).** When placed in ON position, the white pilot light will glow indicating control circuit is energized and the cooling fan will run.
- B. **Output Current Control.** Adjustable from 15 to 35 amperes to suit cutting conditions.
- C. **Air Check Push Button Switch.** When energized, air filter-regulator can be adjusted to desired pressure (55-65 psig) before cutting operations. Allow air to flow for a few minutes. This should remove any condensation that may have accumulated during shutdown period. After setting the pressure, release the button to its normal position.
- D. **"Over Temperature" LED Yellow light** - will turn on if the machine becomes overheated. Will turn off automatically after the machine cools down if the on/off switch is still on.

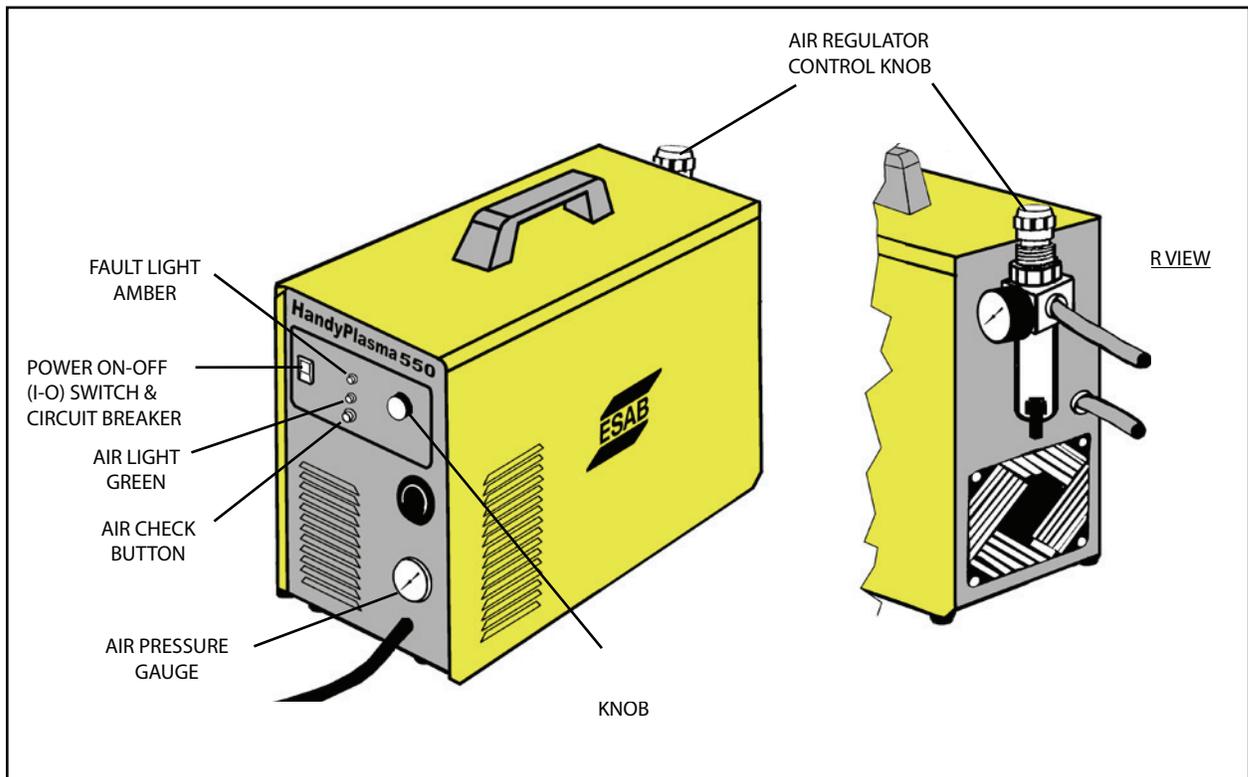


Figure 4-1. HandyPlasma[®] 550 Controls

- E. **"Low Air Flow" LED Green light** - will turn on during operation when the air flow is correct. Will switch off below 15psi (1 bar).
- F. **On/Off Switch (Whitelight)** - will light when switched on, even if the machine stopped for any reason. Will turn off when switch is in OFF position or the light bulb is defective.
- G. **Air Pressure Gauge (Front Panel)** - Shows air pressure in bars and psi.

4.3 ASSEMBLING PT-31XL CONSUMABLE PARTS



Make sure power switch on power source is in OFF position and primary input power is deenergized.

To assemble "XT" consumables, remove the seat supplied with the torch. Insert the plunger into the head. (The plunger is reversible.) Then reassemble the seat firmly with a wrench. Install the electrode, baffle, nozzle, and heat shield as shown in Fig. 4-2. Tighten heat shield snugly but do not overtighten.



BE SURE to install the swirl baffle in the torch. Failure to do so would allow the nozzle (tip) to contact the electrode. This contact would permit high voltage to be applied to the nozzle. Your contact with the nozzle or workpiece could then result in serious injury or death by electric shock.

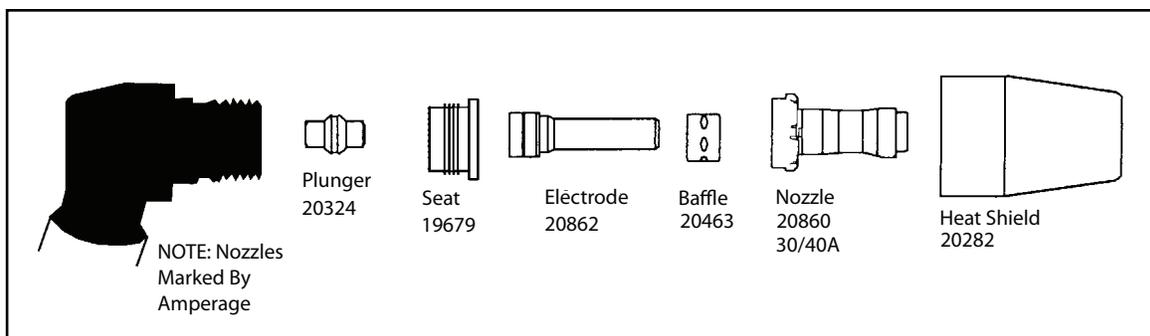


Fig. 4-2 - Assembly of "XT" Consumable Parts



The PT-31XL torch head contains a gas flow check valve that acts in conjunction with the flow switch and circuitry within the power source. This system prevents the torch from being energized with high voltage if the torch switch is accidentally closed when the shield is removed. ALWAYS REPLACE TORCH WITH THE PROPER TORCH MANUFACTURED BY ESAB SINCE IT ALONE CONTAINS ESAB'S PATENTED SAFETY INTERLOCK.

For additional torch information, see booklet (F-14-246) packed with the PT-31XL torch.

4.4 CUTTING WITH THE PT-31XL



Wear the usual protective gloves, clothing, and helmet. Helmet with filter lens shade No. 6 or 7 should provide adequate protection for your eyes.



Never touch any parts forward of the torch handle (tip, heat shield, electrode, etc.) unless the power switch is in the OFF position.

CAUTION: Do not depress the torch switch unless the torch nozzle is touching or within 0.020-in. (less than 1/32-in.) of the workpiece.

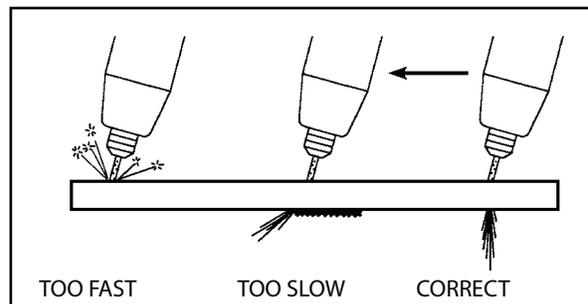


Fig. 4-3 - Effect of Cutting Speed

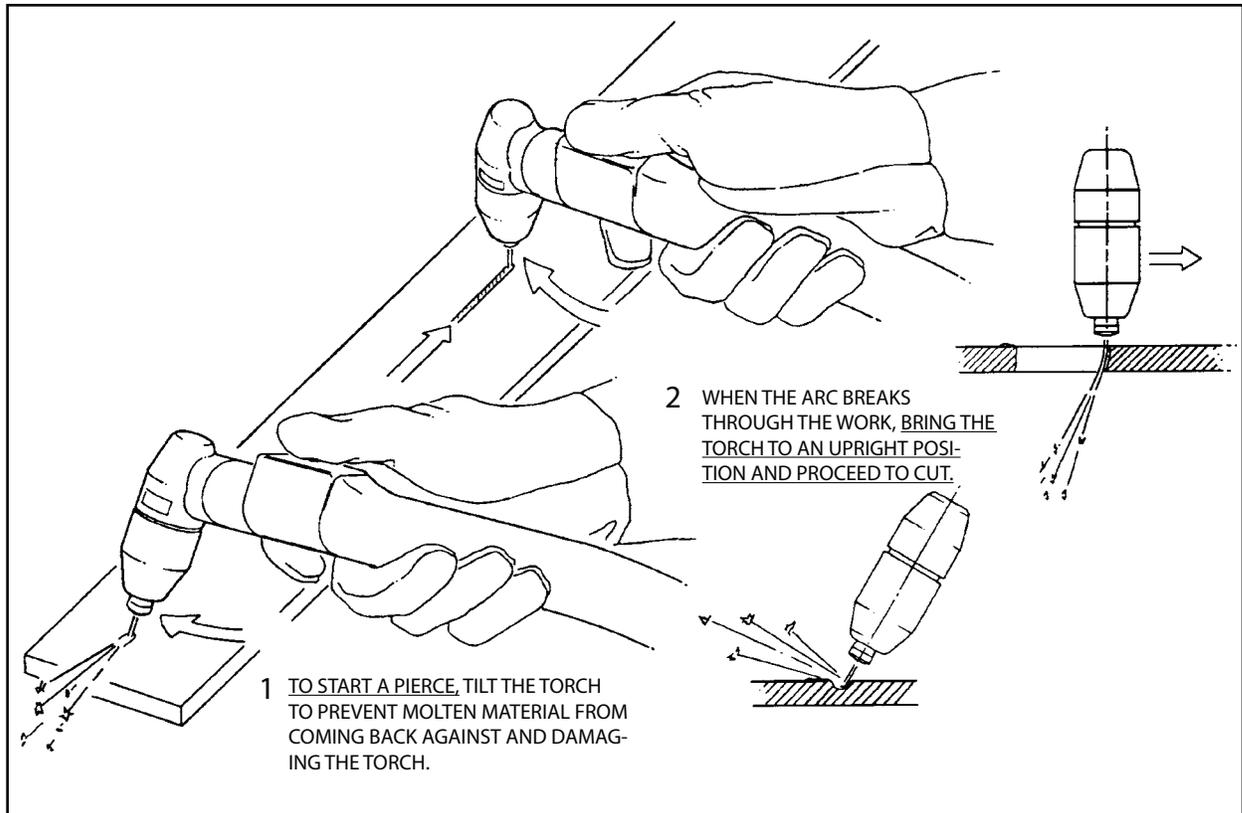


Figure 4-4. Piercing Technique using the PT-31XL

CAUTION: Locate the console at least 10-ft. from the cutting work area. Chips and hot slag from the cutting operation can damage the console.

After placing the primary (wall) switch to the ON position and making control and air pressure adjustments as described above, proceed as follows:

1. Touch the tip of the torch to the workpiece (or within 0.020-in. of the workpiece) holding the torch at about 15-30° angle to avoid damaging the tip.
2. Depress the torch switch. (Air and high frequency should energize.)
3. Two seconds after depressing torch switch, the plasma arc will start cutting.
4. After starting the cut, the tip can be dragged along the workpiece if cutting up to 1/4" thick material. When cutting material greater than 1/4", maintain a 1/8" tip-to-work (standoff) distance.
5. When ending a cut, the torch switch should be released and lifted off the workpiece just before the end of the cut to minimize double-arcing which can damage the tip. This is to prevent high frequency from reigniting after cutting arc extinguishes.
6. In the postflow mode, the arc can be restarted immediately by depressing the torch switch. The two second preflow will automatically cancel.

Cutting Speed Range — HandyPlasma® 550 (Using Air with XT Consumables @ 75 psi)

Material	Thickness (In.)	Output Current (Amps)	Cutting Speed (ipm)
Carbon Steel (AISI 1020)	1/16	30	180
	1/8	30	75
	1/8	35	85
	1/4	35	30
	3/8	35	15
Stainless Steel (AISI 304)	1/16	30	200
	1/8	30	85
	1/8	35	85
	1/4	35	30
	3/8	35	14
Aluminum (6061)	1/16	30	200
	1/8	30	85
	1/8	35	85
	1/4	35	30
	3/8	35	15
	1/2	35	12

NOTE: The speeds given here are typical for best quality cuts. Your actual speeds may vary depending on material composition, surface condition, operator technique, etc. If cutting speed is too fast, you may lose the cut. With slower speeds excessive dross may accumulate. If speed is too slow, the arc may extinguish. Air cutting typically produces a rough face on stainless steel and aluminum.

4.5 OPERATING TECHNIQUES

- 1. Piercing** - Materials (up to 1/4-in. thick) may be pierced with the torch touching the work. When piercing thicker materials (up to 3/16-in. aluminum or 1/4-in. stainless or carbon steel) immediately raise the torch to 1/16-in. standoff after initiating the cutting arc. This will reduce the chance of spatter from entering the torch and prevent the possibility of welding the tip to the plate. The torch should be angled at about 30° when starting to pierce, and then straightened after accomplishing the pierce.
- 2. Grate Cutting** - For rapid restarts, such as grate or heavy mesh cutting, do not release the torch switch. This avoids the 2 second preflow portion of the cutting cycle.

4.6 COMMON CUTTING PROBLEMS

Listed below are common cutting problems followed by the probable cause of each. If problems are determined to be caused by the HandyPlasma® 550, refer to the maintenance section of this manual. If the problem is not corrected after referring to the maintenance section, contact your ESAB representative.

- A. Insufficient Penetration.**
 1. Cutting speed too fast.
 2. Damaged cutting nozzle.
 3. Improper air pressure.
- B. Main Arc Extinguishes.**
 1. Cutting speed too slow.
- C. Dross Formation.** (In some materials and thicknesses, it may be impossible to get dross-free cuts.)
 1. Cutting speed too fast or too slow.
 2. Improper air pressure.
 3. Faulty nozzle or electrode.
- D. Double Arcing.** (Damaged Nozzle Orifice.)
 1. Low air pressure.
 2. Damaged cutting nozzle.
 3. Loose cutting nozzle.
 4. Heavy spatter.
- E. Uneven Arc.**
 1. Damaged cutting nozzle or worn electrode.
- F. Unstable Cutting Conditions.**
 1. Incorrect cutting speed.
 2. Loose cable or hose connections.
 3. Electrode and/or cutting nozzle in poor condition.
- G. Main Arc Does Not Strike.**
 1. Loose connections.
- H. Poor Consumable Life.**
 1. Improper gas pressure.
 2. Contaminated air supply.

5.1 GENERAL

**CAUTION**

If this equipment does not operate properly, stop work immediately and investigate the cause of the malfunction. Maintenance work must be performed by an experienced person, and electrical work by a trained electrician. Do not permit untrained persons to inspect, clean, or repair this equipment. Use only recommended replacement parts.

**WARNING**

Be sure that the wall disconnect switch or wall circuit breaker is open before attempting any inspection or work inside of the HandyPlasma® 550.

5.2 INSPECTION AND CLEANING

Frequent inspection and cleaning of the HandyPlasma® 550 is recommended for safety and proper operation. Some suggestions for inspecting and cleaning are as follows:

- A. Check work cable to workpiece connection.
- B. Check safety earth ground at workpiece and at power source chassis.
- C. Check heat shield on torch. It should be replaced if damaged.
- D. Check the torch electrode and cutting nozzle for wear on a daily basis. Remove spatter or replace if necessary.
- E. Make sure cable and hoses are not damaged or kinked.
- F. Make sure all fittings and ground connections are tight.

**CAUTION**

Water or oil occasionally accumulates in compressed air lines. Be sure to direct the first blast of air away from the equipment to avoid damage to the HandyPlasma® 550.

- G. With all input power disconnected, and wearing proper eye and face protection, blow out the inside of the HandyPlasma® 550 using low-pressure dry compressed air.

5.3 FLOW SWITCH (FIGURE 5-1)

When excessive contamination is found in the air, the flow switch (FS) should be removed, disassembled and cleaned as follows:

- A. Ensure the system is shut down and there is no trapped air under pressure in the piping.
- B. Remove the piston plug.
- C. Remove the spring (FS-4 only). Use care when handling spring to prevent distortion.
- D. Remove the piston.
- E. Clean all parts with cleaning agent.

NOTE

Ensure cleaning agent does not contain solvents which can degrade polysulfone. Warm water and detergent is recommended for cleaning. Allow all parts to dry thoroughly before reassembly.

Reassemble the flow switch in reverse order.

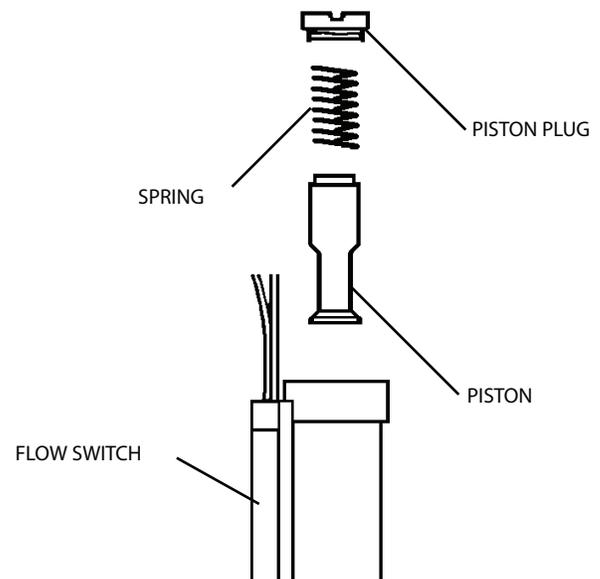


Figure 5-1. Disassembly / Assembly of Flow Switch

6.1 TROUBLESHOOTING



ELECTRIC SHOCK CAN KILL! Be sure that all primary power to the machine has been externally disconnected. Open the line (wall) disconnect switch or circuit breaker before attempting inspection or work inside of the power source.

Check the problem against the symptoms in the following troubleshooting guide. The remedy may be quite simple. If the cause cannot be quickly located, shut off the input power, open up the unit, and perform a simple visual inspection of all the components and wiring. Check for secure terminal connections, loose or burned wiring or components, bulged or leaking capacitors, or any other sign of damage or discoloration.

The cause of control malfunctions can be found by referring to the sequence of operations and electrical schematic diagram (Figure 5-1) and checking the various components. A volt-ohmmeter will be necessary for some of these checks.



Voltages in plasma cutting equipment are high enough to cause serious injury or possibly death. Be particularly careful around equipment when the covers are removed.

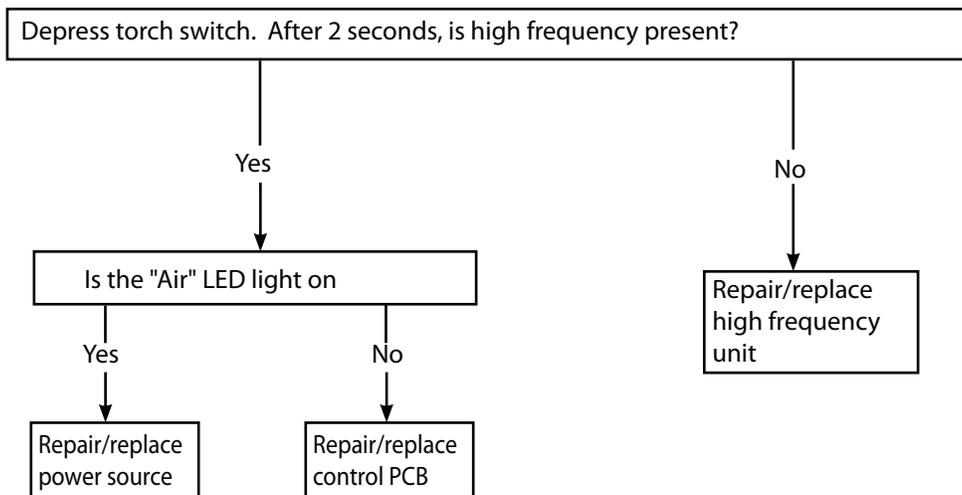
NOTE

Before checking voltages in the circuit, disconnect the power from the high frequency generator to avoid damaging your voltmeter.

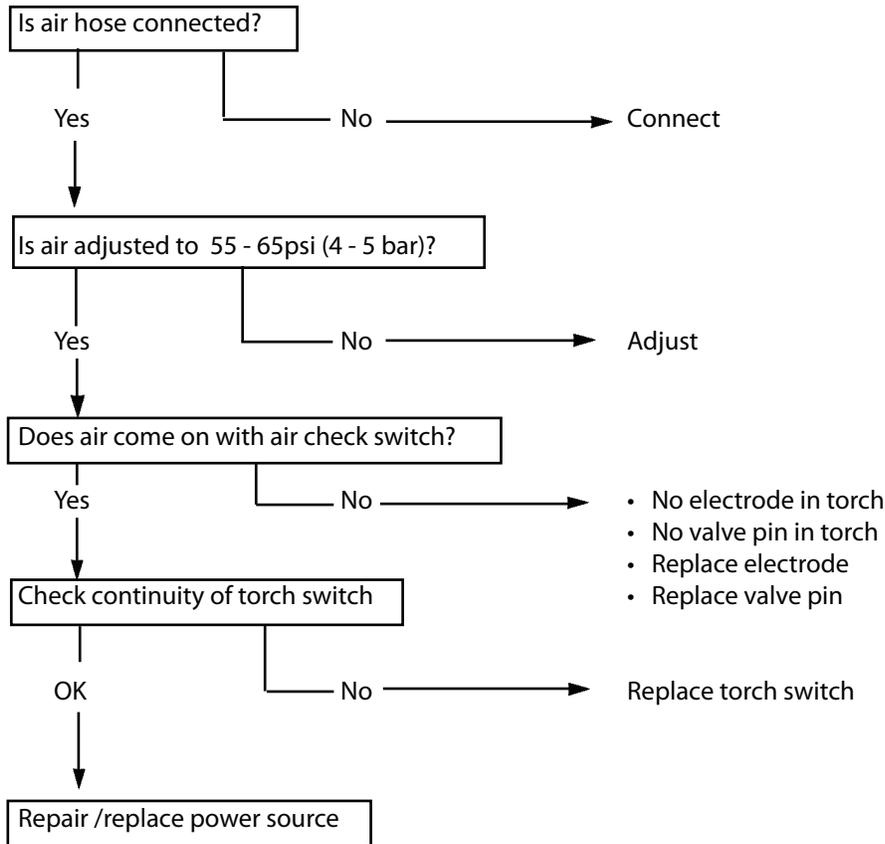
6.2 TROUBLESHOOTING GUIDE

A. Difficult Starting.

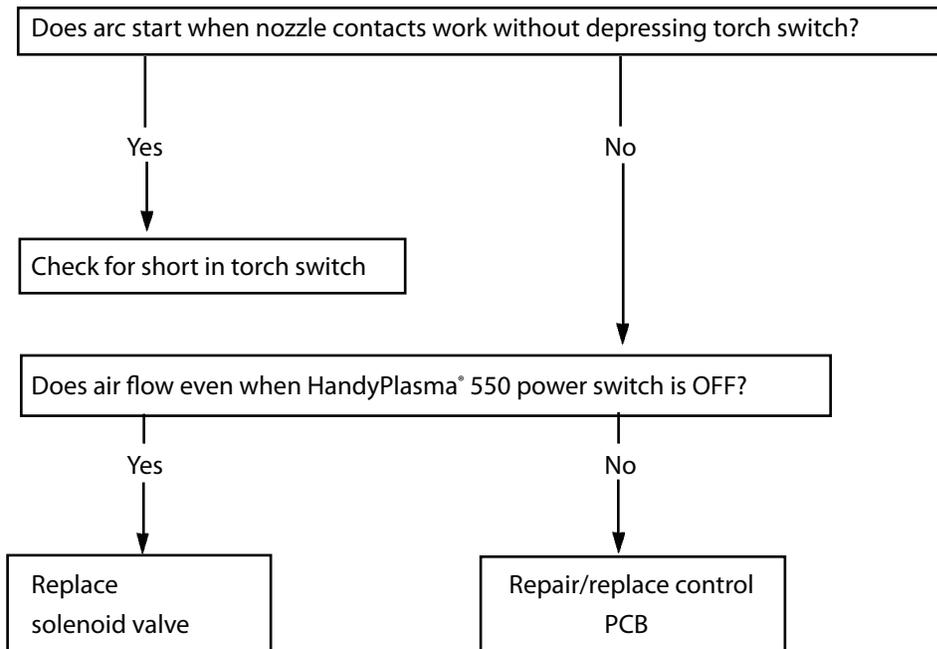
- Change electrode
- Change nozzle
- Check for good, clean connection of work lead to workpiece
- Check air pressure 55 -65 psi (4 - 5 bar)
- Check torch power cable for continuity



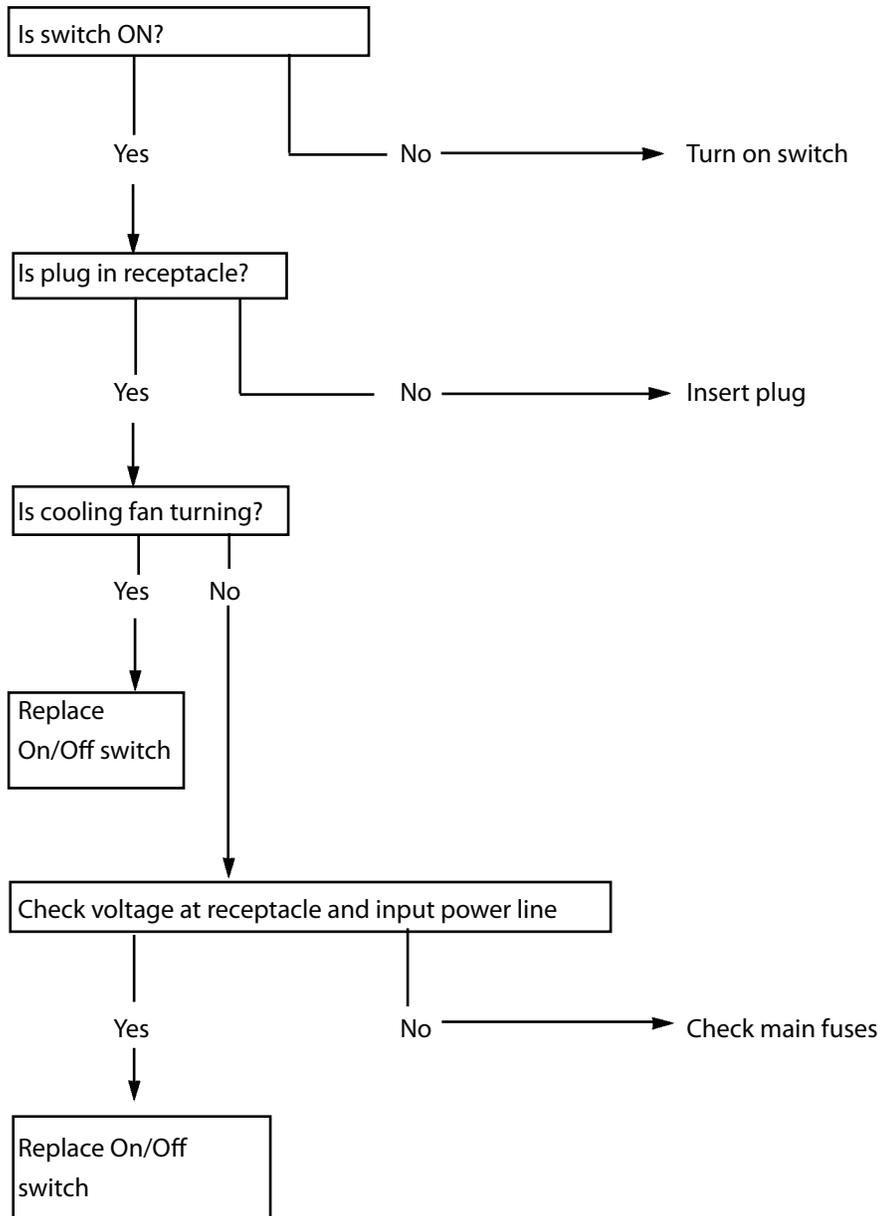
B. No Air



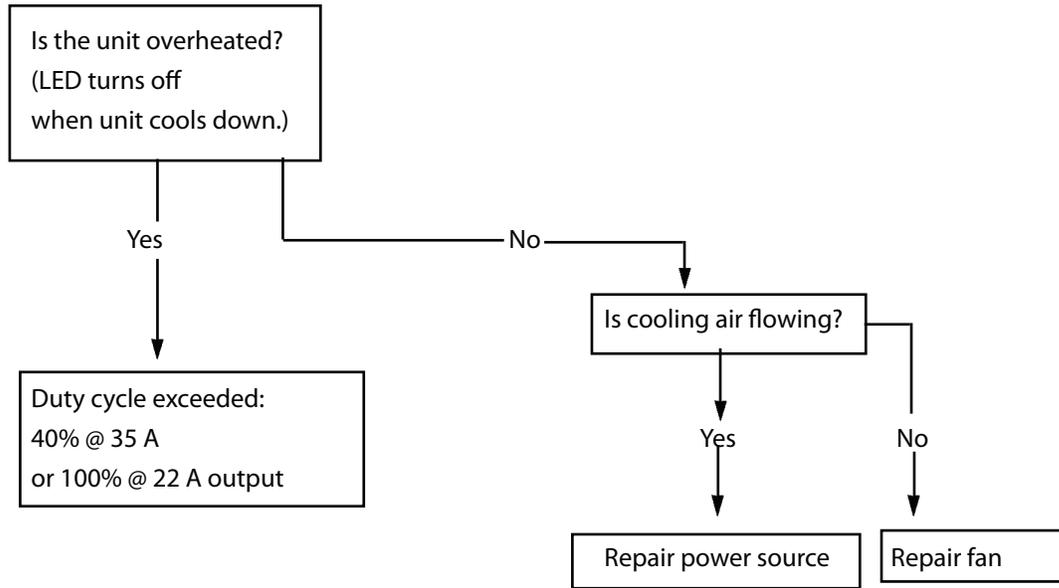
C. Air does not shut off



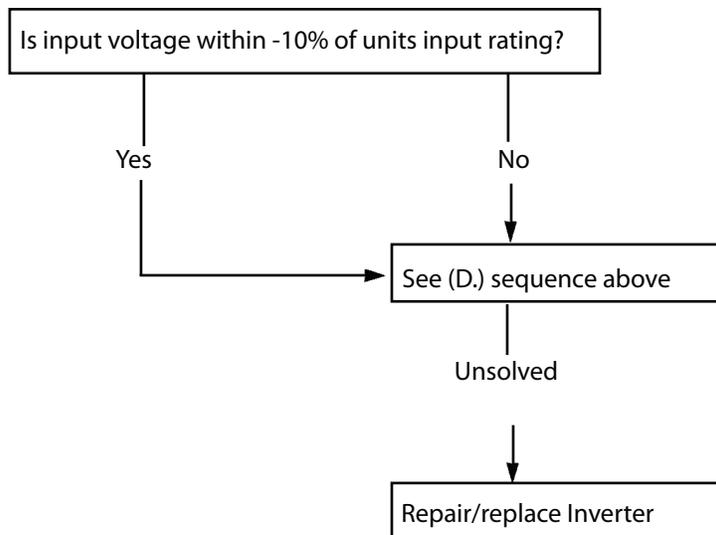
D. On/Off switch light not energized.

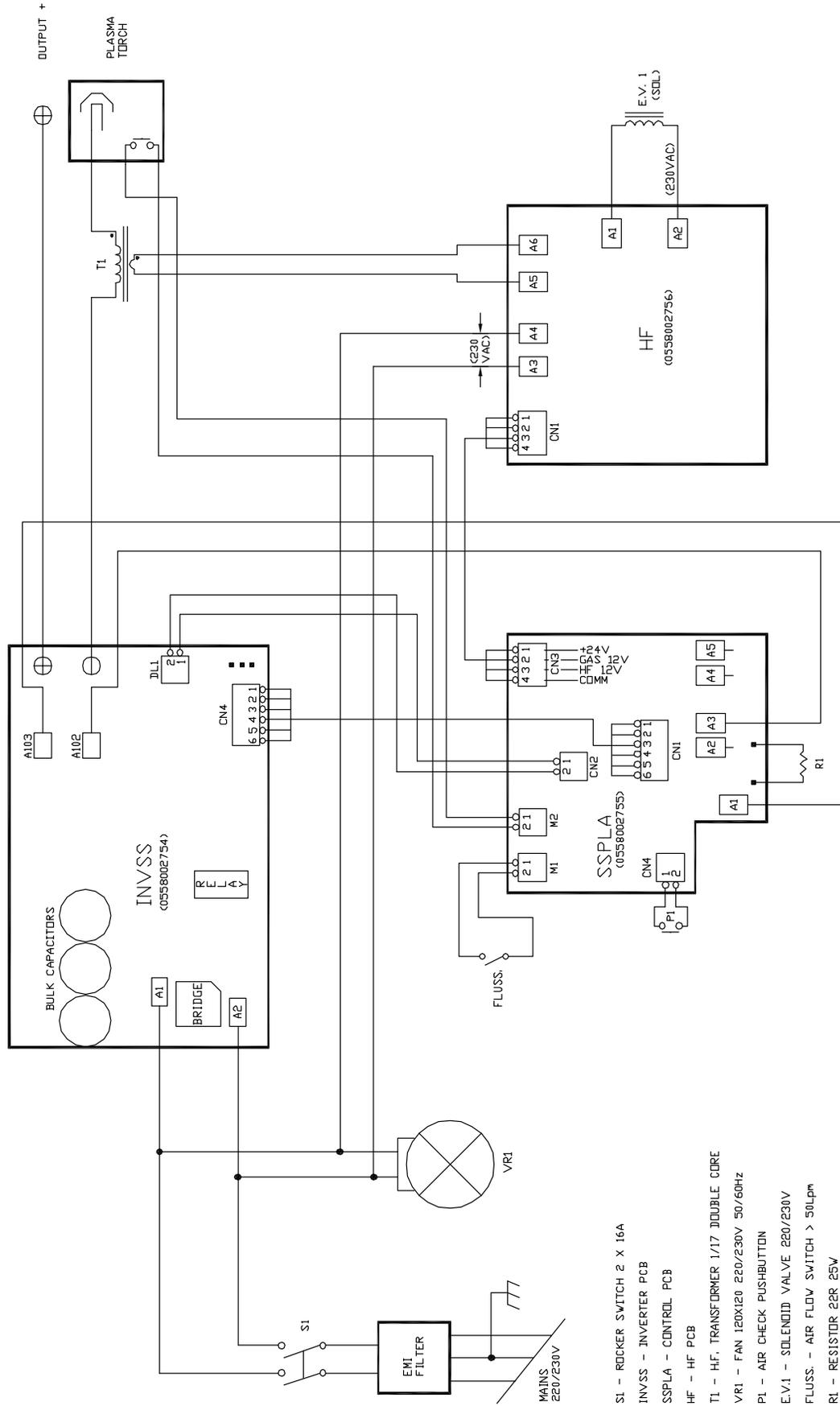


E. Temperature LED light ON.



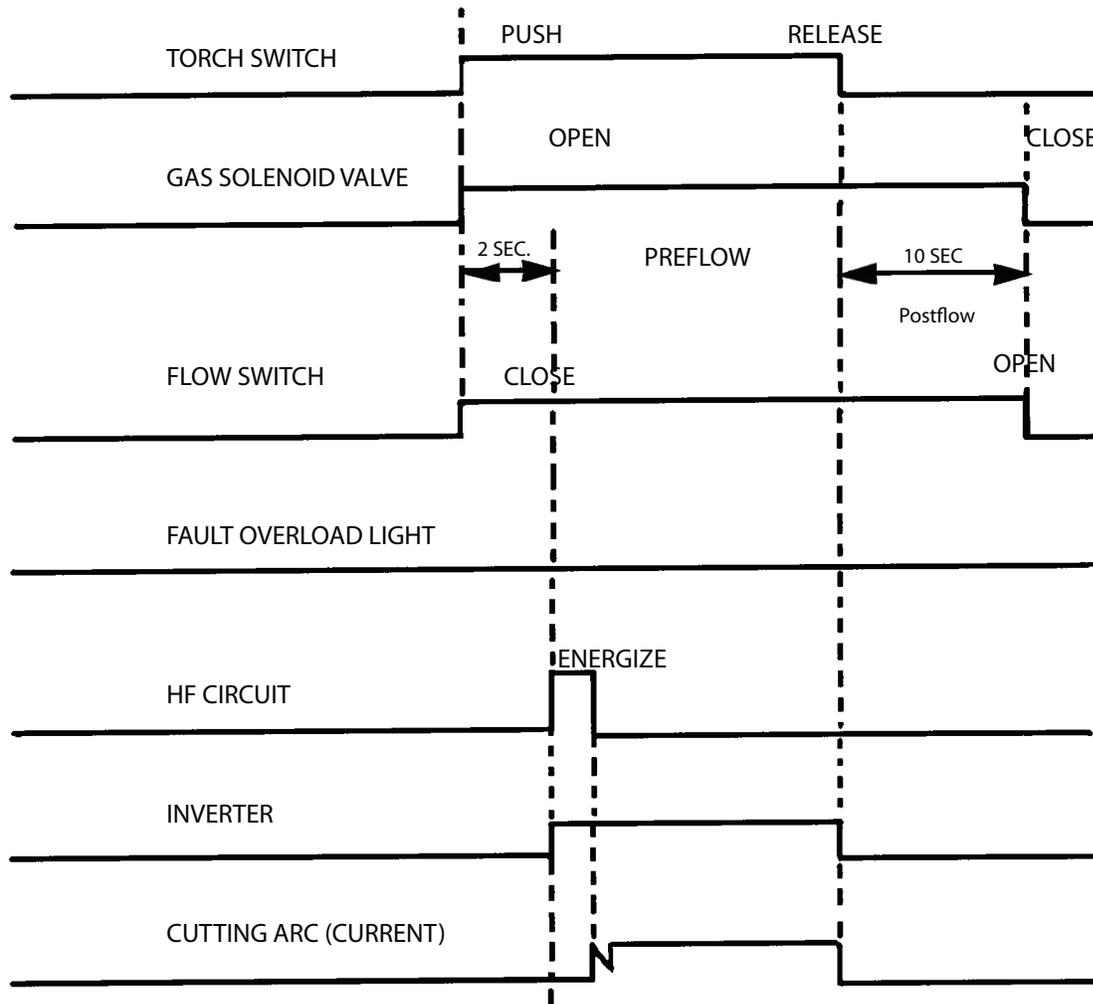
F. No current output





- S1 - RICKER SWITCH 2 X 16A
- INVSS - INVERTER PCB
- SSPLA - CONTROL PCB
- HF - HF PCB
- T1 - HF. TRANSFORMER 1/17 DOUBLE CORE
- VR1 - FAN 120X120 220/230V 50/60HZ
- P1 - AIR CHECK PUSHBUTTON
- E.V.1 - SOLENOID VALVE 220/230V
- FLUSS. - AIR FLOW SWITCH > 50Lpm
- R1 - RESISTOR 22R 25W

6.3 SEQUENCE OF OPERATION

**NOTES:**

1. When the torch switch is depressed during postflow period, the postflow and preflow times are canceled, and the HF is energized immediately. The postflow time starts from the moment the torch switch is released.
2. When the amber fault pilot light comes on, cutting operation should be stopped.

7.0 Replacement Parts

7.1 General

Always provide the serial number of the unit on which the parts will be used. The serial number is stamped on the unit nameplate.

7.2 Ordering

To ensure proper operation, it is recommended that only genuine ESAB parts and products be used with this equipment. The use of non-ESAB parts may void your warranty.

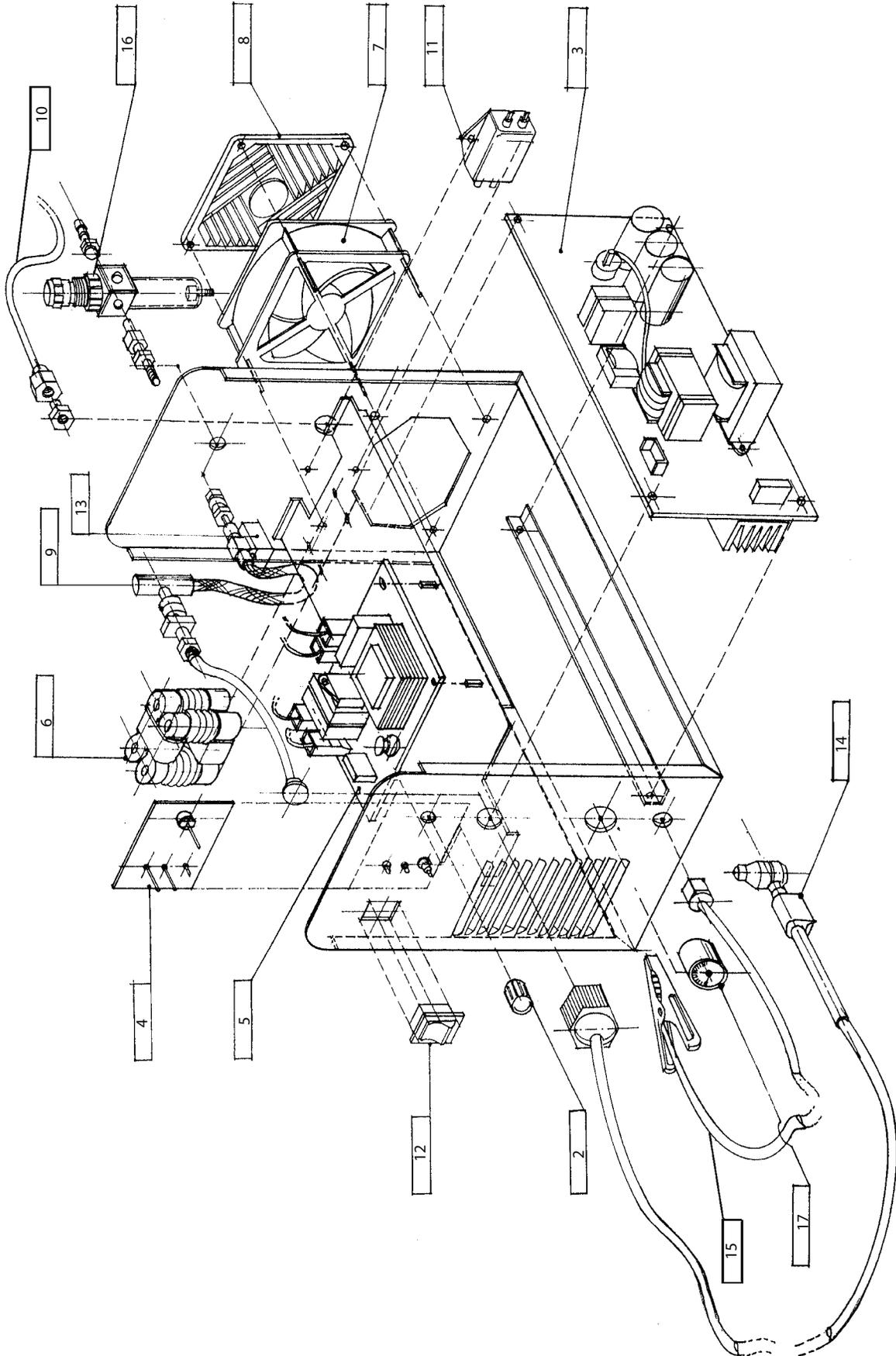
Replacement parts may be ordered from your ESAB Distributor.

Be sure to indicate any special shipping instructions when ordering replacement parts.

Refer to the Communications Guide located on the back page of this manual for a list of customer service phone numbers.

Note

Bill of material items that have blank part numbers are provided for customer information only.
Hardware items should be available through local sources.



Spare Parts List
HandyPlasma® 550

Item No.	Part No.	Description	Cct. Ref.
1	0558004493Y	Cover (<i>Not Shown</i>)	
2	0558002033	Knob	
3	0558002754	Inverter/Main PCB	
4	0558002755	Control PCB	
5	0558002756	HF PCB	
6	0558002757	HF Generator	
7	0558002738	Fan	VR1 & 2
8	0558004479	Fan Grid	
9	951202	Flow Switch	
10	0558004399	Main Power Cable w/Plug 10Ft.	
11	0558002746	EMI Filter	
12	0558002747	ON/OFF Switch	S1
13	0558002764	Solenoid Valve Assembly	
14	0558004498	Plasma Torch	
15	680560	Earth Cable w/Clamp	
16	21710	Air Regulator/Filter	
17	21711	Pressure Gauge	
18	0558004494Y	Side Panel (<i>Not Shown</i>)	
19	0558004478	Handle (<i>Not Shown</i>)	

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REVISION HISTORY

1. "A" revision of this manual denotes changes and additions to the replacement parts section and incorporates various editorial changes.
2. "B" revision changes Spare Parts Kit from 21980 to 0558003301.
3. Revision "C" -
 - Front - Deleted "208" reference in description.
 - Section 1 - Table 1-2, changed NOTE p/n from: 21985 to: 0558004498.
 - Section 1 - Table 1-3, deleted 208 V & 29 A reference at Rated Primary Input row.
 - Section 2 - Deleted "**DO NOT connect a power source configured for 208/230 V to a 460 V input power supply.**" from caution paragraph.
 - Section 2 - Table 2-1, deleted 208 V / 29 A row.
 - Section 2 - Deleted "200/208" reference in heading and added "230".
 - Section 3 - Enlarged figure 3-2.
4. Added schematic per Larry Bryant request.
5. Revision "D" - 05/2005 - added Air Line Filter Regulator p/n 0558005394 note in Replacement Parts section per CN #053013. Updated format.
6. Revision "D" - 12/2005 - Removed Air Line Filter Regulator p/n 0558005394 note in Replacement Parts section per D. Smith.

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