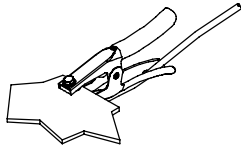


Sequence Of Cutting Operation

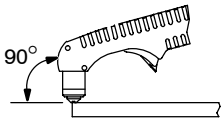


Connect work clamp to a clean, paint-free location on metal workpiece, as close to cutting area as possible.

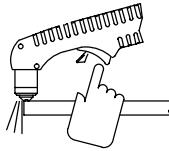


If your plasma system includes adjustable air, set the air pressure to the factory recommended pressure (psi) for cutting.

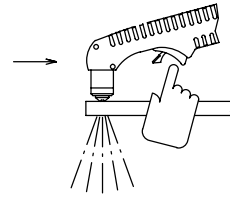
⚠ The pilot arc starts immediately when trigger is pressed.



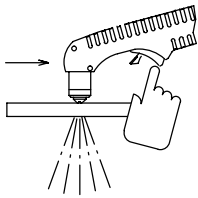
For standard (shielded) cutting, place drag shield on edge of metal. For non-shielded cutting, use 1/8 in (3.2 mm) standoff distance (dragging tip will reduce tip life).



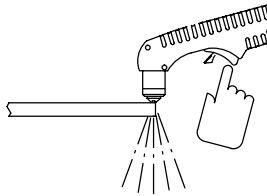
Raise trigger lock and press trigger. Pilot arc starts.



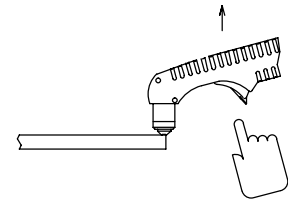
After cutting arc starts, slowly start moving torch across metal.



Adjust torch speed so sparks go thru metal and out bottom of cut.



Pause briefly at end of cut before releasing trigger.



Postflow continues for approx. 20 seconds after releasing trigger; cutting arc can be instantly restarted during postflow by raising trigger lock and pressing trigger.