

SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

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▲ **Warning: Protect yourself and others from injury — read and follow these precautions.**

1-1. Symbol Usage



Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.

▲ **Marks a special safety message.**

☞ Means "Note"; not safety related.



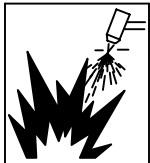
This group of symbols means Warning! Watch Out! possible ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Plasma Arc Cutting Hazards

▲ **The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-5. Read and follow all Safety Standards.**

▲ **Only qualified persons should install, operate, maintain, and repair this unit.**

▲ **During operation, keep everybody, especially children, away.**



CUTTING can cause fire or explosion.

Hot metal and sparks blow out from the cutting arc. The flying sparks and hot metal, hot workpiece, and hot equipment can cause fires and burns. Check and be sure the area is safe before doing any cutting.

- Remove all flammables within 35 ft (10.7 m) of the cutting arc. If this is not possible, tightly cover them with approved covers.
- Do not cut where flying sparks can strike flammable material.
- Protect yourself and others from flying sparks and hot metal.
- Be alert that sparks and hot materials from cutting can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that cutting on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not cut on closed containers such as tanks or drums.
- Connect work cable to the work as close to the cutting area as practical to prevent cutting current from traveling long, possibly unknown paths and causing electric shock, sparks, and fire hazards.
- Do not use plasma cutter to thaw frozen pipes.
- Never cut containers with potentially flammable materials inside – they must be emptied and properly cleaned first.
- Do not cut in atmospheres containing explosive dust or vapors.
- Do not cut pressurized cylinders, pipes, or vessels.
- Do not cut containers that have held combustibles.
- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Do not locate unit on or over combustible surfaces.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any cutting.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.



ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The torch and work circuit are electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. Plasma arc cutting requires

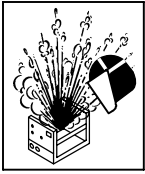
higher voltages than welding to start and maintain the arc (200 to 400 volts dc are common), but also uses torches designed with safety interlock systems which turn off the machine when the shield cup is loosened or if tip touches electrode inside the nozzle. Incorrectly installed or improperly grounded equipment is a hazard.



ELECTRIC SHOCK can kill.

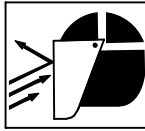
SIGNIFICANT DC VOLTAGE exists in inverter power sources AFTER the removal of input power.

- Turn Off unit, disconnect input power, check voltage on input capacitors, and be sure it is near zero (0) volts before touching any parts. Check capacitors according to instructions in Maintenance Section of Owner's Manual or Technical Manual before touching any parts.



EXPLODING PARTS can injure.

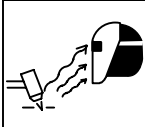
- On inverter power sources, failed parts can explode or cause other parts to explode when power is applied. Always wear a face shield and long sleeves when servicing inverters.



FLYING SPARKS can cause injury.

Sparks and hot metal blow out from the cutting arc. Chipping and grinding cause flying metal.

- Wear approved face shield or safety goggles with side shields.
- Wear proper body protection to protect skin.
- Wear flame-resistant ear plugs or ear muffs to prevent sparks from entering ears.



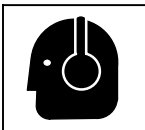
ARC RAYS can burn eyes and skin.

Arc rays from the cutting process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin.

- Wear face protection (helmet or shield) with a proper shade of filter lenses to protect your face and eyes when cutting or watching. ANSI Z49.1 (see Safety Standards) suggests a No. 9 shade (with No. 8 as minimum) for all cutting currents less than 300 amperes. Z49.1 adds that lighter filter shades may be used when the arc is hidden by the workpiece. As this is normally the case with low current cutting, the shades suggested in Table 1 are provided for the operator's convenience.
- Wear approved safety glasses with side shields under your helmet or shield.
- Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather, heavy cotton, or wool) and foot protection.

Table 1. Eye Protection For Plasma Arc Cutting

Current Level In Amperes	Minimum Shade Number	
Below 20		#4
20 – 40		#5
40 – 60		#6
60 – 80		#8



NOISE can damage hearing.

Prolonged noise from some cutting applications can damage hearing if levels exceed limits specified by OSHA (see Safety Standards).

- Use approved ear plugs or ear muffs if noise level is high.
- Warn others nearby about noise hazard.

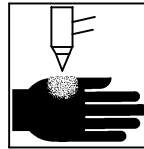


FUMES AND GASES can be hazardous.

Cutting produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use local forced ventilation at the arc to remove cutting fumes and gases.

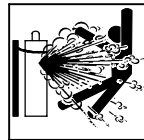
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Material Safety Data Sheets (MSDSs) and the manufacturer's instruction for metals to be cut, coatings, and cleaners.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Fumes from cutting and oxygen depletion can alter air quality causing injury or death. Be sure the breathing air is safe.
- Do not cut in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not cut on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the cutting area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes when cut.
- Do not cut containers with toxic or reactive materials inside or containers that have held toxic or reactive materials – they must be emptied and properly cleaned first.



PLASMA ARC can cause injury.

The heat from the plasma arc can cause serious burns. The force of the arc adds greatly to the burn hazard. The intensely hot and powerful arc can quickly cut through gloves and tissue.

- Keep away from the torch tip.
- Do not grip material near the cutting path.
- The pilot arc can cause burns – keep away from torch tip when trigger is pressed.
- Wear proper flame-retardant clothing covering all exposed body areas.
- Point torch away from your body and toward work when pressing the torch trigger – pilot arc comes on immediately.
- Turn off power source and disconnect input power before disassembling torch or changing torch parts.
- Use only torch(es) specified in the Owner's Manual.



CYLINDERS can explode if damaged.

Gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of metalworking processes, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flame, sparks, and arcs.
- Install and secure cylinders in an upright position by chaining them to a stationary support or equipment cylinder rack to prevent falling or tipping.
- Keep cylinders away from any cutting or other electrical circuits.
- Never allow electrical contact between a plasma arc torch and a cylinder.
- Never cut on a pressurized cylinder – explosion will result.
- Use only correct gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the right equipment, correct procedures, and sufficient number of persons to lift and move cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.

1-3. Additional Symbols For Installation, Operation, And Maintenance



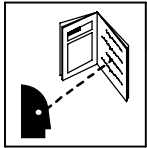
HOT PARTS can cause severe burns.

- Do not touch hot parts bare handed.
- Allow cooling period before working on torch.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



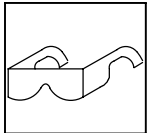
MOVING PARTS can cause injury.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before re-connecting input power.



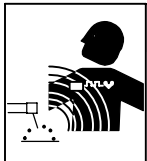
READ INSTRUCTIONS.

- Read Owner's Manual before using or servicing unit.
- Use only genuine Miller/Hobart replacement parts.



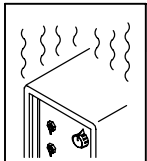
FLYING METAL can injure eyes.

- Wear safety glasses with side shields or face shield.



MAGNETIC FIELDS can affect pacemakers.

- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near plasma arc cutting operations.



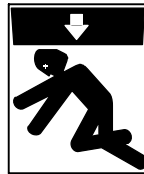
OVERUSE can cause OVERHEATING.

- Allow cooling period; follow rated duty cycle.
- Reduce amperage (thickness) or reduce duty cycle before starting to cut again.



EXPLODING HYDROGEN hazard.

- When cutting aluminum underwater or with the water touching the underside of the aluminum, free hydrogen gas may collect under the work-piece.
- See your cutting engineer and water table instructions for help.



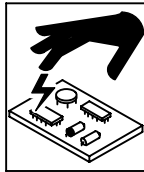
FALLING UNIT can cause injury.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.



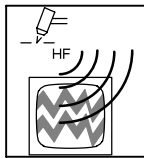
FIRE OR EXPLOSION hazard.

- Do not locate unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.



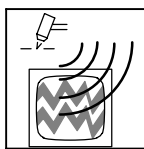
STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



H.F. RADIATION can cause interference.

- High frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



ARC CUTTING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- To reduce possible interference, keep cables as short as possible, close together, and down low, such as on the floor.
- Locate cutting operation 100 meters from any sensitive electronic equipment.
- Be sure this cutting power source is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the machine, using shielded cables, using line filters, or shielding the work area.

1-4. California Proposition 65 Warnings

- ▲ Welding or cutting equipment 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 Section 25249.5 et seq.)
- ▲ Battery posts, terminals and related accessories contain lead and lead compounds, chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Wash hands after handling.

For Gasoline Engines:

- ▲ Engine exhaust contains chemicals known to the State of California to cause cancer, birth defects, or other reproductive harm.

For Diesel Engines:

- ▲ Diesel engine exhaust and some of its constituents are known to the State of California to cause cancer, birth defects, and other reproductive harm.

1-5. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Recommended Practices for Plasma Arc Cutting, American Welding Society Standard AWS C5.2, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, American Welding Society Standard AWS F4.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices For Occupation And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting And Welding Processes, NFPA Standard 51B, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (phone: 617-770-3000, website: www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250 (there are 10 Regional Offices--phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

1-6. EMF Information

Considerations About Welding Or Cutting And The Effects Of Low Frequency Electric And Magnetic Fields

Welding or cutting current, as it flows through the welding or cutting cables, will cause electromagnetic fields. There has been and still is some concern about such fields. However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: "The body of evidence, in the committee's judgment, has not demonstrated that exposure to power-frequency electric and magnetic fields is a human-health hazard." However, studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

To reduce magnetic fields in the workplace, use the following procedures:

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.
4. Keep cutting power source and cables as far away from operator as practical.
5. Connect work clamp to workpiece as close to the cut as possible.

About Pacemakers:

Pacemaker wearers consult your doctor before welding/cutting or going near welding/cutting operations. If cleared by your doctor, then following the above procedures is recommended.