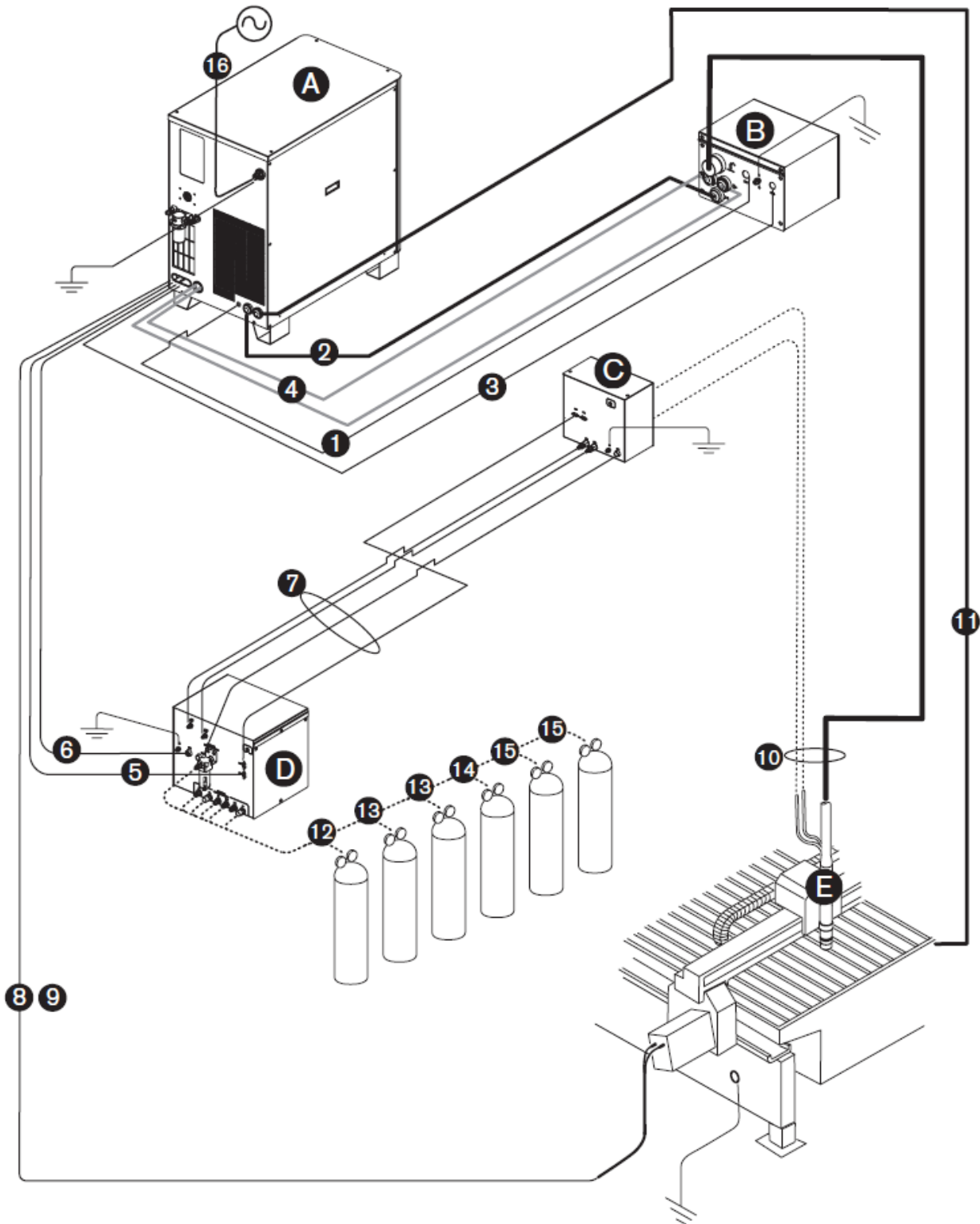


How to connect HPR130 plasma with -X-Mark

The overall schematic of the plasma power supply and the Cooler and machine need to be connected:



System components:

System components	A Power supply	C Metering console
	B Ignition console	D Selection console
		E Torch

Cables and hoses: Marked all need to be connected;

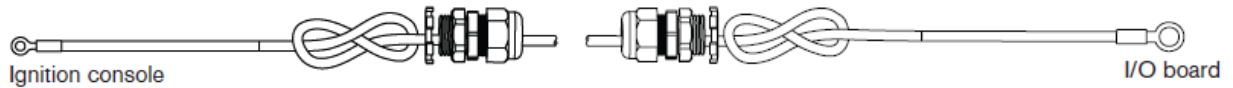
Cables and hoses	1- Pilot arc lead	7- Selection console to metering console hose and lead assembly
	2- Negative lead	
	3- Ignition console power cable	
	4- Coolant hoses	
	5- Gas control cable	11- work lead
	6- Gas power cable	

Service Support Spirit

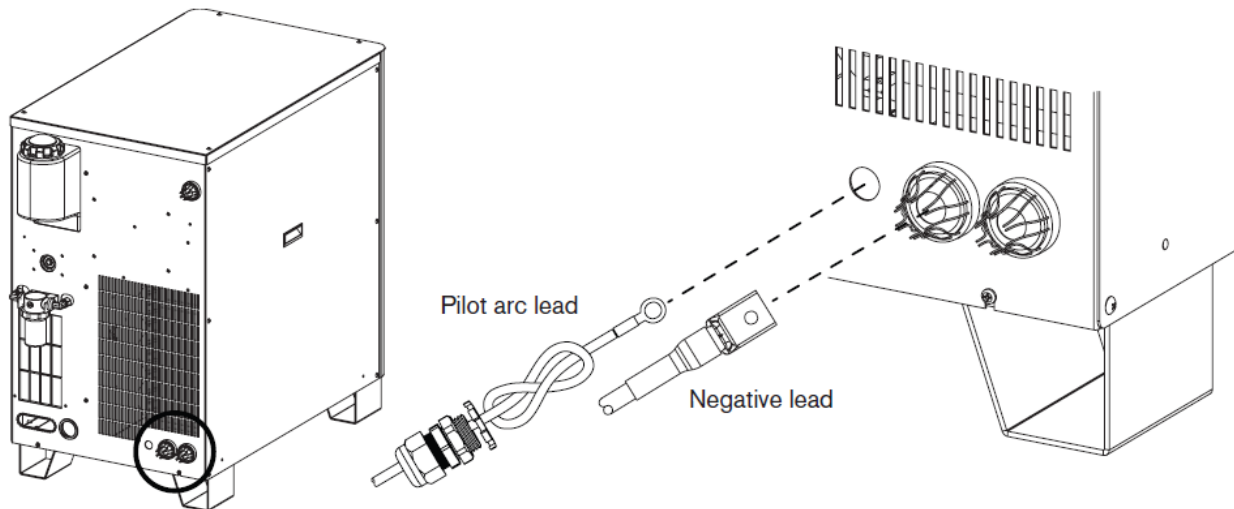
Step 1

- Find the connection position, to connect the Pilot Arc lead and Negative lead like shown in picture.

1 Pilot arc lead

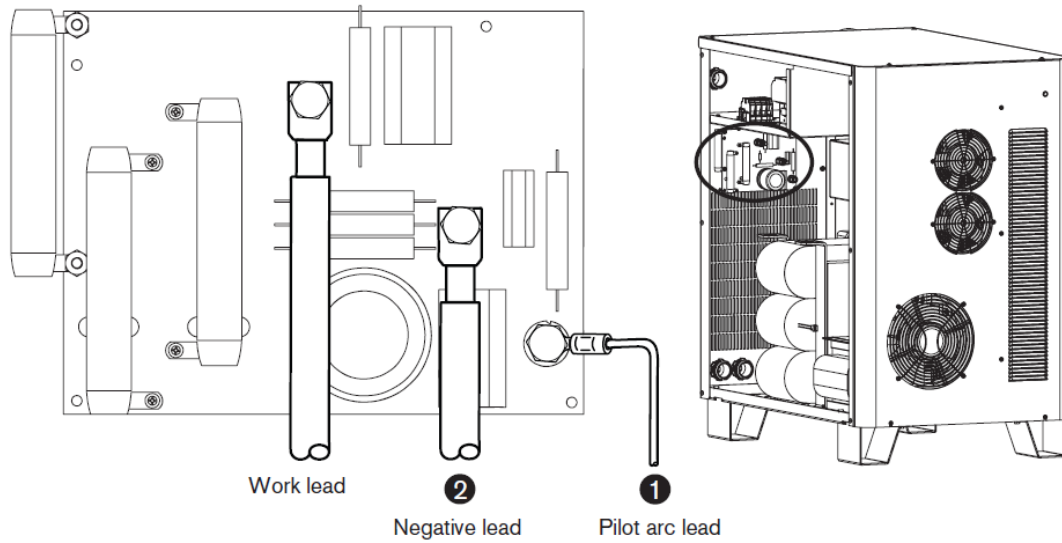


2 Negative lead



Step 2

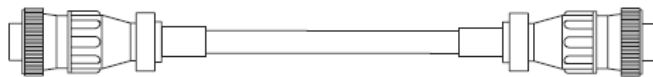
- connect the **Pilot arc lead and Negative lead** from the Plasma power source side. (The other end is already connected)
- the connecting point shown in the picture below



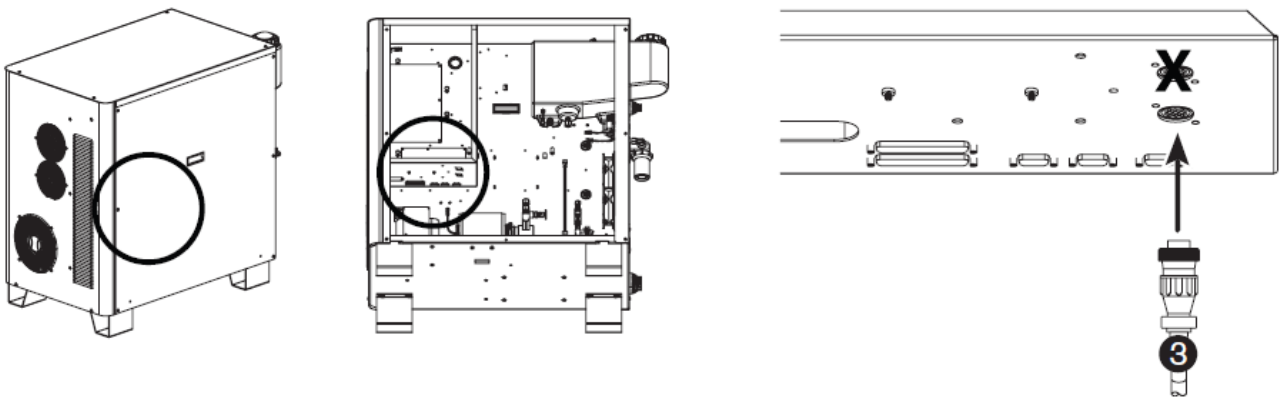
Step 3

- connect the **Ignition console power cable** from the Plasma power source side. (The other end is already connected)

③ Ignition console power cable

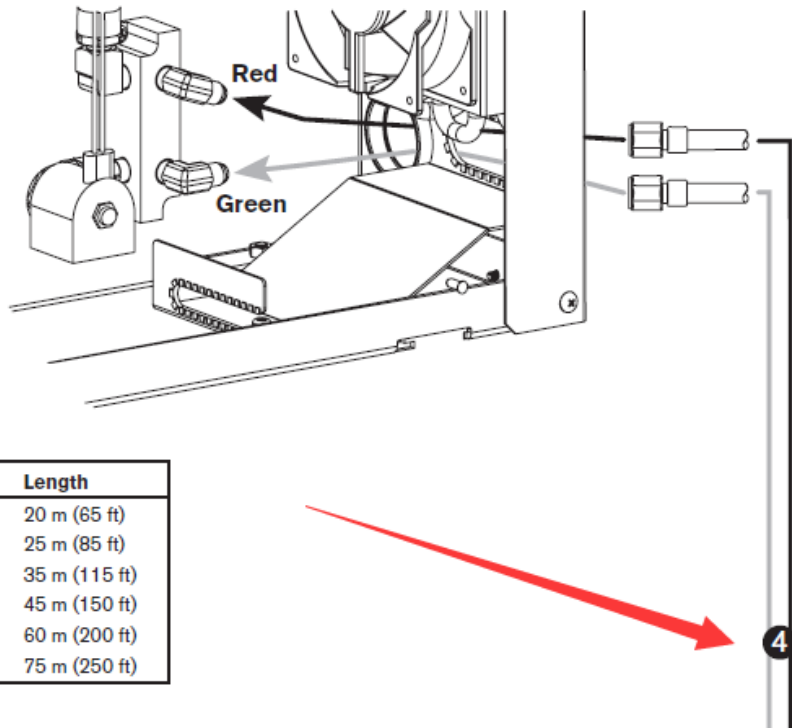
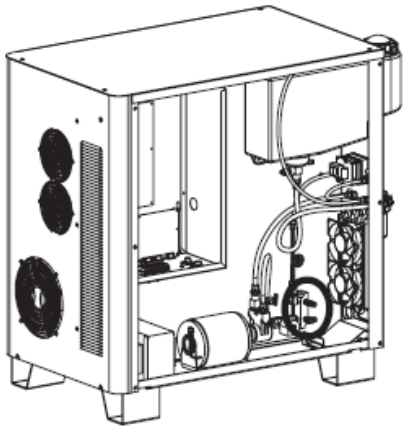


- connect like shown in picture



Step 4

- connect the **Ignition console coolant hoses** from the Plasma power source side. (Cable 4)
- the cable connect direction is from Ignition console to Plasma source
- The other end to Ignition console is already connected

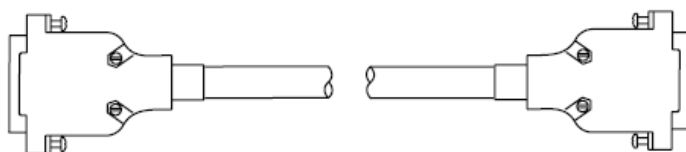


Part no.	Length	Part no.	Length
228030*	0.7 m (2.5 ft)	128984	20 m (65 ft)
028652	3 m (10 ft)	128078	25 m (85 ft)
028440	4.5 m (15 ft)	028896	35 m (115 ft)
028441	7.5 m (25 ft)	028445	45 m (150 ft)
128173	10 m (35 ft)	028637	60 m (200 ft)
028442	15 m (50 ft)	128985	75 m (250 ft)

Step 5

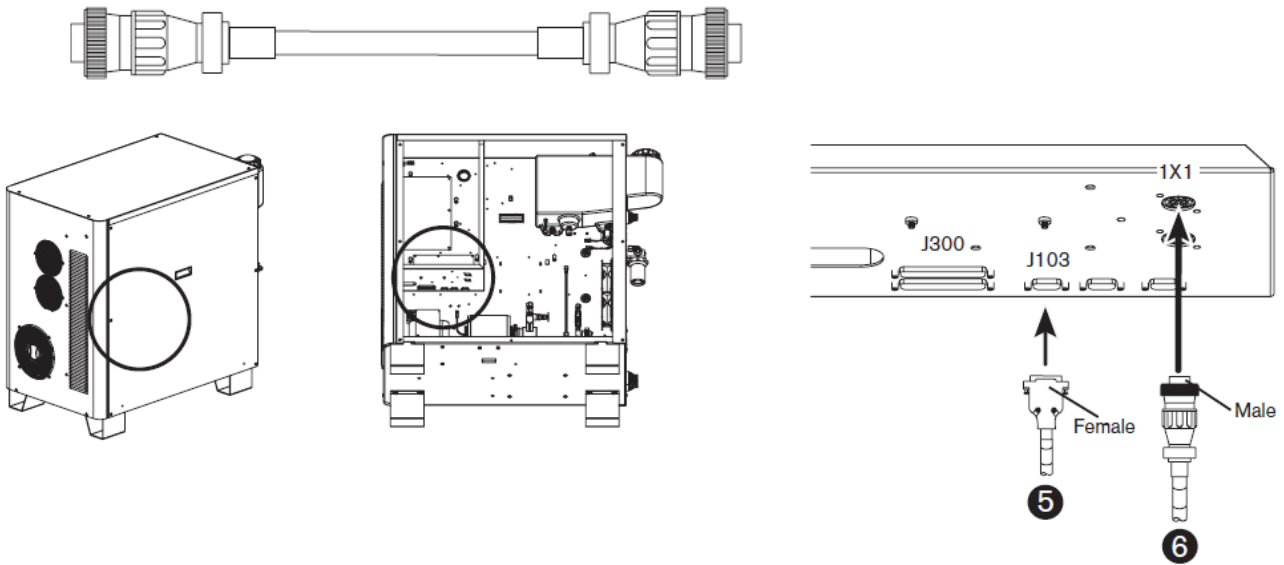
- Connect the **Control cable and Power cable** (Cable 5 and 6).
- The connecting direction is from Selection console to plasma source
- Connect to plasma power source end.
- The connection is shown in picture bellow.

5 Control cable

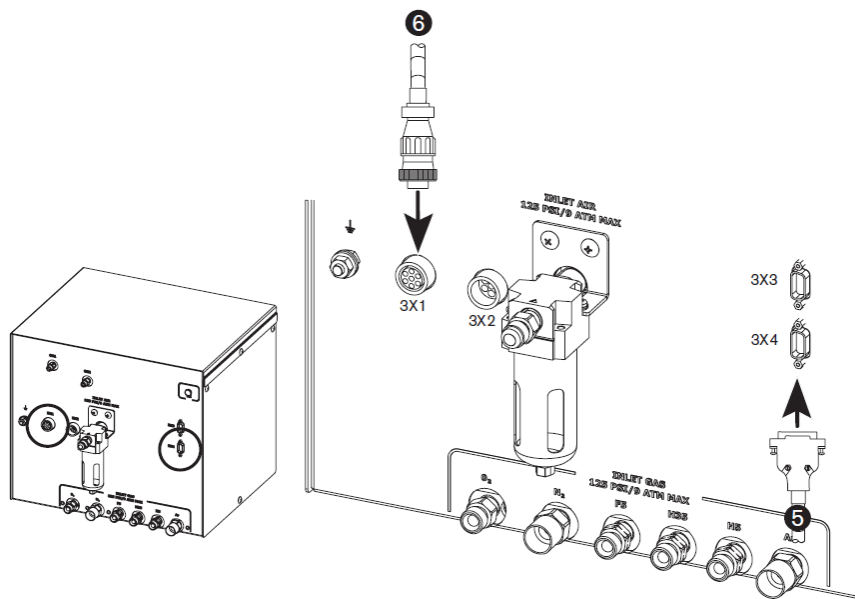


Service Support Spirit

6 Power cable

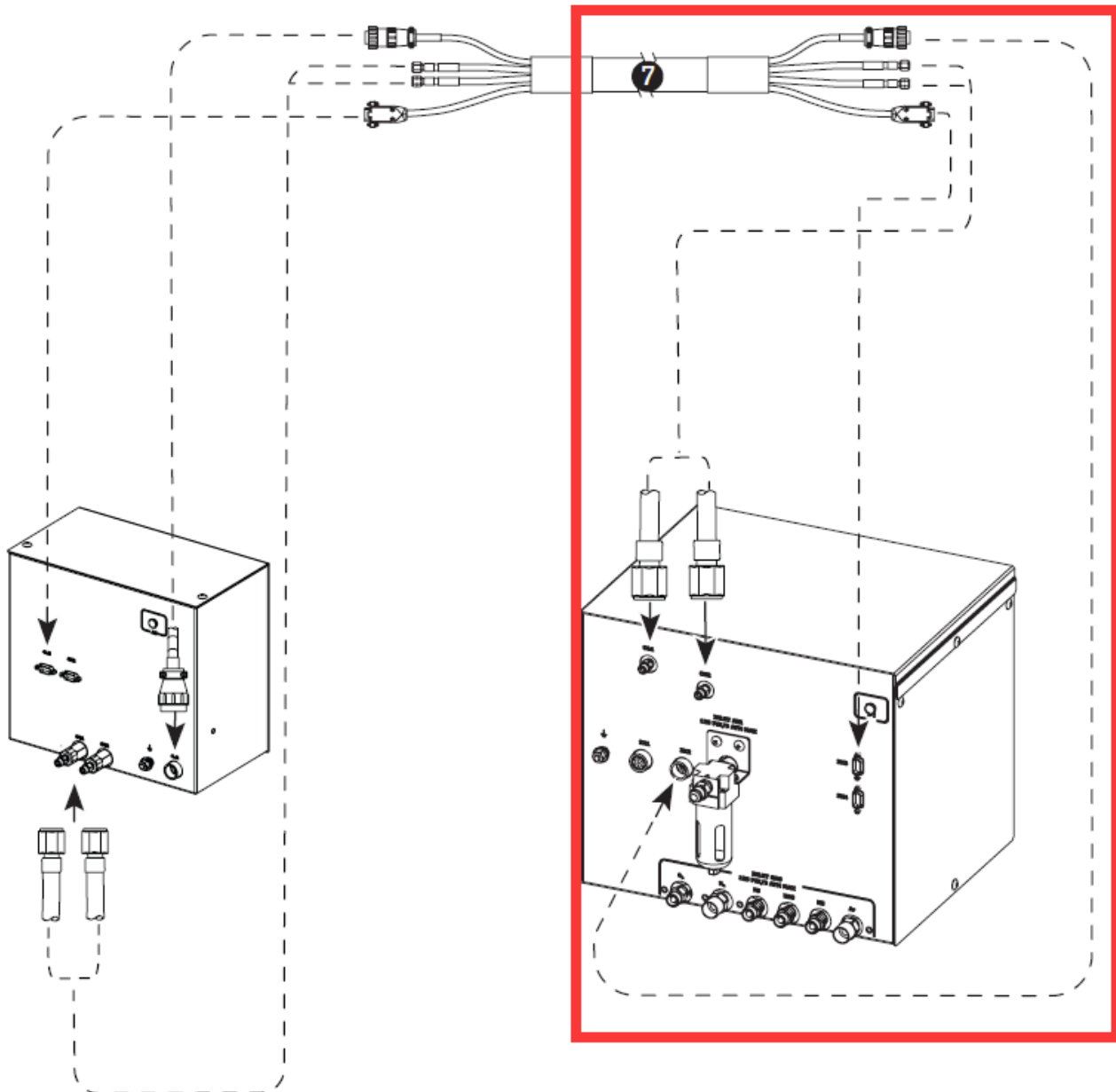
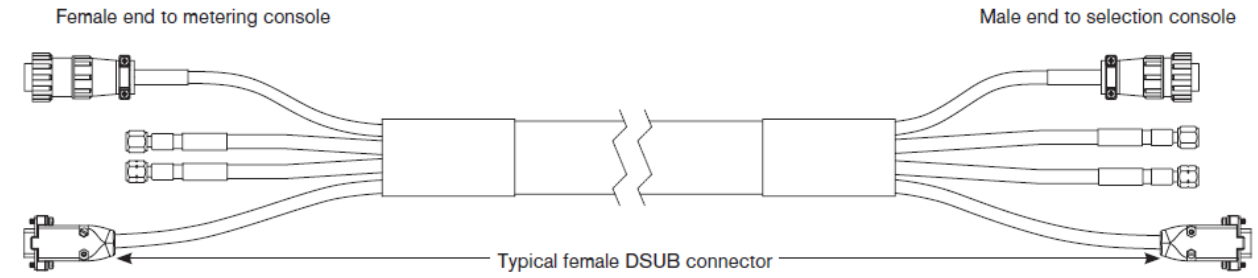


- The other end is going to the Selection console like shown in picture



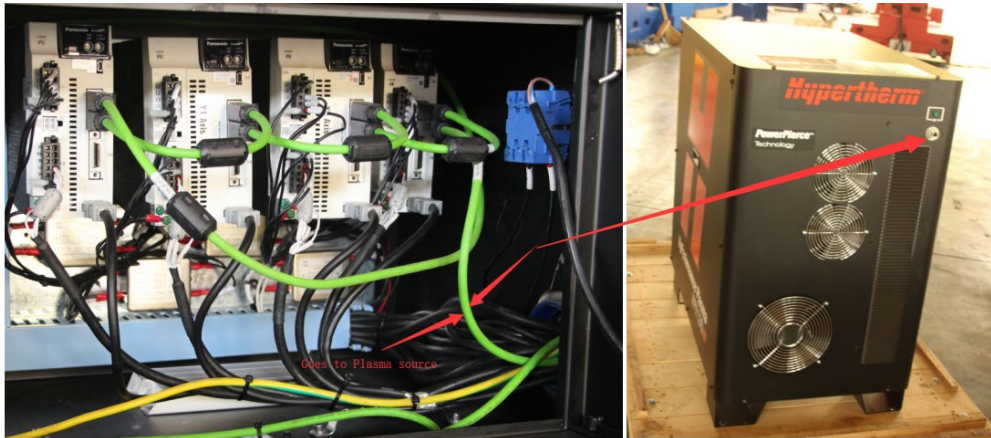
Step 6

- Cable and Gas hose (Cable 7) assembly
- The connecting direction is from Metering console to Selection console
- Connect to Selection console like shown in picture.
- The other end is already connected



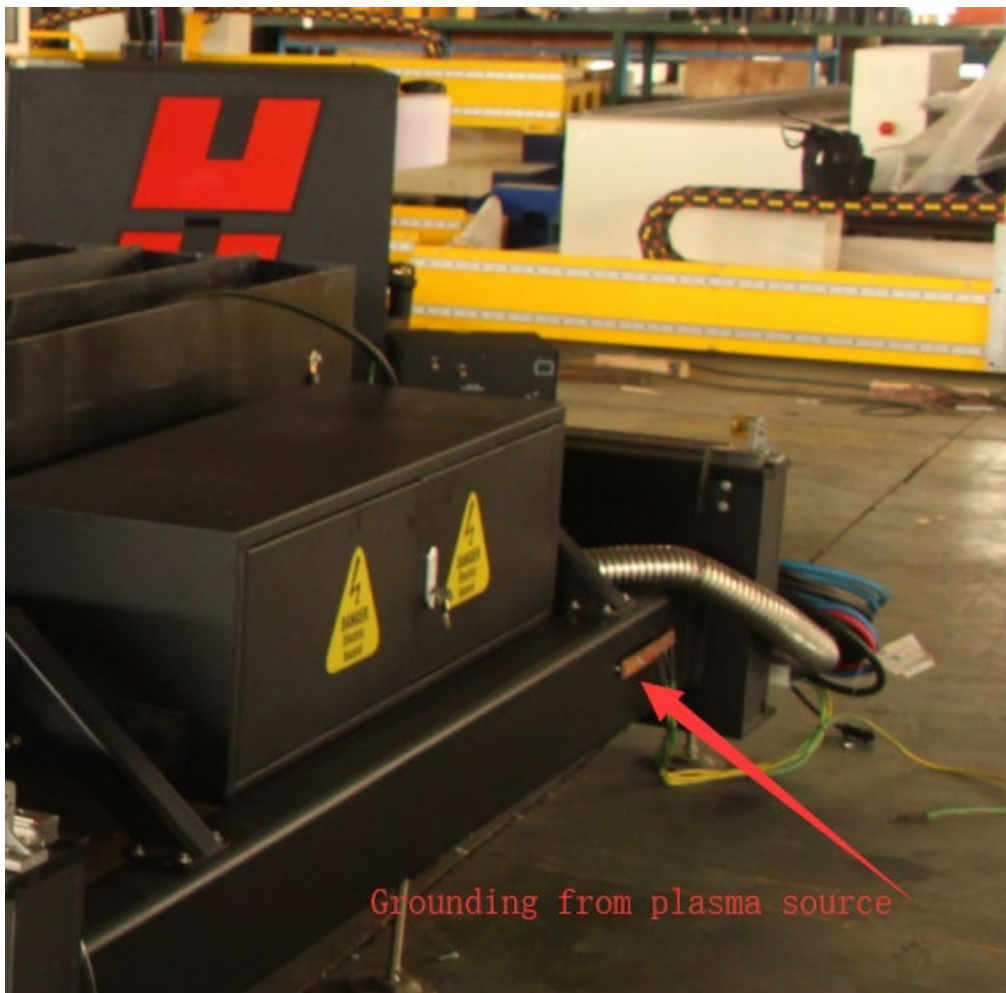
Step 7

- Ethernet cable need to be connected from machine electrical cabinet to plasma power source.
- Ethernet cable is setup in the electrical cabinet.



Step 8

- one grounding wire need to be connected from Plasma source to machine copper terminal like shown in picture.
- the grounding wire is in the plasma source package



Step 9

- Plasma working lead need to be connected to machine cutting table like shown in picture. (cable 11)

