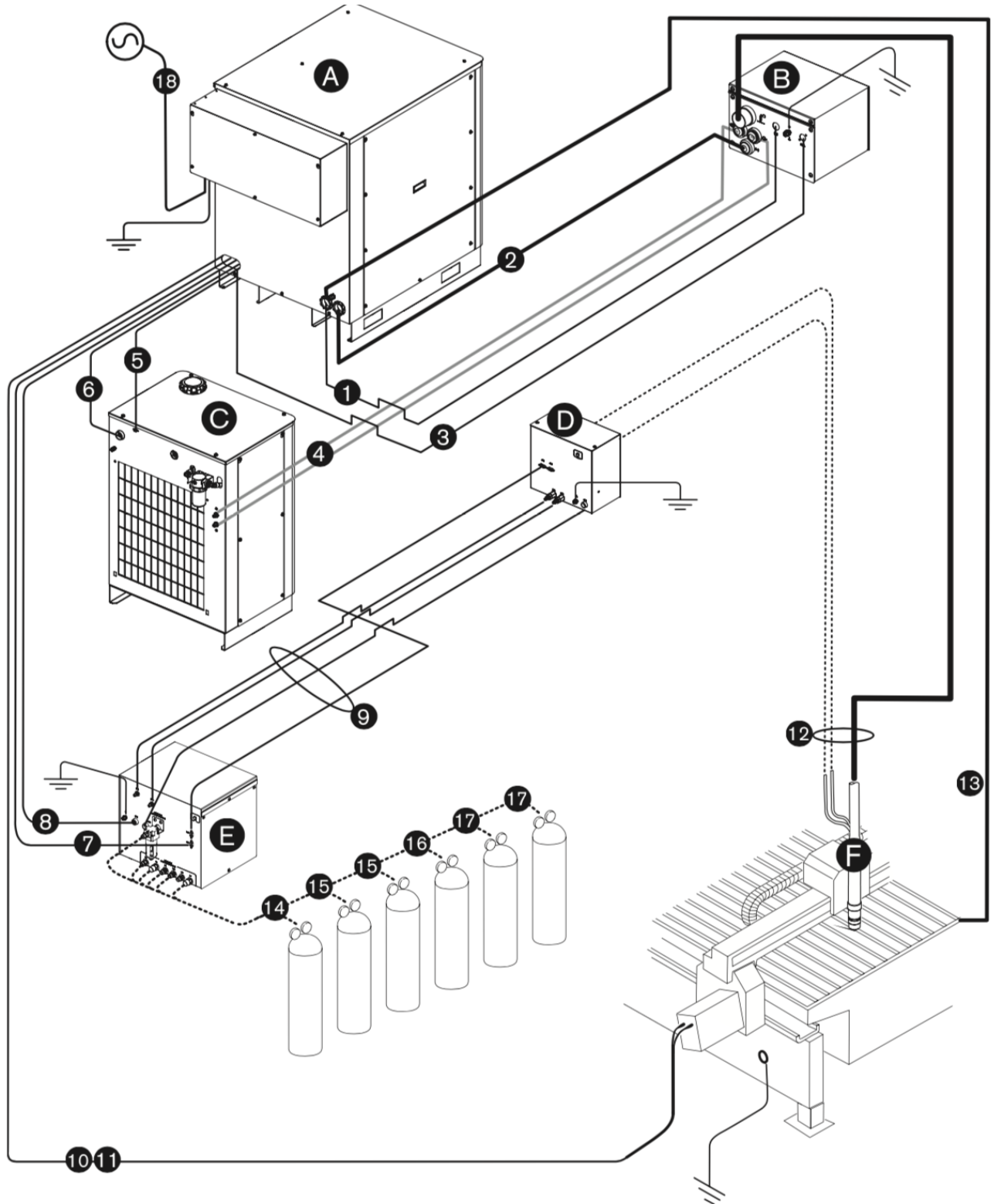


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How to connect HPR400 with the machine X-mark

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



System components:

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

Cables and hoses: Marked all need to be connected;

Cables and hoses	1- Pilot arc lead	8- Selection console power cable
	2- Negative lead	9- Selection console to metering console hose and lead assembly
	3- Ignition console power cable	10 -CNC interface cable
	4- Coolant hoses	11- Optional CNC interface cable for systems with multiple power supplies
	5- Cooler control cable	12- Torch lead assembly
	6- Cooler power cable	13- Work lead
	7- Selection console control cable	18- Main power cable

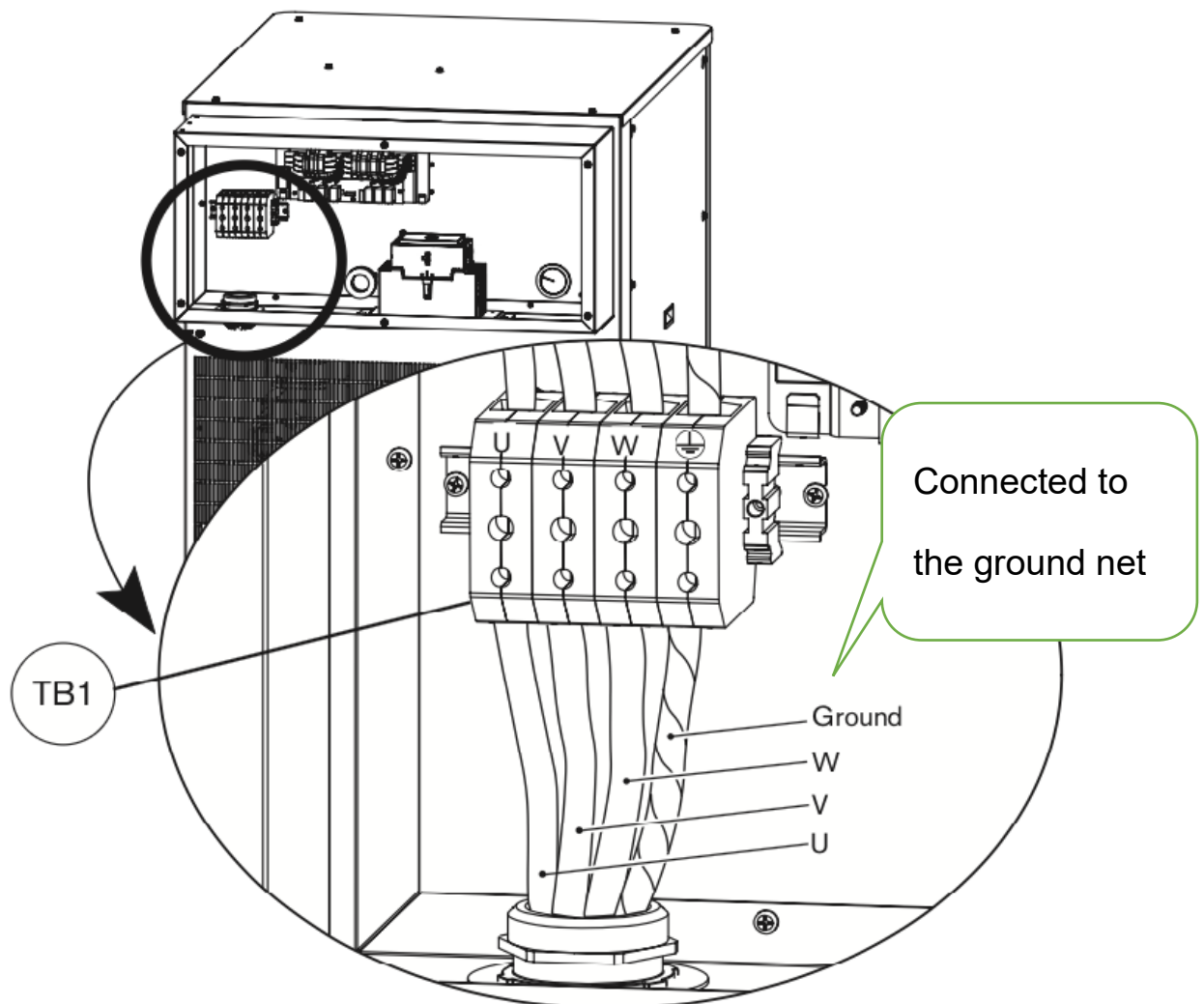
➔ A--Plasma power has 11 positions to be connected:

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- 1-- Grounding Cable and 2-- Power supply Cable; Schematic diagram of the connection:

Power supply Cable specification: 30 square 3 phase 4-wire;

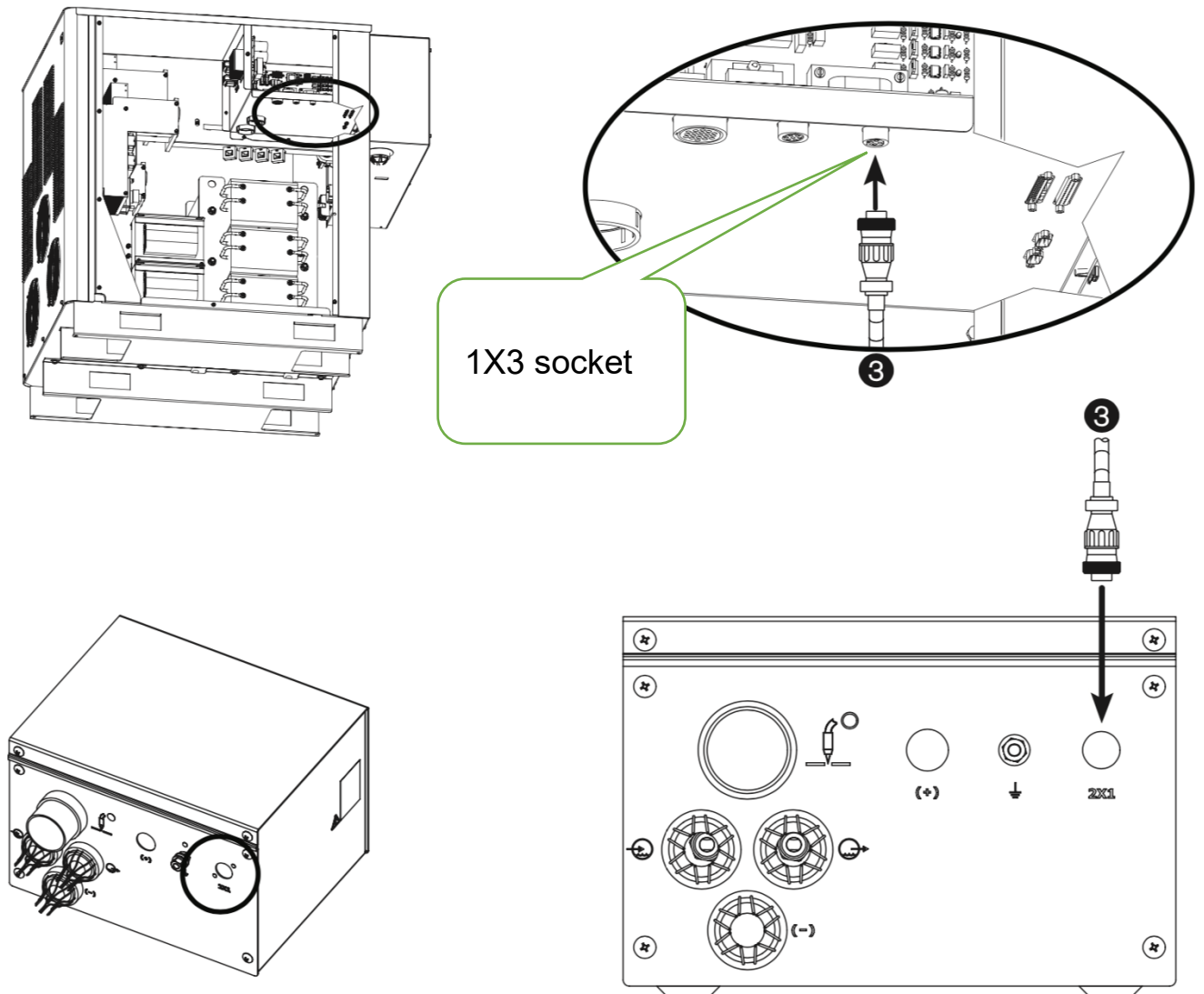
If the power supply is unstable, you need to add a manostat . The manostat is 80kw.



- 3--1X3 socket line : Ignition console power cable;

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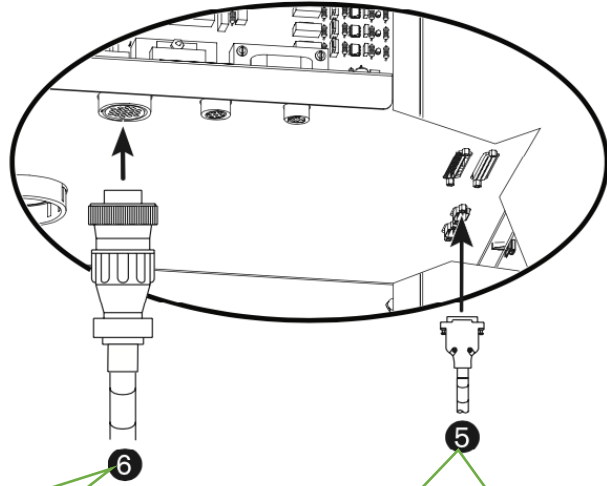
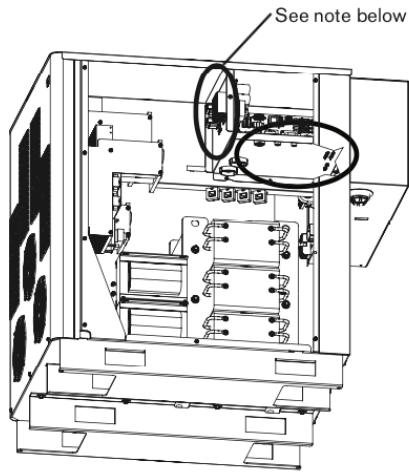
Schematic diagram of the connection:



- --Power supply to cooler cables

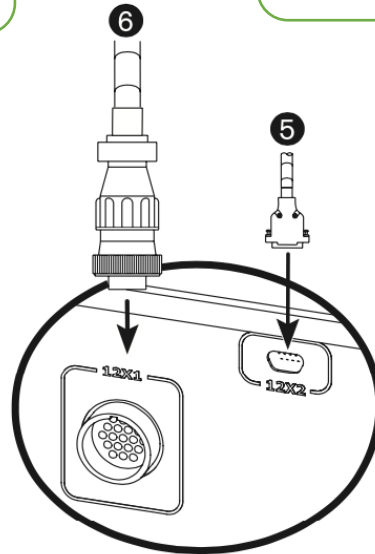
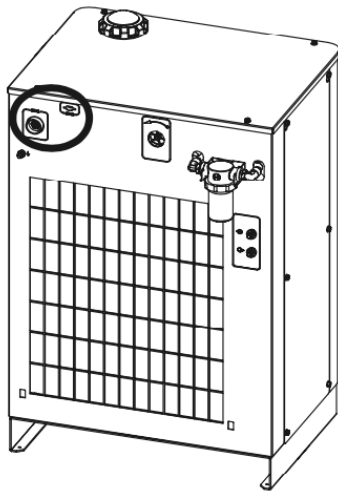
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4--Cooler power cable and 5--Cooler control cable

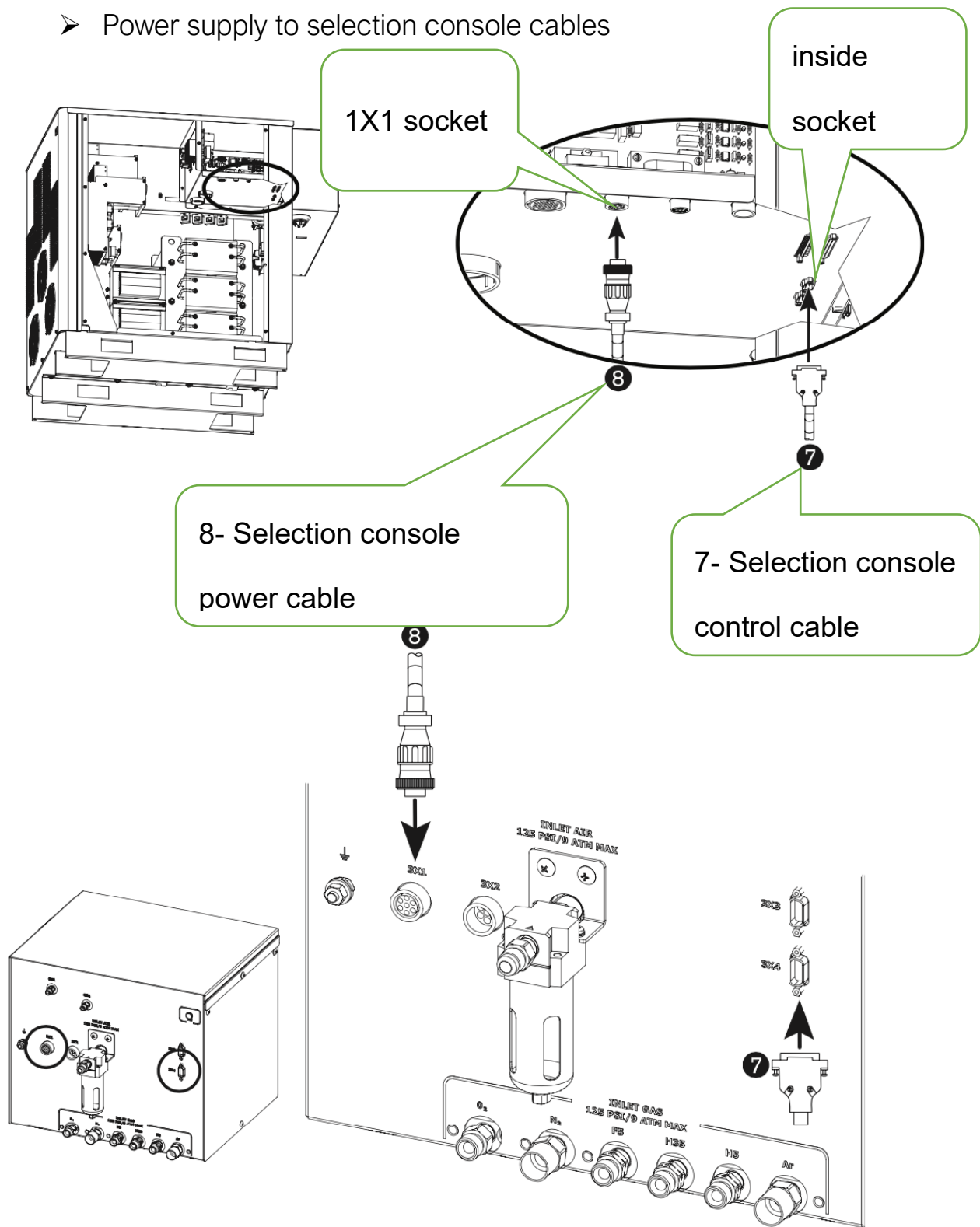


6- Cooler power
cable

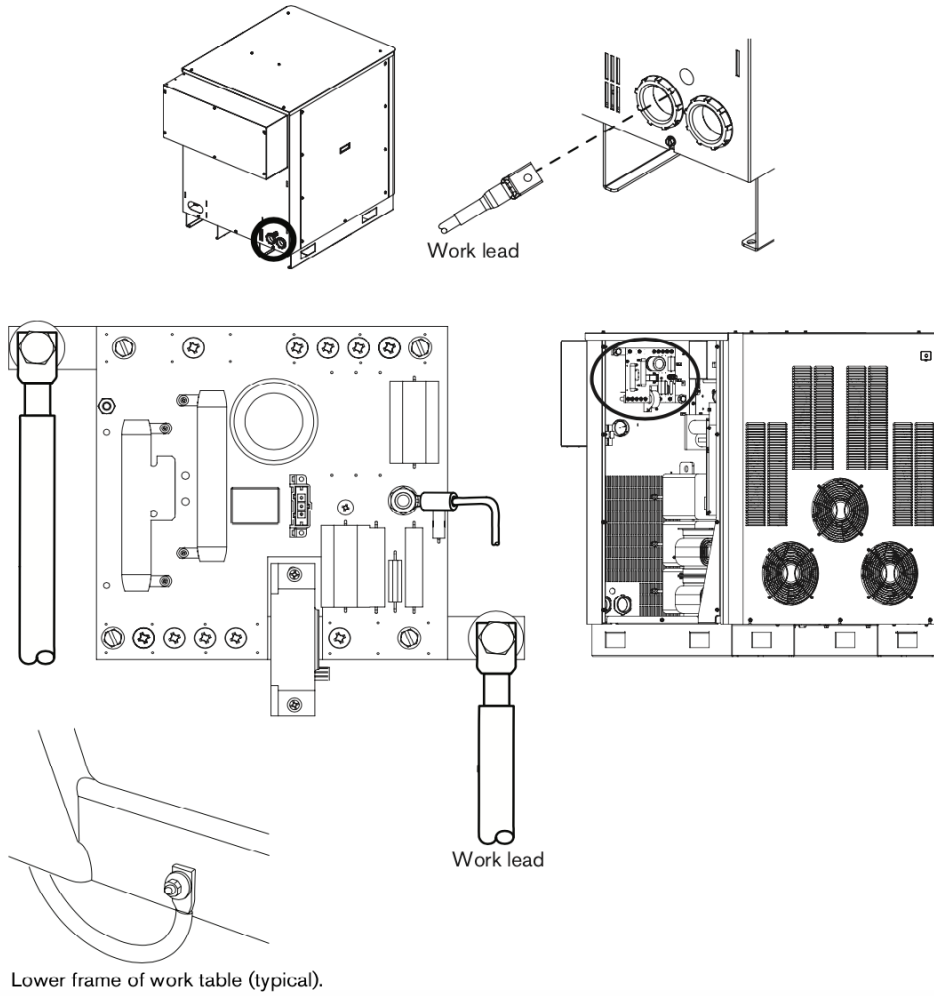
5- Cooler control
cable



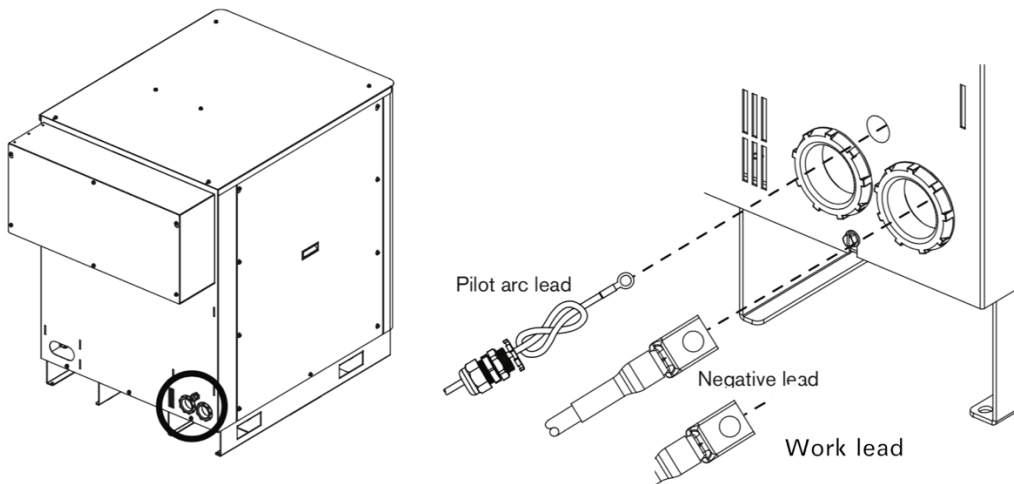
➤ Power supply to selection console cables



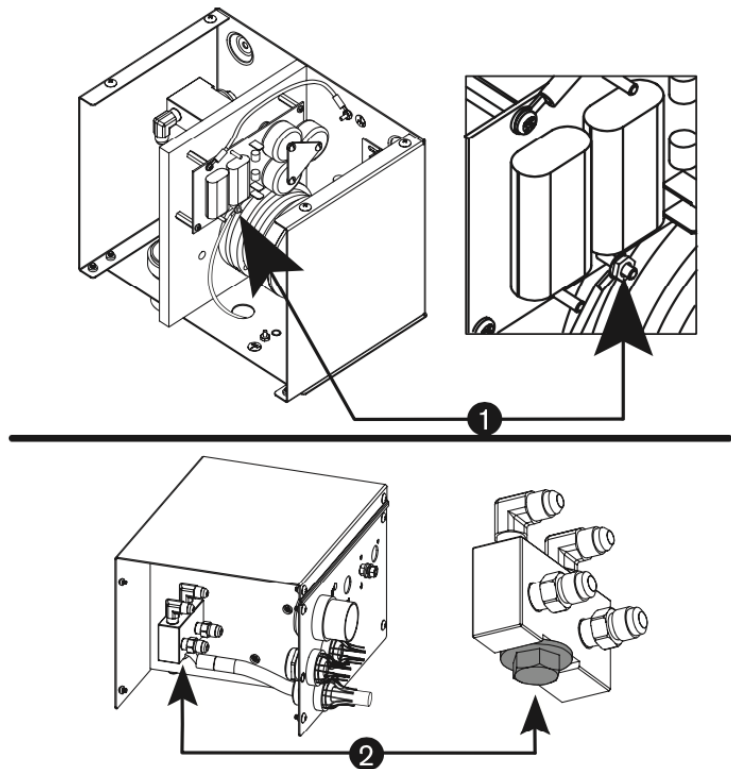
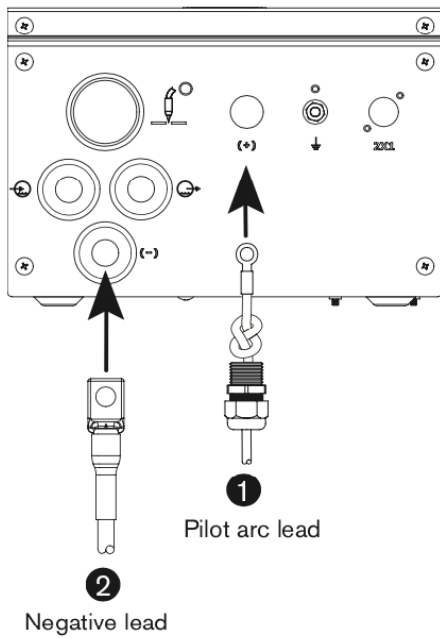
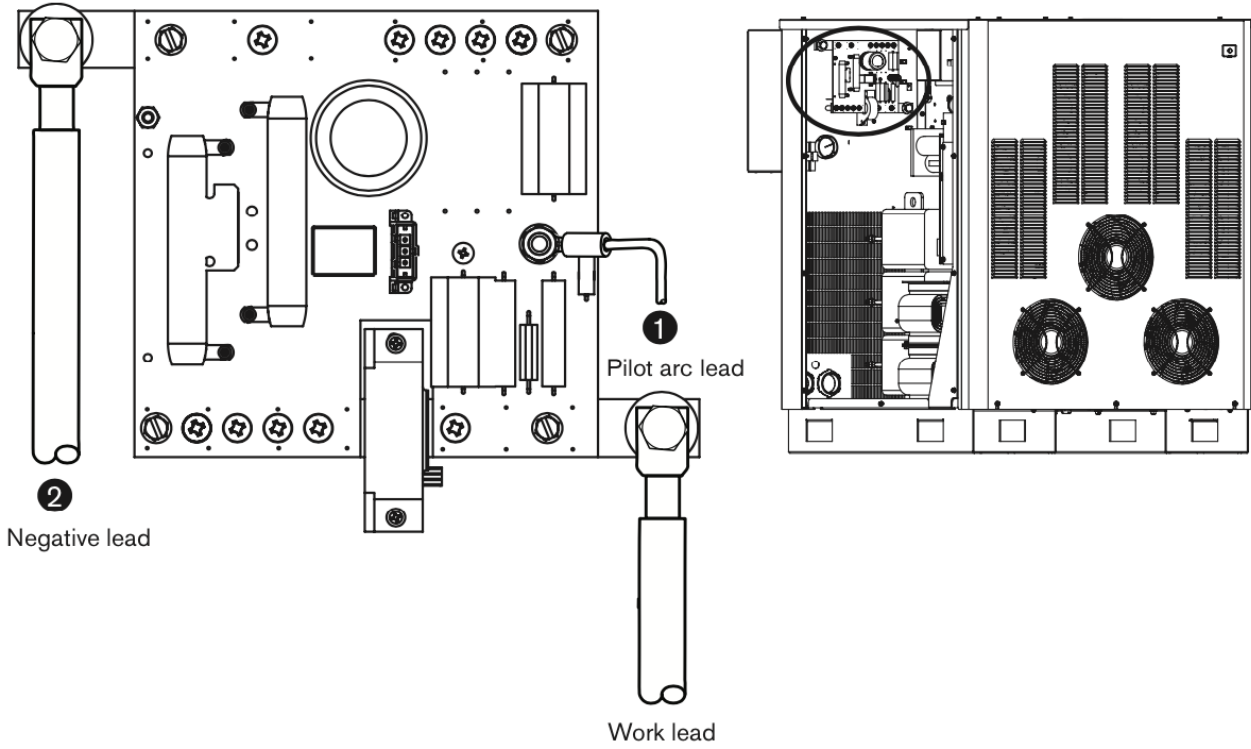
➤ 6—Work lead Schematic diagram of the connection:

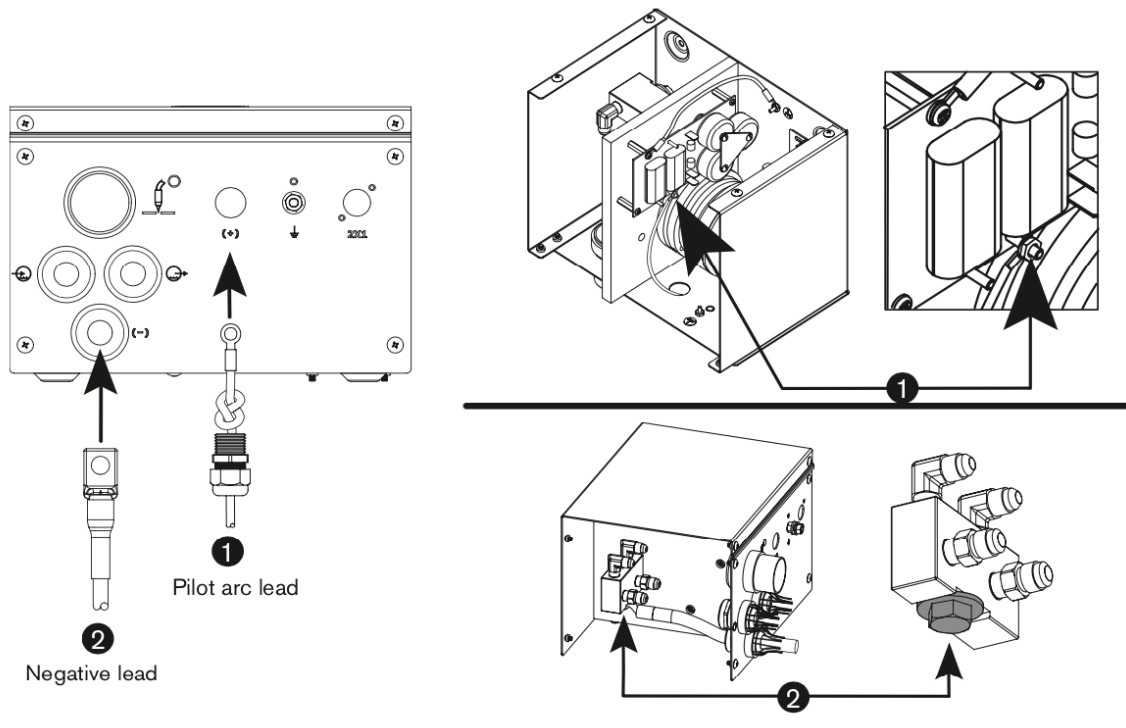
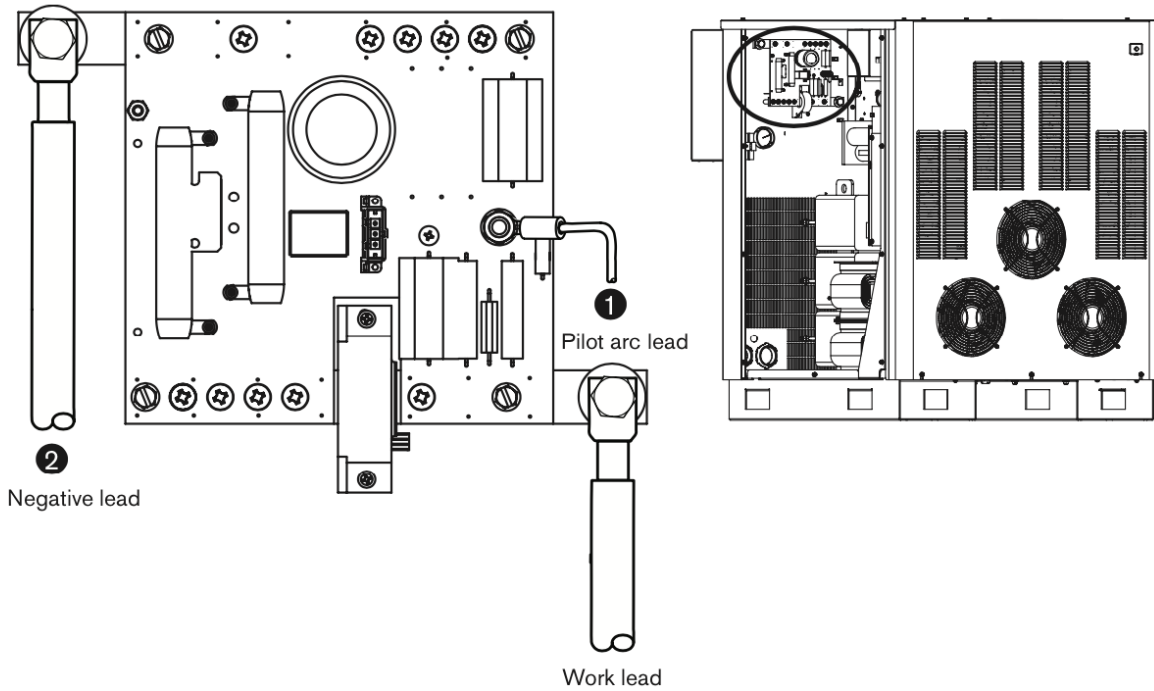


- 7--Negative lead and 8--Pilot arc lead; Schematic diagram of the connection:



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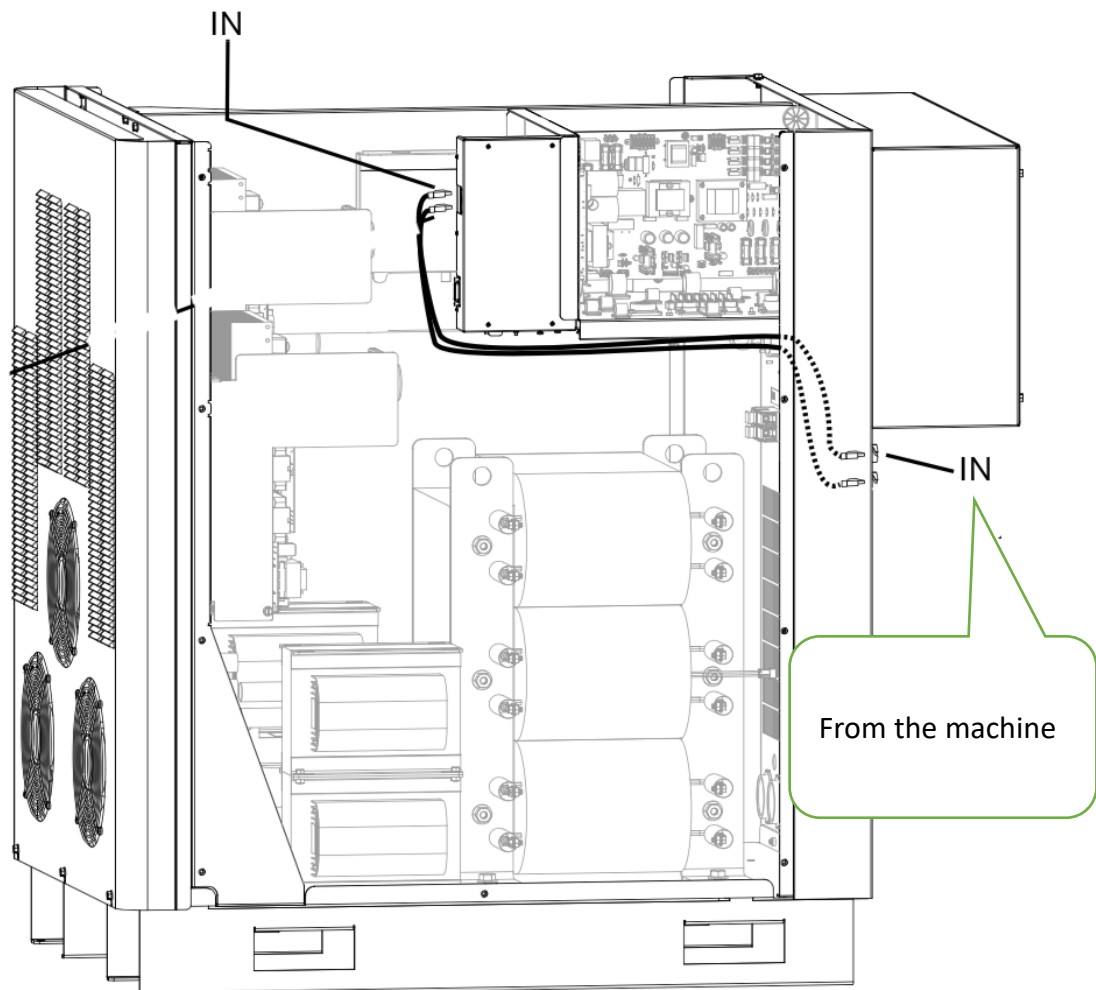




➤ Use 1 cable to connect IN on the HPR Ether-CAT plasma interface

board to the IN connector.

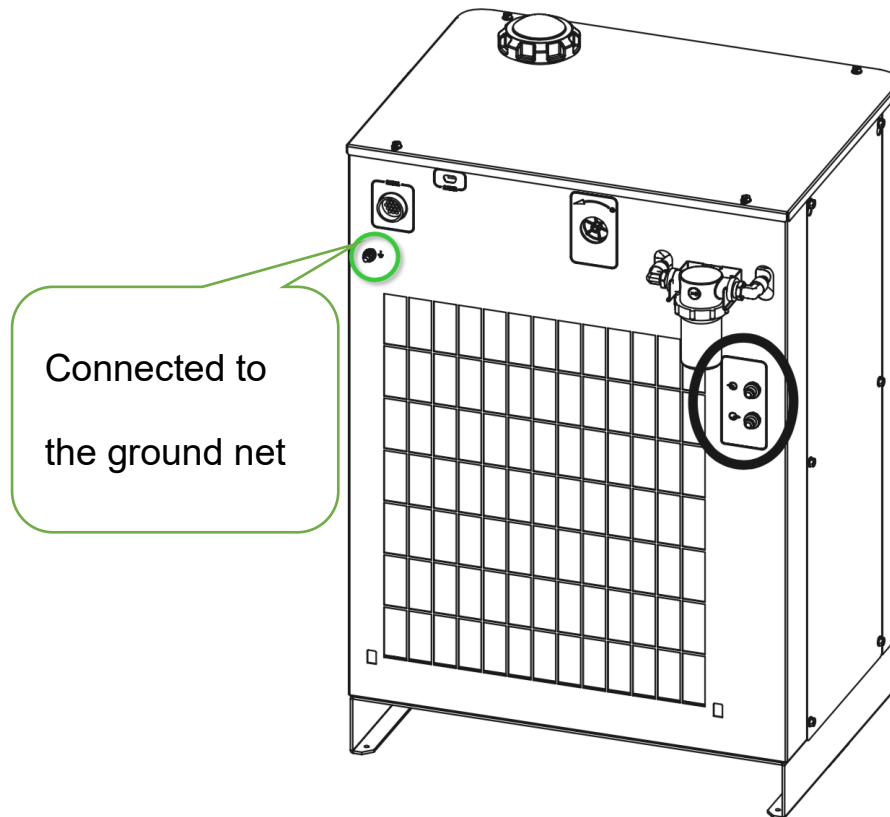
This is a network transmission line



➔ C--Cooler has 5 positions to be connected: 1, grounding wire; 2, 12X2

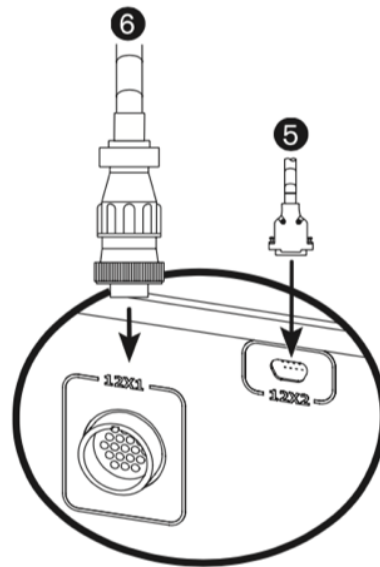
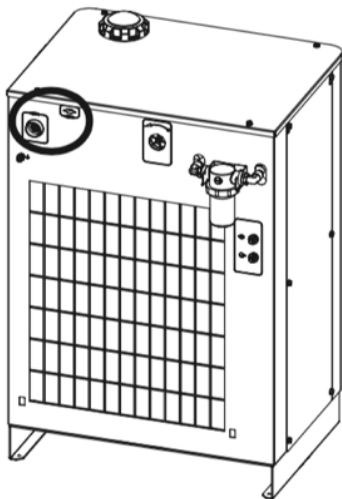
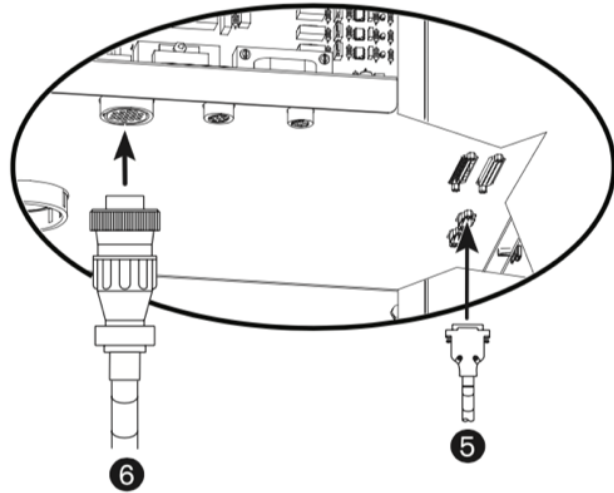
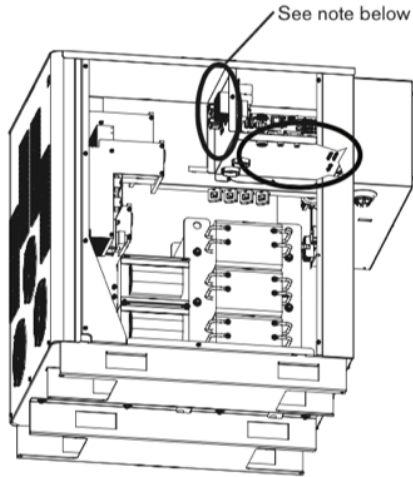
socket; 3, 12X1 socket; 4 and 5 water pipes;

- -- Grounding Cable Schematic diagram of the connection:



- --Cooler control cable : 12X2 Socket and-Cooler power cable :

12X1 Socket Schematic diagram of the connection:



Note: The inductor on the pump motor drive board makes a noise during operation that has been described as a "hum", "sing", and "click". This is normal and can be disregarded.

➤ --Coolant hoses Schematic diagram of the connection:

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④ Coolant hoses

Caution: Never use teflon tape on any joint preparation.

