

INSTALLATION

FLEXCUT 125 CE

SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE

INSTALLATION N° P07085710NG - P07085810NG



EDITION : EN
REVISION : D
DATE : 05-2021

Instructions for use

REF : **8695 4496**

Original instructions

LINCOLN[®]
ELECTRIC

Thank for the trust you have expressed by purchasing this equipment, which will give you full satisfaction if you follow its instructions for use and maintenance.

Its design, component specifications and workmanship comply with applicable European directives.

Please refer to the enclosed CE declaration to identify the directives applicable to it.

The manufacturer will not be held responsible where items not recommended by themselves are associated with this product.

For your safety, there follows a non-restrictive list of recommendations or requirements, many of which appear in the employment code.

Finally we would ask you kindly to inform your supplier of any error which you may find in this instruction manual.

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INFORMATIONS

For operating instructions, adjustments, troubleshooting and spare parts see safety instructions for use and maintenance

ISEE N°	ISUM
IM10375	FLEXCUT 125 CE Power Source
8695 4566	Tool Holder PO150D
8695 4568	Tool Holder THD

DISPLAYS AND PRESSURE GAUGES

The measuring devices or displays for voltage, current, speed, pressure, etc., whether analog or digital, should be considered as indicators

REVISIONS

REVISION B 02/19

DESIGNATION	PAGE
Creation in English language	

REVISION C 03/20

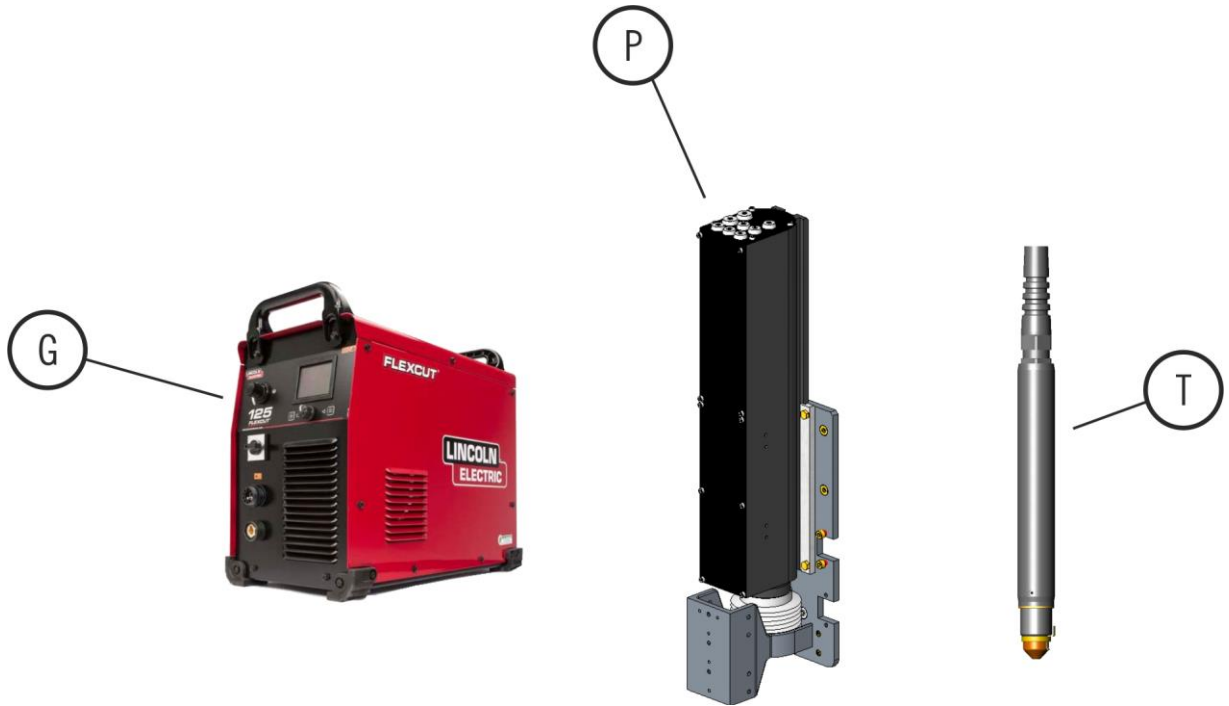
DESIGNATION	PAGE
Update	

REVISION D 05/21

DESIGNATION	PAGE
Addition of HPC III	

A - IDENTIFICATION

1 - FLEXCUT 125 CE INSTALLATION



Please note the serial number of your installation in the box below.
 This information will be required if you need to contact our after-sales service staff.
 Other locations have been provided for stating the references of each component of the installation

Object	Type	Serial no	Year manufactured
FLEXCUT 125 CE POWER SOURCE (G)			
TOOL HOLDER (P)			
TORCH LC125M (T)			

FLEXCUT 125 CE INSTALLATION	
REFERENCE	DESCRIPTION
T	Torch LC125M + torch bundle
G	FLEXCUT 125 CE power source
P	Tool-Holder PO150D Tool-Holder THD

2 - TOOL HOLDER

Please refer to the document:

- 86954566 => **PO150D**
- 86954568 => **THD**

3 - FLEXCUT 125 CE POWER SOURCE

Please refer to the document: IM10375.

4 - TORCH LC125M

Please refer to the document: IM10375.

5 - HMI FOR HPC INSTALLATION

Please refer to the document:

- 86954944 => **HPC DIGITAL PROCESS II**
- 86954995 => **HPC DIGITAL PROCESS III**

B - SAFETY INSTRUCTIONS

1 - GENERAL SAFETY INSTRUCTION



For general safety instructions, please refer to the specific manual supplied with the equipment: référence IM10375

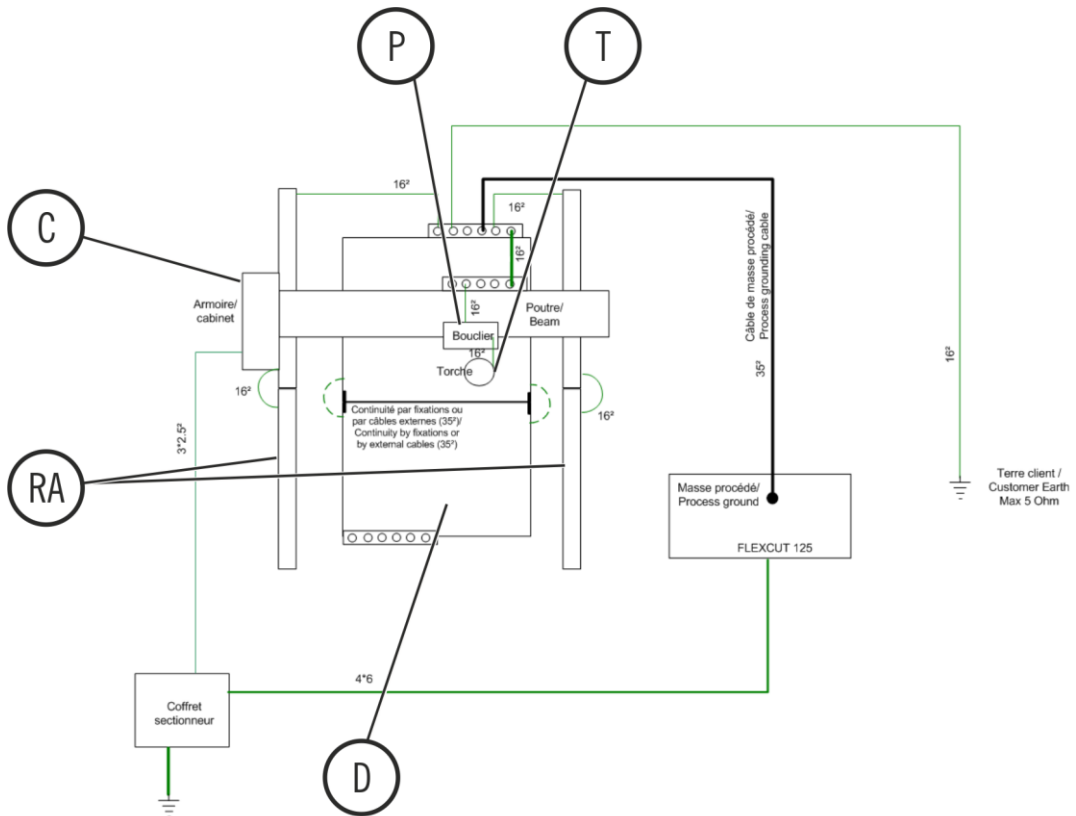
In the operating phase, and also in the adjustment phase, appropriate personal protection is required (see document IM10375 for more details).

Standard EN 169 requires the use of shade 10 dark glass for the intensities from this process.

2 - GROUNDING PRINCIPLE



In the event of electrical faults, in order to prevent all troubles on the FLEXCUT 125 CE installation, all metallic parts within the operator's reach must imperatively be linked to the ground.



MARKS			
B	Shield	P	Tool holder
C	Cycle function	RA	Rail
D	Cutting table		

3 - ELECTRICAL USER SAFETY



Before starting any work on the installation, make sure that the power source is switched off. Emergency stop does not turn off the power supply of the power source.

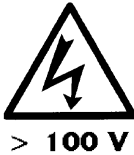
Plasma arc cutting imposes relatively high output voltages, in open circuit, to the equipment. It is thus necessary to take special precautions as regards the electrical supply of that equipment.



Check regularly the condition of power and ground connections

We remind you that the power supplies of **FLEXCUT 125 CE** and machine must be equipped with primary protection devices, i.e. manual locking and unlocking breakers or breakers activated when an electrical fault is detected. Emergency stop buttons are to be installed on the general locking circuit of all installations and placed on the machine receiving the cutting installation to allow its grounding from the operator's stand and from one or several points on the machine.

Turn off the power supply of the electrical cabinet doesn't turn off power supply of the power source.



A voltage over 100 V is present in the power source when in operation

4 - THERMAL HAZARDS



It is absolutely necessary to be protected from the risk of burns (direct contact)

Plasma cutting generates a large quantity of heat.
There is risk of burns at the torch and at the cut material.



It is absolutely necessary to be protected from the splatter of molten metals during cutting (indirect contact)

High-temperature metal splatter can be emitted during cutting.

5 - ELECTROMAGNETIC POLLUTION



It is indispensable to protect the eyes from arc radiation

The plasma arc, like all electric arcs, is a source of high intensity radiation ; the radiation emitted in the ultraviolet spectrum can damage eyes and skin. The operator must thus wear filtering glasses to prevent eye fatigue.

6 - GASEOUS POLLUTION



It is indispensable to be protected from the fumes produced during cutting

Plasma cutting provokes an emission of fumes (metallic vapours and oxides). In order to reduce their concentration near the operator, the cutting area must be ventilated. The installation is designed to operate with an appropriate extraction table (please call us for rating). Regularly check the effectiveness of the extraction. Standard EN ISO 17916 imposes a speed of 1m/s per torch at the table:



It is indispensable to regularly carry out preventive maintenance of the installation

The installation can sometimes be damaged (pierced hoses, leaking solenoid valves). That can lead to the uncontrolled discharge of gas. Fittings and pipes must be verified every month.

7 - SOUND POLLUTION



It is indispensable to protect the ears from the noise produced during cutting

Plasma arc cutting generates variable quantities of noise depending on the cutting conditions. It is to be noted that legislation allows noise emission of 80 dB (A) for 8 hours of exposure. In fact, the period of use of plasma cutting is often less (ISO R1996 and R1999).

8 - AIRBORNE NOISE

1 - MEASUREMENT SITE QUALIFICATION

The machine was tested in the workshop of Pont Sainte Maxence:

5 place Chatelier
60700 PONT SAINTE MAXENCE
FRANCE.

That qualification was the subject of Report n°17563386/1

2 - SOUND PRESSURE MEASUREMENTS

The values are given in equivalent weighted sound level (LAeq)

The unit of measurement is the dB (A) : weighted decibel "A"

The measurements were taken at a height of 1.6m above the ground with a sound-level meter, type FUSION, nbr 10925, checked in an accredited laboratory (LNE)

3 - MESURES

LC 125M	MEASUREMENT CONDITIONS	
	M1	M2
Current	85A	125 A
Materials	Mild steels: 8 mm	Mild steels: 20 mm
Gas	compressed air	compressed air

		Level LAeq dB(A)	Level LCpeak dB(C)	Level LAeq dB(A)	Level LCpeak dB(C)
Distance from measure point to torch	1 m	101,2	114,3	95,2	108
	2 m	96,2	109	90,6	103,6
	3 m	93,2	106,3	89	103,8
	4 m	90,8	103,8	85,9	98,6
	5 m	89,7	102,6	84,4	98,8

C - DESCRIPTION

1 - CAPACITIES OF THE FLEXCUT 125 CE INSTALLATION

This complete installation consists of a group of industrial equipment (power source, torch, control unit, tool holder, bundles...) especially designed to allow automatic thermal cutting by plasma jet.

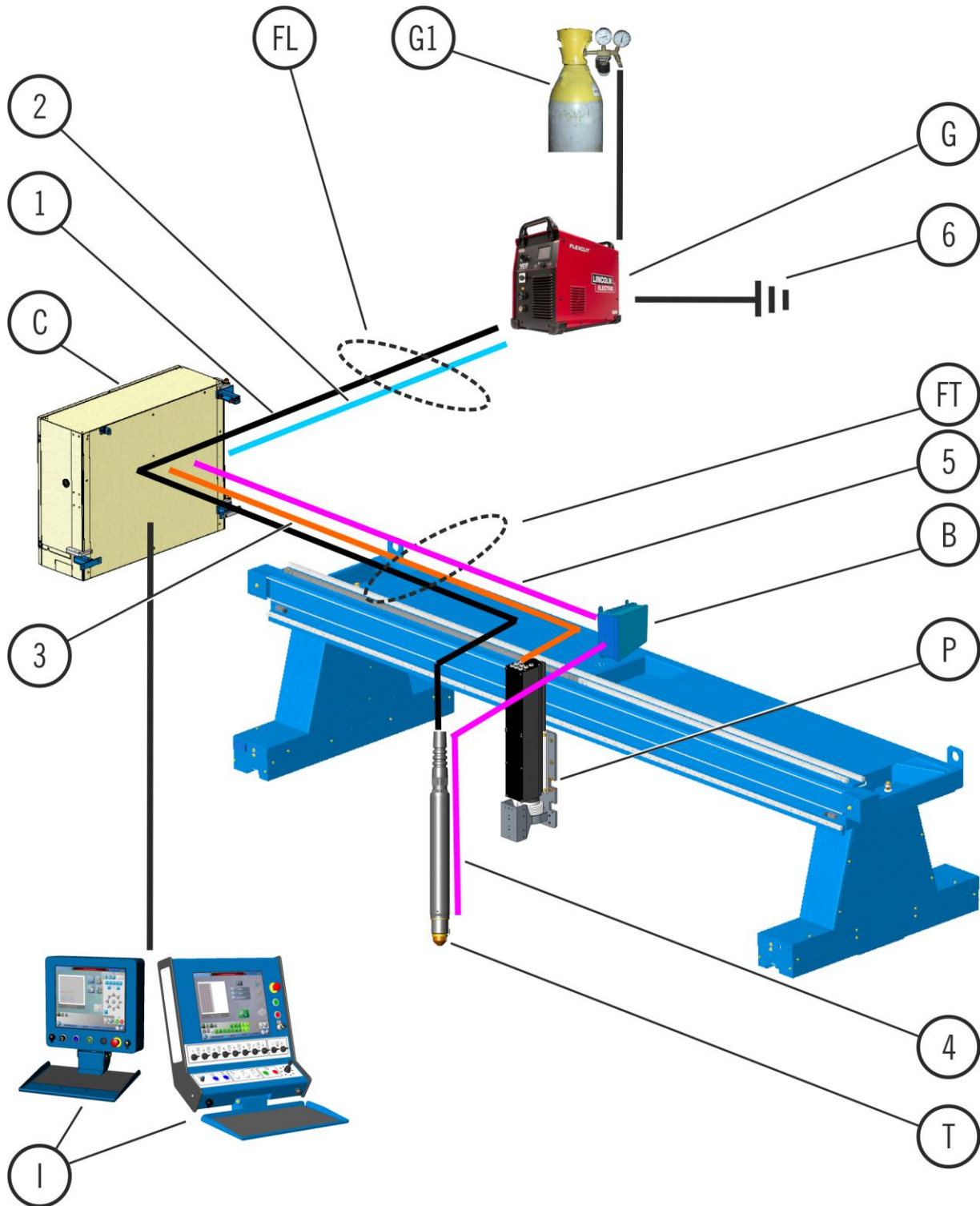
Thermal cutting using plasma jet is a cutting process by fusion and ejection of the molten metal by the plasmagene gas.

The installation is designed for cutting from 45A to 125A up to 30mm at middle sheet cutting start (40mm at sheet edge cutting start), mainly with steel, stainless steel or aluminium, using the following gases: air, nitrogen and argon-hydrogen. The installation can also do plasma markin from 12A up to 16A.

NOTE : The speed/quality ratio can be chosen according to the final use of the parts cut out.

2 - INTEGRATED INSTALLATION ON LINCOLN MACHINE

This installation may be used in an integrated manner on a machine supplied by us. The main functions are accessible by the NC that will steer the cutting processes via Ethernet. This installation can manage the plasma cutting function for a maximum of 2 torches.



FLEXCUT 125 CE INSTALLATION		
Mark	Designation	Reference
B	Detection cabinet	P07085608
C	Cycle function assembly	-
P	Tool Holder	See documentation
I	Programming interface	-
T	Torch LC125M + torch bundle	P07085711NG (15m) P07085712NG (22m)
G	FLEXCUT 125 CE power source	K4811-2
G1	Cutting gas (Air)	
FT	Transverse chain	
FL	Longitudinal chain	
1	Torch harness	P07085711NG (15m) P07085712NG (22m)
2	Power source / cycle control harness	P07085719
3	Motor bundles - TH motor moteur L = 10m - TH control bundle L = 10.5m - TH stepper encoder L = 13m	P07085106 P07085107 P07085108
4	Detection 1 bundle	P07085622
5	Detection 2 bundle	P070 5627
6	Power source earth / working place bundle, L=10 M : Power source earth / working place bundle, L=20 M : Power source earth / working place bundle, L=40 M :	P07085730NG P07085731NG P07085732NG

3 - DETECTION BOX

It is usually mounted on the beam of the thermal cutting machine. When choosing the location of this unit, make sure that the distance is compatible with the length of the detection cable.

CHARACTERISTICS :	
Reference:	P07085608
Dimensions:	131mm x 176mm x 65mm

4 - TOOL HOLDER AND TORCH IMPACT SAFETY

The functions of the tool holder are as follows:

- Management of the Z axis (vertical axis)
- Torch holding to prevent vibrations

The functions of the torch impact safety system are as follows:

- Indication of mechanical impacts on the torch
- Protection of the torch during mechanical impacts

The tool holder is usually mounted on the tool holder carriage (mobile part).

Space taken up by the equipment :

Please refer to the document:

- 8695 4566 => **PO150D**
- 8695 4568 => **THD**

5 - TORCH LC125M+ BUNDLE

The **FLEXCUT 125 CE** installation is designed to operate with the **LC125M** torch

The function of the torch is to diffuse gas and current so as to achieve high quality cutting

The torch is connected to the power source via its bundle. It is fixed to the machine via the torch impact safety system of the tool holder.

The torch is cooled by cutting air.

Space taken up by the equipment :

Please refer to the document: IM10375

6 - POWER SOURCE

The function of **FLEXCUT 125 CE** power source is to regulate the cutting current according to the required setpoints

The **FLEXCUT 125 CE** can deliver a maximum of 125A.

The power source is generally located close to the installation.

Space taken up by the equipment :

Please refer to the document: IM10375.

D - ASSEMBLY AND INSTALLATION

1 - CONDITIONS OF INSTALLATION

THE FOLLOWING CONDITIONS MUST BE COMPLIED WITH BEFORE INSTALLING THE EQUIPMENT



THE LAYOUT OF THE INSTALLATION MUST COMPLY WITH SAFETY STANDARD NF EN 547 -1 -3 TO ASSURE PERSONAL PROTECTION.

1.1 GAS SUPPLY

Provide the gas sources (cylinders, cylinder frames, evaporators etc.) below, each with a regulator that is capable of supplying the recommended flow rates and pressure values and a shut-off valve if the supply is through a pipe.



Never exceed the pressure value of 8 bars.


Starting up the gas sources



Please refer to section :
"6-2 CYLINDER CHANGE PROCEDURE"
in the safety booklet 8695 7050

Conditions for gas types

CUTTING GAS			
Fluids used	Purity type	Supply pressures of the installation (pressure reducing valve exit)	Fully flow rates used
CARBON STEEL			
Compressed air	ISO 8573-1:2010, Class 1.4.1	7.2 bar +/-1	260 l/mn
COMPRESSED AIR			
Compressed air	ISO 8573-1:2010, Class 1.4.1	7.2 bar +/-1	260 l/mn




* The quality of the compressed air has a significant effect on the cutting results.
 It must be filtered (5µm)
IT MUST BE DRY AND FREE OF OIL

Layout of cables and flexible pipes

The customer should provide the means for supporting and keeping away from mechanical, chemical, or thermal damage, the cables and flexible pipes from their source to the entry of the power source.

1.2 ELECTRICAL SUPPLY



In order to comply with European safety regulations, connection to the mains must be made using a wall box fitted with an individual disconnecting switch of suitable size according to the mains' voltage and to the consumption of the apparatuses.

This protective disconnecting switch will have to have a cutting capacity > 50kA.

We markets units meeting such requirements. Do not hesitate to contact us.

The operative power depends on the serviceable voltage used.

A cable of adequate section is to be provided to link the isolating switch to the power source.

Consumption of installation except power source

For installations integrated into LINCOLN ELECTRIC machines, refer to the machine instructions.

Consumption of FLEXCUT 125 CE power source

Alimentation 3 phases + terre	400 V
I eff (125A-175VDC)	40A
Fuse rating	40 A aM
Fuse rating	10*38
Power supply cable section	4*6 mm ²
Cable part number	PC5519035NG

The consumption values are stated for working with 125 A - 175 VDC for cutting

Sectioning box

3-phase power supply + ground		400 V
FLEXCUT 125 CE	Single torch	P06942318NG
	Dual torch	P06942322NG

Control console harness (with console on the floor)

The customer should ensure that all cables and flexible pipes between the machine and the control console inlet are protected from mechanical, chemical, and thermal damage.

1.3 OPERATING TEMPERATURE

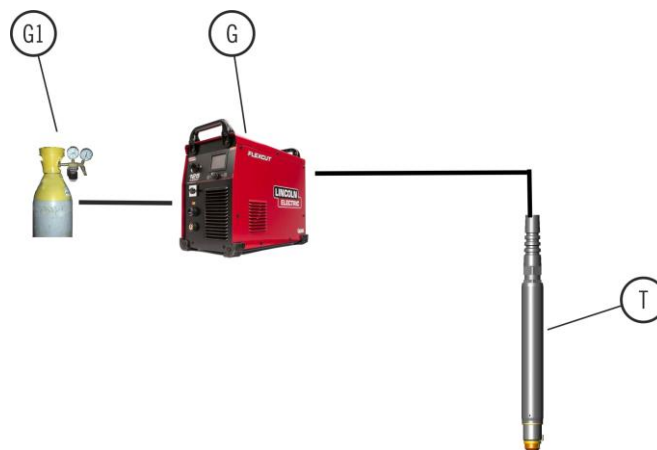
The optimum operating conditions range from 0°C to 40°C.

2 - INSTALLATION

Installation is carried out in the following order:

- placing and securing of each component of the installation
- connection of each component of the installation, starting with:
 - cycle function
 - the tool-holder
 - the detection cabinet
 - torch **LC125M**
 - the power source **FLEXCUT 125 CE**
 - air and power supply.

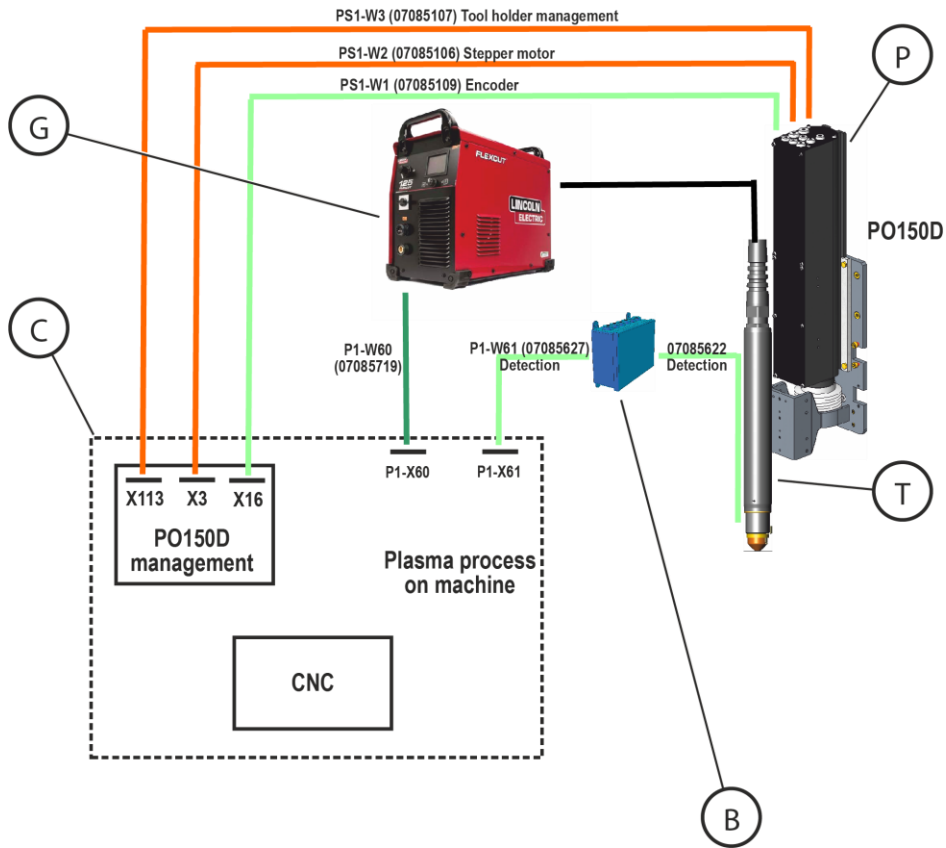
2.1 FLUID CONNECTIONS



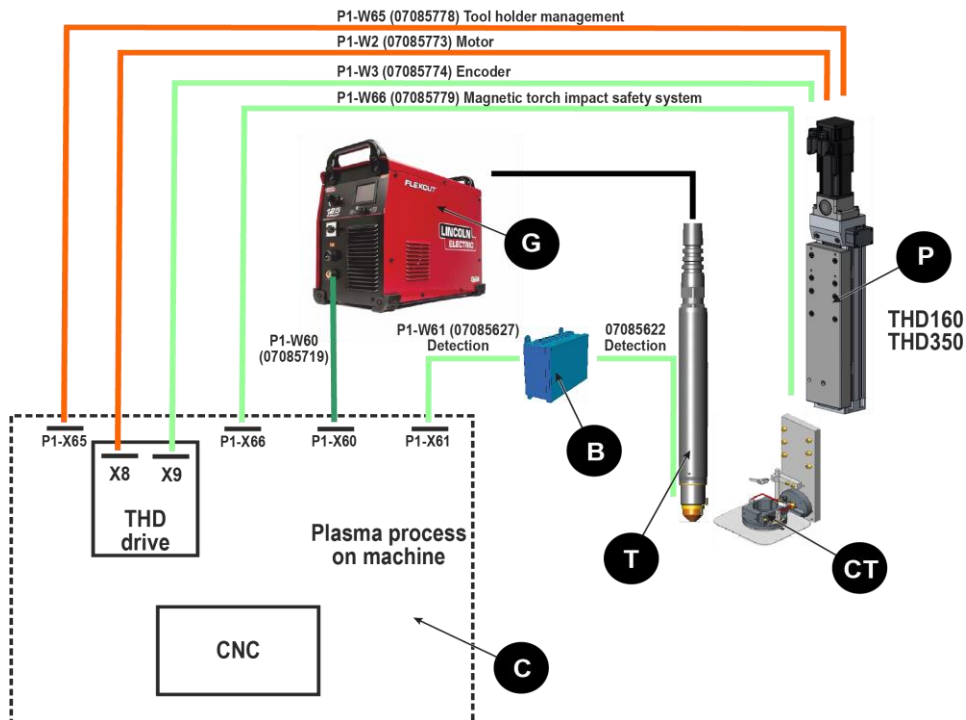
Mark	Designation
G	FLEXCUT 125 CE power source
G1	Cutting gas (Air)
T	Torch LC125M + torch bundle

2.2 ELECTRICAL CONNECTIONS

- With tool holder PO150D



- With tool holder THD



Mark	Designation
B	Detection box
C	Cycle function assembly
G	FLEXCUT 125 CE power source
P	Tool holder
T	Torch LC125M + torch bundle
CT	Magnetic torch impact safety system

3 - CYCLE FUNCTION INSTALLATION FOR INTEGRATED INSTALLATION

3.1 ASSEMBLY

The cycle function is mounted in the factory in the main cabinet

3.2 CONNECTIONS

The cycle function is connected in the factory in the main cabinet

4 - TOOL-HOLDER INSTALLATION

Please refer to the document:

- 8695 4566 => **PO150D**
- 8695 4568 => **THD**

5 - INSTALLING THE DETECTION BOX

5.1 ASSEMBLY

The box is fastened mechanically behind the tool-holder.



5.2 ELECTRICAL CONNECTIONS



J1 connector	Detection cable to torch - P07085622
J2 connector	Detection cable to cycle box - P07085627
J3 connector	Detection cable to cycle box - P07085627

6 - TORCH LEAD-BUNDLES INSTALLATION

Refer to document IM10375

7 - POWER SOURCE INSTALLATION

Place the power source near the chain end (see layout).

Connect the power source to a power supply and to a gas or air supply (see the power source's instructions in the present folder).

Connect the power source to the machine:

- Connect P1-W60 to the back of the power source
- Connect the torch harness to the front of the power source
- Connect the earth cable to the sheet metal holding table



Important: after connection, check there is no leak (water and gas) and that no pipe is bent

E - OPERATOR MANUAL

1 - OPERATOR CONTROLS

1.1 UI CONTROLS

All the user interface controls are available in the documentation 86954944 or 86954995, in the sections relating to **FLEXCUT 125 CE** installation

1.2 TORCH MOVEMENT CONTROLS

At any time (except if there is a fault or if the torch is not selected), the height of each torch can be modified in slow speed. To do so, use the buttons in UI.

Available in the documentation :

- 86954944 => **HPC DIGITAL PROCESS II**
- 86954995 => **HPC DIGITAL PROCESS III**,

in sections addressing installation **FLEXCUT 125 CE**.

2 - ADJUSTMENTS

2.1 PROCESS PARAMETER ADJUSTMENT

Process parameters can be adjusted from the UI. See the documentation 86954944 or 86954995, in the sections relating to **FLEXCUT 125 CE** installation

The part program particularities (size and location of striking, cutting quality etc.) also influence cutting quality. The post-processor must comply with the recommendations of **LINCOLN ELECTRIC**.

The gas pressure values are to be adjusted on the power source (See the documentation IM10375)

2.2 TOOL HOLDER HEIGHT

See specific documentation of tool holder

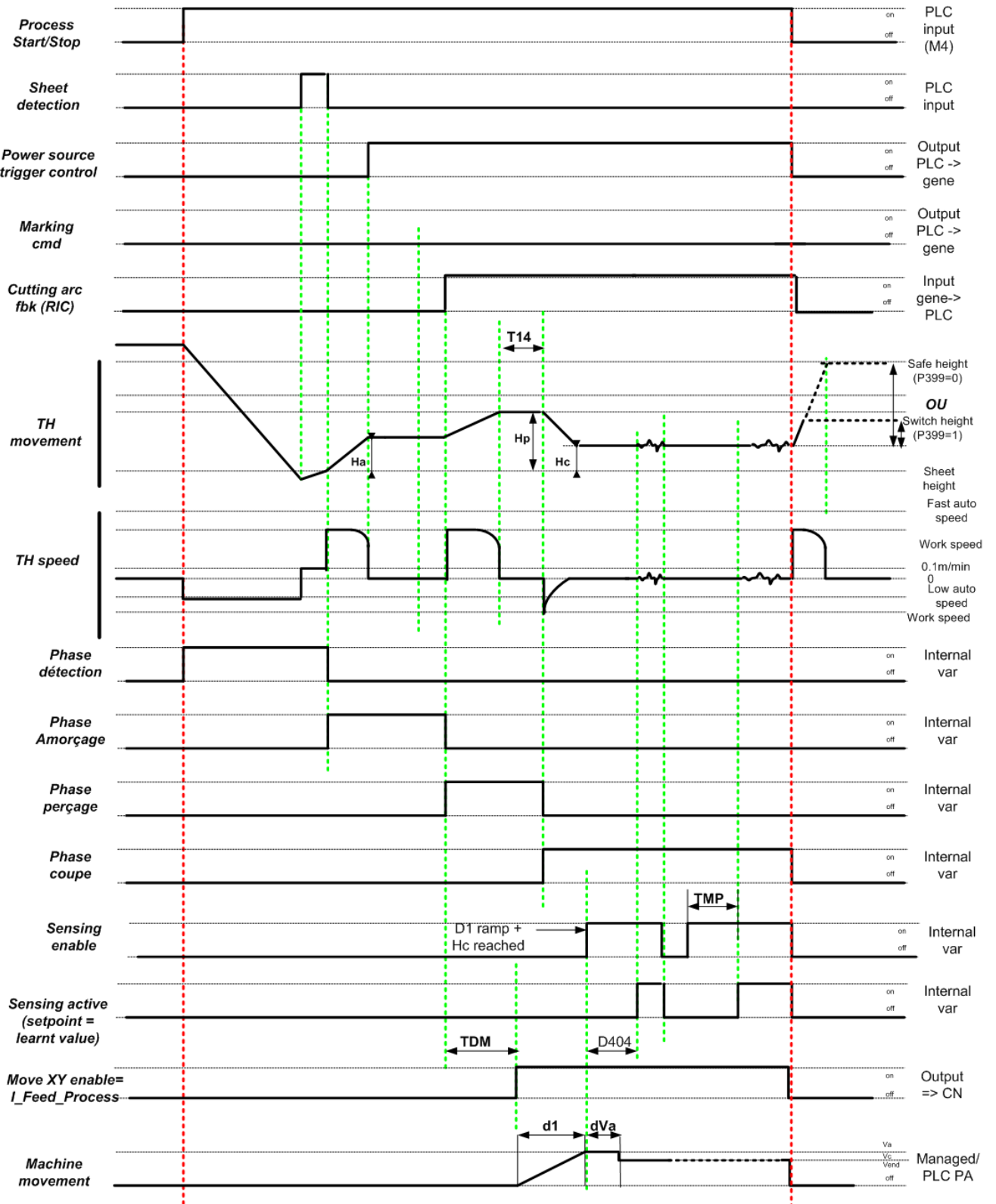
3 - GAS SUPPLY CHANGE

When the gas supply is changed (cylinder change, for example), we recommend the following:

- Shut the cylinder to change
- Carry out a gas test on the power source till the fault appears
- Press the emergency stop button
- Change the cylinder in accordance with the supplier's recommendations.
- Check that there is no dust or pollution
- Check that there is no leak after each cylinder change.

4 - CYCLES

Plasma cutting auto cycle and sensing with learnt value, unknown height



TDM = Start movement timer
 T14 = Retract height remaining timer
 dVa : Distance to activate lead-in speed
 D1 = Distance for acceleration on lead-in
 D404 = Distance before learning voltage

Ha = Arcing height
 Hp = Retract height
 Hc = Cutting height
 TMP : Timer before sensing

F - MAINTENANCE

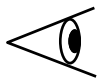
1 - SERVICING

- So that the machine continues to provide good service for as long as possible, a certain minimum of care and maintenance is necessary
- The frequency of this maintenance work is given on the basis of the production of one work station per day. Maintenance should be more frequent if production is greater.
- For the maintenance of the **FLEXCUT 125 CE** power source, please refer to instructions IM10375.
- For the maintenance of the tool holder **PO150D**, please refer to instructions 8695 4566.
- For the maintenance of the tool holder **THD**, please refer to instructions 8695 45686

Your maintenance department may photocopy these pages so that it can follow up maintenance dates and operations (tick as appropriate)

Monthly

Date of maintenance : / /



- Check that the gas circuit operates properly: pressure gauge, pressure regulator, electrovalve, valve, couplings, etc.
Note : any piping showing the slightest signs of fatigue, wear, damage, should be replaced by a standard identical pipe.

- Check the condition of all the electrical cables, especially near the torches and in the cable support chain (change them if required). Check that electrical wires are tightened.

2 - TROUBLESHOOTING

2.1 Electrical problems



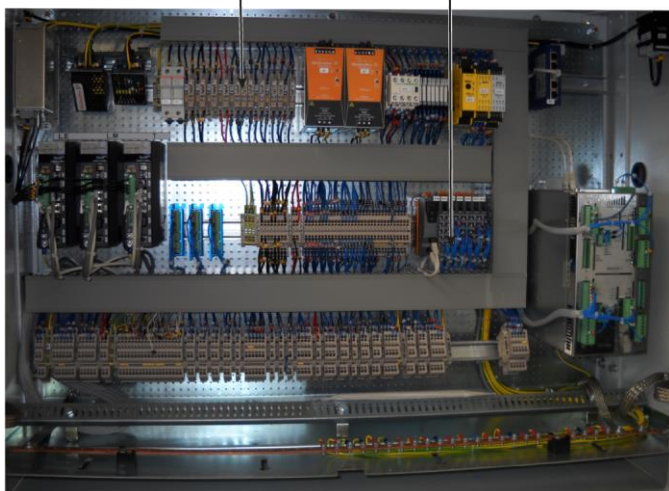
Reminder: all work is to be carried out by approved and trained personnel

If any fault occurs in the plasma cutting equipment due to an electrical problem, first check the fuses. Before opening the manifold box, switch the machine off. Using the emergency stop does not mean that there is no voltage in the box.

HPC DIGITAL PROCESS II

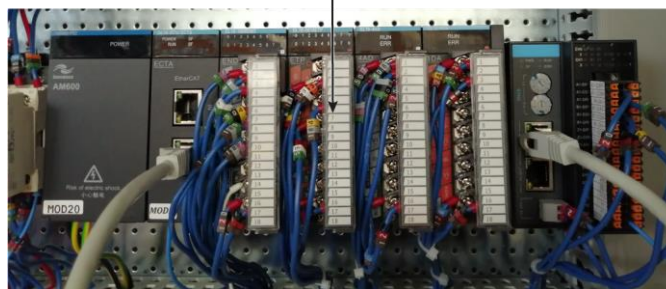
E1

E2



HPC DIGITAL PROCESS III

E2



The fuses « **E1** » :

F17 powers the motors of the tool holders (description: FUSE 5X20 5A 250V FSF)

(F15 to F18) switch off the 24V power to the remainder of the process. (Description: FUSE 5X20 5A 250V FSF)

While troubleshooting, the technician may ask you to check the status of the indicators on the PLC « **E2** », and also those on each of the solenoid valves, which have an indicator that goes on when the valve supply is on.

On the PLC, faulty inputs/outputs are red.

2.2 Explanation of alarms: overall process fault

These faults are common to plasma and oxycutting

Alarm	Probable causes	Possible remedies
3 : Loss of communication with the PLC	Communication between the UI and the NC PLC has been interrupted for 10 seconds (watchdog)	Check proper Ethernet addressing and reset communication
1001 : The emergency stop is active!	The process cannot start without switching on the power to the machine	Remove the cause of the emergency stop and switch the power back on
01011 = Cycle stop for Head Collision. Jog in limited speed	Probe impact (oxycutting) or torch impact (plasma)	Correct the fault, raise the tool holder and clear the alarm

2.3 Explanation of alarms : plasma FLEXCUT 125 CE

The alarms indicating **FLEXCUT 125 CE** plasma process faults are indicated on the UI.

Alarm	Probable causes	Possible remedies
1071: No operating feedback from the filter	The filter has been activated, but the feedback indicating that it is working properly is not correct.	Check that the extraction system is being powered.
01254 = Plasma 1 electrode/workpiece voltage fault	The voltage between the electrode and the workpiece has risen too fast. Often due to an arc break.	Put the plasma back on the plate and restart cutting.
01255 = Plasma 2 electrode/workpiece voltage fault	The voltage between the electrode and the workpiece has risen too fast. Often due to an arc break.	Put the plasma back on the plate and restart cutting.
01262 = Upper limit switch fault and plasma TH being regulated	One of the upper limit switches of a torch that is being regulated is active.	Mechanically raise the tool holder so that it can cut higher
01263 = Plasma TH in low position fault	One of the lower limit switches of the torch is active	Correct the fault, raise the tool holder and clear the alarm
01264 = Cutting start fault or power source 1 off	A pilot arc request has been made, but the arc has not been transferred on sheet	Switch on the power source or change the consumables or decrease the transfer height.
01265 = Cutting start fault or power source 2 off	A pilot arc request has been made, but the arc has not been transferred on sheet	Switch on the power source or change the consumables or decrease the transfer height.
01268 = Voltage fault plasma 1	Slag inside the external cap	Check the spare parts, or select a bigger amperage (aluminum), or disconnect the detection cable to make a mechanical detection
01269 = Voltage fault plasma 2	Slag inside the external cap	Check the spare parts, or select a bigger amperage (aluminum), or disconnect the detection cable to make a mechanical detection
01272 = Arc interrupted plasma 1	The arc has disappeared during cutting	Reposition the program on the sheet or restart program.
01273 = Arc interrupted plasma 2	The arc has disappeared during cutting	Reposition the program on the sheet or restart program.

2.4 Other faults

Fault	Probable causes	Possible remedies
The tool-holder does not move	The torch has not been selected Lower limit switch (UI alarm) Probe impact (UI alarm) Upper limit switch (no alarm)	Select the torch manually Correct the fault and set the tool holder position if required. Correct the fault and clear the alarm Correct the fault and set the tool holder position if required.
Two torches cannot be selected	The two torches are not identical (type)	Select two identical torches
Cutting cannot be started	Lack of extraction or ineffective extraction	Start/clean the extraction before cutting
Cutting is not correct	Several possible causes.	Refer to the process training manual
Incorrect cutting height	The tool holder speed offset has not been set. The plate is not on fixed supports	Set the speed offset of the variable speed drive Reposition the plate or change the detection method (using pilot arc)

3 - TOOL HOLDER MAINTENANCE

Please refer to the document:

- 8695 4566 => **PO150D**
- 8695 4568 => **THD**

4 - FLEXCUT 125 CE POWER SOURCE MAINTENANCE

Please refer to the document : IM10375.

5 - TORCH LC125M MAINTENANCE

Please refer to the document : IM10375.

6 - SPARE PARTS

How to order

The photos or sketches identify nearly every part in a machine or an installation

The descriptive tables include 3 kinds of items:

- those normally held in stock: ✓
- articles not held in stock: ✗
- those available on request: no marks

(For these, we recommend that you send us a copy of the page with the list of parts duly completed. Please specify in the Order column the number of parts desired and indicate the type and the serial number of your equipment.)


For items noted on the photos or sketches but not in the tables, send a copy of the page concerned, highlighting the particular mark.

For example:

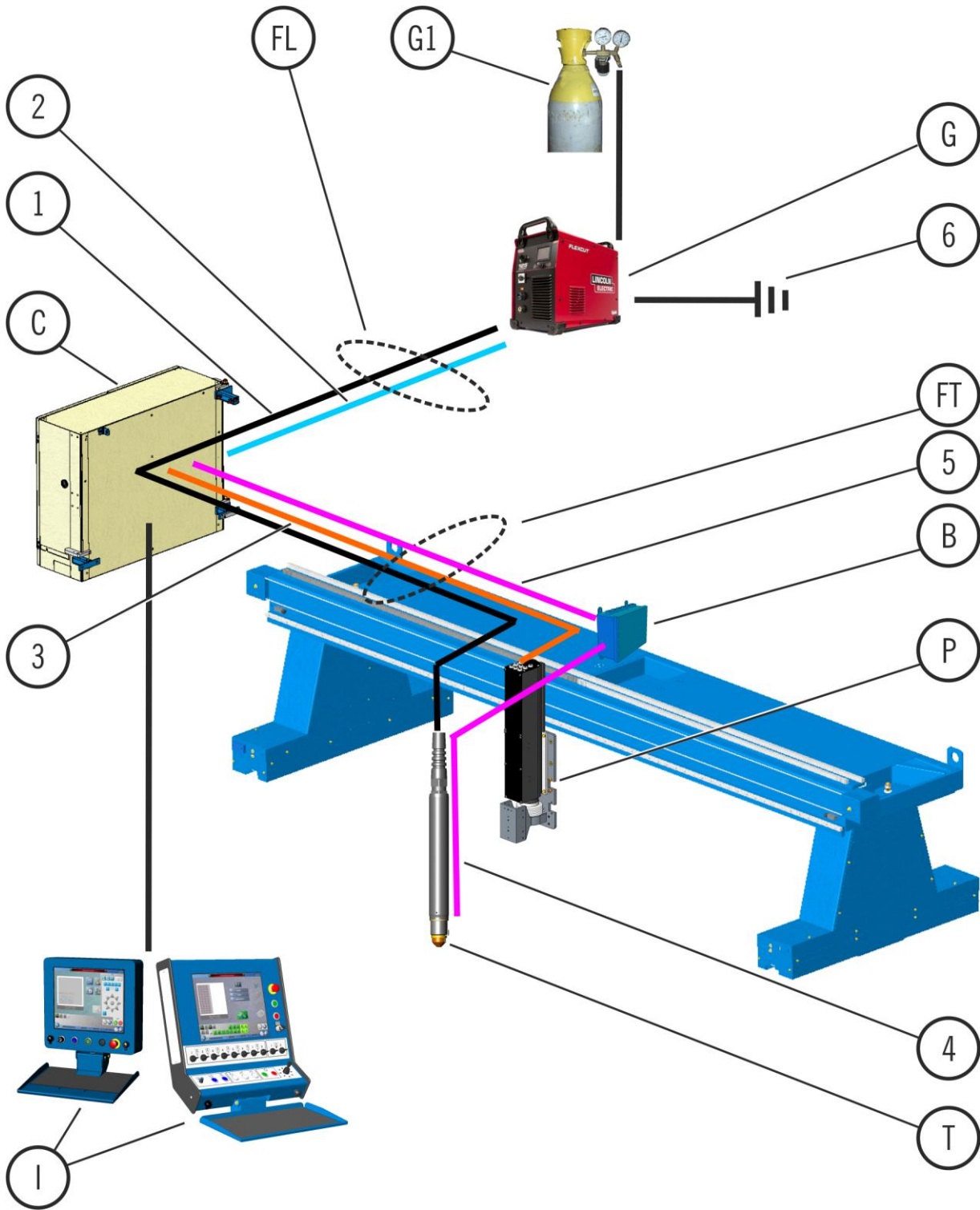
Item	Ref.	Stock	Order	Designation
E1	W000XXXXXX	✓		Machine interface board
G2	W000XXXXXX	✗		Flowmeter
A3	9357 XXXX			Silk-screen printed front panel

✓	normally in stock
✗	not in stock
	on request

- For parts order, give the quantity required and put the number of your machine in the box below.

 Type <input type="text"/> Matricule <input type="text"/>	TYPE :
	Number :


6.1 MAIN PARTS



Item	Ref.	Stock	Order	Designation
B	P07085608			Detection box
C				Cycle function assembly
T	K4300-5	X		Torch LC125M + torch bundle (15m)
T	K4300-6	X		Torch LC125M + torch bundle (22m)
G	K4811-2	✓		FLEXCUT 125 CE power source
P	P07085025			Tool holder PO150D
	AS-CS-070554360	✓		Tool holder THD 160
	AS-CS-070554370	✓		Tool holder THD 350

✓	normally in stock
X	not in stock
	on request

➤ For parts order, give the quantity required and put the number of your machine in the box below.

 Type <input type="text"/> Matricule <input type="text"/>	TYPE :
	Number :


6.2 DETECTION BOX



Item	Ref.	Stock	Order	Designation
E6	W000276961	X		Detection board

✓	normally in stock
X	not in stock
	on request

➤ For parts order, give the quantity required and put the number of your machine in the box below.

 Type <input type="text"/> Matricule <input type="text"/>	TYPE :
	Number :

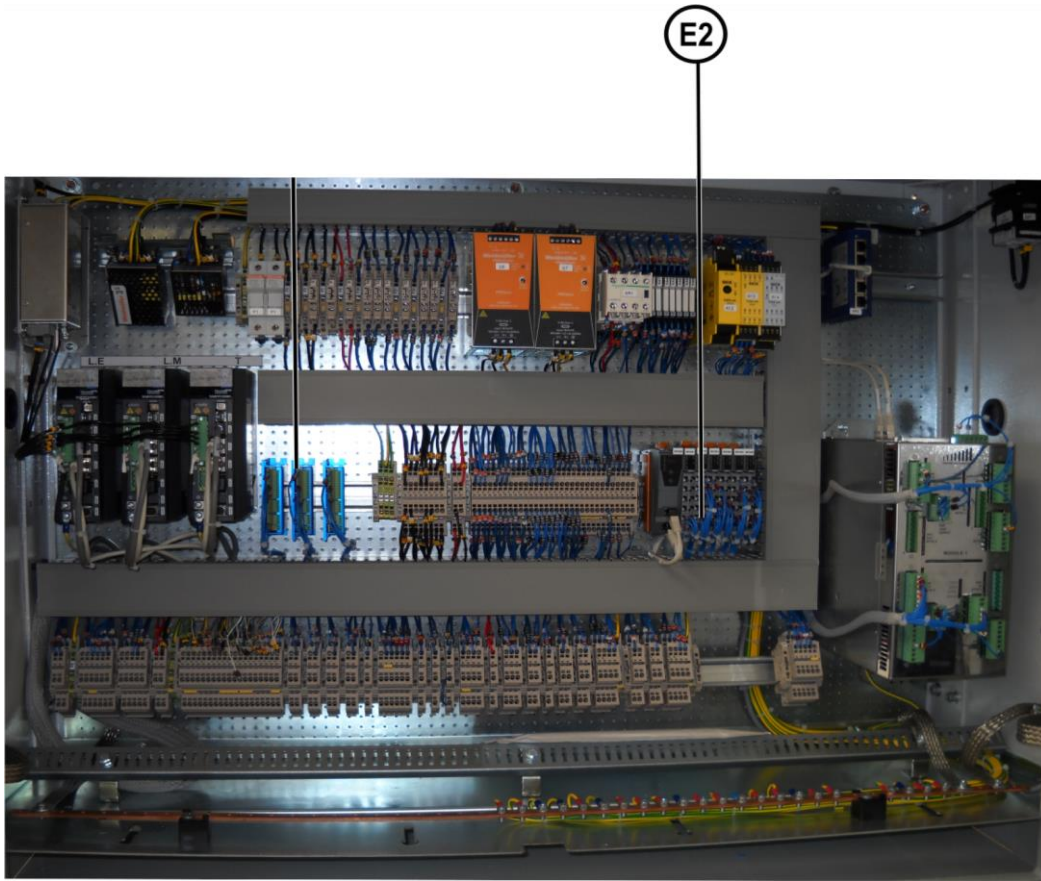
6.3 TOOL HOLDER PO150D ASSEMBLY

Please refer to the document : 8695 4566.

6.4 TOOL HOLDER THD ASSEMBLY

Please refer to the document : 8695 4568.

6.5 PROCESS AND TOOL HOLDER CONTROL SYSTEM IN MAIN CABINET



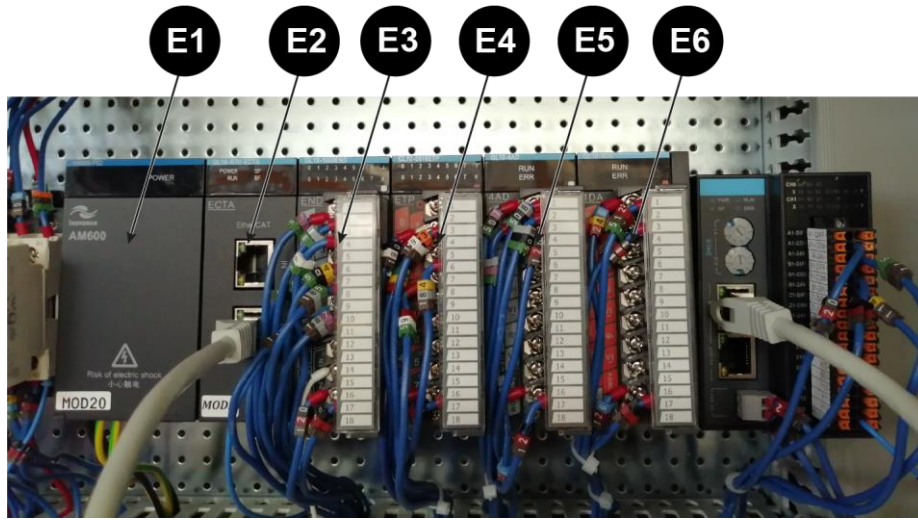
✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
E2	W000400412	✗		X20BC00G3 Ethercat coupler module
	W000400413	✗		X20PS9400 power supply module
	W000400414	✗		X20CM8281 input/output module
	W000383711	✗		X20BB80 back panel
	W000383702	✗		X20BM11 back panel
	W000383703	✗		X20TB12 terminal block

➤ For parts order, give the quantity required and put the number of your machine in the box below.

CE Type <input type="text"/> Matricule <input type="text"/>	TYPE :
	Number :

6.6 HPCIII PROCESS CONTROL ASSEMBLY (MAIN CABINET)



✓	normally in stock
✗	not in stock
	on request

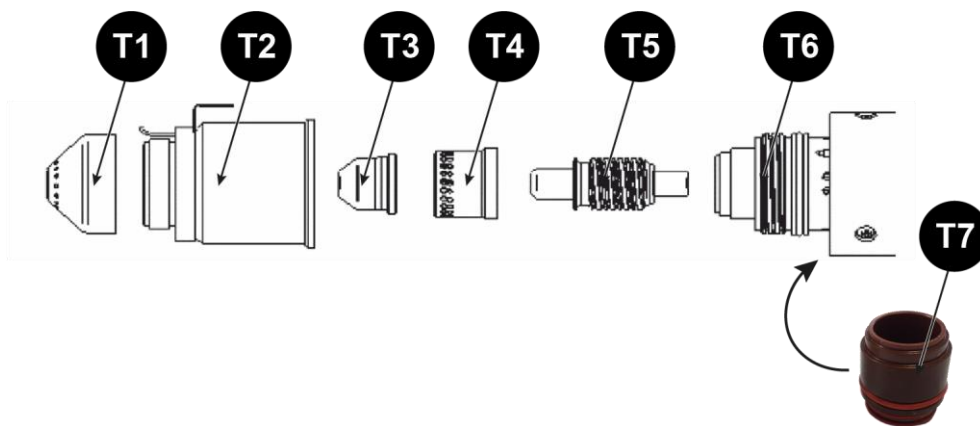
Item	Ref.	Stock	Order	Designation
E1	AS-CS-C5703329	✓		GL10 power supply module
E2	AS-CS-C5703330	✓		GL10 EtherCAT module
E3	AS-CS-C5703324	✓		GL10 16 digital inputs module
E4	AS-CS-C5703325	✓		GL10 16 digital outputs module
E5	AS-CS-C5703326	✓		GL10 4 analogue inputs module
E6	AS-CS-C5703327	✓		GL10 4 analogue outputs module

➤ For parts order, give the quantity required and put the number of your machine in the box below.

	TYPE :
	Number :

Important: the input/output modules are powered with 230VAC.

6.7 TORCH LC125M WEAR PARTS



✓	normally in stock
✗	not in stock
	on request.

Item	Ref.	Stock	Order	Designation
T1	BK14300-3	✓		Shield cap 45A65A LC125M
	BK14300-4	✓		Shield cap 85A125A LC125M
T2	BK14300-15	✓		Retaining cap CTP 45A 125A LC125M
T3	BK14300-7	✓		Nozzle 45A LC125M
	BK14300-8	✓		Nozzle 65A LC125M
	BK14300-9	✓		Nozzle 85A LC125M
	BK14300-10	✓		Nozzle 105A LC125M
	BK14300-11	✓		Nozzle 125A LC125M
T4	BK14300-13	✓		Swirl Ring 45A125A LC125M
T5	BK14300-1	✓		Electrod 45A125A LC125M
T6	K4300-5	✓		Torch LC125M + torch bundle (15m)
	K4300-6	✓		Torch LC125M + torch bundle (22m)
T7	BK14300-18	✓		Insulator FLEXCUT 125

➤ For parts order, give the quantity required and put the number of your machine in the box below.

CE Type <input type="text"/> Matricule <input type="text"/>	TYPE :
	Number :

