



HEAD QUARTERS

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MODEL: RE CUT60

User's Manual

Palasma Cutting Mahicne



PLEASE READ THE USER MANUAL BEFORE USE

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1 SAFETY

WARNING!



Before use, read and understand the instruction manual and follow all labels, employer's safety practices and Safety Data Sheets (SDSs).

1.1 Safety Precautions



WARNING!

Arc welding and cutting may cause injury to yourself and others. Take precautions when welding and cutting.

ELECTRIC SHOCK - Can kill



- Install and ground the unit in accordance with instruction manual.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves, or wet clothing.
- Insulate yourself from work and ground.
- Ensure your working position is safe

ELECTRIC AND MAGNETIC FIELDS - Pose health risks



- Welders with pacemakers fitted should consult their doctor before welding. EMF may interfere with some pacemakers.
- Exposure to EMF may have other health effects which are unknown.
- Welders should follow these steps to reduce their exposure to EMF:
 - Route the electrode and work cables together on the same side of your body. Secure them with tape when possible. Never coil the torch or work cable around your body. Keep the welding power source and cables as far away from your body as possible.
 - Connect the work cable to the work piece as close as possible to the area being welded.



FUMES AND GASES - Can be dangerous to your health

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area.



ARC RAYS - Can injure eyes and burn skin

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.



NOISE - Excessive noise can damage hearing

Protect your ears. Use ear defenders or other hearing protection

MOVING PARTS - Can cause injuries



- Keep all doors, panels and covers closed and securely in place. Have only qualified people remove covers for maintenance and troubleshooting as necessary. Reinstall panels or covers and close doors when service is finished and before starting engine.
- Stop engine before installing or connecting unit.
- Keep hands, hair, loose clothing and tools away from moving parts.





FIRE HAZARD

- Sparks (spatter) can cause a fire. Make sure there are no inflammable materials nearby.
- Do not use on closed containers.

MALFUNCTION - Call for expert assistance in the event of malfunction.

PROTECT YOURSELF AND OTHERS!



WARNING!

Do not use the power source for thawing frozen pipes.



CAUTION!

This product is solely intended for arc welding.

1.2 User Responsibility

Users of equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of equipment. The following recommendations should be observed, in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the equipment. Incorrect operation of the equipment may lead to hazardous situations, which could result in injury to the operator and damage to the equipment.

1. Anyone who uses the equipment must be familiar with:
 - its operation
 - the location of emergency stops
 - its function
 - the relevant safety precautions
 - welding and cutting or other applicable operation of the equipment
2. The operator must ensure that:
 - no unauthorized person is within the working area of the machine when it is started up
 - no-one is unprotected when the arc is struck or work is started with the equipment
3. The workplace must:
 - be suitable for the purpose
 - be free from drafts
4. Personal safety equipment:
 - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves
 - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns
5. General precautions:
 - Make sure the return cable is connected securely
 - Work on high voltage equipment may only be carried out by a qualified electrician
 - Appropriate fire extinguishing equipment must be clearly marked and close at hand

2 INTRODUCTION

The **RE CUT-60** is a self-contained **voltage 220V** Plasma Cutter.

- **[Powerful Cutting Ability]** : Featuring a substantial 50A high current for maximum power, it delivers deeper cutting thickness. CLEAN CUT: 18MM@220V // MAX CUT: 25MM@220V. Powered by international leading MCU intelligent digital control technology, it ensures deep, precise, and clean results every time.
- **[NON-TOUCH PILOT ARC]**: The PT-31 PRO torch has great cutting performance, which efficiently cuts through rough, painted, and rusty surfaces. Non-touch pilot arc technology allows you to cut without touching the tips to the metal, offering better cutting quality and longer consumable life.
- **[LED Screen Display]**: The screen centrally displays parameters such as air pressure, voltage, and current, allowing users to understand the equipment status in real-time and adjust operations in a timely manner, improving operational efficiency.
- **[PA/PT/2T/4T Function]**: Polit Arc time function adjustable from -10 seconds. Improve arc striking success rate, protect consumables. Post flow time function, adjustable from 5-15seconds. Adjust the cooling time of the welding head to extend the life of consumables. 2T, a semi-automatic cutting control for accurate cutting. 4T, an automatic cutting control for long-term continuous cutting.
- **【Portable and Support】 RE CUT-60** with a easy carrying handle, compact design, light weight, easy for carrying and storage, can be used anywhere you need.

3 TECHNICAL DATA

<div>MODEL</div> <div>Paramters</div>	RE CUT-60
Power voltage(V)	1 phase AC 220V±15%
Frequency(HZ)	50/60
Rated input current(A)	37
No-load voltage(V)	350
Output current(A)	20-60A
Duty cycle(%)	60
Efficiency(%)	85
Power factor(cosφ)	0.7
Insulation class	H
Protection class	IP21S

Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld or cut at a certain load without overloading.

Enclosure class (Protection grade)

The **IP** code indicates the enclosure class, i.e. the degree of protection against penetration by solid objects or water.

4 INSTALLATION

The installation must be carried out by a professional.

4.1 Location

Position the power source so that its cooling air inlets and outlets are not obstructed, otherwise the cooling system could not work

4.2 Power Supply

The Machine is quipped with power compensation. When the power voltage fluctuation between $\pm 15\%$ of rated voltage, it still can work normally.

The power source can be supplied from different types of generators. However, some generators may not provide sufficient power for the welding power source to operate correctly. Select input voltage grade in the permission range.

5 OPERATION

5.1 Overview

General safety regulations for handling the equipment can be found in the chapter "Safety." Read it before you start using the equipment.

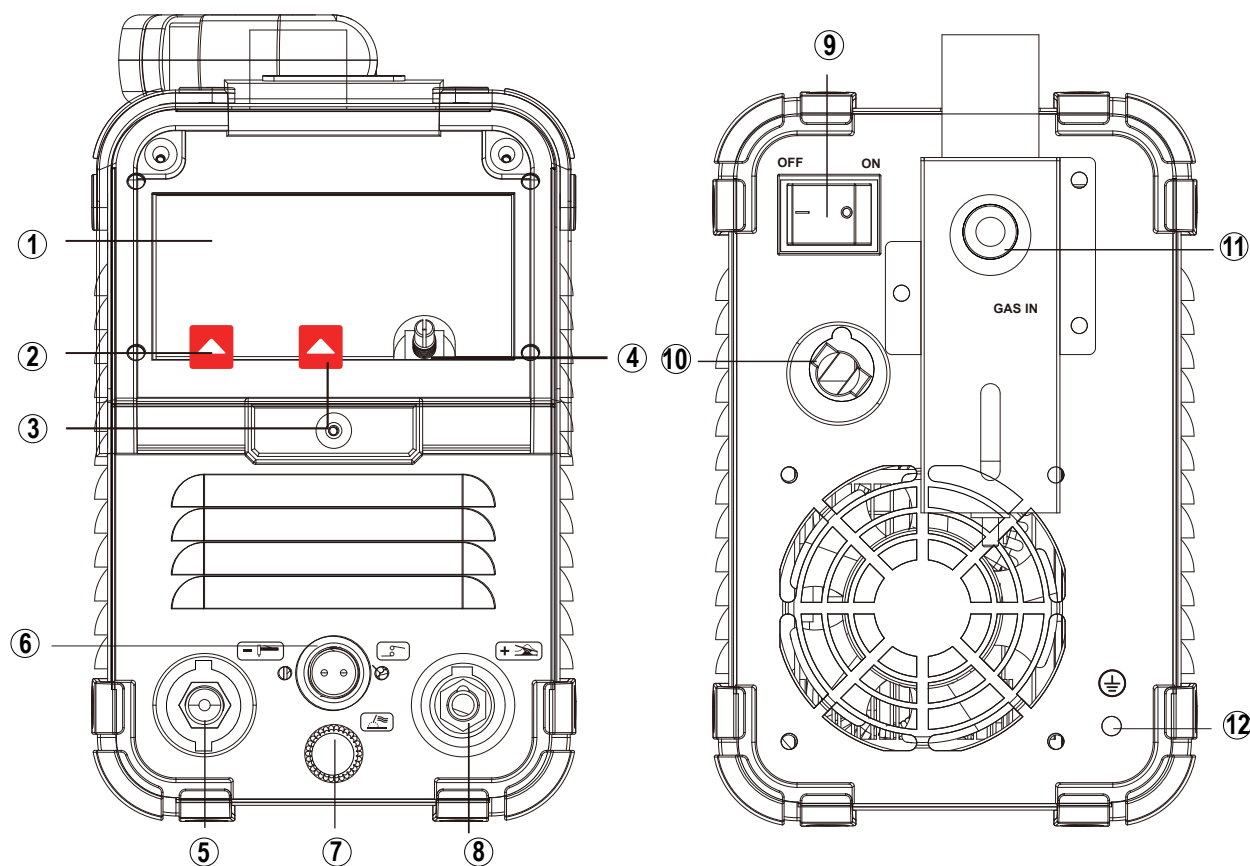
**NOTE!**

When moving the equipment, use the handle. Never pull the cables.

**WARNING!**

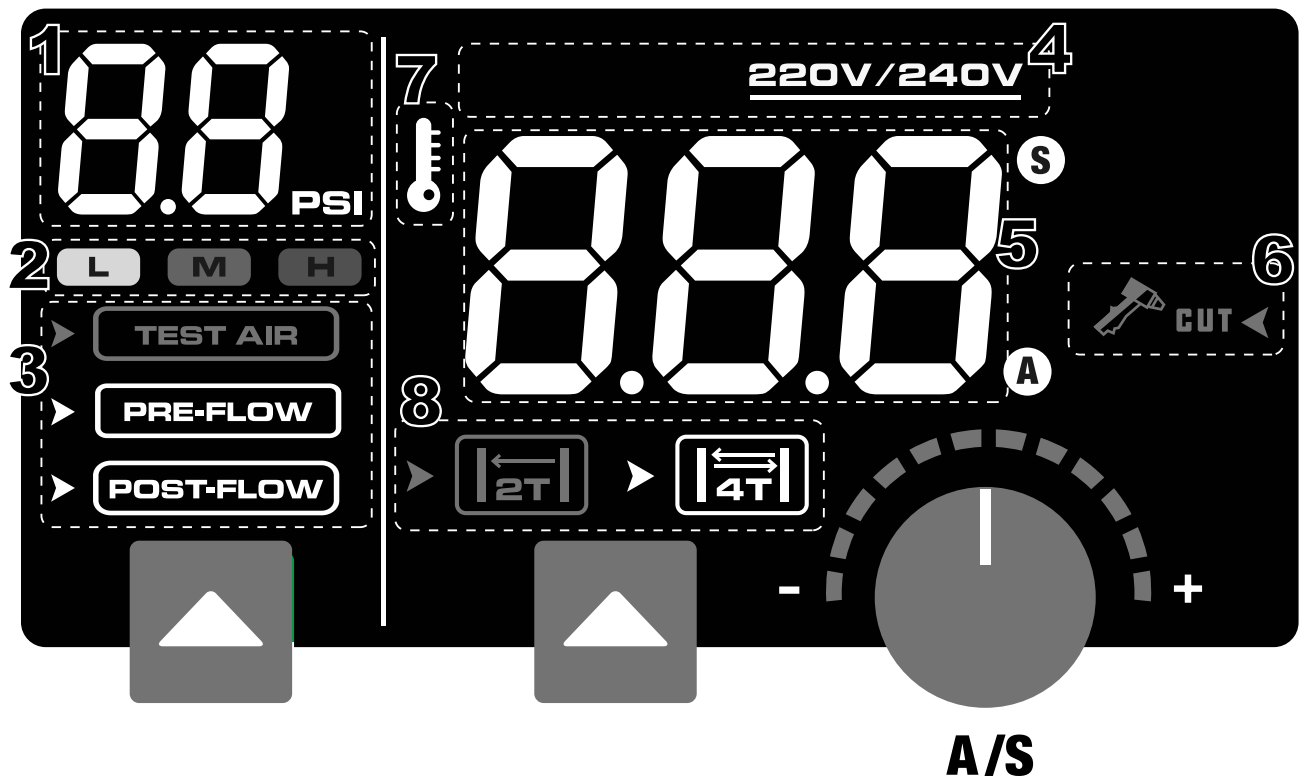
Electric shock! Do not touch the workpiece or the welding head during operation!

5.2 Panel and backboard introduction



NO.	Object	NO.	Object
1	LED display screen	7	Pilot ARC
2	TEST AIR/PRE-FLOW/POST-FLOW selection button	8	Positive terminal(+)
3	2T/4T choose button	9	Power switch
4	Parameter adjustment knob	10	Power cable
5	Plasma gun	11	GAS in
6	Plasma gun switch	12	Ground connection

5.3 Screen instruction



NO.	Mark	Name	Instruction
1		Air pressure display	Show real air pressure data(PSI)
2		Air pressure warning	L:low,it may affect the cutting performance M:middle,standard pressure H:high,it may affect the arc performance,blowing out the arc
3		Test air Pre-flow Post-flow	TESTAIR:test the air PRE-FLOW:pre-flow time ranges from 0 to 1S. Aftering turning on the machins,press pre-flow first, then to start arc.If the arc starting is slow,adjust the pre-flow time to 0. POST-FLOW:post-flow time ranges from 0.1 to 3 S. It is the breathable time after cutting
4		Power Voltage	If the power voltage is connected to "220V/240V", the "220V/240V"light will illuminate.

5		LED Digital Display	
6		Function display	Cutting function
7		Overheat light	When the output current and internal temperature exceed the set standards, the overheat light will illuminate, initiating the cooling process. After the cooling process is completed, the overheat light will turn off, indicating that it's safe to resume operation.
8		2T/4T	

5.4 Turning the Power On/Off

Turn on the power by turning the switch to the “ON” (I) position.

Turn the unit off by turning the switch to the “O” position.

Whether the power supply is interrupted or the power source is switched off in the normal manner, weld programs are stored so that they are available the next time the unit is started.



CAUTION!

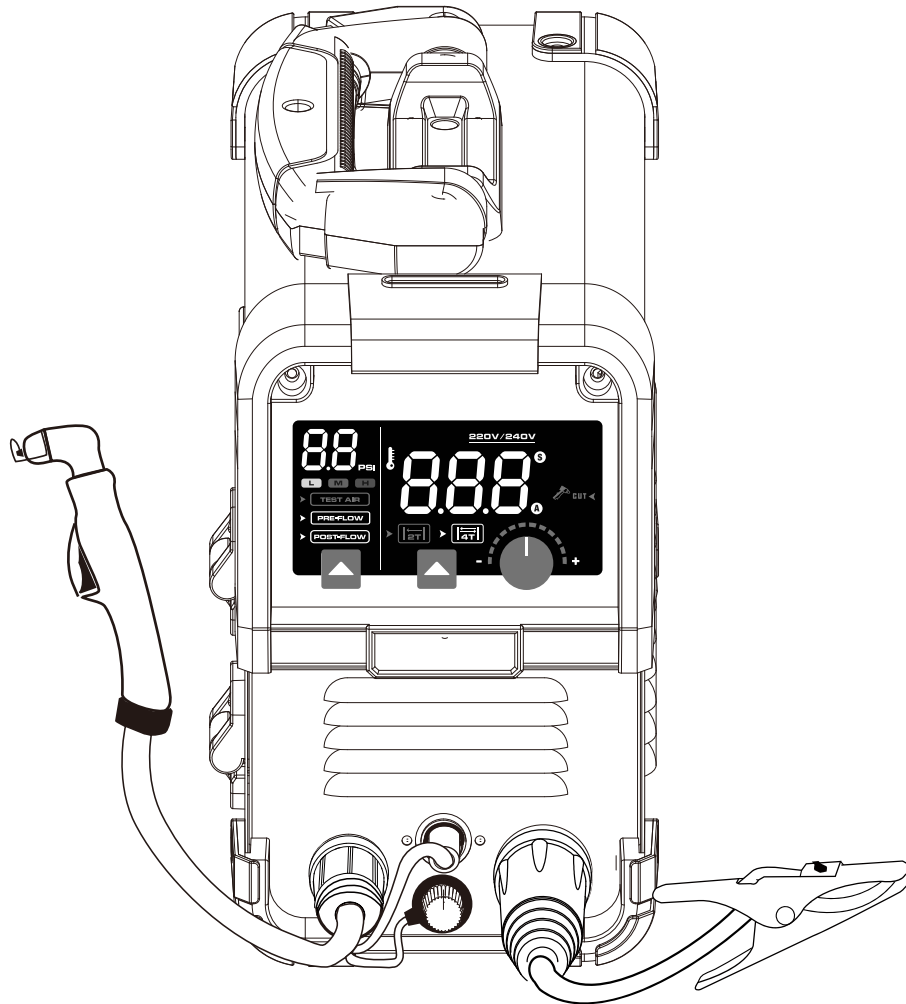
Do not turn off the power source during welding (with load).

5.5 Thermal Protection



The power source includes thermal protection against overheating. When overheating occurs, welding stops, the overheating indicator on the panel illuminates, and an error message appears on the display screen. The protection is automatically reset once the temperature has decreased to a safe level.

5.6 Welding Operation and diagram

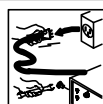


6 MAINTENANCE



WARNING!

Disconnect power before maintaining.



NOTE!

Regular maintenance is important for safe and reliable operation.



NOTE!

Perform maintenance more often during severe dusty conditions.



NOTE!

Ensure welding lead plugs are connected tightly.



NOTE!

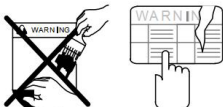
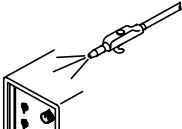
Check welding leads and power cord for damage. If damaged replace parts.

Before each use, make sure that the:

- Product and cables are undamaged
- The torch is clean and undamaged.

6.1 Routine Maintenance

Maintenance schedule during normal conditions. Check equipment before every use.

Interval	Area to maintain		
Every 3 months	 Clean or replace unreadable labels.	 Clean weld terminals.	 Check or replace weld cables.
Every 6 months	 Clean inside unit with reduced compressed air		

6.2 Cleaning Instructions

To maintain the performance and increase the lifetime of the power source, it is mandatory to clean it regularly. How often depends on:

- The welding process,
- The arc time, and
- The working environment.

**CAUTION!**

The repair and maintenance work must be performed by authorized personnel.

**CAUTION!**

The cleaning procedure should be done in a suitable workspace.

**CAUTION!**

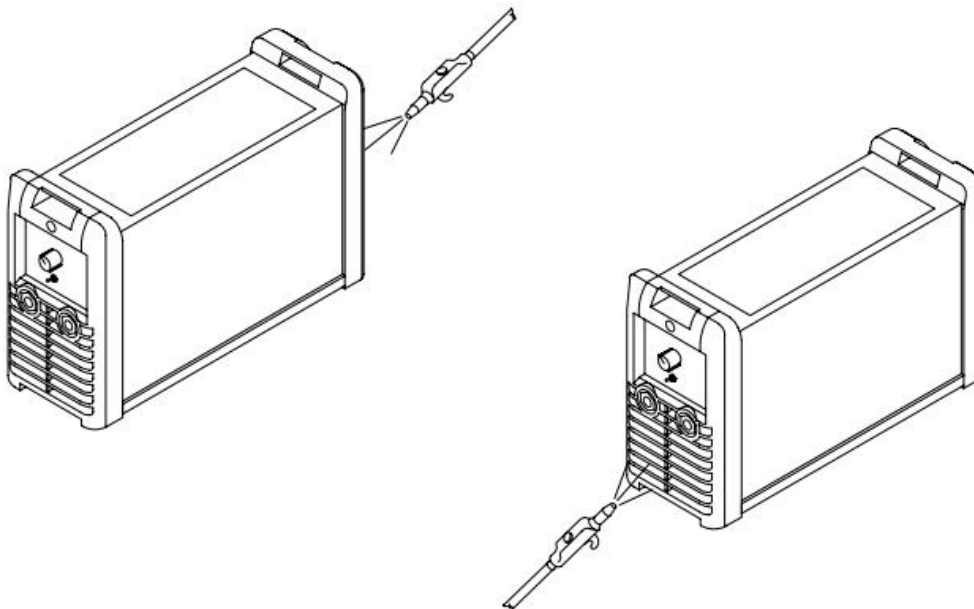
Always wear recommended personal protective equipment, including earplugs, safety glasses, masks, gloves and safety shoes during cleaning.

1. Disconnect the power source from the power supply.

**WARNING!**

Wait for 4 minutes until the capacitors have discharged!

2. Do not remove case when blowing out inside of unit.
Blow out inside. During heavy service clean monthly.



7 TROUBLE SHOOTING

Perform these checks and inspections before contacting an authorized service technician.

Trouble	Remedy
No weld output; unit completely inoperative	Place line disconnect switch in On position.
	Check that the welding and return cables are correctly connected to the power source.
	Be sure power cord is plugged in and that receptacle is receiving input power.
No weld output; unit is on.	Check and secure loose weld cable(s) into receptacle(s).
	Check and correct poor connection of work clamp to workpiece.
Erratic or improper welding arc or output.	Use proper size and type of weld cable (see your Distributor).
	Clean and tighten weld connections.
	Verify electrode polarity; check and correct poor connections to work piece.
Fan not operating.	Unit not warmed up enough to require fan cooling.
	Check for and remove anything blocking fan movement.
	The fan is faulty, reconnect the cable
Stick welding problems: Hard starts; poor welding characteristics; unusual spattering.	Check that the correct electrodes and polarity are being used.
	Verify electrode polarity; check and correct poor connections.
	Check that the correct Welding current (A) is set.
Wire burns back to contact tip.	The wire feed speed is set too low, use the voltage setting to increase the wire feed speed.
	Stick-out too short, increase stick-out, the amount of wire extended beyond the tip of the contact
	Contact tip blocked or damaged, need to replace contact tips
	Contact size is incorrect, you need to use the correct size contact.