

INSTRUCTIONS FOR USE

SPARCIN 8 SPARCIN 8C

TO THE OPERATOR: PLEASE READ AND UNDERSTAND THIS MANUAL BEFORE USING THE SPARCIN 8/8C. IT IS *ABSOLUTELY VITAL* TO KNOW THE INFORMATION PRESENTED IN THIS MANUAL IN ORDER TO USE THE SPARCIN 8/8C IN THE BEST WAY. WITH THIS KNOWLEDGE AND A PROFESSIONAL APPROACH, YOU WILL BE ABLE TO SOLVE MANY COMPLICATED CUTTING APPLICATIONS WITH THE SPARCIN 8/8C.

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1. TECHNICAL DATA

Power supply:	3~50Hz, 400V (standard) 3~50Hz, 415V on request	
Main fuse:	16A slow blow	
Process power:	120V, 20-70A	
Duty cycle:	35% @ 70A 60% @ 60A 100% @ 45 A	
Maximum power:	10,4 kVA	
Power factor:	0,95	
Open circuit voltage:	240V	
Gas pre-flow:	1 sec	
Gas post-flow:	5 sec	
Dimensions:	SPARCIN 8	SPARCIN 8C
	Length	550mm
	Width	300mm
	Height	310mm
		550mm
		300mm
		440mm
Weight:	22kg	28kg

2. INSTALLATION

SPARCIN 8 is ready for use after connection to electric power and compressed air or some technical gas for plasma cutting.

SPARCIN 8C (with built-in compressor) is ready for use after connection to electric power. Please note that the compressor will run constantly when the machine is switched on and that air will flow constantly.

Power supply:

3~50Hz, 400V
Fuse: 16A slow blow

Important!

If the machine is to be connected to a power generator it is absolutely vital that the machine be fitted with generator filter. If the machine is not fitted with generator filter, serious damage to the machine and costly repair can be the result. Such damage is NOT covered by the warranty.

The generator must supply minimum 15 kVA exclusively for the SPARCIN 8/8C.

Gas supply (SPARCIN 8 only)

Air plasma cutting:

Connect the compressed air to the filter regulator and adjust to 3,5-4 bar.

Gas plasma cutting:

Connect the constant flow regulator of the gas cylinder to the filter regulator and adjust to 3,5-4 bar.

The gas flow should be approx. 18 l/min.

3. OPERATING INSTRUCTIONS

Check that the machine has been properly connected to the power supply and gas, see chapter 2, installation.

NOTE! The machine may only be used with 400V power supply!

Connect the earth-lead to the front of the machine. Connect the earth clamp directly to the work piece. If necessary, clean the surface from paint, rust, dirt, etc.

Cutting

Place the POWER switch in position ON.

The power lamp READY will light.

The pump, fan (and built-in compressor) will start.

Choose process power (cutting current 20-70A)

Place the torch in position for contact cutting or distance cutting and press the START button on the torch handle.

Contact cutting

Slide the nozzle against the work piece.

As an accessory, there are special contact cutting nozzles, part no. 199 108, made for profile cutting.

Contact cutting is suitable for cutting up to 4 mm plate thickness.

Distance cutting

Keep a distance of a few millimetres between the nozzle and the work piece.

The accessories for distance cutting are the distance cutting guide, part no.

199107/199124, the distance roller, part no. 299 078/299 027 and the circle cutting bar, part no. 299 079/299 082.

After activating cutting start the air/gas will flow for a short while before the plasma arc (pilot arc) strikes. If the cutting process does not start, the pilot arc will go out. Then make another try.

To stop the cutting process, release the START button on the torch handle. The plasma arc will go out instantaneously. Gas/air will flow for a few more seconds.

PLEASE NOTE! When the machine is not in use or is only used at long intervals, please switch off the machine. It contains mechanical components like fan, pump, (and built-in compressor), which should not be exposed to unnecessary wear.

Air plasma cutting

Use the electrode for air as plasma generating gas. This electrode is nickel plated.

Gas plasma cutting (SPARCIN 8 only)

Use the electrode for technical gas; nitrogen (N₂), argon/hydrogen mix (Ar/H₂) or nitrogen/hydrogen mix (N₂/H₂)
This electrode is copper plated.

Use the nozzle marked 0,9, part no. 199 060 for cutting plate thickness up to 6 mm, for thicker plates, use the nozzle marked 1,1, part no. 199 001. For contact cutting, use the special contact cutting nozzle, part no. 199 108.

PLEASE NOTE! The plasma cutting torch is a component designed for high power outputs. Please handle the torch body and hose assembly with care. With the proper handling, by an operator with the proper knowledge, the lifetime of the cutting torch will be very long, and the low wear on nozzles and electrodes will give good cutting economy. A damaged hose assembly, e.g. with air or water leakage, will infallibly damage the torch body.
NEVER USE A DAMAGED PLASMA CUTTING TORCH!

4. GENERAL INFORMATION ON PLASMA CUTTING

With exception of the systems that have built-in compressors (SPARCIN 5C/8C/9C), all SPT Plasmatechnik AB manufactured plasma cutting systems with water cooled torch have full multi-gas capability.

When using technical gases, a pressure regulator as opposed to a flow regulator must be fitted to the gas cylinder. The use of flow regulators may lead to ignition problems and torch malfunction.

This chapter also describes in general how to optimise cutting quality and consumable lifetime.

When to use technical gas

Mild steel

Mild steel is cut with good quality using air as plasma generating gas. In some applications however, when better cut quality is desired, pure oxygen can be used as plasma generating gas.

In order to reach an acceptable lifetime of the electrode there are specially designed electrodes for this purpose. For low power cutting (<40A), use the FineL electrode. For high power cutting (>40A), use the Hi-Power oxygen electrode.

When cutting with oxygen the consumable lifetime is shorter than with air.

Stainless steel

Most types of stainless steel are cut with good result with air as plasma generating gas. The weldability of the kerf however may be improved by using a technical gas.

Using pure nitrogen as plasma generating gas you can reduce the amount of chrome-oxide in the kerf. When cutting with nitrogen, the gas electrode as well as the air electrode may be used.

To further improve the kerf quality, a mixture of 10% hydrogen in nitrogen (NH10) may be used. Since this mixture contains hydrogen a tendency to develop dross may occur. This can be minimised if not eliminated by very precisely adjusting cutting parameters as speed, distance, gas flow, nozzle size, process power etc. When cutting with NH10 the gas electrode as well as the air electrode may be used.

Aluminium

There are a great number of different aluminium alloys available. Most of them are cut without dross and with high speed using air as plasma generating gas. The aluminium-oxide in the kerf may reduce the weldability of the cut.

To reduce the aluminium-oxide a gas mixture of 10% hydrogen in nitrogen (NH10) may be used. When cutting with NH10 the gas electrode as well as the air electrode may be used.

To further reduce the aluminium oxide a mixture of 35% hydrogen in argon (AH35) may be used. When cutting with AH35 the gas electrode must be used.

Note that when cutting with AH35 it may be necessary to use a nozzle with a bigger orifice to prevent double arcing.

Copper/brass

Copper and brass can depending on alloy be cut with air, nitrogen or a mixture of 10% hydrogen in nitrogen (NH10). When cutting with air, air electrode must be used. When cutting with nitrogen or NH10 air electrode as well as gas electrode may be used.

Titanium

Titanium is best cut with a mix of 70% helium in argon. When using this mixture, gas electrode must be used. Some titanium alloys are better cut with air or oxygen.

Piercing

Piercing is not recommended above 15 mm material thickness at >80A and 12 mm at <80A. When firing the pilot arc the nozzle must be protected from molten metal spattering back by keeping an adequate distance to the work piece. The piercing standoff distance must be at least double the cutting distance.

The piercing capacity is highly material dependant.

How to improve cutting quality

To reach the best possible results the first step is to assure that the plasma cutting system is properly installed and adjusted.

The cut quality is primarily determined from angle deviation, dross formation and the surface of the kerf.

Angle deviation

The angle deviation is either positive or negative. A positive angle deviation (V-shaped) occurs as a result of more material being removed in the upper part than the lower part of the cut. A negative angle deviation occurs as a result of the reversed conditions.

Problems with angle deviation consists either of the cut having too much angle deviation or inconsistent angle deviation, i.e. positive on one side, negative on the other.

Too much angle deviation

- Incorrect distance between nozzle and work piece. Adjust the distance.
Too much distance > positive angle deviation
Too little distance > negative angle deviation
- Worn or damaged consumables. Check the parts and change if necessary.
- Wrong cutting direction. The left side of the cut seen from the cutting direction of the torch has less angle deviation than the opposite side. Check the direction and change if necessary.
- Too high cutting speed. By slowing the cutting speed the angle deviation can be minimised.

Inconsistent angle deviation

- Worn or damaged consumables. Check the consumables and change if necessary.
- The torch is not fitted straight in relation to the work piece. Check the torch position and adjust if necessary.
- Magnetic remanence in the work piece. Parts that are handled with electro-magnetic lift tools may become magnetic. Make sure that the material is handled without using magnetic lift tools.

Dross formation

Dross free cutting requires that all parameters for each job are optimised.

Dross formation as a result of too low cutting speed

- This type of dross formation occurs when the cutting speed is too low. The dross is extensive and porous. It is easy to remove. Reduce the dross formation by increasing cutting speed.

Dross formation as a result of too high cutting speed

- This type of dross formation occurs when the cutting speed is too high. The dross looks like drops of molten metal and is hard to remove.
By lowering the cutting speed the dross formation can be reduced. If reducing the speed does not solve the problem it may help to lower the distance between nozzle and work piece.

Sporadic dross formation

- Worn or damaged consumables. Check and change if necessary.
- This type of dross formation may be material dependant. Some materials cause more dross than others.
- Work piece temperature. When cutting the first parts from a work piece the dross formation can be less than when the material has become heated.

The surface of the kerf

The kerf may be convex or concave. An accurate adjustment of the cutting speed and distance can help in obtaining a straight cut.

Concave kerf

- Too little distance between nozzle and work piece. Increase the distance in order to straighten the kerf.

Convex kerf

- Too much distance between nozzle and work piece, or too high cutting current. By first lowering the torch and then if necessary lowering the current the kerf can be

straightened.

Some combinations of plasma generating gas and material can more than others cause convex kerfs.

Optimising consumable lifetime

The patented consumable parts of the water cooled torch guarantee the best possible consumable lifetime and optimum cutting economy. To optimise the consumable lifetime the following instructions must be followed.

Optimising electrode lifetime

- When piercing, the torch must not be too close to the work piece
- If the cutting is automated, program the sequence so that the plasma arc goes out before the torch goes over the edge of the work piece. If the pilot arc re-ignites the electrode lifetime is reduced.
- The electrode lifetime can be increased by programming the sequence so that several parts are cut in one sequence, thereby reducing the number of starts.
- When changing plasma generating gas the gas system must be flushed.

Optimising nozzle lifetime

- When piercing, the torch must not be too close to the work piece. The piercing distance should be at least double the cutting distance.
- The distance between nozzle and work piece must be kept constant so that the nozzle does not touch the work piece.

5. ACCESSORIES FOR MANUAL PLASMA CUTTING

There are a number of accessories available for SPARCIN and SPARCON cutting systems equipped with hand torch.

Plasma gouging

All SPARCIN and SPARCON systems, except SPARCIN 5/5C, have gouging capability. By fitting the torch with nozzle extension, gouging nozzle (2,2 mm for <80 A, 3,0 mm for >80A), and protective cup for gouging (see torch parts lists) a powerful tool for gouging is obtained.

20 mm nozzle extension set

As an accessory there is a set of 20 mm nozzle extension, extended electrode and extended protective cup. This is useful for cutting in narrow places, corners, etc.

Contact cutting nozzle

By dragging the nozzle directly against the work piece a good cut quality can be obtained in material thickness up to 4 mm. To aid cutting against a template there are cylindrical contact cutting nozzles (art. No. 199108) available. Note that contact cutting is only allowed with cutting current up to 40 A.

Cutting wagon

For SPARCUT XL a two-wheel cutting wagon (art. No. 299027) is available. For both SPARCUT XL and DURACUT there is a four-wheel cutting wagon (art. No. 299078) adaptable for both torches available.

Circle cutting attachment

A circle attachment for DURACUT (art. No. 299079) and SPARCUT XL (art. No. 299082) for cutting radius between ca. 100 and 450 mm.

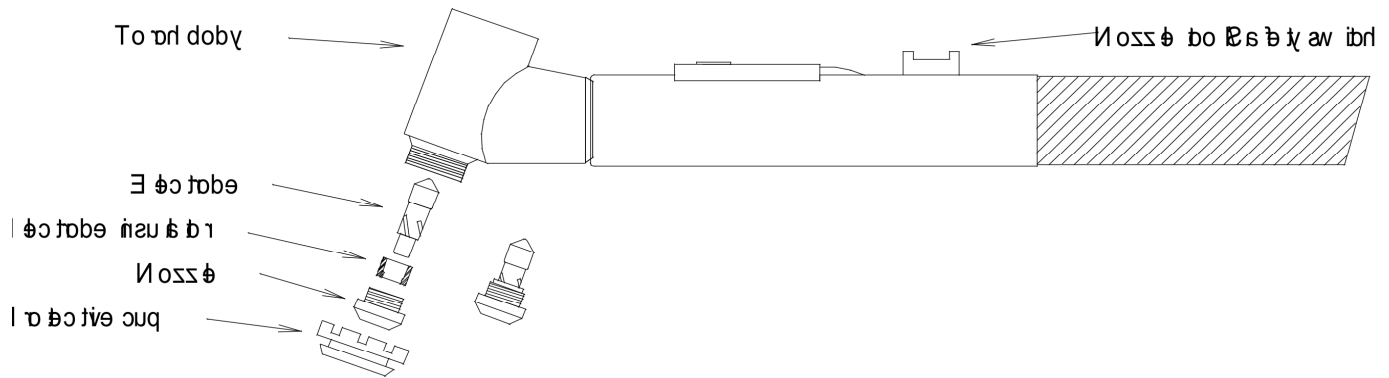
Distance cutting guide

For all hand torches there are two different types of distance cutting guides, art. No. 199107 and 199124. See the torch parts lists for more information.

6. CHANGING CONSUMABLES

WARNING! THE MACHINE MUST ALWAYS BE SWITCHED OFF WHEN CHANGING CONSUMABLES!

1. After removing the protective cup, loosen the nozzle with the nozzle tool. All the consumables can now be removed.
2. Please observe carefully the correct assembly of the consumables.
3. Tighten the nozzle with the nozzle tool.
4. Tighten the protective cup.



7. MAINTENANCE

Daily

Inspect and, if necessary, change nozzle, electrode and electrode insulator.
Empty and, if necessary, clean the moisture trap situated on the rear of the machine. This is easily done by pressing the bottom sealing of the glass cover while compressed air is connected, or completely unscrewing the cover and cleaning it from dirt. Disconnect compressed air or gas before unscrewing the glass cover.

Carefully inspect the torch body and the hose assembly with regard to any damage or leakage of air, gas or water, mechanical damage or other.

NEVER USE A TORCH WITH A DAMAGED TORCH BODY OR HOSE ASSEMBLY!

Every six months

Remove the plates from the machine. Inspect cable connections. Blow away dust and dirt with compressed air.

Check coolant level, if necessary, fill up with distilled or de-ionised water.

Coolant conductivity: $<5\mu\text{S}/\text{cm}$.

Fill up with anti freezing agent when necessary. When the machines leaves the factory the coolant consists of 70% de-ionised water and 30% pure mono-ethylene-glycol.

NOTE! The anti freezing agent must be pure glycol!

8. TROUBLE SHOOTING

Thermal overload

If the pump, fan (and compressor) are working but the green READY lamp is not lit, the thermal overload protection is active.

Let the machine cool down while switched on until the lamp lights. Now the machine is in working order.

Malfunction

If the pilot arc does not strike:

- check and, if necessary, change nozzle, electrode and electrode insulator.
- check and, if necessary, adjust inlet air/gas pressure to 3,5-4 bar.
- If possible, check air/gas flow, approx. 18 l/min. Too high air/gas flow will prevent the pilot arc from striking.

If the pilot arc is not stable:

- too high air/gas flow, adjust inlet pressure to 3,5-4 bar.
- the machine is working two-phase, check mains fuses.

Inferior performance or cutting quality:

- check inlet air/gas pressure, 3,5-4 bar.
- inspect torch body and hose assembly for damage and leaks.
- check nozzle, electrode and electrode insulator.
- check earth lead connection. If necessary, clean it from dirt, paint and oxide.

9. SAFETY INSTRUCTIONS

All endangerments through plasma cutting are related with the process itself. Endangerments may occur due to:

- High contact voltage
- HV ignition
- Electromagnetic interferences
- Heat and light radiation
- Gases, fumes and smoke
- Noise
- Hot metal and spatter
- Handling of pressure cylinders

The Plasma Cutting Machine has been developed in conformity with following standards:

- EN 60974-1 safety requirements for installations for arc welding and welding power sources
- EN 50199 electromagnetic compatibility

Before starting the Plasma Cutting Machine carefully read this Instruction Manual. Only advised personnel are allowed to operate the plasma installation!

Endangerment due to high contact voltage

Warning!

Before opening the plasma rectifier generally the input power has to be disconnected physically from the mains (unplug mains cable)! Only advised personnel are allowed to carry out any repairs to the machine.

Attention! Connect the work piece cable and earth the workplace before starting the machine!

The power source is equipped with a cooling unit and there is an electric potential between the housing and work piece in case the work piece isn't earthed and the machine is switched on. Because of the high resistance of more than 10 kOhm in the coolant the contact voltage is absolute not dangerous but sensible.

Special hints:

- Connect power source only to correctly earthed mains socket with proper connected safety conductor
- Wear insulating protective clothing (safety shoes, leather apron, gloves), place torch on insulated holder,
- Wear cutting area and plasma machine components dry and clean, arrange regular inspections, never shorten safety circuits.

Working under elevated electrical endangerment

This plasma cutting machine in conformity with valid standards (EN 60974-1) can be used for operation under elevated electrical endangerment

- The power source and the plasma torches are forming a safety-proofed installation which can be separated only by using tools.
- The patented design of the torch prevents electrical danger when the torch consumables are disassembled.

Therefore the power source is marked with the S-sign and operation under enhanced electrical endangerment is allowed.

Attention! Always follow the local safety rules!

Endangerment through high voltage (HV)

A HV-igniter starts the pilot arc. The HV-supply is cut-off automatically after pilot arc has struck.

Attention! Never touch nozzle or nozzle cap when power source is switched ON!

HV-ignition may establish electromagnetic fields and can influence:

- heart pace-makers
- electronic devices

Endangerment through electromagnetic interferences

The plasma cutting unit is in conformity with the conditions of the EN 50199 “Electromagnetic compatibility”. This standard is valid for arc welding and related processes (plasma cutting) that come in use in commercial and private fields.

Warning!

Special precautions may be required if the plasma unit is used in private fields (for instance screened cables etc.)

The user takes the full risk when installing and using the machine. He has to follow strictly the instructions of the supplier. If electromagnetic interferences are noticed the user is to contact the producer to solve the problem.

Recommendations to classify the environment (EN 50199):

Before the installation takes place the user has to value the environment for electromagnetic problems and to take into consideration:

- Other mains supplies, control cables, signal and telecommunication lines along, above, below or beside the installation
- Broadcasting or television installations
- Computers or other controls
- Safety devices, protection circuits
- The health of people in the area (heart pace makers, hearing aids etc.)
- Devices for measuring and calibrating
- The noise immunity of equipment around the installation, so that they are compatible with electromagnetic interferences. Special measures may be required.
- The time of day that plasma cutting is performed

Recommendations to minimise interferences:

If interferences take place, the following should be done:

- Apply filter for mains connection
- Screening of mains cable of the plasma installation (safe contact between screen and housing required)
- Constant maintenance

- Always keep cover plates and doors of the plasma machines closed
- Avoid excessive length of cutting cables
- Arrange potential equalisation between metallic parts around the installation (the operator has to be insulated from those parts)
- Earthing of the work piece
- Selective screening of other cables and installations

Endangerment through heat and light radiations

The plasma arc produces intense ultraviolet and infrared radiation that can hurt the eyes and skin. Therefore the following precautions have to be arranged:

- Wearing of flame-retardant welding clothes (helmet, apron, gloves, safety shoes)
- Hand or head shield with protective glasses of medium shade for watching the cutting process
- Preparing the cutting area so that reflection and transmission of ultraviolet light is reduced:
 - painting of walls in dark colour
 - use of protective walls and screens

Endangerment through fumes and smoke

Due to the plasma process itself hazardous substances may be produced. To avoid risks on health the following has to be done:

- Keep cutting place well ventilated
- Remove fumes and smoke by exhaustion devices
- Remove all chlorinated and other solvents from the cutting area. They could form phosgene gas when exposed to ultraviolet radiation
- Wear a breathing mask when cutting galvanised materials
- Ensure that toxic limits are not exceeded

Endangerment through noise

Be aware that during plasma cutting a high noise level arises.

Cutting current	Thickness	Noise level in distance of	
		0,5 m	1,0 m
No load			56dB(A)
80A	4mm	82 dB(A)	79 dB(A)
160A	16mm	86 dB(A)	83 dB(A)
240A	16mm	96 dB(A)	92 dB(A)

Above levels are general. Variations may occur.

Therefore wear proper ear protection.

Endangerment through spatter

During plasma cutting sparks, slag and hot metal are produced. The risk of burns and fire exists! To avoid these endangerments the following has to be advised:

- remove all potential flammable materials from cutting area, at least in a 10 m distance
- cool down freshly cut material before handling

- make fire extinguisher available in the cutting area

Handling of pressure cylinders

In some cases compressed gases are required for the plasma cutting process. To avoid endangerments the following has to be advised:

- Place cylinders upright in secured position
- Never use damaged cylinders, pressure reducers and armatures
- Use pressure reducers only for the gas it is determined
- Never lubricate pressure reducers with grease or oil
- All parts coming in contact with oxygen must be free from oil and grease
- When using oxygen and/or flammable gases the pressure reducer has to be equipped with an explosive-proofed device (backfire-device)
- Regularly check the gas hoses and other equipment for leaks etc.
- Always follow regulation regarding gas equipment

Handling of coolant

In all liquid cooled machines produced by SPT a coolant normally consisting of 30% mono-ethylene glycol (99,9 %) and 70 % de-ionised water is used.

When handling the coolant the following must be observed:

- Never drink coolant
- Store coolant away from food and drink
- Avoid all contact with the skin and eyes
- Always wash your hands after handling coolant
- Never wear clothing that is contaminated with coolant

First aid measures:

- **After breathing fumes:** Fresh air and rest
- **After skin contact:** Remove contaminated clothing and rinse with water
- **After eye contact:** Rinse with water. Consult a doctor if problems arise
- **After swallowing:** If it is more than an insignificant amount medical treatment is necessary. If it takes more than 30 minutes to receive treatment, and the patient is fully conscious, try to induce vomiting. The patient should drink water before vomiting.

Upon request, a product information sheet for the coolant is available from SPT. Call +46 46 18 48 00.

10. WARRANTY

SPT Plasmatechnik AB grants a warranty for its products. The warranty covers damage caused by faulty raw material or production errors. A faulty part will be replaced by a new one, or, if possible, we will repair the faulty part without cost.

The warranty period is 2 years provided the machine is used under normal conditions (one shift working).

The warranty does not cover damage caused by improper or careless handling, overload, irresponsible maintenance or natural wear.

Any use of non-original parts or consumables renders the warranty void.

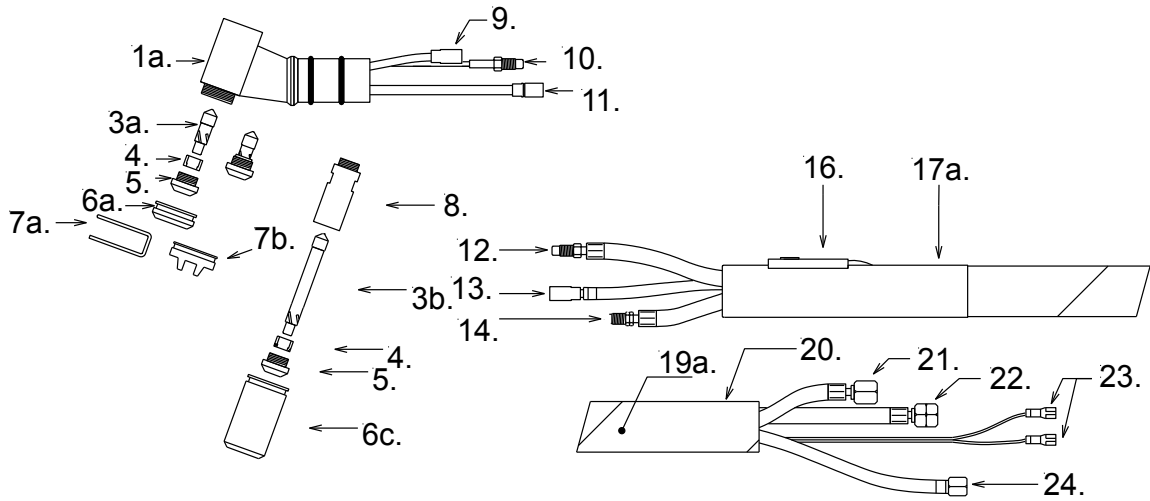
Travel costs in connection with warranty repairs or freight costs is not included in the warranty.

Warranty repairs may only be performed by SPT Plasmatechnik AB or a representative assigned by SPT.

11. TORCH/TORCH PARTS LISTS

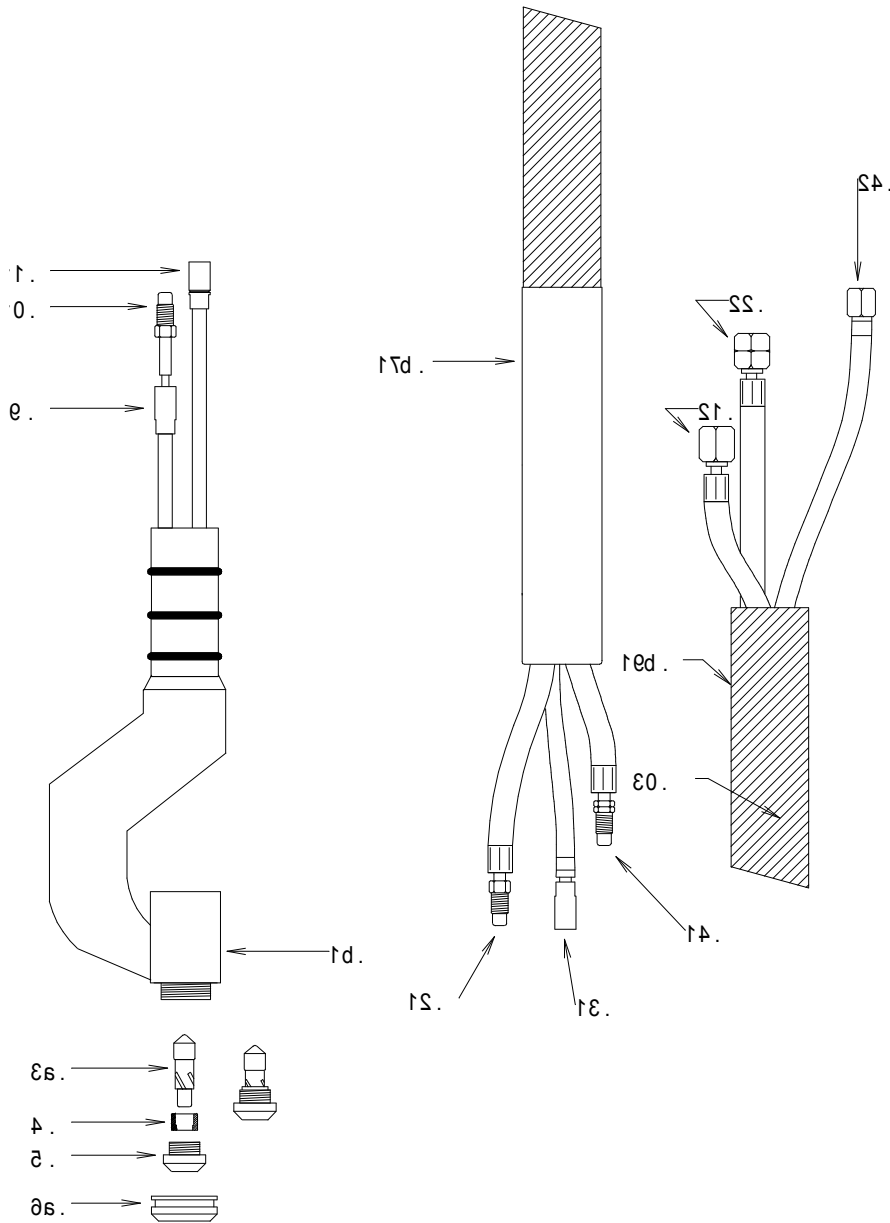
SPARCUT XL

LIQUID COOLED MANUAL TORCH



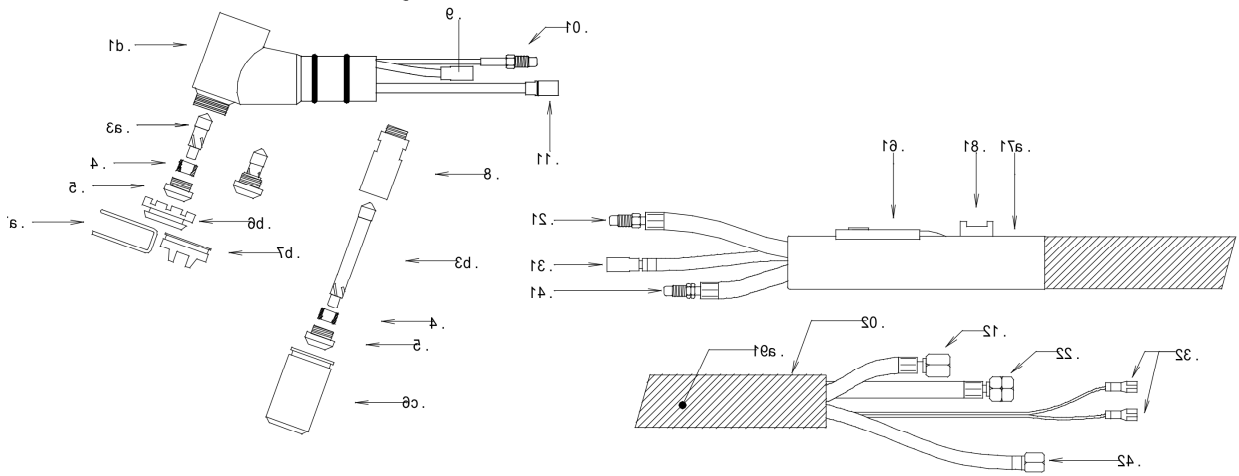
SPARCUT XL/M

LIQUID COOLED MACHINE TORCH



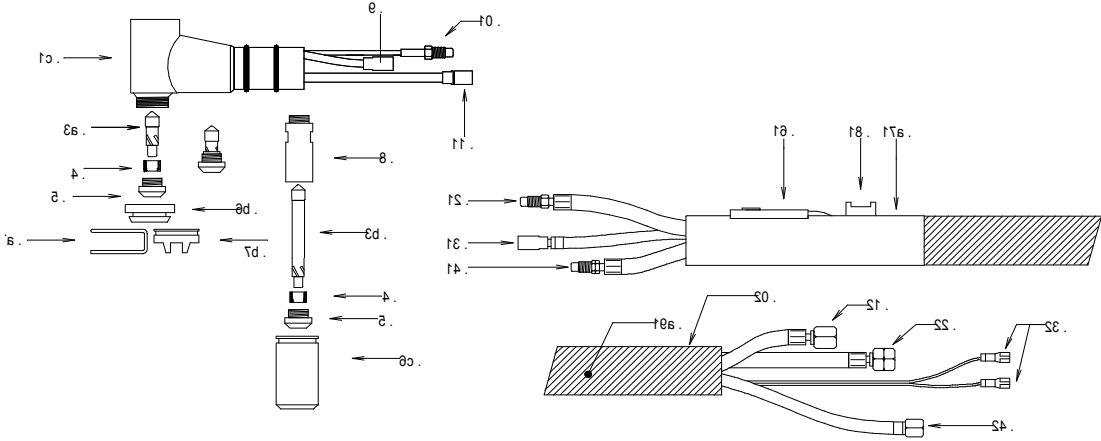
DURACUT

LIQUID COOLED MANUAL TORCH



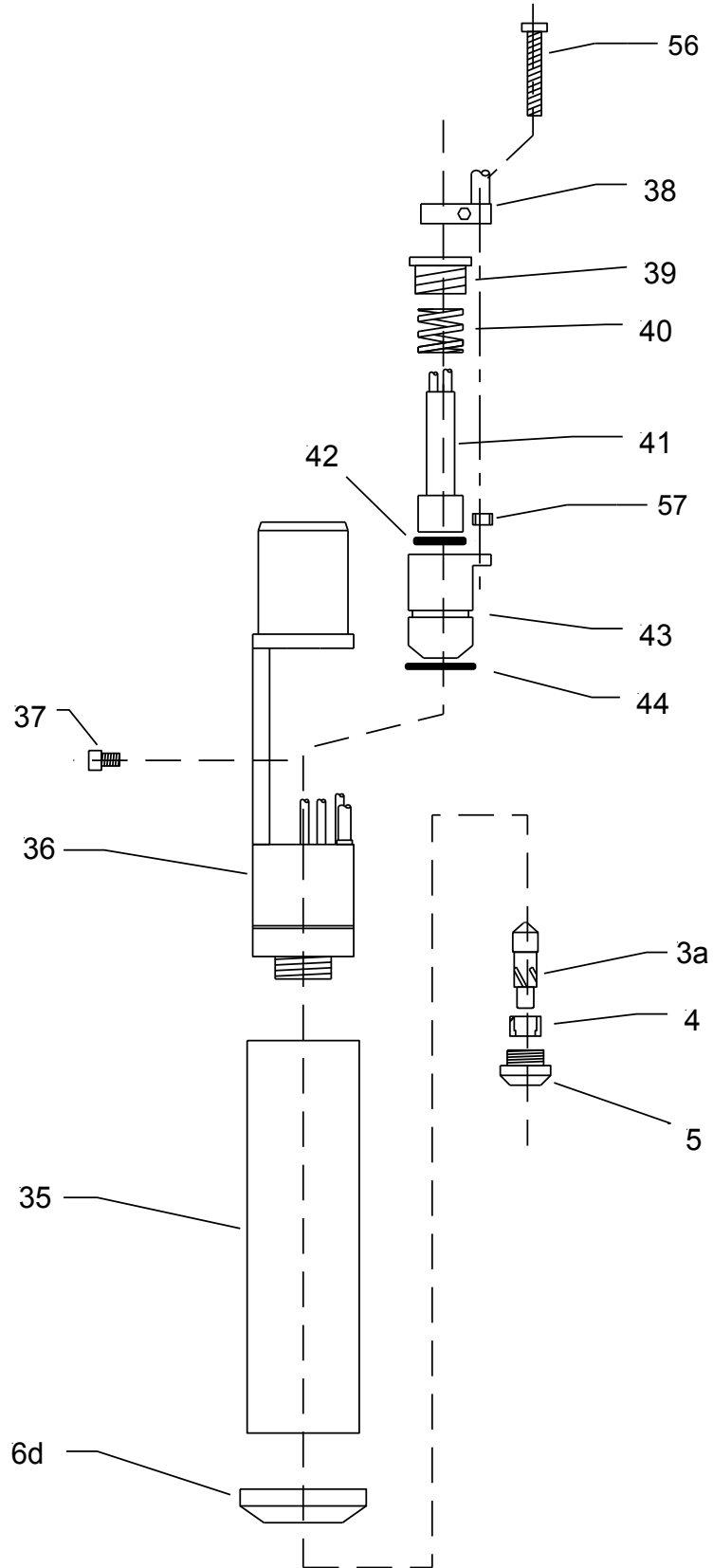
DURACUT 90

LIQUID COOLED MANUAL TORCH



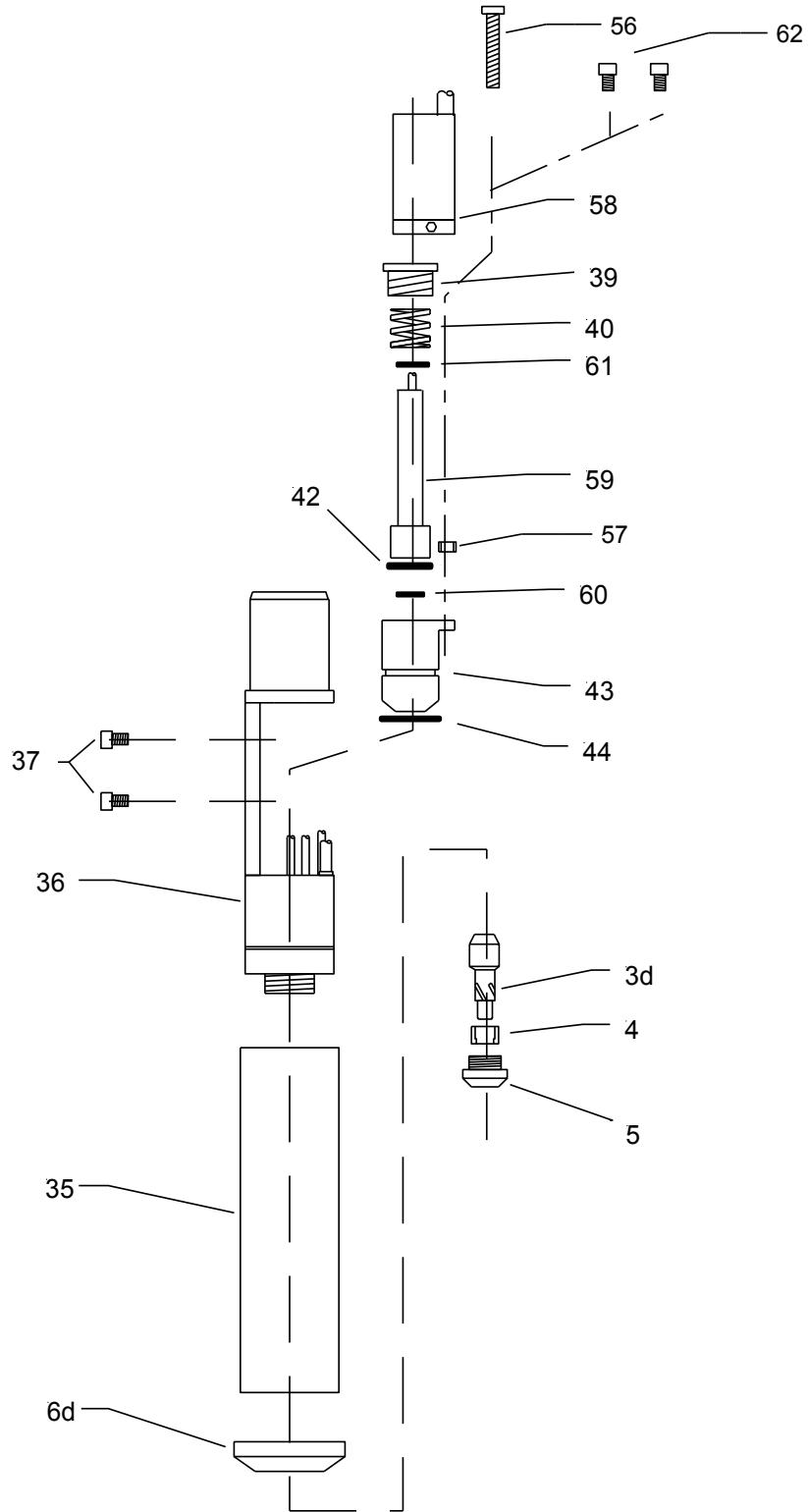
BAZOOCUT™

SERVICEABLE HEAVY DUTY PLASMA CUTTING TORCH



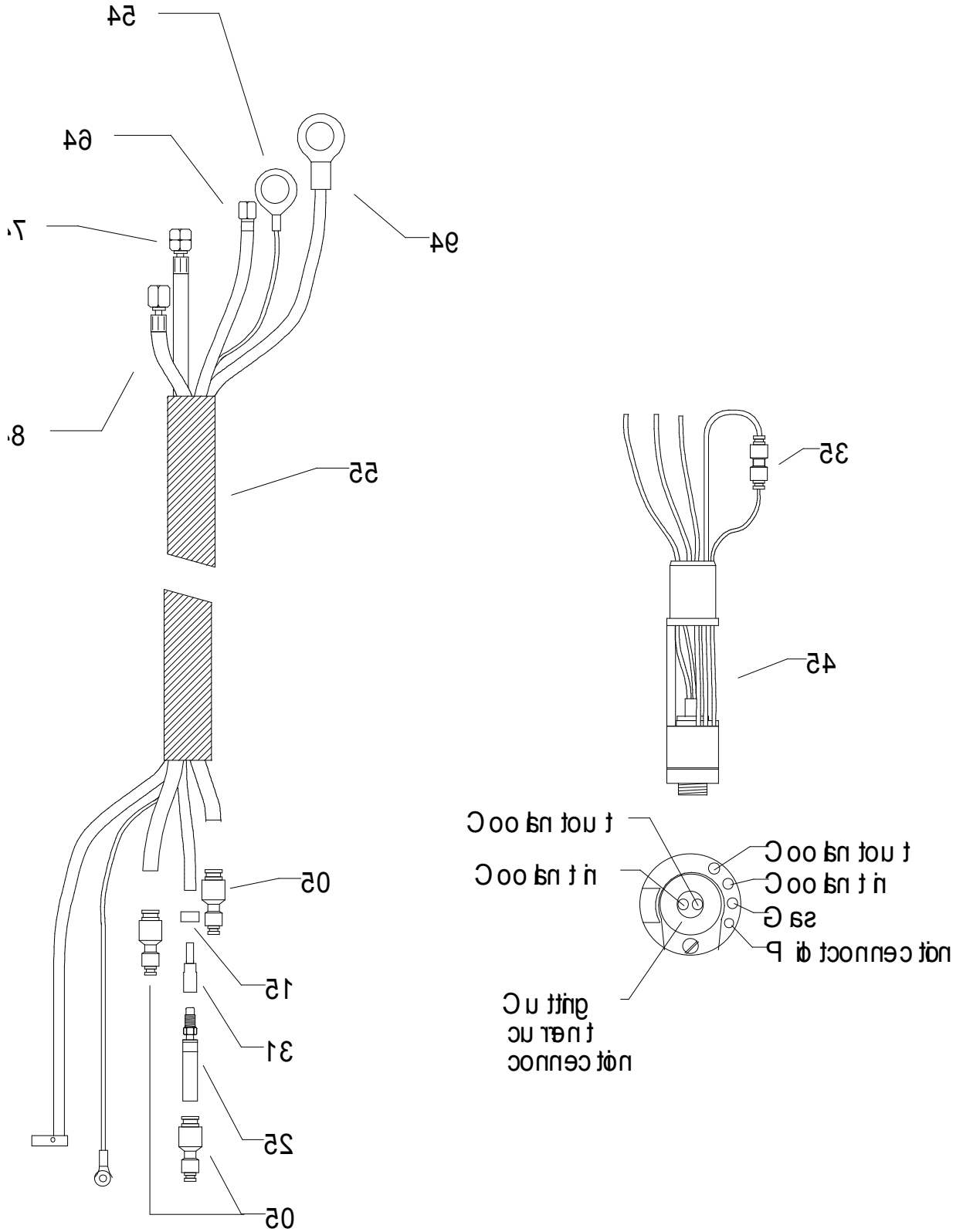
EXCALIBUR

SERVICABLE HEAVY DUTY PLASMA CUTTING TORCH
WITH DIRECT WATER COOLED ELECTRODE



HOSE ASSEMBLY

BAZOOCUT/EXCALIBUR



SPARCIN 8 / SPARCIN 8C

PARTS LIST

Ref. No.	Det. No.	Denomination
1a.	299081	Torch body SPARCUT XL
1b.	299103	Torch body SPARCUT/M
1c.	299108	Torch body DURACUT 90
1d.	299072	Torch body DURACUT
2.	299010	Electrode cap
3a.	199002	Electrode, air
	199003	Electrode, gas
	199127	Electrode, O ₂ FineL
	199128	Electrode, O ₂ HI-Power
	199162	Electrode, Long Life
3b.	199114	Electrode for gouging
3c.	199202	Electrode, air long
3d.	199192	Electrode, air, EXCALIBUR
	199193	Electrode, gas, EXCALIBUR
4.	199006	Electrode insulator
5.	199060	Nozzle 0,9
	199001	Nozzle 1,1
	199101	Nozzle 1,4
	199113	Nozzle 2,2 for gouging
	199123	Nozzle 3,0 for gouging
	199143	Nozzle 0,7 FineL
	199144	Nozzle 0,8 FineL
	199146	Nozzle 1,1 S High Precision
	199147	Nozzle 1,4 S High Precision
6a.	199064	Protective cup, PTFE
6b.	199125	Protective cup, PTFE for DURACUT/DURACUT 90
6c.	199364	Protective cup for gouging
6d.	199158	Protective cup, PTFE for BAZOOCUT
--	199126	Spatter shield for DURACUT/DURACUT 90
§		(Not shown in picture)
7a.	199107	Distance cutting guide
7b.	199124	Distance cutting guide, brass
8.	199112	Nozzle extension 40mm for gouging
	199203	Nozzle extension 20mm for use with electrode 199202
9.		Connection to current/water
10.		Connection to gas/air
11.		Connection to pilot/water
12./22.		Current water hose
	299004	6m
	299039	12m
	299042	20m
13.	299020	Throttle pin for Type I hose assembly
	299051	Throttle pin for Type II hose assembly
	199018	Throttle pin for Type III hose assembly
14./21.		Pilot water hose
	299005	6m

SPARCIN 8 / SPARCIN 8C

	299038	12m
	299041	20m
15.		Connection to current lead
16.	199015	Torch switch START
17a.	199016	Torch handle for manual torches
17b.	199067	Torch handle for SPARCUT XL/M™ torch
18.	299074	Safety switch
19a.		Hose assembly for manual torch, liquid cooled, Type I
	299003	6m
	299032	12m
	299033	20m
		Hose assembly for manual torch, liquid cooled, Type II/III
	299045	6m
	299046	12m
	299047	20m
19b.		Hose assembly for machine torch, Type I
	299034	6m
	299035	12m
	299036	20m
		Hose assembly for machine torch, Type II/III
	299048	6m
	299049	12m
	299050	20m
20.	199110	Protective hose, Type I
	199111	Protective hose, Type II/III
23.	183202	Control cable
24.		Gas hose (without throttle pin)
	299006	6m
	299040	12m
	299043	20m
35.	199157	Cover
36.	299101	Front piece with holder
37.	199161	Nylon screw
38.	199155	Electrical connector
39.	199154	Tightening screw
40.	199153	Spring
41.	199156	Contact piece
42.	199159	Inner O-ring
43.	199152	Insulator
44.	199160	Outer O-ring
45.		Pilot lead
	299089	6m
	299090	12m
	299091	20m
46.		Gas hose
	299006	6m
	299040	12m
	299043	20m
47.		Coolant return hose
	299098	6m

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	299099	12m
	299100	20m
48.		Coolant hose
	299095	6m
	299096	12m
	299097	20m
49.		Current lead
	299092	6m
	299093	12m
	299094	20m
50.	199164	Reduction nipple 8-4
51.	199036	Hose clamp
52.	299102	Gas hose l=55 mm
53.	199165	Reduction nipple 4-4
54.	299080	BAZOOCUT torch head complete
	299107	EXCALIBUR torch head complete
55.		Hose assembly BAZOOCUT/EXCALIBUR Type I
	299083	6m
	299084	12m
	299085	20m
		Hose assembly BAZOOCUT/EXCALIBUR Type II
	299086	6m
	299087	12m
	299088	20m
56.	199186	Nylon nut
57.	199187	Nylon screw
58.	199189	Electrical connector, EXCALIBUR
59.	199188	Contact piece, EXCALIBUR
60.	199190	O-ring, inner, contact piece, EXCALIBUR
61.	199191	O-ring, inner, electrical connector, EXCALIBUR

ACCESSORIES

299078	Distance roller, all torches
299082	Circle cutting bar, SPARCUT XL
299208	Circle cutting bar, SPARCSPLIT
299079	Circle cutting bar, DURACUT

COMPLETE TORCHES**IMPORTANT!**

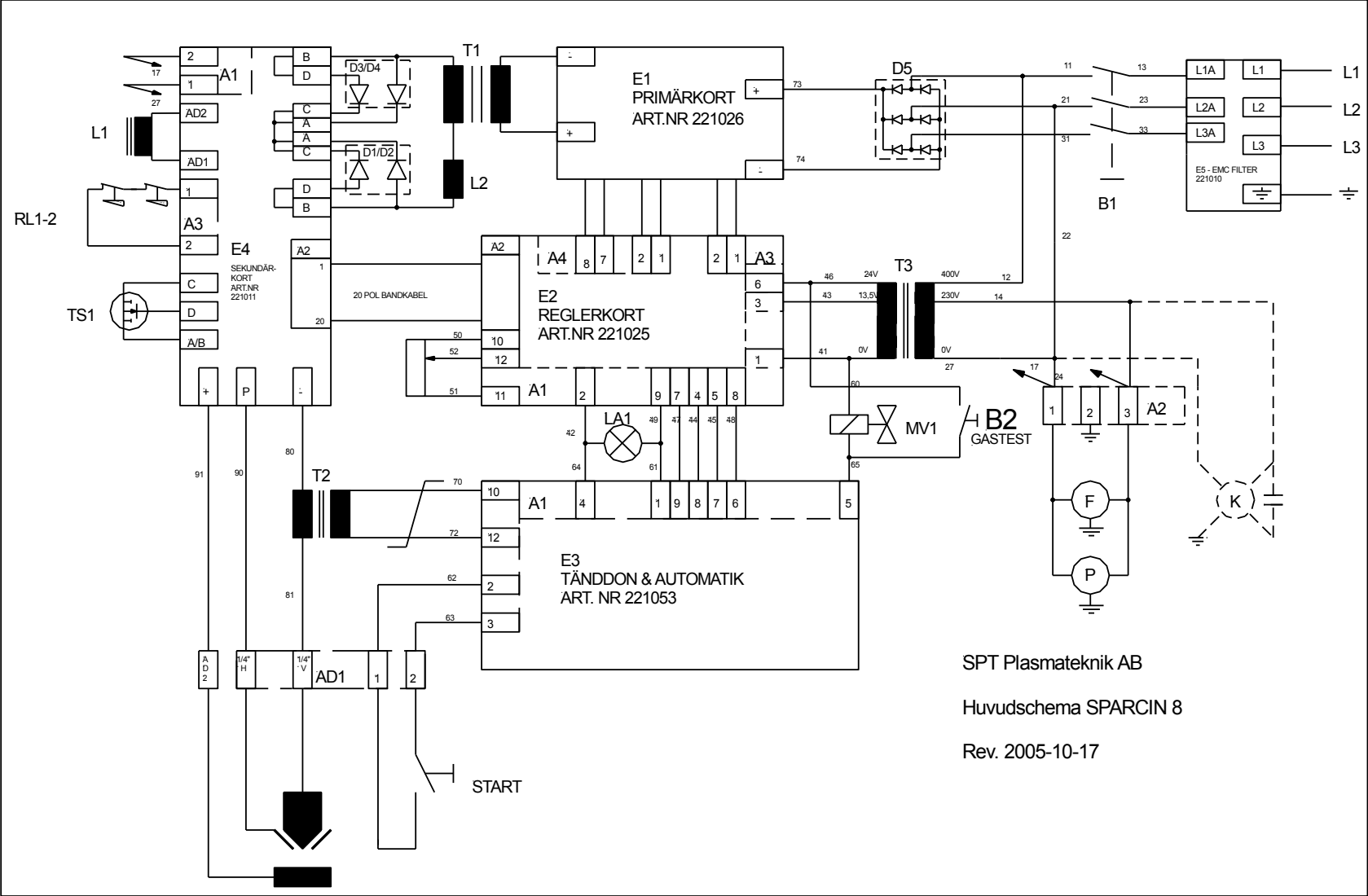
For SPARCON 9 and SPARCON 900 use only Type I torches. For SPARCIN 5/5C, SPARCIN 9, SPARCON 1200 and SPARCIN 1800 use only Type II torches. For SPARCIN 9C use only Type III torches. Type I torches have the text "...SPARCON 9 SPARCON 900..." on the hose assembly. Type II and III torches have the text "...SPARCIN SPARCON 1200..." on the hose assembly. On Type III torches, the throttle nozzle has been removed. The use of incorrect torches may result in damage to torch and power source.

399001	SPARCUT XL 6m Type I
399005	SPARCUT XL 12m Type I
399006	SPARCUT XL 20m Type I
399009	SPARCUT XL 6m Type II
399010	SPARCUT XL 12m Type II
399011	SPARCUT XL 20m Type II
399047	SPARCUT XL 6m Type III
399004	SPARCUT XL/M 6m Type I
399007	SPARCUT XL/M 12m Type I
399008	SPARCUT XL/M 20m Type I
399012	SPARCUT XL/M 6m Type II
399013	SPARCUT XL/M 12m Type II
399014	SPARCUT XL/M 20m Type II
399046	SPARCUT XL/M 6m Type III
399020	SPARCSPLIT 6m Type I
399021	SPARCSPLIT 12m Type I
399022	SPARCSPLIT 20m Type I
399030	SPARCSPLIT 6m Type II
399031	SPARCSPLIT 12m Type II
399032	SPARCSPLIT 20m Type II
399048	SPARCSPLIT 6m Type III
399033	DURACUT 6m Type I
399034	DURACUT 12m Type I
399035	DURACUT 20m Type I
399036	DURACUT 6m Type II
399037	DURACUT 12m Type II
399038	DURACUT 20m Type II
399045	DURACUT 6m Type III
399042	DURASPLIT 6m
399049	BAZOOCUT 6m Type I
399050	BAZOOCUT 12m Type I
399051	BAZOOCUT 20m Type I
399052	BAZOOCUT 6m Type II
399053	BAZOOCUT 12m Type II
399054	BAZOOCUT 20m Type II
399055	EXCALIBUR 6m Type I
399056	EXCALIBUR 12m Type I
399057	EXCALIBUR 20m Type I
399058	EXCALIBUR 6m Type II

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399059	EXCALIBUR 12m Type II
399060	EXCALIBUR 20m Type II

12. WIRING DIAGRAM



SPT Plasmateknik AB
 Huvudschema SPARCIN 8
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