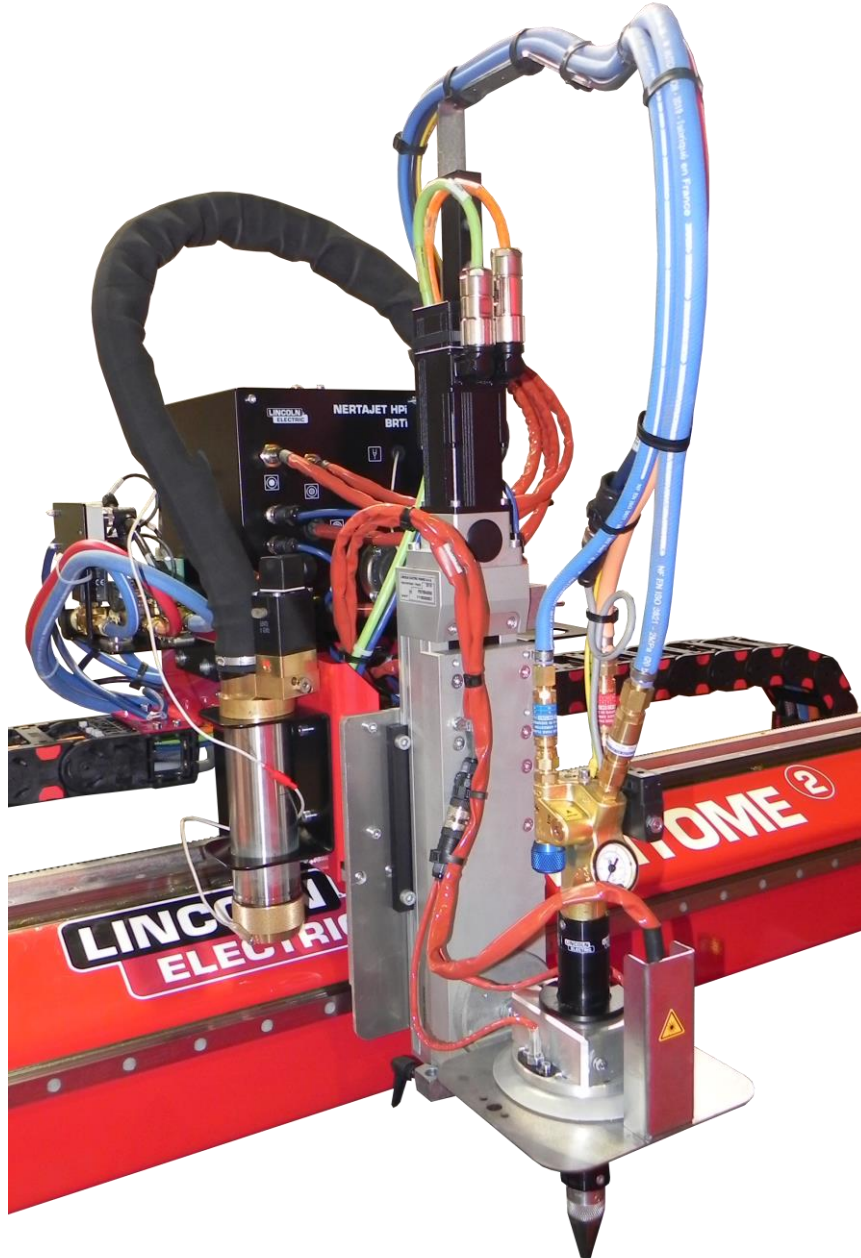


# OPTIONAL OXY-FUEL CUTTING

*FOR OPTITOME II HPCII & OPTITOME II HPCIII*  
No P07004530NG - P07004537NG



EDITION : EN  
REVISION : C  
DATE : 11-2023

Instructions for use

REF. : **8695 4789**

*Original instructions*

**Thank you 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 shall not be liable if the product is used in association with items not recommended by the manufacturer.**

**For your safety, below is a non-limitative list of recommendations or requirements, many of which appear in the labour code.**

**Lastly, please inform your supplier of any error you may find in this instruction manual.**

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# REVISIONS

**REVISION C**

**11/23**

DESCRIPTION	PAGE
Created in English	

# A - IDENTIFICATION

Please refer to machine documentation

## B - SAFETY INSTRUCTIONS

### 1 - GENERAL SAFETY INSTRUCTIONS



For general safety instructions, please refer to the specific manual supplied with the equipment, reference 8695 7050



Special safety systems are also recommended in the documentation of **ESSENTIAL OXY-FUEL CUTTING** (86954985)



**Electrical safety**, refer to the specific manual.  
The plasma/oxy-fuel cutting tool must be changed with the emergency stop engaged.



During the tool change process, the use of **Personal Protective Equipment (PPE)** is **mandatory**.  
The tools may be very hot.



**Tool change, no climbing** on the table to change tools.  
Put the tool holder in a position that allows safe tool changes before pressing the emergency stop.



### 2 - AIRBORNE NOISE

Refer to the special instructions supplied with the equipment.

# C - DESCRIPTION

## 1 - DESCRIPTION

The torch is fixed to the tool holder of the plasma installation.

The maximum cutting thicknesses are:

- 6 to 30 mm for regular cutting
- 50 mm for occasional cuts.



Refer to the documentation of **ESSENTIAL OXY-FUEL CUTTING**  
(86954985)



Optional **ESSENTIAL SEAM TRACKING** is not permitted in this configuration.



Optional **ESSENTIAL FIRING** is not permitted in this configuration.

# D - ASSEMBLY AND INSTALLATION

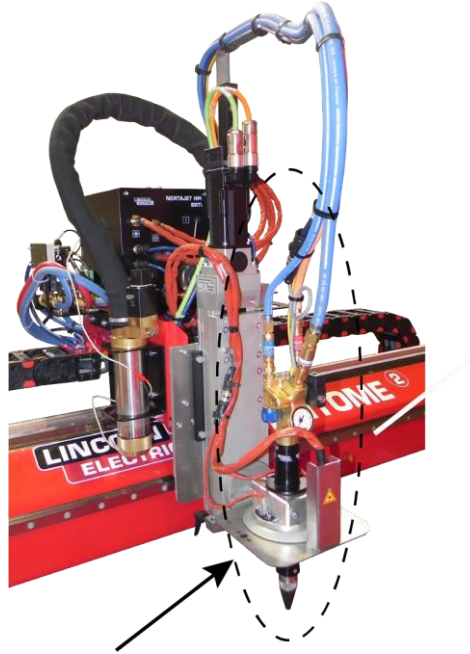
## 1 - CONNECTIONS



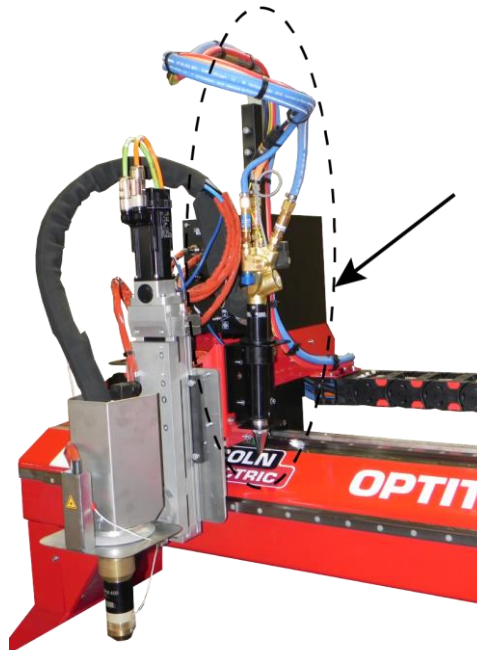
Refer to the documentation of **ESSENTIAL OXY-FUEL CUTTING** (86954985), section D - ASSEMBLY AND INSTALLATION.

The torch is fixed:

- either in the torch impact safety system if it is used while cutting



- or standing by near the **THDi** tool holder



# E - OPERATING MANUAL

## 1 - HMI CONTROLS

All the HMI controls can be found in the documentation of **HPC DIGITAL PROCESS**, in the sections relating to **ESSENTIAL OXY-FUEL CUTTING**.



Refer to the documentation of:

- **HPC DIGITAL PROCESS II** (8695 4944) or
- **HPC DIGITAL PROCESS III** (8695 4995)

## 2 - TORCH MOVEMENT CONTROLS

**Away from cutting:** the high-speed up/down controls can be used from the HMI (plasma related).

**During and away from cutting:** the up/down controls can be used from the console of **OPTITOME II**.



Refer to the documentation of:

- **HPC DIGITAL PROCESS II** (8695 4944) and **OPTITOME II HPCII** (8695 4788) or:
- **HPC DIGITAL PROCESS III** (8695 4995) and **OPTITOME II HPCIII** (8695 4791)

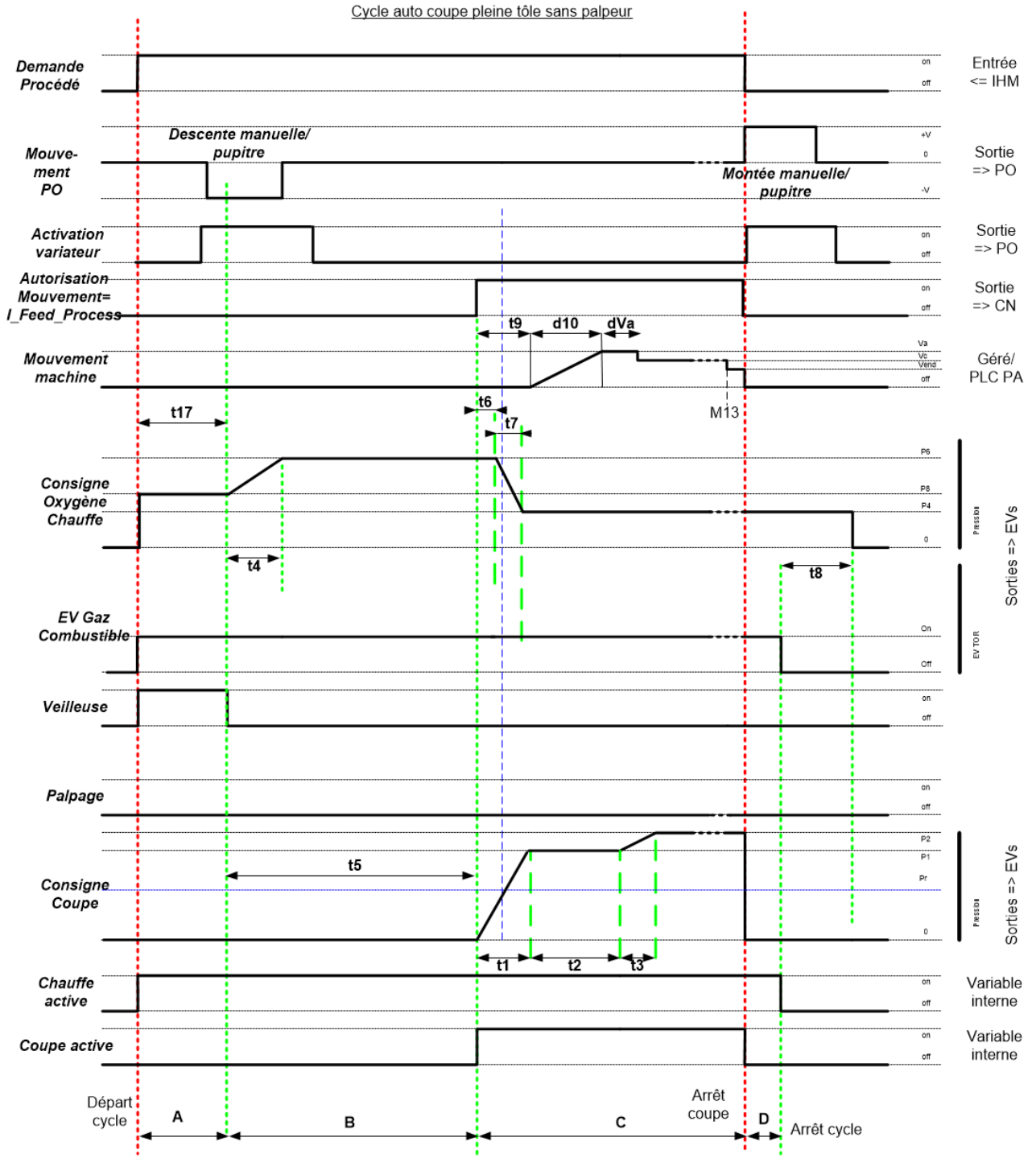
## 3 - GAS SUPPLY AND CHANGE



Refer to the documentation of **ESSENTIAL OXY-CUTTING** (86954985)



# 4 - CYCLE TIME CHART



A	<u>Firing stage</u>
B	<u>Overheating stage</u> : plate piercing. <b>Important!</b> This stage does not exist with plate-edge starts.
C	<u>Cutting stage</u> : the cutting pressure increases gradually (no step if plate edge) and moves from overheating pressure to cutting pressure. Then the movement starts.
D	<u>Heating stage</u> (up to the next strike): At the end of the part program, the torch goes out.

The tool holder does not move up automatically at the end of the part program, it can only be moved manually.  
The tool holder does not retract automatically at the start of the cut, it can only be moved manually.



Torch firing is determined by the plasma torch, which must be in its holder in the standby position near the tool holder **THDi**.

## F - MAINTENANCE

### 1 - CARE



Refer to the documentation of **ESSENTIAL OXY-FUEL CUTTING** (86954985), section F - MAINTENANCE.

### 2 - TROUBLESHOOTING



Refer to the documentation of **ESSENTIAL OXY-FUEL CUTTING** (86954985) section F - MAINTENANCE.

Fault	Probable cause	Remedy
The torch will not fire	The plasma torch is not in its holder in the standby position near the tool holder <b>THDi</b> .	Stop the process and put the plasma torch back in its place in the holder in the standby position near the tool holder <b>THDi</b> .

### 3 - 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 references

(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 reference.

For example:

Item	Part no	Stock	Order	Description
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.

CE Type <input type="text"/> Matricule <input type="text"/>	TYPE: <input type="text"/> Number: <input type="text"/>
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Refer to the documentation of **ESSENTIAL OXY-FUEL CUTTING** (86954985), section F - MAINTENANCE.

Item	Part no	Stock	Order	Description
				Brushless variable drive, 5A 230V INFRANOR See instructions 86954615 "BRGi assembly"
	PC5704346			ZCMD21L2 position detector
	PC5704379			Detector rotating head, ZCE01

✓	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.

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

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