

OPTION

HPi INOX

SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE

OPTION N° 04097535NG

EDITION : EN
REVISION : F
DATE : 11-2020

Instructions for use

REF : **8695 4617**

Original instructions

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.

CONTENTS

A - IDENTIFICATION	6
B - SAFETY INSTRUCTIONS.....	8
C - DESCRIPTION	8
D - MONTAGE INSTALLATION	8
1 - CONDITIONS OF INSTALLATION	8
2 - UNPACKING - HANDLING	8
3 - INSTALLATION.....	8
E - OPERATOR MANUEL	13
1 - SETUP OF INDEPENDENT INSTALLATION.....	13
2 - SETUP OF INTEGRATED INSTALLATION	13
3 - USE	13
F - MAINTENANCE.....	14
1 - SPARE PARTS	14
PERSONAL NOTES	16

REVISIONS

REVISION B **07/14**

DESIGNATION	PAGE
Creation in several languages	

REVISION C **02/19**

DESIGNATION	PAGE
To change logos	

REVISION D **02/20**

DESIGNATION	PAGE
Add T5 torch	

REVISION E **10/20**

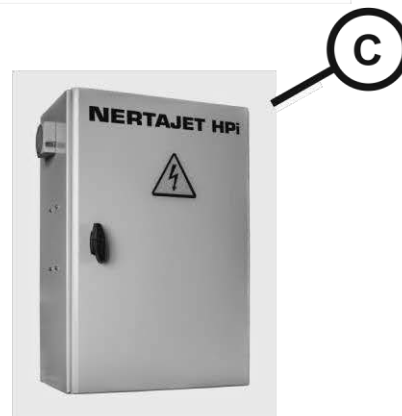
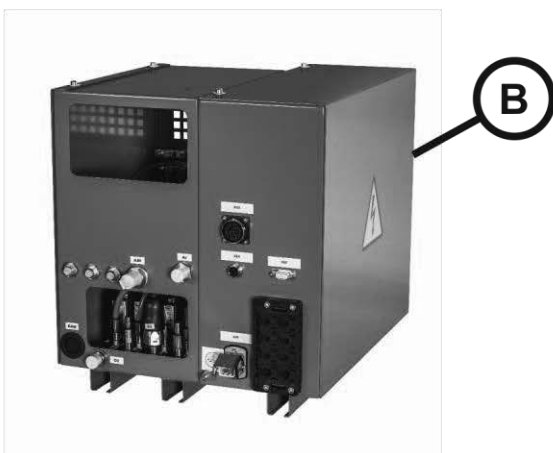
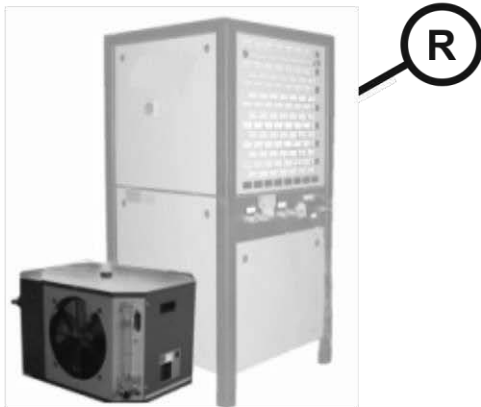
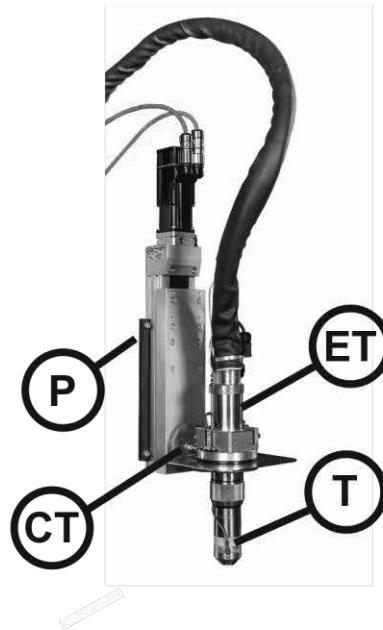
DESIGNATION	PAGE
Update	11

REVISION F **11/20**

DESIGNATION	PAGE
CPM600wi => CPM PRO INOX	

A - IDENTIFICATION

Please refer to the document: 8695 4615.



INSTALLATION NERTAJET HPi	
REFERENCE	DESCRIPTION
A	Torch connection box (BRTi)
B	Gas connection box (BRGi)
C	Cycle function assembly (LINCOLN ELECTRIC machine cabinet or process box)
CT	Magnetic torch impact safety system
ET	Torch connector + torch bundle
G	NERTAJET HP 150 HPi power source or NERTAJET HP 300 HPi power source
P	Numerical tool holder (THDi)
R	Cooling unit
T	CPM400 BLACK torch tip or CPM PRO INOX torch tip or T5 torch tip

B - SAFETY INSTRUCTIONS

Please refer to document : 8695 4615.



The solenoid valve test procedure must absolutely be carried out regularly.



This option uses gases such as argon/hydrogen and oxygen. The mixing of these two gases can be hazardous.

C - DESCRIPTION

This option makes it possible to add the stainless steel cutting function to an independent or standard integrated NERTAJET HPI installation.

D - MONTAGE INSTALLATION

1 - CONDITIONS OF INSTALLATION

Nitrogen must absolutely be available to allow the use of the installation when this option is present.
The gas conditions are defined in the document 8695 4615.

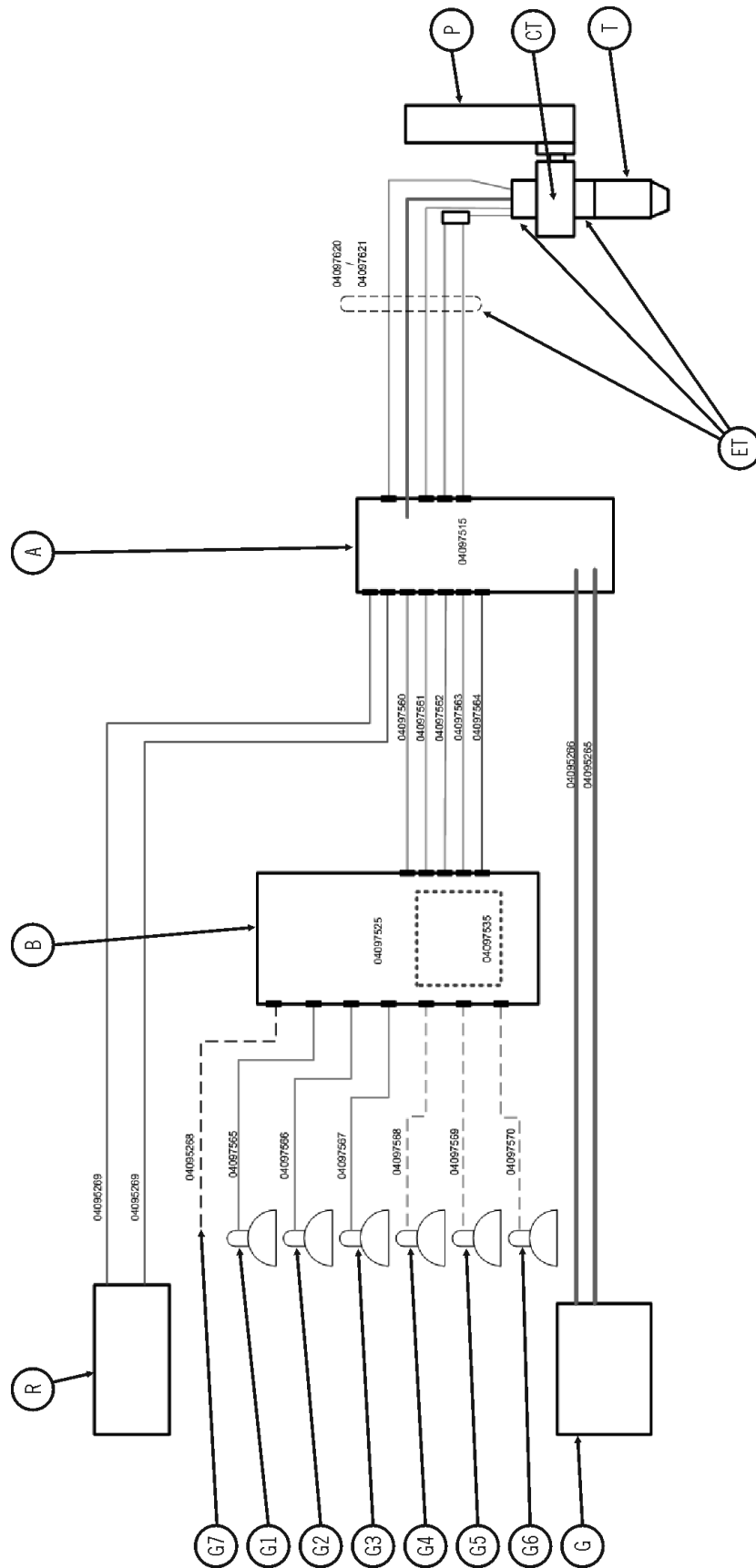
2 - UNPACKING - HANDLING

No specific instructions.

3 - INSTALLATION

The addition of this option makes it necessary to add several hoses at the entry of the **BRGi** and to modify the **BRGi**.

3.1 FLUID CONNECTIONS

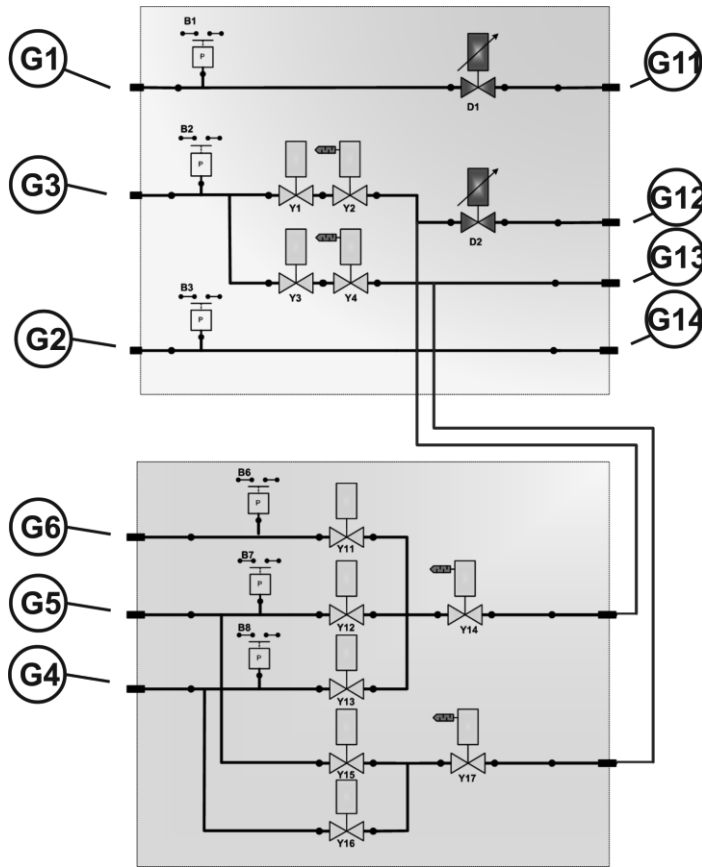


Add the bundles in orange dotted lines.

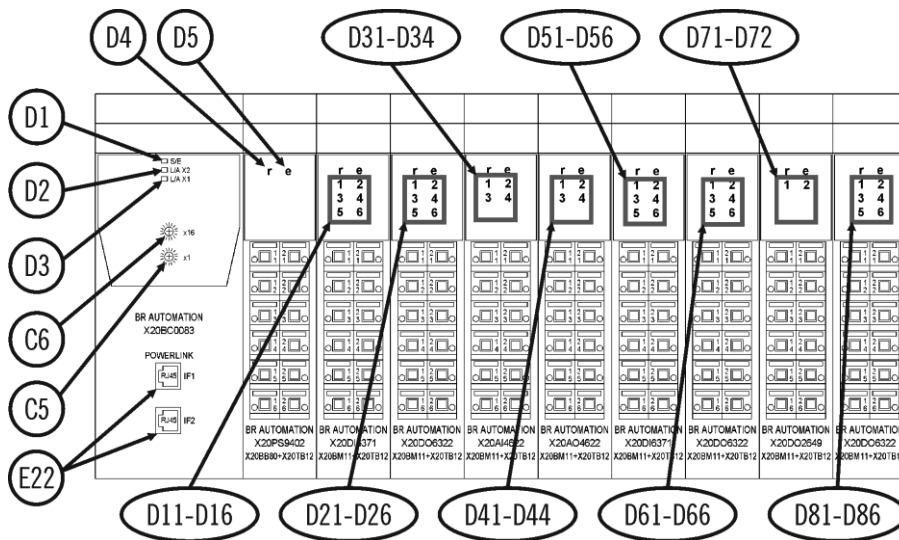
3.2 ELECTRICAL CONNECTIONS

No external difference. The changes are internal to BRGi.

3.3 MODIFICATION OF THE GAS CONNECTION BOX



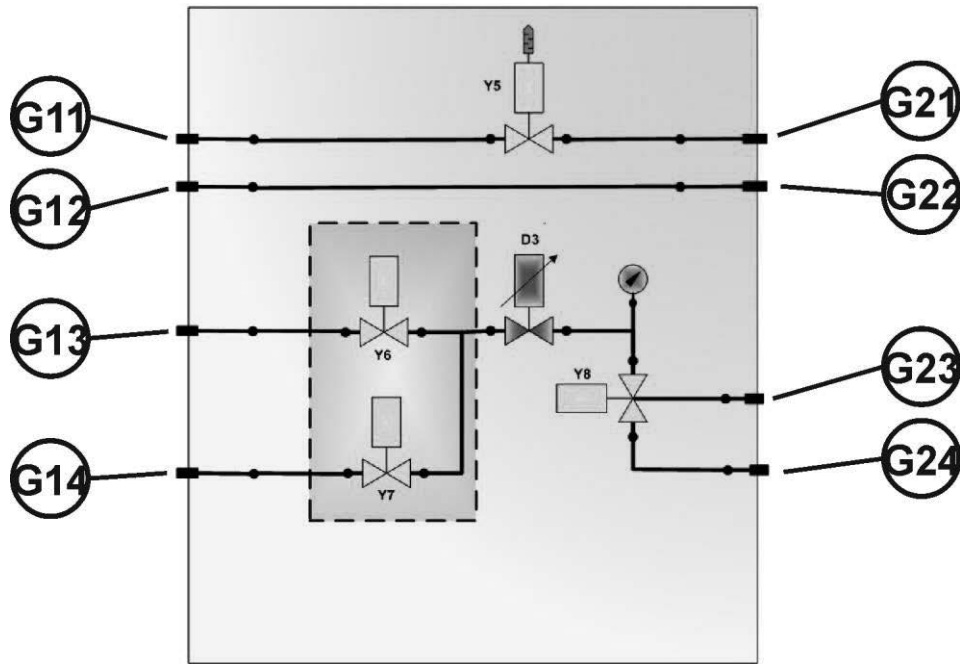
The lower part containing G4, G5, G6, B6, B7, B8, Y11, Y12, Y13, Y14, Y15, Y16 and Y17 is added when this option is installed.



Addition of modules containing indicators D11-D16 and D21-D26.

Indicator	Colour	Status	Meaning
D11 (B6 - option inox)	Green	Off	Gas F5 absent or air for torch T5
	Green	On and steady	Gas F5 present or air for torch T5
D12 (B7 - option inox)	Green	Off	Gas Ar/H2 or H17 absent
	Green	On and steady	Gas Ar/H2 or H17 present
D13 (B8 - option inox)	Green	Off	Gas Nitrogen absent
	Green	On and steady	Gas Nitrogen present
D14 (B9 - option inox + vortex)	Green	Off	Water absent
	Green	On and steady	Water present
D15	Green	-	Not used
D16	Green	-	Not used
D21 (Y12 - option inox)	Yellow	Off	Ar/H2 or H17 gas not selected as cutting gas.
	Yellow	On and steady	Ar/H2 or H17 gas selected as cutting gas.
D22 (Y13 - option inox)	Yellow	Off	N2 gas not selected as cutting gas.
	Yellow	On and steady	N2 gas selected as cutting gas.
D23 (Y14 - option inox)	Yellow	Off	None of Nitrogen, Ar/H2 or H17 and F5 or air gases selected as cutting gas.
	Yellow	On and steady	Nitrogen, Ar/H2 or H17 or F5 or air gas selected as cutting gas.
D24 (Y15 - option inox)	Yellow	Off	Ar/H2 or H17 gas not selected as annular gas.
	Yellow	On and steady	Ar/H2 or H17 gas selected as annular gas.
D25 (Y16 - option inox)	Yellow	Off	N2 gas not selected as annular gas.
	Yellow	On and steady	N2 gas selected as annular gas.
D26 (Y17 - option inox)	Yellow	Off	None of Nitrogen, Ar/H2 or H17 gases selected as annular gas.
	Yellow	On and steady	Nitrogen, Ar/H2 or H17 gas selected as annular gas.

3.4 MODIFICATION OF TORCH CONNECTION UNIT



No change in the **BRTi**.

E - OPERATOR MANUEL

1 - SETUP OF INDEPENDENT INSTALLATION

Please refer to the document 8695 4946.

2 - SETUP OF INTEGRATED INSTALLATION

Please refer to the document

- 8695 4948 => **HPC DIGITAL PROCESS HPI**
- 8695 4944 => **HPC DIGITAL PROCESS II.**

3 - USE

Note that in certain conditions (starting up, hazardous method change), inerting and filling are carried out. As a result, method changes can take more time when this option is present.

Automatic installations

The system takes charge of flushing the affected lines.

Manual installations

The operator must:

- Disconnect the current gas from the line to flush
- Connect neutral gas to the line to flush
- Run a cutting gas test for 25 to 60 seconds depending on the size of the installation
- Connect the gas to use for cutting on the corresponding line
- Run a cutting gas test for 25 to 60 seconds depending on the size of the installation

Then select the process to use

F - MAINTENANCE

Please refer to the document 8695 4615.

1 - 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.)

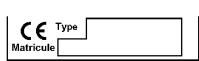
For items noted on the photos or sketches but not in the tables, send a copy of the page concerned, highlighting the particular mark.

For example:

Item	Ref.	Stock	Order	Designation
1	W000XXXXXX	✓		Machine interface board
2	W000XXXXXX	✗		Flowmeter
3	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:
	Number:

✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
	P04097536			BRGi stainless steel gas line
B6 B7 B8	W000265273	✓		Pressure sensor
Y14 Y17	W000382512	✓		Three-way solenoid valve
Y11 Y12 Y13 Y15 Y16	W000382510	✓		Two-way solenoid valve
D11- D16	W000383705	✗		Six-input module, on/off
D21- D26	W000383707	✗		Six-output module, relay on/off

➤ 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 :
	Matricule :

