

PLASMA CUTTING MACHINE

PEGAS 100 PLASMA

OPERATING MANUAL

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1. INTRODUCTION

Congratulations on your new ALFA IN product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry.

This Operating Manual has been designed to instruct you on the correct use and operation of your ALFA IN product. Your satisfaction with this product and its safe operation is our ultimate concern. Therefore please take the time to read the entire manual, especially the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product.

Read and understand this entire Manual and your employer's safety practices before installing, operating, or servicing the equipment. While the information contained in this Manual represents the Manufacturer's best judgement, the Manufacturer assumes no liability for its use.

Machine PEGAS 100 PLASMA is designed for cutting metal on the basis of modern technology cutting material through a thin beam plasma gas.

PEGAS 100 PLASMA is designed for high-quality cutting of materials up to 30 mm thick carbon steel (for more information, see instructions below). Productive cutting of carbon steel can be to a thickness of 25 mm. At lower demands on the quality of the cut can be cut through (separate) the material thickness to 40 mm.



2. SAFETY INSTRUCTIONS AND WARNINGS

1. OPERATION AND MAINTENANCE OF PLASMA ARC EQUIPMENT CAN BE DANGEROUS AND HAZARDOUS TO YOUR HEALTH.
2. Plasma arc cutting produces intense electric and magnetic emissions that may interfere with the proper function of cardiac pacemakers, hearing aids, or other electronic health equipment. Persons who work near plasma arc cutting applications should consult their medical health professional and the manufacturer of the health equipment to determine whether a hazard exists.
3. Once the packing has been opened, make sure that the machine is not damaged. If in any doubt, call the service centre.
4. This equipment must only be used by qualified personnel.
5. During installation, any electric work must only be carried out by trained personnel.
6. The machine must be used in a dry place with good ventilation.
7. Make sure that no metal dust can be drawn in by the fan inside the machine, as this could cause damage to the electronic circuits.
8. It is prohibited to connect more than one INVERTER generator in series or in parallel.
9. When installing the machine, follow the local regulations on safety.
10. The position of the machine must allow easy access by the operator to the controls and connectors.
11. When the cutting machine is operating, all its covers and doors must be closed and well fixed.
12. Do not expose the cutting machine to direct sunlight or to heavy rain. This equipment conforms to protection rating IP23S.
13. The operator must wear gloves, clothes, shoes, and a helmet or a welder's helmet, which protect and are fire-resistant in order to protect him against electric shock, flashes and sparks from cutting.
14. The operator must protect his eyes with safety visor or mask designed for welding, fitted with standard safety filters. He should also be aware that during plasma cutting ULTRAVIOLET RADIATION is emitted. Therefore it is vital that his face is also protected from radiation. Ultraviolet rays produce the same harmful effect as sun burning on unprotected skin.
15. The operator is obliged to warn anyone near the cutting area of the risks that cutting involves and to arrange to provide adequate protection equipment.
16. Keep all fumes and gases from the breathing area.
17. Keep your head out of the fume plume.
18. Use an air-supplied respirator if ventilation is not adequate to remove all fumes and gases.
19. The kinds of fumes and gases from the plasma arc depend on the kind of metal being used, coatings on the metal, and the different processes. You must be very careful when cutting or welding any metals which may contain

one or more of the following:

Antimony	Chromium	Mercury
Nickel	Cobalt	Arsenic
Barium	Copper	Selenium
Beryllium	Lead	Silver
Cadmium	Manganese	Vanadium

20. Always read the Material Safety Data Sheets (MSDS) that should be supplied with the material you are using. These MSDSs will give you the information regarding the kind and amount of fumes and gases that may be dangerous to your health.
21. It is very important to arrange for sufficient ventilation, especially when cutting in enclosed spaces. We suggest using suitable fume extractors to prevent the risk of intoxication by fumes or gas generated by the cutting process.
22. Noise can cause permanent hearing loss. Plasma arc processes can cause noise levels to exceed safe limits. You must protect your ears from loud noise to prevent permanent loss of hearing.
23. To protect your hearing from loud noise, wear protective ear plugs and/or ear muffs. Protect others in the workplace.
24. Noise levels should be measured to be sure the decibels (sound) do not exceed safe levels.
25. The operator must ensure all flammable materials are removed from the work area to avoid any risk of fire.
26. The operator must NEVER cut containers that have previously contained petrol, lubricants, gas or similar flammable materials, even if the container has been empty for a considerable time. **THERE IS A VERY HIGH RISK OF EXPLOSION.**
27. The operator must be aware of all the special regulations which he needs to conform to when cutting in enclosed spaces with a high risk of explosion.
28. To prevent electric shock, we strongly suggest the following rules:
 - a) Do not work in a damp or humid environment.
 - b) Do not use the machine if its cables are damaged in any way.
 - c) Make sure that the earthing system of the electric equipment is correctly connected and operational.
 - d) The operator must be insulated from the metal components connected to the return wire.
 - e) The earthing of the piece being worked could increase the risk of injury to the operator.
29. EN 60974-1 Standard: Open-circuit voltage. During the operation of the machine, the highest voltage, with which it is possible to come into contact, is the open-circuit voltage between the clamps. In our generator this voltage is 350V.
30. The maximum open-circuit voltage of the plasma machines is established by national and international standards (EN 60974-1) depending on the type

of current to be used, on its waveform and on the hazards arising from the work place. These values are not applicable to the strike currents and those for stabilisation of the arc that could be above it.

31. The open-circuit voltage, for as many adjustments as possible, must never exceed the values relating to the various cases shown in the following table:

Case	Working conditions	Open-circuit voltage	
1	Places with increased risk of electric shock	DC current: 113V peak value	AC current: 68V peak value and 48V effective
2	Places without increased risk of electric shock	DC current: 113V peak value	AC current: 113V peak value and 80V effective
3	Torches held mechanically with increased protection for the operator	DC current: 141V peak value	AC current: 141V peak value and 100V effective
4	Plasma cutting	DC current: 500V peak value	

32. In case 1, the dc machines with rectifier must be built in such a way that, in case of a fault developing in the rectifier (for example open circuit, short circuit or lack of power), the permitted values cannot be exceeded. The

plasma cutting machines of this type can be marked with the symbol: 

33. Before opening the machine switch off the machine and disconnect it from the power socket.
34. Only personnel authorised by this company can carry out maintenance on the machine.

2.1 ELECTROMAGNETIC COMPATIBILITY (EMC)

1. This machine conforms to EN 60974-10 standard. However, the electromagnetic emissions generated could prove not be compatible with the maximum permitted levels for some classes of electrical equipment, such as the following:
 - a) Domestic electronic appliances (radios, TVs, videos, telephones, burglar alarms, etc.).
 - b) Computers, robots, electro-medical instruments and life-support systems.
 - c) Radio-television transmitters and receivers.
 - d) Pacemakers and hearing aids.
 - e) All very sensitive electrical equipment.
2. The operator is responsible for the installation and use of the cutting machine. If there should be any fault in operations of other systems located in the immediate vicinity of the generator, we recommend suspending

operations and consulting the manufacturers.

2.2 PROTECTIVE UTILITIES

1. Welding helmet with filter shade at least 10
2. Welding gloves
3. Welding apron and cloth
4. Welding boots

2.3 RISK OVERVIEW

1. Risk of electric shock.
2. Ultraviolet light and light radiation
3. Risk of inhaling gas fumes and dust particles
4. Burns
5. Noise



The Machine Torches (AUT) must not be used with PEGAS 100 PLASMA. It may only be used together with PEGAS 100 PLASMA CNC.



1. It is forbidden to operate a machine with damaged insulation of the cutting torch or supply cable.
2. Never operate the machine taken down or damaged covers.
3. It is forbidden to operate the machine in wet environments and outdoors in rain or snow.
4. Ensure proper grounding clamping pliers, which also reduces the risk of electric shock.
5. Use prescribed protective utilities, keep them dry.
6. Plasma arc cutting produces intense electric and magnetic emissions that may interfere with the proper function of cardiac pacemakers, hearing aids, or other electronic health equipment. Persons who work near plasma arc cutting applications should consult their medical health professional and the manufacturer of the health equipment to determine whether a hazard exists.
7. Never aim the torch against the eyes, body or other person.

3. CONDITIONS OF USE

1. This equipment must only be used by qualified personnel.
2. During installation, any electric work must only be carried out by trained personnel.
3. Do not expose the plasma machine to direct sunlight or to rain or snow. This equipment conforms to protection rating IP23S.
4. Place the machine the way that the cooling air can enter the vents without

restriction to. It is necessary to ensure that no impurities, especially metal particles, are not drawn into the machine.

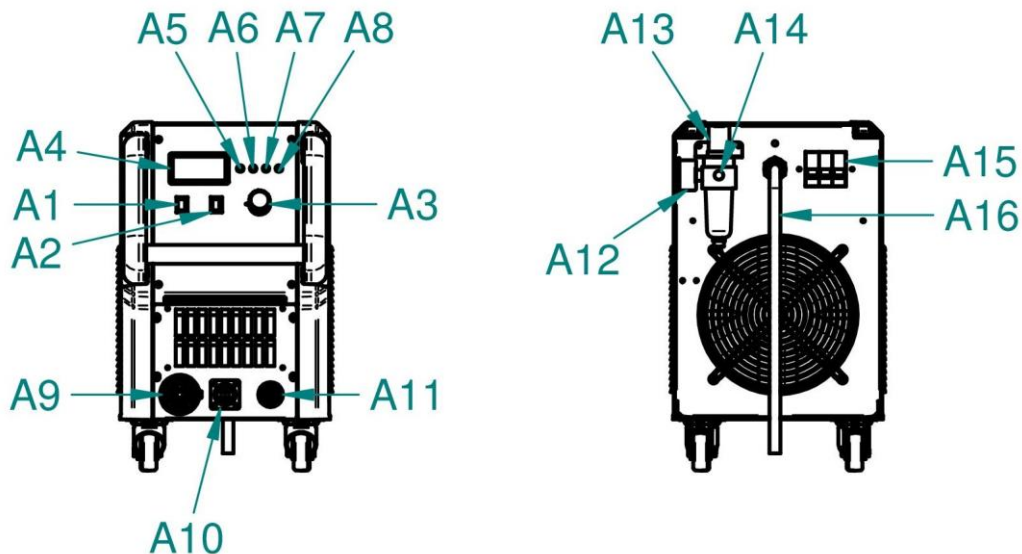
5. Cutting machine in terms of interference suppression is intended primarily for industrial premises. In the case of use of other areas may be need for special measures (see EN 60974-10).
6. The machine must be protected against
 - a) moisture and rain and snow
 - b) mechanical damage
 - c) draft and any ventilation of neighbouring machine
 - d) excessive overloading - crossing technical parameters
 - e) rough handling







4. TECHNICAL DATA

Method			Plasma cutting
Mains voltage		V/Hz	3 x 400/50-60
Mains protection		A	25 @
Max. input power I_1		A	26,7
Max. effective current I_{1eff}		A	21,7
Cutting current range		A/V	10/84,0 - 100/120,0
Open-circuit voltage U_{20}		V	350
Cutting current (DC=100%) I_2 / U_2		A/V	80/112,0
Cutting current (DC=60%) I_2 / U_2		A/V	100/120,0
Cutting current (DC=x%) I_2 / U_2		A/V	---
Max. productive cut. thickness - carbon steel		mm	25
Max. cutting thickness - carbon steel (separate mat.)		mm	40
Quality cutting thickness	Carbon steel	mm	30
	Stainless steel	mm	20
	Aluminium	mm	15
	Copper	mm	10
Working pressure		bar	5,0
Max. Input pressure		bar	8,5
Air consumption		l/min	180
Arc ignition			contact
Current regulation			continuous
Insulation class			F
Protection			IP 21 S
Standards			EN 60974-1
Dimensions (w x l (with and without Pressure regulator) x h)		mm	280 x 728 (682) x 460
Weight		kg	37,5

5. OPERATOR CONTROLS

5.1 FRONT AND REAR PANELS



A1	Switch CUT / AIR SET - for setting the gas pressure
A2	Switch  panel/  remote control (remote ctrl is only per order)
A3	Cutting current potentiometer
A4	Display – displays set parameters (A)
A5	 LED – low air pressure
A6	 LED – mains under voltage
A7	 LED – machine is over heated
A8	 LED – power overload
A9	Torch central connector
A10	Remote control connector (only per order)
A11	Work leads with the plagues
A12	Manometer
A13	Pressure regulator
A14	Air quick connector
A15	ON/OFF switch
A16	Mains supply cable

6. ACCESSORIES

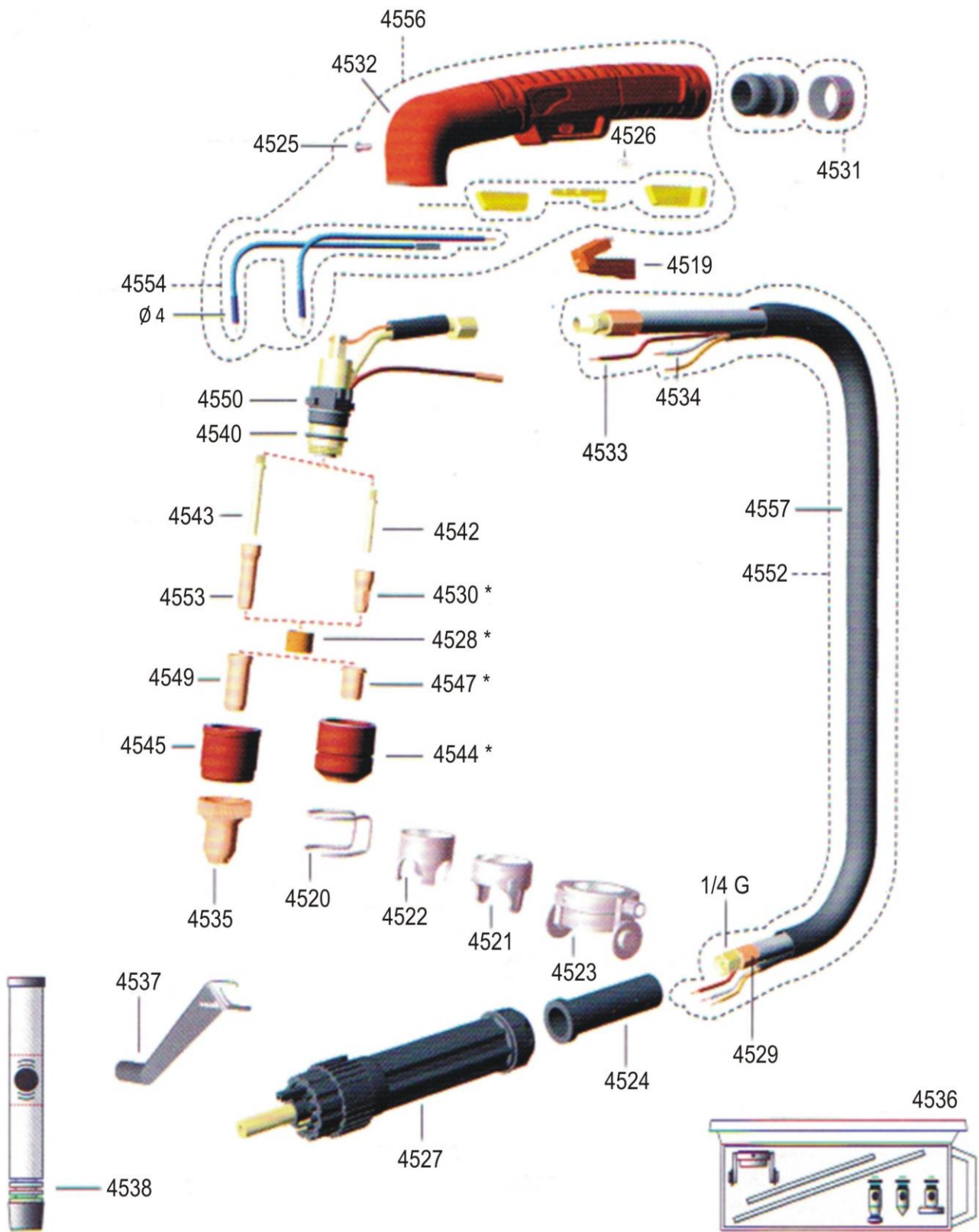
6.1 PART OF DELIVERY

	Code	Description
	5.0236	PEGAS 100 PLASMA
One of them	4514	Torch S 105 6m Plasma PEGAS 100 Plasma
	SCP120-6	Torch SCP120 6m
	V9030038	Earthing cable with clamp 3m 10-25 150A

6.2 ON REQUEST

Pos.	Code	Description
	4536	Circular Cutting Attachment S 105
	SCP1250	Circular Cutting Attachment 120
	5302	Air filter AT 1000
	5304	Set for filter AT 1000 to P 100-160 Plasma
	S777a	Welding Helmet ALFA IN S777a Black
	4515	Torch S 105 12m Plasma PEGAS 100 Plasma
The Machine Torches (AUT) must not be used with PEGAS 100 PLASMA. It may only be used together with PEGAS 100 PLASMA CNC.		
	4516	Torch S 105 6m Plasma PEGAS 100 Plasma AUT
	4517	Torch S 105 12m Plasma PEGAS 100 Plasma AUT

Torch S 105



Item No	Description	
4518	Switch - fuse for A81	
4519	Switch Torch A81, 141 (plasma)	
4520	Stand Off Guide A141	
4521	Two Pins Crown A141, S105	

4522	Four Pins Crown A140, A90, S105	
4523	Trolley Guide A141	
4524	Cuff plasma A80	
4525	Screw 2,9x13	
4526	Stand Off trigger	
4527	Central torch connection PLASMA	
4528	Diffuser S74	*
4529	Power cable 6m 1/4G	
4530	Electrode standard S74-105 plasma	*
4531	Cable support	
4532	Red Plasma handle	
4533	Pilot arc cable 2.5 mm ²	
4534	Control leads cable 2x0.50 Ø5.2	
4535	Stand off long guide	
4536	Circular Cutting Attachment S 105	
4537	Electrode wrench	
4538	Flowmeter S 105	
4539	Screw M4x4	
4540	O ring 18x2 Viton	
4541	O ring 22x2 Viton	
4542	Air tube	
4543	Long air tube	
4544	Nozzle Long Life	*
4545	Contact nozzle Long Life	
4546	Tip 1,0 standard	
4547	Tip 1,2 standard	*
4548	Tip 1,4 standard	
4549	Tip 1,2 long	
4550	Torch head	
4551	Torch head	
4552	cable assembly 6m - 1/4G S105 (for central adaptor)	
4553	Long electrode S105	
4554	Ergocut spring pins kit	
4555	black handle metallic	
4556	handle kit (Ergocut S/A/CB)	
4557	EPDM cover Ø 19x21	

Note – * items are equipped on the torch

Recommended starting kit for the Torch:

Item No	Description	Quantity
4559	Starting Kit for S 105 PEGAS	
4544	Nozzle Long Life	1
4546	Tip 1,0 standard	2
4547	Tip 1,2 standard	2
4548	Tip 1,4 standard	2
4530	Electrode standard S74-105 plasma	4
4528	Diffuser S74	1
4535	Stand off long guide	1
4520	Stand Off Guide A141	1
4543	Long air tube	1
4545	Contact nozzle Long Life	1
4549	Tip 1,2 long	2
4553	Long electrode S105	1

6.3 COMMENTS ON CONSUMABLES

6.3.1 Nozzles

1. You can choose from two nozzles.
2. Standard Nozzle Long Life **4544** that is used together with **4520** Stand Off Guide A141 (respective **4522**, **4521**, **4523**). The Stand of guide or the crowns provide the constant distance 3,5 mm between the cutting tip and the metal sheet.
3. The Contact nozzle Long Life **4545** and Stand off long guide **4535** is used for direct contact with the material, or for cutting in areas where the standard Nozzle **4544** would not fit. Another use is for cutting by means of templates.

6.3.2 Long electrode 4535 and a Tip 1,2 long 4549

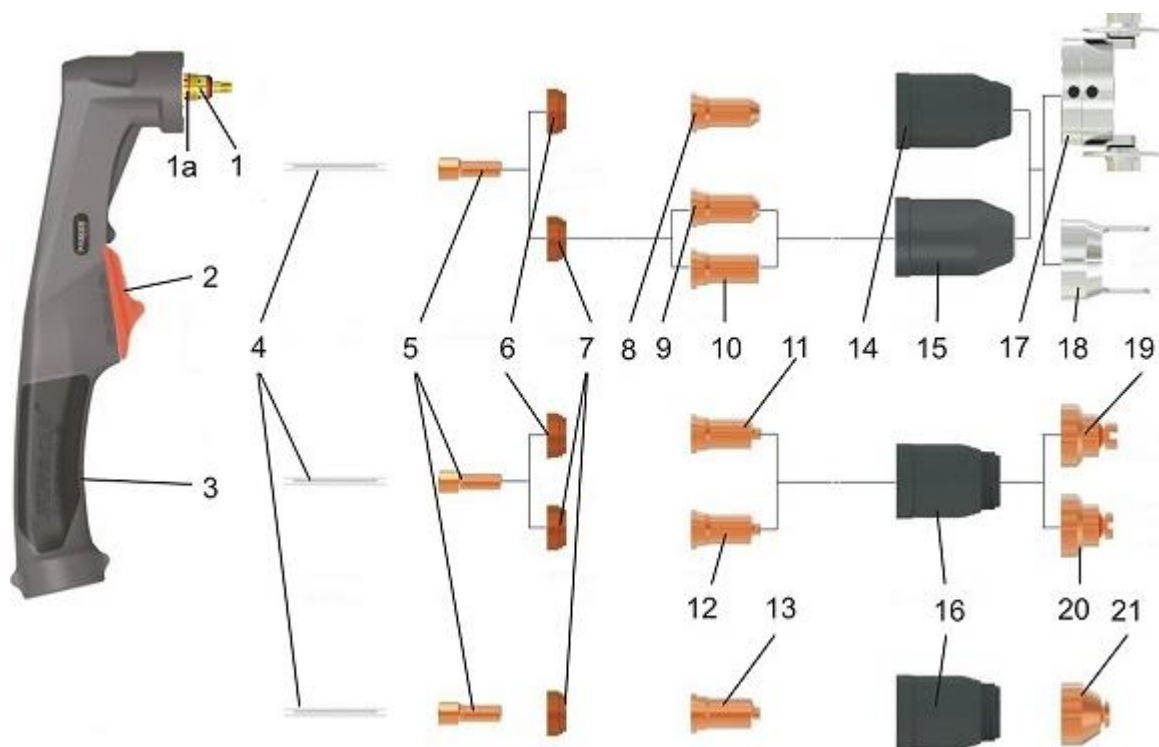
1. The long electrode **4535** is used in combination with Stand off long guide **4535** for cutting in angles and areas where it is not possible reach with the standard cutting tip. The recommended material thickness is 8 – 18 mm at 70 A (carbon steel).

6.3.3 Standard electrode and standard cutting tips

S 105	Carbon steel – material thickness and recommended cutting tips															Tip
Cutting current	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	
50 A																4546 (1,0)
70 A																4547 (1,2)
100 A																4548 (1,4)

The darker colour highlights heat area where the consumables are more worn

off.

Torch SCP 120

Pos	Item No	Description
1	SCP1201	Torch Head
1a	5008	O-Ring
2	SCP2516	Button
3	SCP8014	Handle
4	SCP1202	Cooling Tube
5	SCP1204	Electrode
6	SCP1206	Diffuser 6 Holes
7	SCP1207	Diffuser 4 Holes
8	SCP1221-14	Cutting Tip 1,4 80-90A
8	SCP1221-15	Cutting Tip 1,5 100-110A
9	SCP1220-10	Cutting Tip 1,0 40-50A
9	SCP1220-11	Cutting Tip 1,1 50-60A
9	SCP1220-12	Cutting Tip 1,2 60-70A
10	SCP1222-09	Cutting Tip 0,9 Contact 30-40A
11	SCP1226-10	Cutting Tip 1,0 Contact 40-50A
11	SCP1226-11	Cutting Tip 1,1 Contact 50-60A
11	SCP1226-12	Cutting Tip 1,2 Contact 60-70A
12	SCP1227-14	Cutting Tip 1,4 Contact 80-90A

12	SCP1227-15	Cutting Tip 1,5 Contact 100-110A
13	SCP1228-22	Cutting Tip Gouging
14	SCP1230	Nozzle
15	SCP1231	Nozzle
16	SCP1232	Nozzle
17	SCP1251	Cutting Buggy
18	SCP1240	Double Pointed Spacer
19	SCP8041	Shield Cup Contact 30-80 A
20	SCP1241	Shield Cup Contact 80-120 A
21	SCP8043	Shield Cup Gouging

Recommended starting kit for the Torch SCP 120

Item No	Description	Quantity
5753	Starting kit for SCP 120 (obsah sady níže)	
SCP1207	Diffuser 4 holes 30-70A	1
SCP1222-09	Cutting Tip 0,9 Contact 30-40A	2
SCP1220-10	Cutting Tip 1,0 40-50A	2
SCP1220-11	Cutting Tip 1,1 50-60A	2
SCP1220-12	Cutting Tip 1,2 60-70A	2
SCP1221-14	Cutting Tip 1,4 80-90A	2
SCP1221-15	Cutting Tip 1,5 100-110A	2
SCP1204	Electrode	10
SCP1230	Nozzle 30-70 A	1
SCP1226-10	Cutting Tip 1,0 Contact 40-50A	1
SCP1226-11	Cutting Tip 1,1 Contact 50-60A	1
SCP1232	Nozzle	1
SCP8041	Shield Cup Contact 30-80 A	1

7. GETTING STARTED

7.1 FIRST STEPS

 **NOTE**  This equipment must only be used by qualified personnel.

1. Before beginning work is necessary to connect the machine to the mains.
2. Check completeness of the mounted cutting torch.
3. See the picture below. Connect the torch to the connector. By means of the thorn (part of the delivery) press the safety pin. Turn the nut of the connector clock wise and tight it properly.



4. Connect the compressed air on connector **A14** on the rear wall of the machine.
5. Set the air pressure by means of regulator **A13** and manometer **A12** to 5 bars.
6. Connect the mains plug to the mains socket.
7. After turning on the ON/OFF switch **A15** the display **A4** will illuminate.
8. Connect the work lead cable to the material being cut and to the connector **A11**.
9. Check up the input air pressure (min 5 bar, max 8,5 bar) and make a regulation if necessary.
10. Set potentiometer **A3** to the cutting power you need.
11. Fit the torch with appropriate type of cutting tip electrode and shield cup according to the selected cutting current.
12. Press the trigger on the cutting torch, the pre gas will flow for 1 s.
13. The pilot arc will start.
14. Shift the torch with the pilot arc close to the material, the pilot arc will change to cutting arc automatically. If you do not start cutting within 2 s, the arc will snuff off.
15. To finish the cutting process, release the torch trigger.

7.2 REQUIREMENTS FOR SOURCE OF COMPRESSED AIR

1. Delivered air pressure must be max. 8,5 bar and min. 5 bar.
2. Air consumption minimal 180 l/min
3. Compressed air for the plasma must be clean and dry.
4. Pressure dew point +3 ° C
5. Maximum oil content 0.1 mg/m³
6. Maximal size of solid particles 15 microns
7. The minimal size of an air tank is 50 l
8. No additional oiling if the pressure air is permitted. That could damage the plasma machine and the cutting torch.

7.3 OPTIONAL AIR FILTERS

To achieve high quality cutting and to avoid serious disturbances to the torch it

is highly advised to include the air filter.

Pos.	Item No	Description
B2	5302	Air filter AT 1000
B1	5304	Set for filter AT 1000 to P 100-160 Plasma

👉 **NOTE** 👉 Max. allowable pressure of filter AT 1000 is 8,5 bar



7.4 CUTTING

The table below show just referential values. The real values may change according the material qualities. The darker colour highlights heat area where the consumables are more worn off.

S 105	Carbon steel – material thickness and recommended cutting tips															Tip	
Cutting current	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30		
50 A																	4546 (1,0)
70 A																	4547 (1,2)
100 A																	4548 (1,4)

1. Press the torch trigger. The pilot arc will ignite. Then you have to immediately attach the torch to the cut material. At this point begins to burn the main arc between the torch and the material.
2. Move the torch with a constant speed. Cutting speeds vary according to torch output amperage, the type of material being cut, and operator skill.
3. Output current setting or cutting speeds may be reduced to allow slower cutting when following a line, or using a template or cutting guide while still producing cuts of excellent quality

4. To achieve a good cutting quality make sure the distance between the tip and the material is about 3,5 mm. The Stand Off Guide **4520** located at the end of the plasma torch guarantees the distance (or Stand off long guide **4535**). At a greater distance decreases cutting power and the arc may go off. With too small distance the torch parts will be worn off faster.
5. Plasma cutting may be done in all possible positions (vertically, horizontally, overhead, vertical ascending and descending), but as far as possible choose primarily horizontal cut. In other positions the operator is increasingly threatened by flying drops of molten material.
6. We recommend starting cutting at the edge of the material. If needed to start from the centre of the material, or to cut hole into the material, slightly tilt the torch head and gradually it straighten into a vertical position so the spraying material would not damage the cutting tip (see Figure 3). This workflow must always be followed, if the thickness of material is above above 3 mm.
7. In case of cutting in the corner or around the corner (see Figure 4), use the long electrode and cutting tip (pos. **17** and **20**). The cutting power while using the Long cutting tip is decreased.

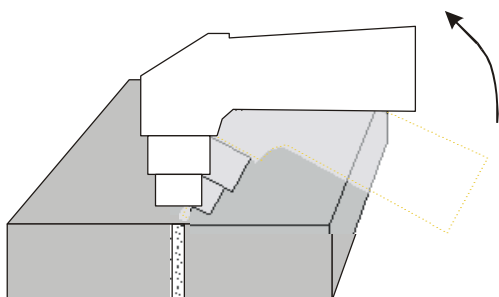


Fig. 3

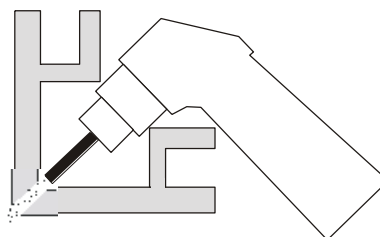


Fig. 4

7.5 IMPORTANT RULES

1. The pilot arc burning time should be limited only to the time necessary. It lowers the wear of the cutting tips and electrodes.
2. Never turn off the main switch immediately after finishing cutting but always leave time to run cooling cycle to cool down the torch. Immediate turn-off only in case of emergency.
3. Ensure a good el. Contact of the work lead clamps and cutting material.
4. Check and timely exchange cutting tips and the electrodes. Lifetime of these parts is only a few hours of cutting time and is highly dependent on compliance with the principles of good cutting.
5. Disconnect the machine from the mains before replacing the torch consumable parts.
6. Unplug the machine from the mains before any intervention inside the machine.
7. PEGAS 100 PLASMA is adapted for use with torch S 105. This

combination comply with EN 60974-7 Article 10.1.4. Using any other type and design of a torch must be approved by ALFA IN a.s.

8. Imperfect capture of condensate would cause its elimination in the area of the cutting tip and it would prevent ignition of the pilot arc.

7.6 SOURCES OF POOR QUALITY CUTS

7.6.1 Shallow penetration of the cut

1. The cutting speed is too high. Make sure the slope of the cutting arc does not exceed about 15° (see Figure 5).
2. High wear of the cutting tip or electrode (see Figure 6)
3. Too large thickness of material and not adequately chosen value of current and diameter of the cutting tip.
4. Bad contact between the work lead clamps and material.

7.6.2 Cutting arc is unstable, goes off and "shoots"

1. Worn out cutting tip or electrode
2. High pressure
3. Impurities in the pressure air
4. Not captured water condensate

7.6.3 Conical cut

1. If there is a false cut (see Figure 7) turn off the machine, release the shield cup and rotate the cutting tip about $1/4$ and again try to cut.
2. Damaged cutting tip and electrode
3. The position of the torch is not perpendicular to the material
4. Too large distance from the cutting tip to the material.

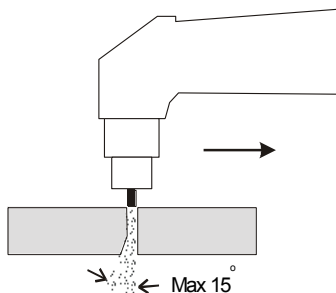


Fig. 5

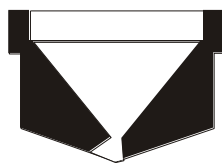


Fig.6



Fig.7

8. MAINTENANCE

1. A great care should be taken to the cutting torch. The molten material sprays while cutting. This sputter contaminates the interior space of the torch. The worn parts (consumables) of a plasma torch should be regularly maintained and timely exchanged. Regularly check the condition of diffuser channels (see diagram of the torch). If contaminated, you must clean it with

a pressure air or to replace the diffuser. Poor state of the diffuser has a negative impact on the quality of cutting and causes very strong interference that may cause the collapse of the machine control electronics or influence the surrounding devices. If the cable bundle of the torch is worn out it must be replaced immediately - danger of electrical shock.

2. Disconnect the PEGAS from the mains supply voltage before disassembling.
3. Special maintenance is not necessary for the control unit parts in the plasma cut machine. If these parts are damaged for any reason, replacement is recommended.

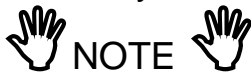


4. Do not blow air into the plasma cut during cleaning. Blowing air into the plasma cut can cause metal particles to interfere with sensitive electronic components and cause damage to the welder.
5. To clean the plasma cut, disconnect it from the mains supply voltage then open the enclosure and use a vacuum cleaner to remove any accumulated dirt and dust. The plasma cut should also be wiped clean. If necessary, solvents that are recommended for cleaning electrical apparatus may be used.
6. Troubleshooting and repairing of PEGAS equipment should only be carried out only by suitably qualified or competent person.
7. A 'competent person' must be a person who has acquired through training, qualification or experience, or a combination of them, the knowledge and skills enabling that person to safely carry out a risk assessment and repairs to the electrical equipment in question.
8. The person carrying out the servicing needs and repairs must know what to look at, what to look for and what to do.

9. STATEMENT OF WARRANTY

1. In accordance with the warranty periods stated below, ALFA IN guarantees the proposed product to be free from defects in material or workmanship when operated in accordance with the written instructions as defined in this operating manual.
2. ALFA IN products are manufactured for use by commercial and industrial users and trained personnel with experience in the use and maintenance of electrical welding and cutting equipment.
3. ALFA IN will repair or replace, at its discretion, any warranted parts or components that fail due to defects in material or workmanship within the warranty period. The warranty period begins on the date of sale to the end user.
4. If warranty is being sought, please contact your ALFA IN product supplier for the warranty repair procedure.
5. ALFA IN warranty will not apply to:

- a) Equipment that has been modified by any other party other than ALFA IN's own service personnel or with prior written consent obtained from ALFA IN Service Department.
 - b) Equipment that has been used beyond the specifications established in the operating manual.
 - c) Installation not in accordance with the installation/operating manual.
 - d) Any product that has been subjected to abuse, misuse, negligence or accident.
 - e) Failure to clean and maintain (including lack of lubrication, maintenance and protection), the machine as set forth in the operating, installation or service manual.
6. Within this operating manual are details regarding the maintenance necessary to ensure trouble free operation.



Warranty repairs must be performed by either an ALFA IN Service Centre, an ALFA IN distributor or an Authorised Service Agent approved by the company ALFA IN.

10. DISPOSAL



Only for EU countries. Do not dispose of electric tools together with household waste material.

In accordance with European Council Directive 2002/96/EC on electrical and electronic equipment waste and its implementation in accordance with national law, electric tools that have reached the end of their service life must be collected separately and returned to an environmentally

compatible recycling facility.