METAL MAN®

WORK GEAR

# Handy CUT 40 PLUS

Item# 9002197

## OPERATOR'S MANUAL




**Read carefully and understand RULES FOR SAFE OPERATION and instructions before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.**

***Please read and save these instructions. Read through this owner's manual carefully before using product. Protect yourself and others by observing all safety information, warnings, and cautions. Failure to comply with these instructions could result in personal injury and/or damage to product or property. Please retain instructions for future reference.***

# Handy CUT 40 PLUS

## Description

The Handy CUT 40 PLUS is an IGBT inverter plasma cutter with thermal overload protection, a Trafimet torch and a built-in gas regulator. This easy to use plasma cutter has the
power to cut up to 3/8 in. materials and a pilot arc that makes cutting expanded metal possible. This machine required single-phase 230V (220V-240V), 60 Hz input power.




## Specifications and Dimensions

| | |
|---|---|
| Power Supply | 1ph-230V-60HZ |
| No-load Voltage | 340V |
| Output Range | 15-40A |
| Duty Cycle | 35% @ 40A |
| Air Pressure | 4.5 CFM@ 60 PSI |
| Power Switch | 250VAC 30Amps |
| Dimension (L x W x H) | 17.7"x6.7"x9" |
| Weight | 21 lbs |

## Removing from carton

1.1 Remove cartons, bags or Styrofoam containing the welder and accessories.
1.2 Check the contents with the packing list below.

| | |
|---|---|
| Plasma Cutter | 1 unit |
| Grounding Cable | 1 pc |
| TRAFIMET Cutting Torch | 1 pc |
| Electrode | 3 pcs |
| Nozzle | 3 pcs |
| Operator's Manual | 1set |

1.3 After unpacking unit, inspect carefully for any damage that may have occurred during transit. Check for loose, missing, or damaged parts. Shipping damage claim must be filed with carrier.

# Handy CUT 40 PLUS

***Know your Welder***




**Gas Pressure Display**
The built-in gas display is used for reading the output gas pressure when cutting.
**Gas Pressure Adjustor**
It is used for adjusting the gas pressure. The gas pressure can be read from the gas pressure display on the front panel. Normally, the pressure should be adjusted between 55-90psi.
When cutting, this light is on to show the unit is on working mode.
**Work Indicator**
**Cutting Current Adjustor**
Variable adjust the output cutting current. The higher output matches the thicker metal. The maximum cutting thickness is up to 3/8″ for this unit. Please note that the maximum cutting thickness varies depending on the material type you are cutting. See the following table for reference.

| Material | Maximum Cutting Thickness |
|---|---|
| Carbon Steel | 3/8” |
| Aluminium | 1/4″ |
| Stainless Steel | 1/4″ |
| Copper | 1/8″ |

# Handy CUT 40 PLUS

**Low Gas Indicator Light**
This light will be on when the gas flow is low.
**Ground Cable Connection**
Connect the ground cable to the postive (+) receptacle on the front of the plasma cutter. The ground cable clamp connects to your work piece.
**Torch Control Cable Connection**
The black cable on the torch connects to the 3-Prong receptacle on the front of the machine. Push on to snap in place. This is the control cable for the torch.
**Torch Arc Starting Cable Connection**
This connector is for the red cable of the torch. It is used to help the arc starting.
**Torch Connection**
Connect the torch to the negative (-) receptacle.
**Protection indicator Light**
When the unit is in thermal overload, is over voltage or lacking voltage, the indicator will be on and the machine will stop working. When the unit is cooled down and voltage stabilizes, the unit will return to work automatically.
**Power indicator Light**
This light will turn on when the input power cord is plugged into the power supply and the power switch on the back of the plasma cutter is in the "ON" position.
**Gas Hose Connection**
The gas hose connection is on the back panel of the plasma cutter. This connections requires a 1/4 inch NPT connection (Not supplied). The other end of the gas hose connects to an air compressor or compressed air supply.
**Power switch**
It is the on/off switch. After the machine is connected to the input power supply, turn on this switch. The power indicator on the front panel will turn on.
**Power cord**
There is a 50 amp plug on this cable. Plug this into a 230V, 50amp circuit breaker power supply
**Specification Table**
The specification table is located on the back panel of the plasma cutter. The Serial Number of this unit is listed on the specification table.

**General Safety Information**
**1.1 Your Welding/Cutting Environment**
-Keep the environment that you will be welding/cutting in free from flammable materials.
-Always keep a fire extinguisher within reach.
-Always have a qualified person install and operate this equipment.
-Make sure the area is clean, dry and well ventilated. Do not operate the plasma cutter in humid, wet or poorly ventilated areas.
-Always have your plasma cutter maintained by a qualified technician in accordance with local, state and national codes.
-Always be aware of your work environment. Be sure to keep other people, especially children, away from you while you are cutting.

-Keep harmful arc rays shielded from the view of others.
-Mount the plasma cutter on a secure bench or cart that will keep the welder secure and prevent it from tipping over or falling.

**1.2 Your Plasma Cutter's Condition**

-Check all cables, power cord and torch to be sure the insulation is not damaged. Always replace or repair damaged components before using the plasma cutter.
-Check all components to ensure they are clean and in good operating condition before use.

**1.3 Use of Your Plasma Cutter**

**⚠ CAUTION**

Do not operate the plasma cutter if the torch is wet. Do not immerse the plasma torch. Do not stand in water while using this plasma cutter. These components and the plasma cutter must be completely dry before attempting to use it.
-Follow the instructions in this manual.
-Keep the plasma cutter in the off position when not in use.
-Connect ground lead as close to the area being cut as possible to ensure a good ground.
-Do not allow any body part to come in contact with the material being cut, or to the ground or electrode from another plasma cutter or welder.
-Do not cut if you are in an awkward position. Always have a secure stance while cutting to prevent accidents. Wear a safety harness if working above ground.
-Do not drape cables over or around your body.
- Wear eye protection (see ANSI Z49.1 safety standard) while cutting to protect your eyes from harmful UV and IR ray's.
-Wear proper gloves and protective clothing to prevent your skin from being exposed to hot metals, UV and IR rays.
-Do not overuse or overheat your plasma cutter. Allow proper cooling time between duty cycles.
-Keep hands and fingers away from moving parts.
- Do not point the Plasma torch at any body part or at anyone else.
-Always use this plasma cutter in the rated duty cycle to prevent excessive heat and failure.

**1.4 Specific Areas of Danger, Caution or Warning**

**Electrical Shock**



**⚠WARNING**

Plasma cutters can produce a shock that can cause injury or death. Touching electrically live parts can cause fatal shocks and severe burns. While cutting, all metal components connected to the wire are electrically hot. Poor ground connections are a hazard, so secure the ground lead before cutting.
-Wear dry protective apparel: coat, shirt, gloves and insulated footwear.
-Insulate yourself from the work piece. Avoid contacting the work piece or ground.
- Do not attempt to repair or maintain the plasma cutter while the power is on.

# Handy CUT 40 PLUS

-Inspect all cables and cords for any exposed wire and replace damaged or wore cables immediately.
-Use recommended replacement cables and cords.
-Always attach the ground clamp to the work piece or work table as close to the cutting area as possible.
-Do not touch the torch and the ground or grounded work piece at the same time.



**Fumes and Gases**

**⚠WARNING**

-Fumes emitted from the plasma cutting process displace clean air and can result in injury or death.
-Do not breathe in fumes emitted by the plasma cutting process. Make sure your breathing air is clean and safe.
-Work only in a well-ventilated area or use a ventilation device to remove plasma cutting fumes from the environment where you will be working.
-Do not plasma cut on coated materials (galvanized, cadmium plated or containing zinc, mercury or barium). They will emit harmful fumes that are dangerous to breathe. If necessary use a ventilator, respirator with air supply or remove the coating from the material in the area to be cut.
-The fumes emitted from some metals when heated are extremely toxic. Refer to the material safety data sheet for the manufacturer's instructions.
-Do not weld/cut near materials that will emit toxic fumes when heated. Vapors from cleaners, sprays and degreasers can be highly toxic when heated.



**UV and IR Arc Rays**

**⚠ DANGER**

The plasma cutting arc produces ultraviolet (UV) and infrared (IR) rays that can cause injury to your eyes and skin. Do not look at the plasma cutting arc without proper eye protection.
- Always use safety glasses, a shield or a helmet that meets ANSI Z49.1 standards for plasma cutting.
- Cover all bare skin areas exposed to the arc with protective clothing and shoes. Flame-retardant cloth or leather shirts, coats, pants or coveralls are available for protection.
-Use screens or other barriers to protect other people from the arc rays emitted from your plasma cutting arc.
-Warn people in your cutting area when you are going to strike an arc so they can protect themselves.



**Fire Hazards**

**⚠WARNING**

Do not cut on containers or pipes that contain or have had flammable, gaseous or liquid combustibles in them. Plasma cutting creates sparks and heat that can ignite flammable and explosive materials.
-Do not operate any plasma cutter in areas where flammable or explosive materials are present.

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-Remove all flammable materials within 35 feet of the plasma cutting arc. If removal is not possible, tightly cover them with fireproof covers.
-Take precautions to ensure that flying sparks do not cause fires or explosions in hidden areas, cracks or areas you cannot see.
-Keep a fire extinguisher close in the case of fire.
-Wear garments that are oil-free with no pockets or cuffs that will collect sparks.
-Do not have on your person any items that are combustible, such as lighters or matches.
-Keep the work lead connected as close to the plasma cutting area as possible to prevent any unknown, unintended paths of electrical current from causing electrical shock and fire hazards.



**Hot Materials**

**⚠ CAUTION**

Plasma cut materials are hot and can cause severe burns if handled improperly.
-Do not touch plasma cut materials with bare hands.
- Do not touch torch tip after cutting until it has had time to cool down.



**Sparks/Flying Debris**

**⚠ CAUTION**

Plasma cutting creates hot sparks that can cause injury. Chipping slag off cuts can create flying debris.
-Wear protective apparel at all times: ANSI-approved safety glasses or shield, a welder's hat and ear plugs to keep sparks out of ears and hair.



**Electromagnetic Field**

**⚠ CAUTION**

-Electromagnetic fields can interfere with various electrical and electronic devices such as pacemakers.
-Consult your doctor before using any plasma cutting device
-Keep people with pacemakers away from your plasma cutting area while cutting.
-Do not wrap cable around your body while plasma cutting.
- Wrap plasma torch cable and ground cable together whenever possible.
- Keep plasma torch and ground cables on the same side of your body.



**Shielding Gas Cylinder Can Explode**

**⚠WARNING**

High pressure cylinders can explode if damaged, so treat them carefully.
-Never expose cylinders to high heat, sparks, open flames, mechanical shocks or arcs
-Do not touch cylinder with plasma torch.
-Do not plasma cut on the cylinder.
-Always secure cylinder upright to a cart or stationary object
-Keep cylinders away from welding/cutting or electrical circuits.
-Use the proper regulators, gas hose and fittings for the specific application

# Handy CUT 40 PLUS



**Proper Care, Repair and Maintenance**

**⚠WARNING**

-Always have power disconnected when working on internal components.
-Do not touch or handle PC board without being grounded with a wrist strap. Put PC board in static proof bag to move or ship.



-Do not put hands or fingers near moving parts such as drive or fan.

**Proposition 65 Warnings**

**⚠WARNING**

- Plasma cutting equipment produces fumes or gases which contain chemicals known to the state of California to cause birth defects and, in some cases, cancer. (California Health & Safety code section 25249.5 et seq.)

## Installation

**1. Power requirement**

AC single phase 230 (220-240V) 60HZ fused with a 50amp time delayed fuse or circuit breaker is required. DO NOT OPERATE THIS UNIT if the ACTUAL power source voltage is less than 170 volts AC or greater than 250 volts AC.

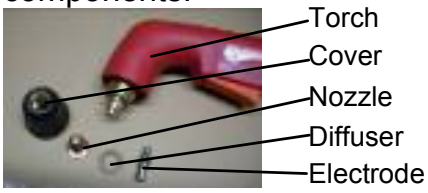
**⚠WARNING**

***• High voltage danger from power source! Consult a qualified***

***electrician for proper installation of receptacle. This cutter must be Grounded while in use to protect the operator from electrical shock.***
***• Do not remove grounding prong or alter the plug in any way. Do not use any adapters between the cutter's power cord and the power source receptacle. Make sure the POWER switch is OFF when connecting your cutter's power cord to a properly grounded 230 VAC, 60Hz, 1 phase, 50 amp input power supply.***

INSTALLING THE CUTTING TORCH

1. Prepare all the necessary components.




2. Screw in the electrode to the cutting torch.



3. Slide on the diffuser.



4. Line the electrode and nozzle and slide on.

# Handy CUT 40 PLUS

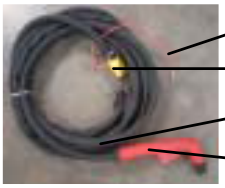


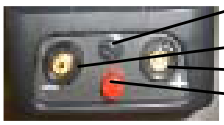
5. Install the cover to the torch and screw on.



INSTALLING THE TORCH

1. Connect the red cable with the red terminal on the front side of the plasma cutter.

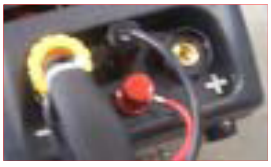



2. Connect the torch control cable to the black, round, 3-pronged connector on the front of the plasma cutter. Be certain to properly align the knotch in the connector with the grove in the plug.

3. Connect the torch to the negative (-) receptacle.

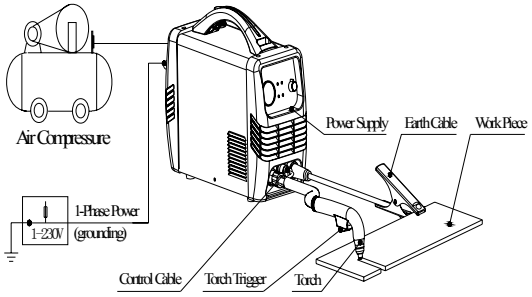
4. The right connection



5. Connect the grounding cable to the positive (+) receptacle.




**6.** Illustration of Complete Assembly




## Operation

**⚠WARNING**

***High voltage danger from power source! Consult a qualified electrician for proper installation of receptacle at the power source. This cutter must be grounded while in use to protect the operator from electrical shock. If you are not sure if your outlet is properly grounded, have it checked by a qualified electrician. Do not cut off the grounding prong or alter the plug in any way and do not use any adapters between the cutter's power cord and the power source receptacle. Make sure the POWER switch is OFF then connect your welder's power cord to a properly grounded 230 Vac (220v-240v), 60Hz, single phase, 50 amp power source.***

**1. Set up**

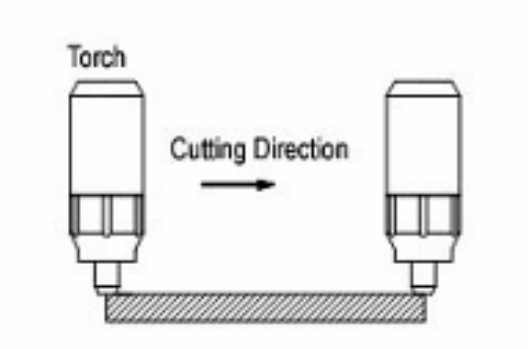
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- Check the plasma cutter to see if it has been connected correctly and is in good working condition as described in Section 1 on Safety and that it complies with safe operation requirements.
- Switch on the power supply switch of the cutter to observe if the operation is normal. If it is normal, the fan should start up and the Power Supply Indicator Light should be on. If there is no compressed air or the air pressure is low the Low Pressure Indicator Light will be on.
- Adjust the air supply valve until the air pressure is up to the cutting torch requirement. (Lowest pressure should be no less than 50PSI), the Low Pressure Indicator Light will not be lit up in those conditions.
- Adjust the air flow to be sure it is consistent.
- Pull the torch trigger. The cutting operation begins after the cutting plasma pilot arc is made.

**2. Cutting Operation**

2.1. Metal Sheet Cutting

- Put the torch's nozzle at the start of the work piece. Turn on the torch switch to ignite the plasma pilot. After the work piece is cut thorough, move the torch along the cutting direction uniformly. The cutting speed is determined by watching to see if the cutting goes all the way through. If the speed is too fast, the work piece won't be cut thorough, or if too slow, the cut quality would be affected, excessive warping may occur, or the arc could stop.




- When you've completed the cutting process, turn off the torch; the plasma pilot arc will stop.

2.2. Metal Mesh Cutting

-Fix the work piece and connect the earth cable with the work piece.
-Put the cutting nozzle onto the work piece, lift torch up slightly from the work piece and turn on the switch to cut.

2.3. Notice while cutting

- Unnecessary igniting of the pilot arc in the air will reduce the life-span of the torch's electrode and nozzle.
- It is best to start cutting at the edge of the work piece, unless you are piercing the work piece.
- Keep a space between the nozzle and the work piece. Pressing the nozzle on the work piece could cause the nozzle to stick, reducing the smoothness of the cutting action creating an undesirable result.
- Keep the torch's nozzle vertical against the work piece, and watch to be sure the arc is moving along the cutting line.
- For thin materials reduce the amperage setting to get the best cutting quality, reduce excessive warping and to extend the life of the electrode and nozzle.
- Do not rapidly switch the torch trigger on and off; this will damage the pilot arc system and work piece.

# Handy CUT 40 PLUS

- The plasma cutter's working air pressure range is 40-90psi. Notice: the internal pressure switch will shut off when the air pressure falls below 50psi. The switch only works when the pressure rises to 50psi or above.
- Every 4-8 hours, check the air filter on your air supply and remove excess moisture. Too much moisture in the cutter or torch may lead to operational trouble.

**⚠WARNING**

- Always unplug the power supply before checking for and removing moisture.

**3. Safety Requirements**

- Never allow the torch to be aimed at any part of a body.
- Make sure to wear protective glasses and gloves while operating.
- Work only in well-ventilated areas. If necessary, use exhaust/ventilation fans to keep fumes or emissions away from the breathing zone.
- Do not touch the work piece while cutting.
- Do not cut a pipes, containers, or other materials that contain, or have ever contained, flammable or explosive materials.
- Do not work underwater or in wet/moist environments.
- Do not bend the torch cable sharply; this may damage the air hose.
- Nobody other than the operator should be allowed to access the working area.
- Always turn off the power supply prior to repairing or moving the machine.
- Always turn off the power supply prior to repairing or installing any spare parts (e.g., torch, electrode, nozzle, ground clamp, etc.).

AVERTISSEMENT:

COUPER L'ALIMENTATION AVANT LA DEPOSE DU CHALUMEAU.

- Never allow a person with a cardiac pacemaker close to the working area without the permission of a doctor. The magnetic field produced by plasma cutters during operation can disrupt pacemakers and similar devices.
- Do not allow the ground cable to be pinched or damaged. If damaged, replace immediately.
- Never clean the slag off the torch head by hitting it against a hard object.

# Handy CUT 40 PLUS

**Trouble shooting Chart**

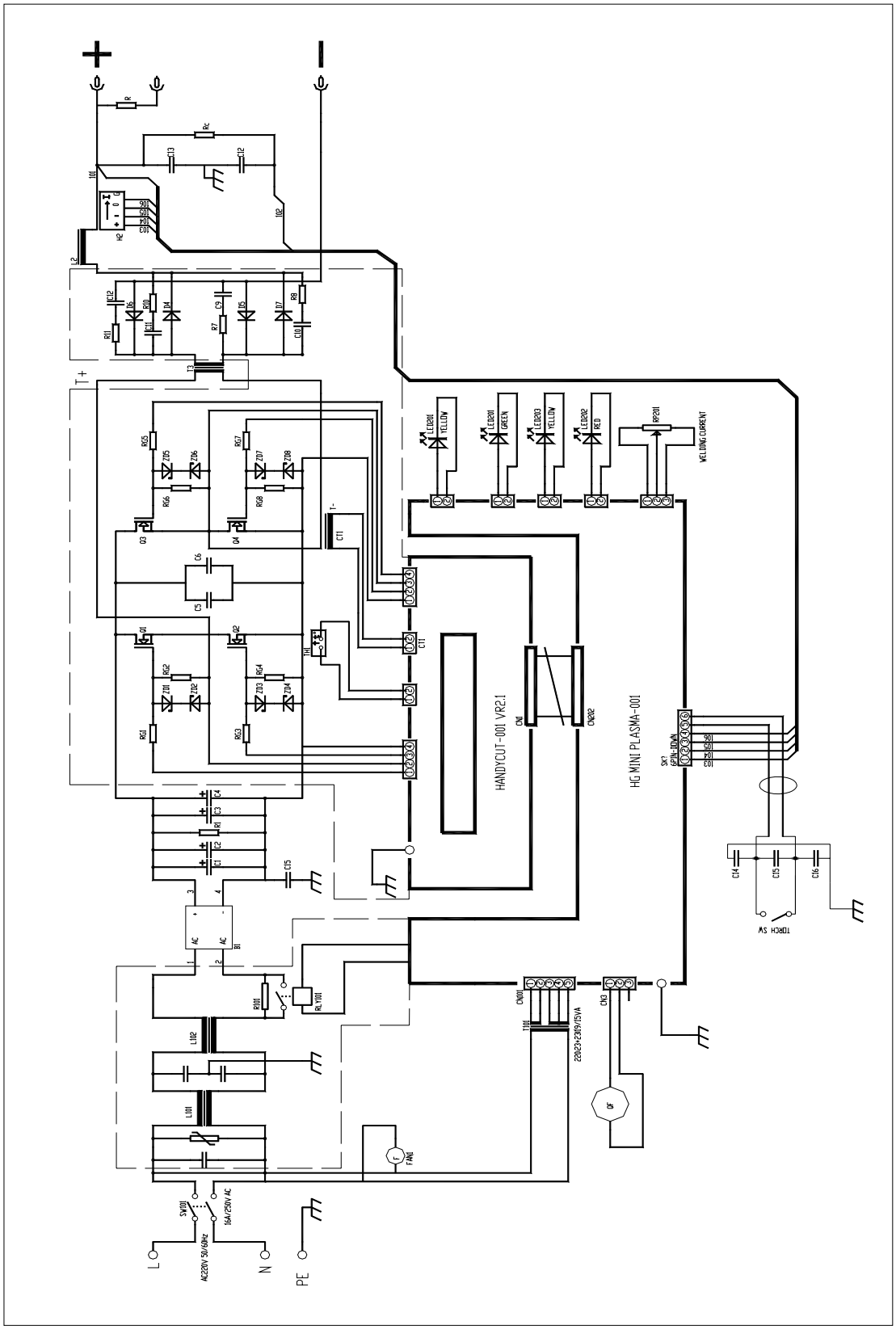
| | | |
|---|---|---|
| Power Indicator Light is off after turning on the power supply. | 1.The light is broken.<br>2.Fuse is blown.<br>3.Not 230V Input Voltage.<br>4.Power supply switch is broken.<br>5.Controlling board or cutter is damaged. | 1.Replace.<br>2.Replace.<br>3.Connect the 230V Input cable.<br>4.Replace.<br>5.Examine and repair. |
| Fan doesn't work after turning on the power supply. | 1.Fan is damaged.<br>2.Fan's ground lead is broken.<br>3.Fan's blade is blocked<br>4.Transformer is damaged. | 1.Replace.<br>2.Examine and repair.<br>3.Clean the block.<br>4. Replace. |
| Low Pressure Indicator Light is on | 1.No input compressed air<br>2.Air/gas pressure valve is adjusted to 0 or broken.<br>3.Air/gas pressure circuit is blocked<br>4.Air/gas pressure valve is damaged | 1.Examine and repair.<br>2.Adjust or replace.<br>3.Clean the block.<br>4.Replace. |
| No Air/gas check function. | 1.Air/Gas valve is ruined.<br>2.Air/Gas circuit is blocked.<br>3.Air/Gas check switch is ruined<br>4.Ground lead is broken. | 1.Replace.<br>2.Clean the block.<br>3.Replace.<br>4.Examine and repair. |
| Can't cut or no high frequency output. | 1.Discharge gap is too big.<br>2.High pressure mica capacitance damaged.<br>3.Pilot transformer is damaged.<br>4.Main controlling board is damaged.<br>5.Ground lead is broken | 1.Adjust to suitable gap.<br>2.Replace.<br>3.Replace.<br>4.Examine and repair.<br>5.Examine and repair. |
| No response after turning on the torch switch. | 1.Switch and ground-lead are broken.<br>2.Switch board is broken.<br>3.Main controlling board is damaged.<br>4.Transformer is damaged.<br>5.Ground lead is broken. | 1.Examine and repair or replace.<br>2.Examine and repair or replace.<br>3.Examine and repair or replace.<br>4.Replace.<br>5.Examine and repair. |

# Handy CUT 40 PLUS

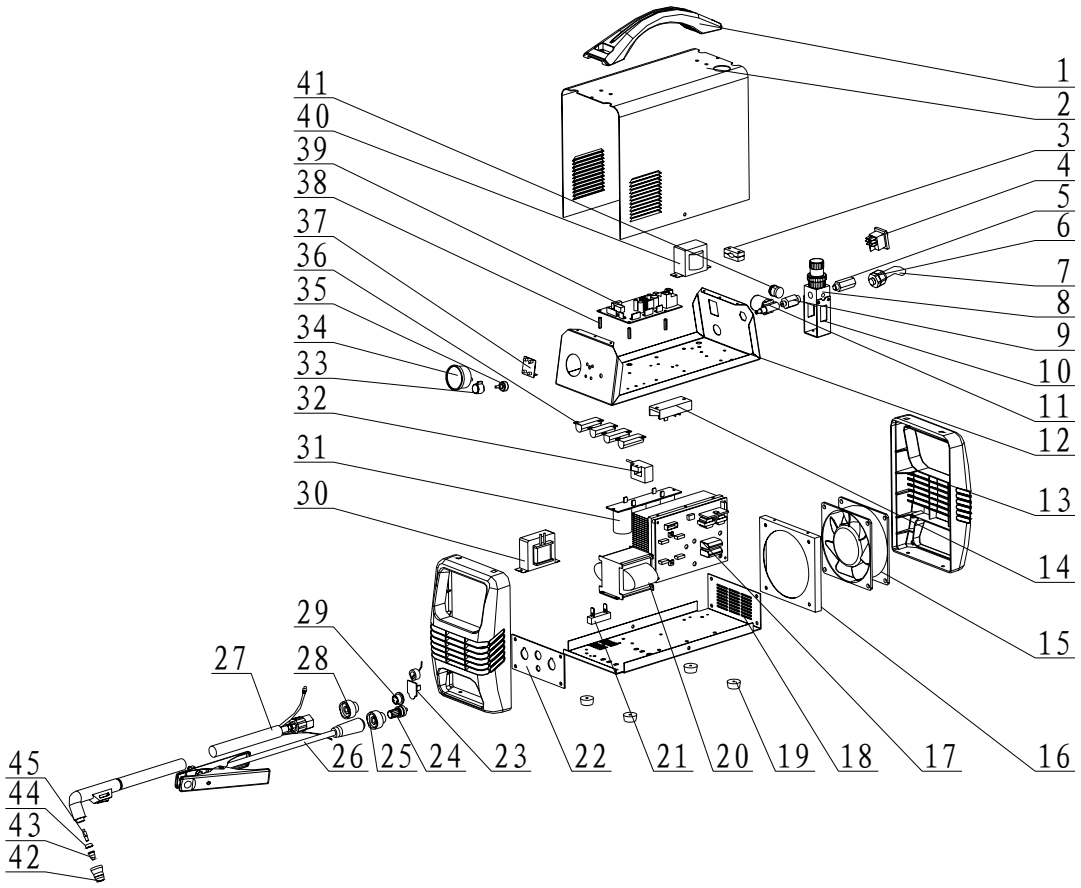
| | | |
|---|---|---|
| No response after turning on power supply. | 1.Power cord hooked up wrong.<br>2.Power supply switch is broken.<br>3.Fuse is damaged.<br>4.Transformer is broken.<br>5.Main controlling board is ruined. | 1.Examine and repair.<br>2.Replace.<br>3.Replace.<br>4.Replace.<br>5.Examine and repair or replace. |
| Protection indicator Light comes on. | 1.High/low voltage<br>2.The High/low voltage setting is incorrect.<br>3.Over heating from exceeding the duty cycle.<br>4.The bad or broken connection in the thermal relay.<br>5.Main PCB board is broken. | 1.The tolerant voltage range is 170V ~ 250V. The machine will stop working and indicator will come on if the input power voltage is not between 170V and 250V AC. Please check the voltage with a volt meter.<br>2.Please open the case to adjust the potentiometer VR101 (for high voltage setting) and VR102 (for low voltage setting) on the main control PCB. Note: VR 101 should be adjusted clockwise, the VR 102 should be adjusted counter clockwise.<br>3.Wait until the machine cools down.<br>4.Repaired by the qualified people.<br>5.Replace. |
| Other problem. | | Please contact customer service number on the outside of the manual |

*Please provide the following:*
- Model Number
- Serial Number (if any)
- Part description and number as shown on parts list

# Handy CUT 40 PLUS



# Handy CUT 40 PLUS




| No | Description | Specification | Code |
|---|---|---|---|
| 1 | Handle | CUT40IIPH-2(G20CUT=) | 2.05.08.019 |
| 2 | Enclosure | G20CUT40IIPH.1 | 1.51.401.01 |
| 3 | Power cord holder | 38*16*8(CUT40IIPH.3-8) | 2.05.17.020 |
| 4 | Main Switch | R210-C2-BG green cover | 2.07.80.213 |
| 5 | Gas valve connector | G20CUT40 | 1.51.401.14 |
| 6 | Power cord holder | EG-13.5(PG13.5) | 2.04.30.102 |
| 7 | Power cord plug | 12AWG/50A/250V*2.8M | 2.03.05.148 |
| 8 | Gas valve | XR4-0.63 | 2.07.55.104 |

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| | | | |
|---|---|---|---|
| 9 | Gas connector II | CUT30PH.3-3 | 1.51.030.03-03 |
| 10 | Gas valve board | CUT40IIPH.3-4 | 1.51.042.03-4 |
| 11 | Gas valve | CUT30PH.3.7 | 1.51.030.03-7 |
| 12 | Middle board | G20CUT40IIPH.3.1 | 1.51.401.03-1 |
| 13 | plastic panel | CUT40IIPH-1(CUT front/back) | 2.05.05.039 |
| 14 | Rectifier | MDQ5010 50A/1000V | 2.07.37.501 |
| 15 | Fan | G12038HA1SL 110V/60HZ | 2.07.89.400 |
| 16 | Fan bracket | G20CUT40IIPH.8.7-1 | 1.51.401.08-7-1 |
| 17 | Heat Sink | G20CUT40IIPH.8.6 | 1.51.401.08-6 |
| 18 | Bottom | G20CUT40IIPH.8-5 | 1.51.401.08-5 |
| 19 | Feet | NULL | 2.05.05.016 |
| 20 | Main transformer | G20CUT40IIP.8.4 | 1.51.401.08-4 |
| 21 | Load wire bunch | G20CUT40IIP.8.1 | 1.51.401.08-1 |
| 22 | Front lower panel | CUT40IIPH.13.1 | 1.51.042.13-1 |
| 23 | Arc control PCB | G20CUT40IIP.13.3 | 1.51.401.13-3 |
| 24 | Connection pole | SJ333(red) | 2.05.03.104 |
| 25 | Quick connector | DKJ-2/10-25 | 2.07.57.123 |
| 26 | Grounding cable | CUT30PH.9 | 1.51.030.09 |
| 27 | Cutting torch | S45 | 2.20.08.258 |
| 28 | Output power PCB | CUT30PH.8.1 | 1.51.030.08-1 |
| 29 | Socket | XS16K3Y | 2.07.54.114 |
| 30 | Chock | CUT40IIP.8.8 | 1.51.409.08-8 |
| 31 | Capcitance Board | G20CUT40IIPH.8.9 | 1.51.401.08-9 |
| 32 | Hall sensor | CUT40IIPH.3.10 | 1.51.042.03-10 |
| 33 | Potentiometer Knob | KDJII23-16-4J red cover | 2.07.11.017 |
| 34 | Regulator | φ40 grey with holder | 2.07.55.105 |
| 35 | Potentiometer | G20CUT40IIP.3.7 | 1.51.401.03-7 |
| 36 | Resistance | RX24N 50W 1Ω | 2.07.02.003 |
| 37 | Power indicating | CUT40IIPH.3.5 | 1.51.042.03-5 |

| | | | |
|---|---|---|---|
| | board | | |
| 38 | Bolt | M3*15 | 2.06.01.701 |
| 39 | Main PCB | CUT40IIP.3.2 | 1.51.409.03-2 |
| 40 | Control Transformer | G20CUT40IIP.3.3 | 1.51.401.03-3 |
| 41 | Pressure switch | G20CUT40IIP.3.10 | 1.51.401.03-10 |
| 42 | Cutting Nozzle | PC0116 S25-S45 | 2.20.04.901 |
| 43 | Tip nozzle | PD0116-0.8 S25-S45 | 2.20.04.902 |
| 44 | Whirlpool Ring | PE106 S25-45 | 2.07.42.010 |
| 45 | Cutting Tip | PR0110 S25-S45(S30-S45) | 2.20.06.301 |

**Other Safety and Standards Information**
This manual is designed to inform the operator of safety and general use of this model only. For further information about welding safety refer to the following standards and comply with them where applicable.

• **ANSI Standard Z49.1** — SAFETY IN WELDING AND CUTTING obtainable from: American Welding Society 550 NW Le Jeune Road, Miami, FL 33126
Tel. (800) 443-9353
Fax (305) 443-7559
www.amweld.org or www.aws.org

• **ANSI Standard Z87.1** — SAFE PRACTICE FOR OCCUPATION AND EDUCATIONAL EYE AND FACE PROTECTION
Obtainable from: American National Standards Institute (ANSI) 11 West 42nd St. New York, NY 10036
Tel. (212) 642-4900
Fax (212) 398-0023 www.ansi.org

• **NFPA Standard 51B** — CUTTING AND WELDING PROCESS obtainable from:
National Fire Protection Association,
1 Batterymarch Park, P.O. Box 9101
Quincy, MA 02269-9101
Tel. (617) 770-3000
Fax (617) 770-0700 www.nfpa.org

# Handy CUT 40 PLUS

• **OSHA Standard 29 CFR**, Part 1910, Subpart Q. —WELDING, CUTTING AND BRAZING obtainable from your state OSHA office or from: U. S. Dept. of Labor OSHA, Office of Public Affairs Room N3647, 200 Constitution Ave. NW Washington, DC 20210 www.osha.gov

# WARRANTY

**METAL MAN WORK GEAR CO**

**EFFECTIVE JANUARY 1, 2014**

**LIMITED WARRANTY**

This warranty applies to the original purchaser and is subject to the terms and conditions listed below. This Limited Warranty is for new equipment sold after the above date, providing coverage for defects in material and workmanship at the time it is shipped from the factory.

Limited to the warranty periods below, Metal Man Work Gear Co will repair or replace the item under warranty that fails due to defects in material and workmanship. Metal Man Work Gear must be notified within 30 days of the failure, so as to provide instructions on how to proceed with the repair of your welder and warranty claim processing. Warranty period begins at the time the welder is purchased from and Authorized Reseller of Metal Man Work Gear Co. products. **Keep your receipt as proof of purchase.**

## Warranty Periods

Limited Warranty is divided into three categories. No Warranty, 90 days, 1 year and 3 year.

## No Warranty

Normal wear items, MIG gun parts (contact tips, nozzle, contact tip adapter, MIG gun liner), drive roll, electrode holder, ground clamps, Plasma torch parts (nozzle, electrode, diffuser, cover) are considered consumable items and are not covered under warranty.

## 90 days

Parts for Metal Man Work Gear welding carts and welding cabinets. This warranty covers the absence of or defective parts.

## 1 year

Parts and Labor on MIG gun parts (except those listed under normal wear items), cables, regulator, plasma torch (except those listed under normal wear items). Any shipping related to warranty repair is the responsibility of the customer.

## 1 year/3 year

Please see your product information to determine if your product has a 1 year or 3 year warranty. This warranty covers parts and Labor on items such as: transformer, reactor, rectifer, solenoid valve, PC Board, switches, controls, gas valve, drive motor, drive system other than drive roll and any other component that requires the removal of the sheet metal to access. Any shipping related to warranty repair is the responsibility of the customer.

## Voiding Warranty

Warranty does not apply to: Shipping Damage, Misuse and abuse of the unit, alteration of the unit in any way.

## Warranty Claim

This is a parts and labor warranty. Do not return your unit to the retailer you purchased it from. Retain your receipt in the case a warranty claim is needed. No warranty will be provided without the original receipt from an authorized reseller of Metal Man Work Gear Products. To make a warranty claim, call our welder help line at 888-762-4045, M-F 8:00 am to 5:00 PM Central time or email sales@metalmangear.com.