Hypertherm®

ArcWriter®

Roller Ball/Lifter Assembly

Field Installation Bulletin

(P/N 802880)

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PURPOSE

This field bulletin provides the necessary information to install the roller ball/lifter assembly for use with the ArcWriter Plasma Marking System.

ROLLER BALL/LIFTER INSTALLATION KIT (128184)

Part No.	Description	Quantity
129196	Assembly, Roller Ball/Lifter	1
027539	Slide, 4-inch Travel	1
027538	Roller Balls, Steel 15 mm Type 0	4
015310	Adapter, Flow Control 10-32 X 10-32	1
015308	Adapter, 10-32 X 5/32-inch Elbow	1
010586	Label, Protective Earth IEC 417-501	1
006105	Valve, Solenoid 120 VAC, 60 Hz	1
015309	Adapter, 1/8 NPT X 5/32-inch Hose	1
046111	Tubing, 5/32-inch O.D. Natural Nylon	2 ft.
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INSTALLATION PROCEDURE

Install the roller ball/lifter assembly, by referring to Fig. 1 and proceeding as follows:

WARNING

Turn off power to the power supply before working on the torch. Set circuit breaker on power supply to OFF (O) and set the line disconnect switch to OFF. Lock-out and tag-out switch. Electric shock can cause serious injury or death.

1. Mount the roller ball/lifter assembly at the lifter station using 1/4-inch mounting hardware. The six mounting holes are 0.281 inch (7 mm) in diameter.

2. Ensure the lifter assembly is grounded. (Good metal-to-metal contact with cutting table.)

3. Mount the solenoid valve at the lifter station or on the gantry. Wiring the valve should be done by a licensed electrician and according to national and local codes. Ensure good metal-to-metal contact exists between the valve and the mounting surface for a proper ground.

4. Attach the two feet of nylon tubing between the 1/8 NPT X 5/32-inch adapter CYL port on the solenoid valve and the elbow fitting on top of the roller ball/lifter assembly.

5. Supply regulated, compressed air at approximately 50 psig to the IN port on the solenoid valve. The maximum allowable air pressure is 100 psig. An air regulator (# 011023) and mounting bracket (# 001160) can be ordered from Hypertherm.

6. Energize the solenoid valve and the lifter will retract to the up position. De-energize the valve and the lifter will lower to the plate.

    - The speed of retract can be adjusted by raising (speed up) or lowering (slow down) the air pressure.

    - The speed of the lifter lowering to the plate is adjusted by the slotted screw on top of the rollerball/lifter assembly.

TORCH MOUNTING PROCEDURE

Mount the torch by referring to Fig. 1 and proceeding as follows:

1. Loosen the knob, so that the bracket can swing open.

2. Place the torch into the bracket and tighten knob, so that the torch can still be positioned in the bracket.

3. Refer to the ArcWriter Instruction Manual IM-252, Section 4, *Operating Data Charts* to set the Torch-to-Work distance.

4. After setting the Torch-to-Work distance, tighten the knob to keep the torch in place.

CHANGING ROLLER BALLS

Change the roller balls by referring to Fig. 1 and proceeding as follows:

1. Punch out roller ball with punch and hammer.

2. Place new roller ball in hole. Using a 3/4-inch socket and rubber mallet, seat the roller ball until it is securely in place.

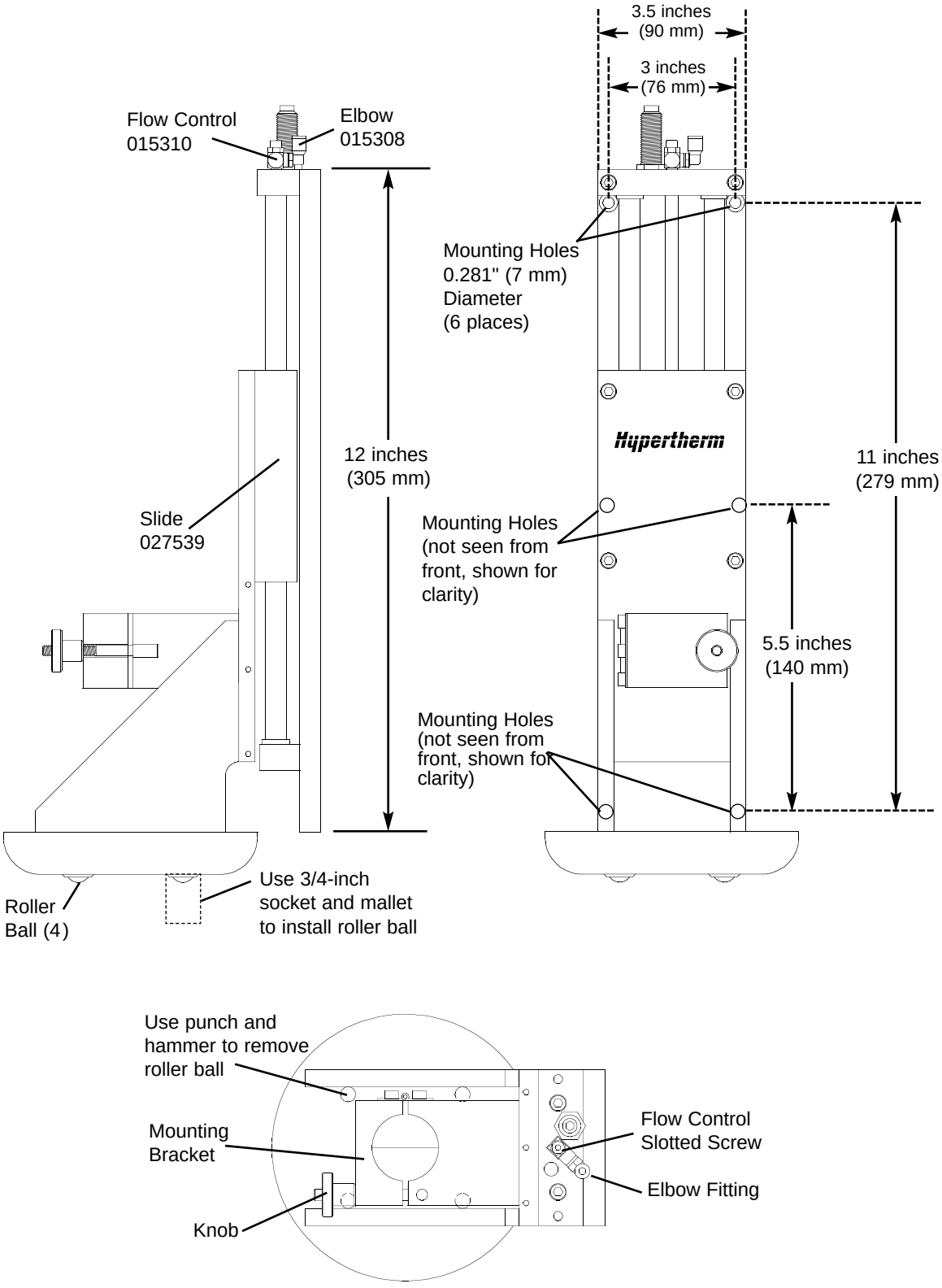

Figure 1 Roller Ball/Lifter Assembly