

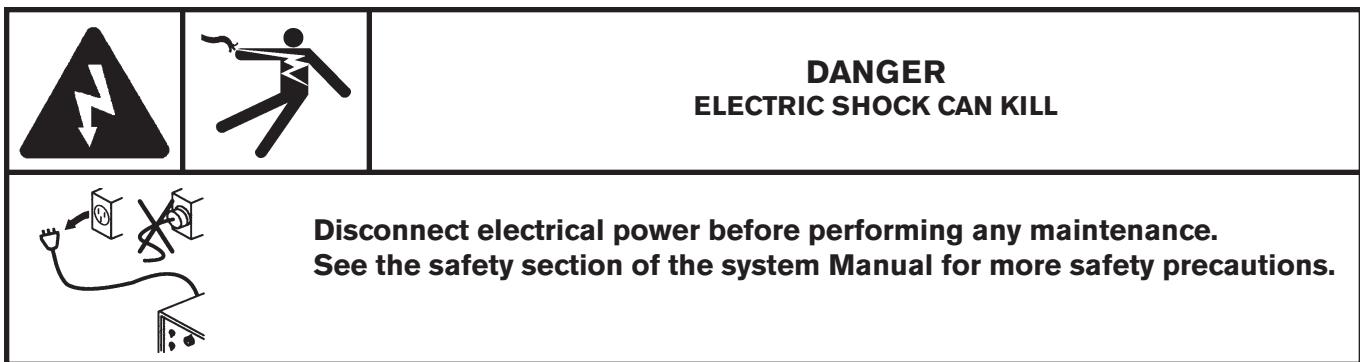
Plasma Interface Kit

HSD130 and Edge Ti

Field Service Bulletin

805690– Revision 0 – June, 2007

Hypertherm®



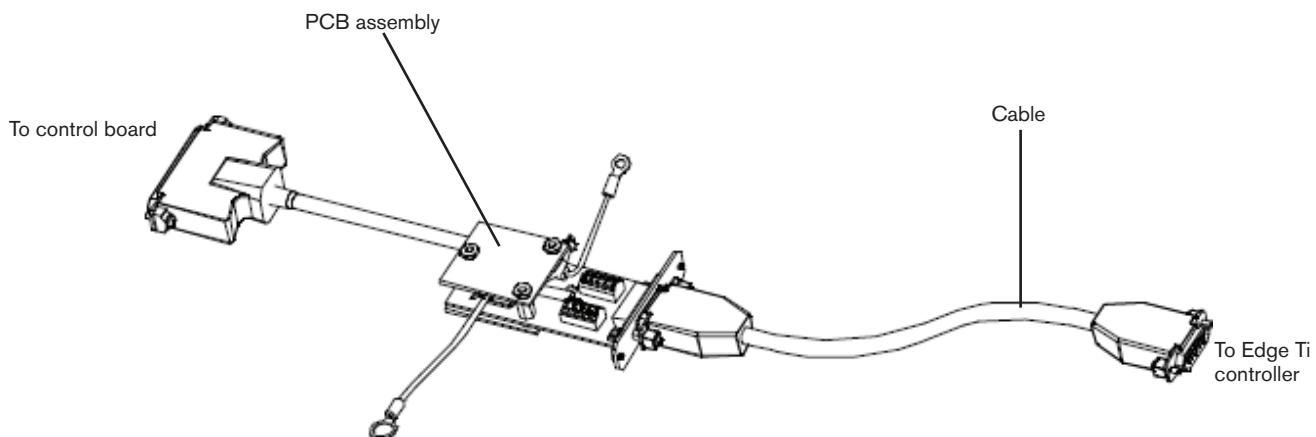
Introduction

Purpose

This field service bulletin enables a trained technician to properly install and connect the HSD130 plasma system and a Edge Ti Controller using the Plasma Interface Kit.

Kit contents

Part number	Description	Qty
CABL-0306	Plasma interface kit with 7.5 m (25') cable	1
CABL-0307	Plasma interface kit with 15 m (50') cable	1



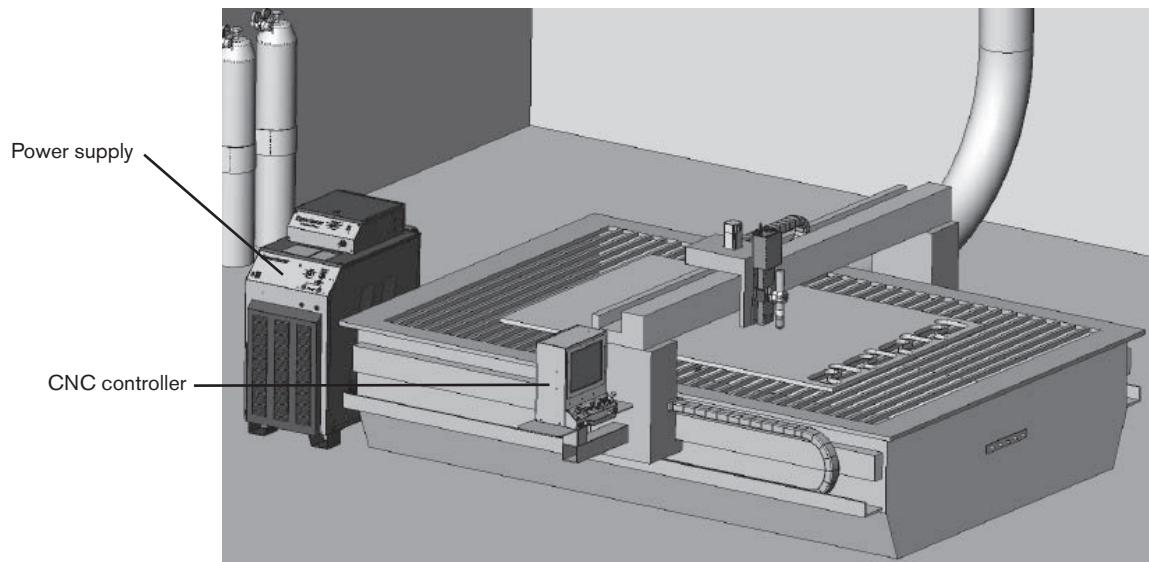
PLASMA INTERFACE KIT FOR HSD130 AND EDGE TI

Overview

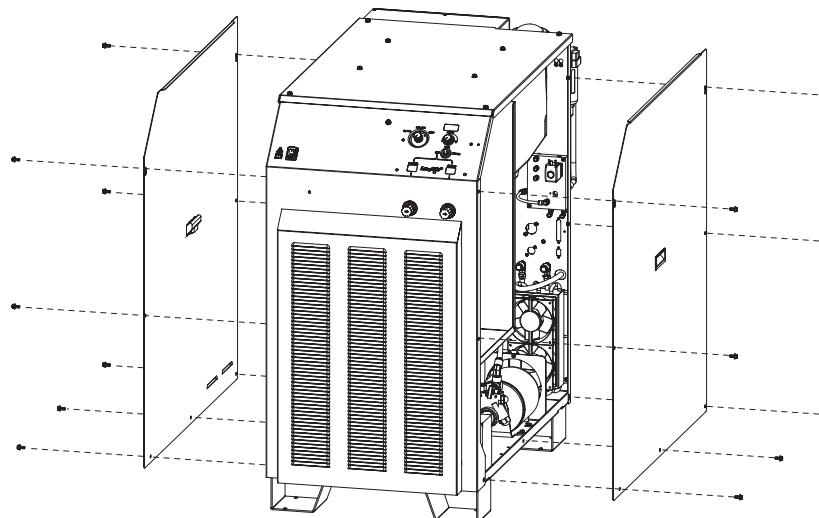
The Plasma Interface Kit combines the I/O communications between the CNC and the HSD130 with the Arc Voltage signal from the Power Supply. This design allows the user to use 1, plug-in cable between the CNC and the HSD power supply

Notes: see the HSD130 instruction manual and the Edge Ti manual for all other cable connections.
Initial height sensing and torch height control while cutting are controlled by the Edge Ti.

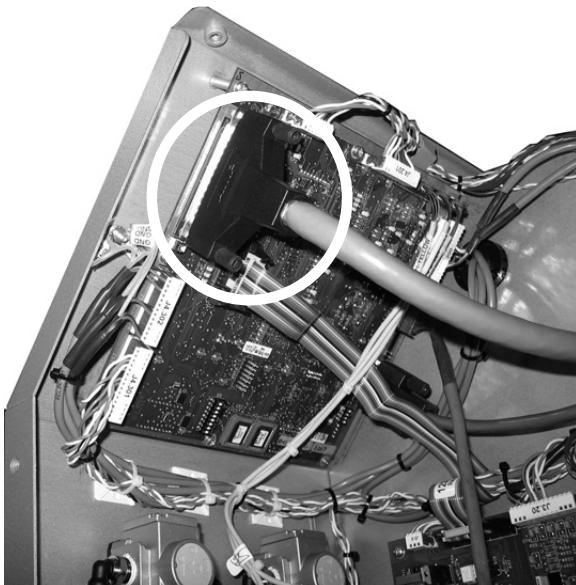
1. Locate the HSD power supply and the CNC controller.



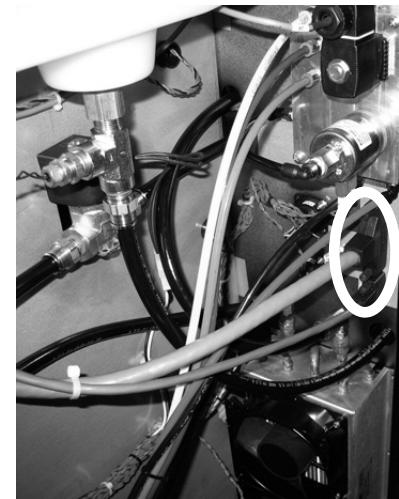
2. Turn OFF the power, and remove the right and left side panels from the power supply.



3. Disconnect the DB-37 cable from the control board and the rear panel of the power supply. Cut the tie-wraps that hold the cable on the power supply. Remove and discard the cable.

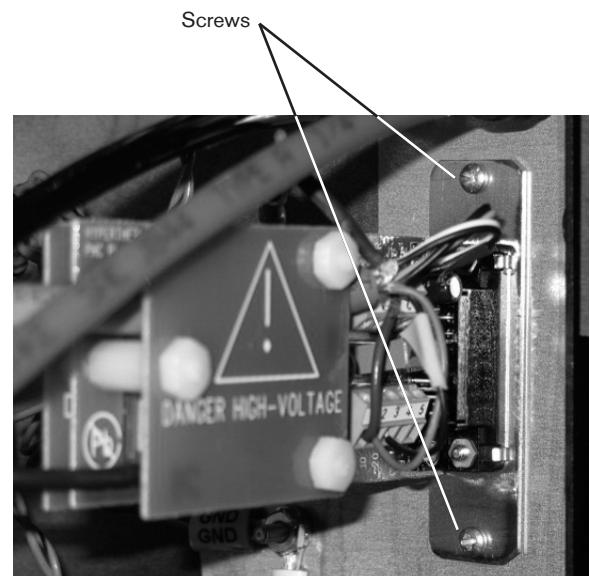
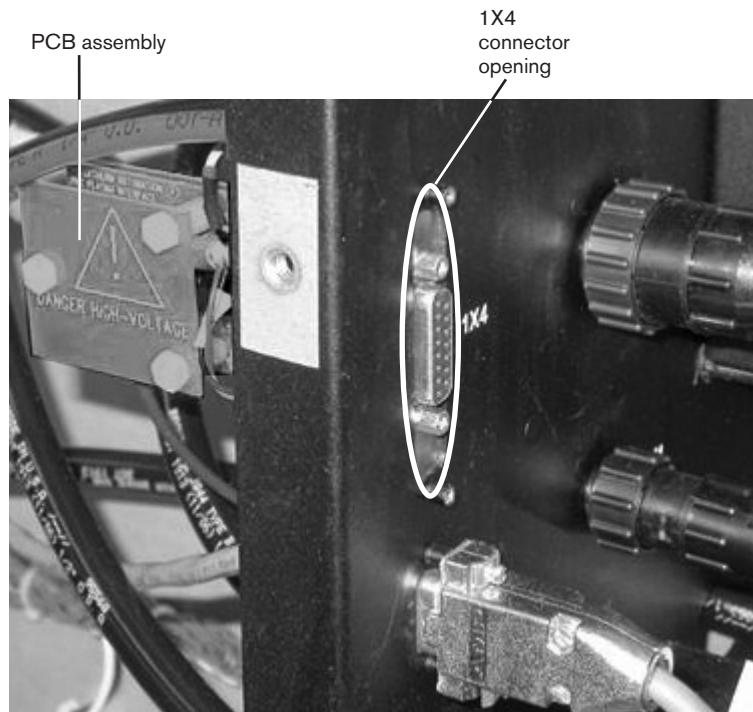


DB-37 connection on the control board



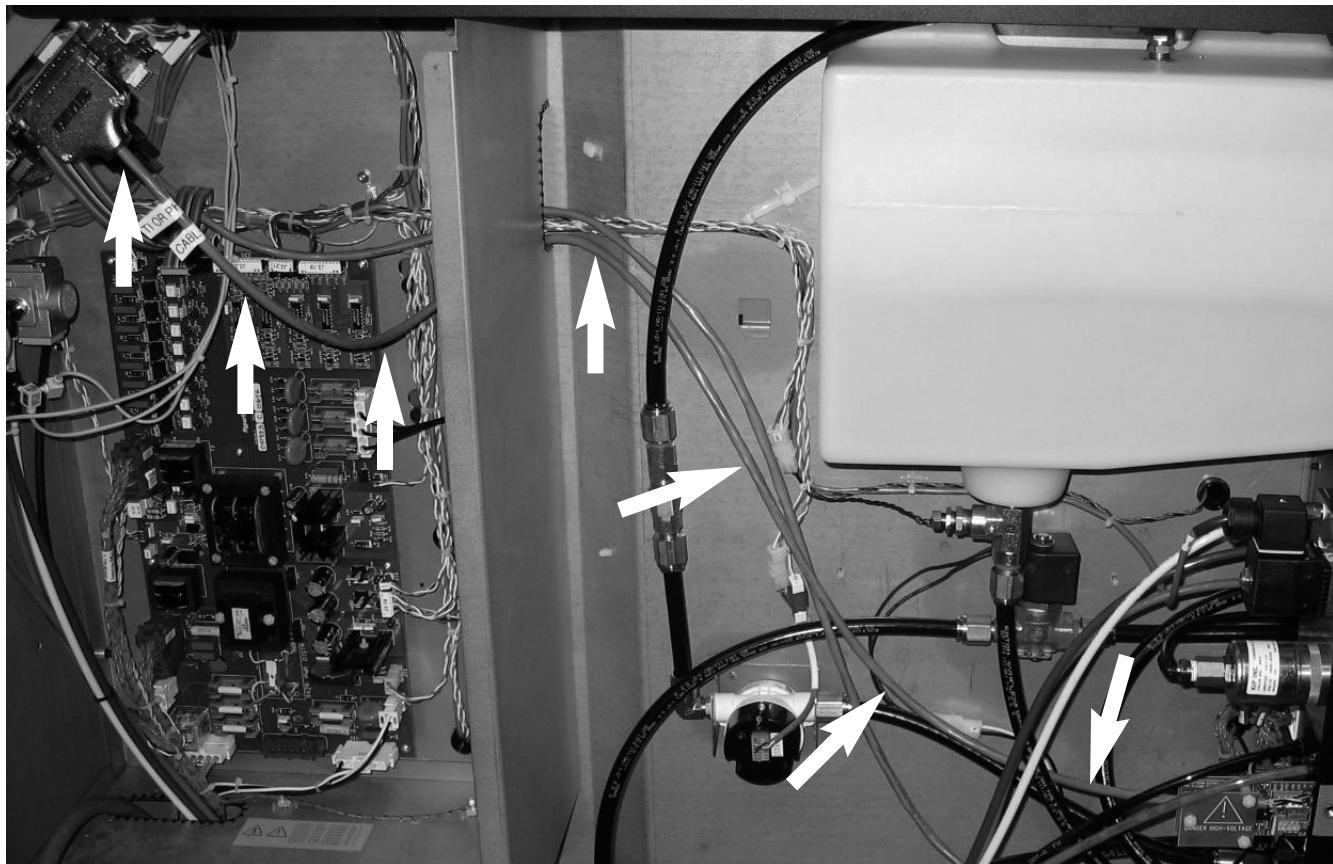
DB-37 connection on the rear panel of the power supply

4. Insert the plasma interface PCB assembly into the 1X4 connector opening in the rear panel of the power supply. Use the 2 screws provided in this kit to secure the PCB assembly.

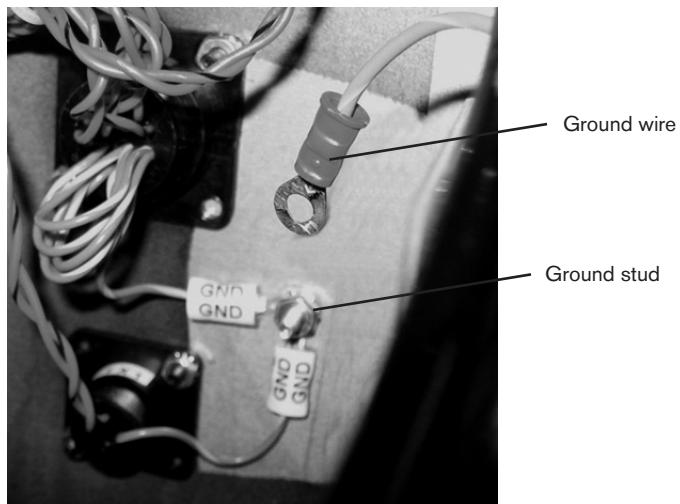


PLASMA INTERFACE KIT FOR HSD130 AND EDGE TI

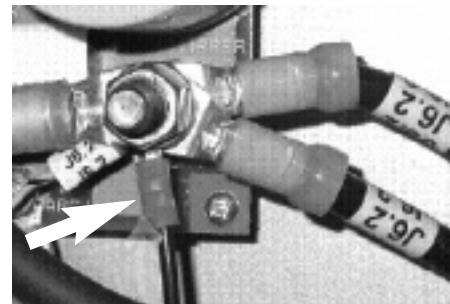
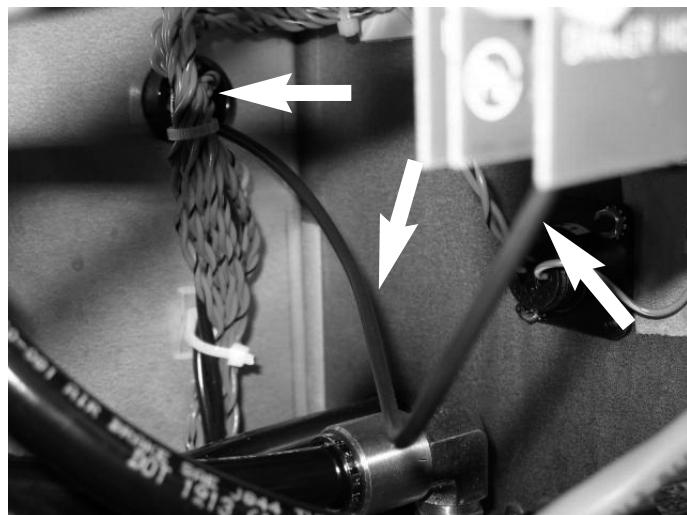
5. Route the cable that is attached to the PCB assembly through the power supply to the Control PCB and reconnect the DB-37 Connector.



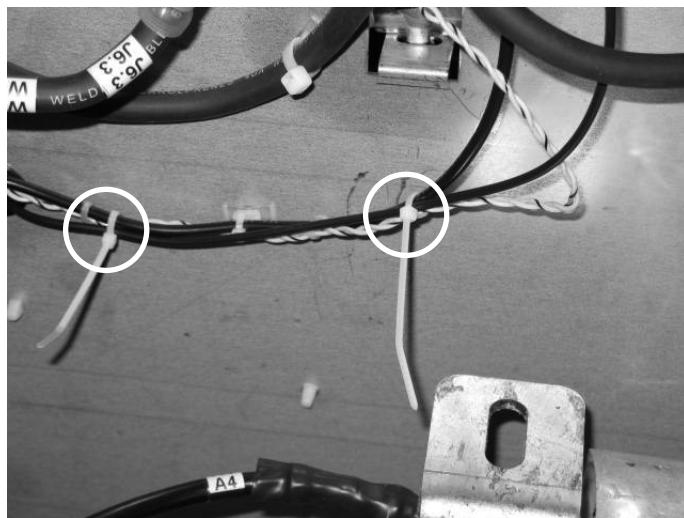
6. Connect the ground wire (GND) to the ground stud on the rear panel of the power supply.



7. Route the long black wire through the center panel to the terminal marked CHOPPER (-) on the I/O PCB.



8. Use tie-wraps to bundle the wires. To avoid damaging wires, do not over tighten the tie-wraps.



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9. Reinstall the 2 power supply side panels.
10. Connect 1 end of the DB-15 cable to the 1X4 connector on the power supply.



11. Route the cable from the power supply to the Edge Ti and connect the cable to the plasma interface connector.



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