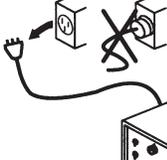


Plasma Interface Kit HSD130 and Sensor PHC

Field Service Bulletin

805740– Revision 0 – June, 2007

Hypertherm®

		DANGER ELECTRIC SHOCK CAN KILL
		Disconnect electrical power before performing any maintenance. See the safety section of the system Manual for more safety precautions.

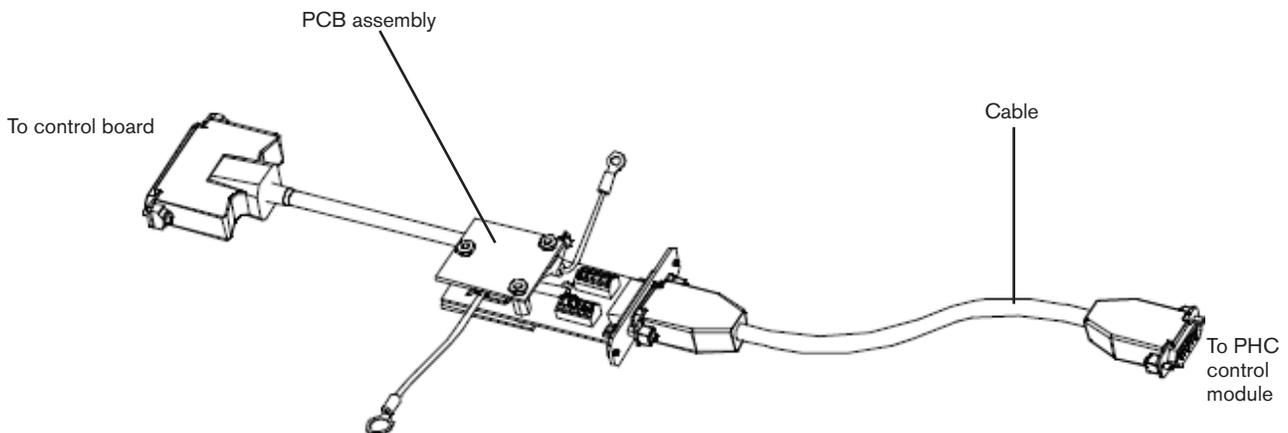
Introduction

Purpose

This field service bulletin enables a trained technician to properly install and connect the HSD130 plasma system to a Sensor PHC (plasma height control).

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

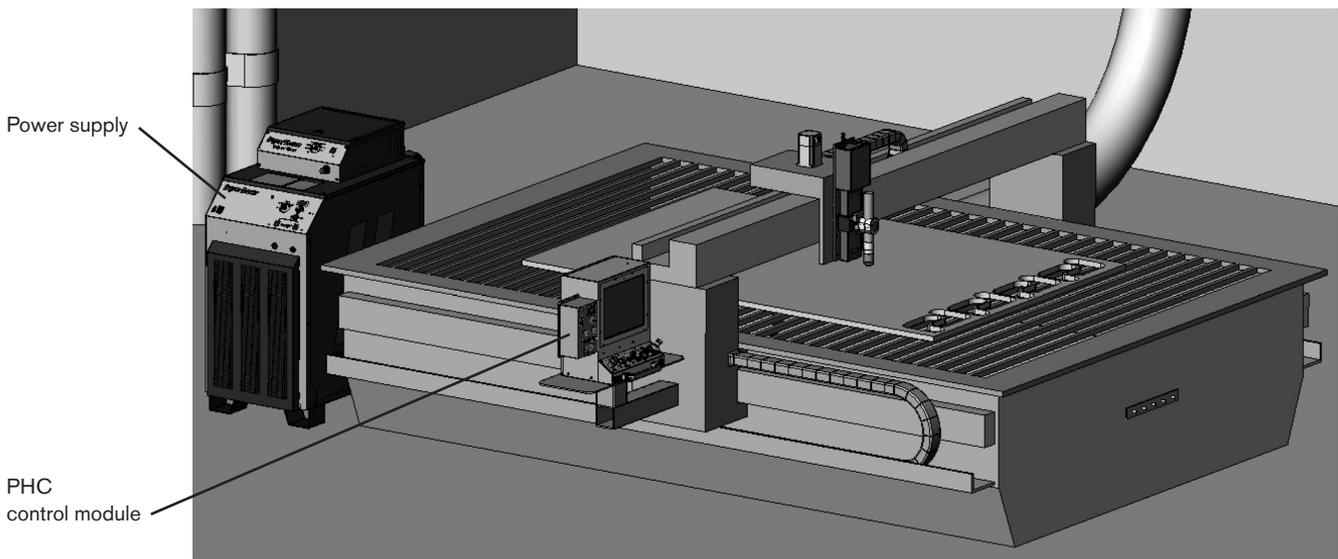


Overview

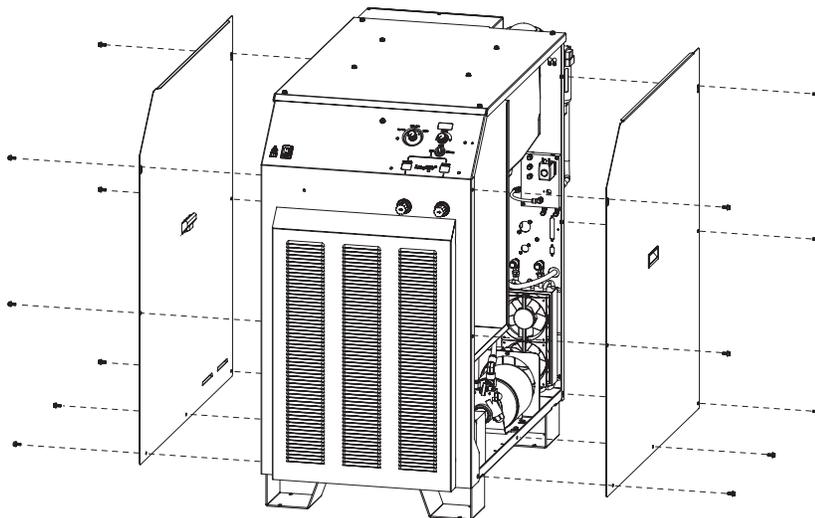
The Plasma Interface Kit combines the I/O communications between the PHC and the HSD130 with the Arc Voltage signal from the Power Supply. This design allows the user to use 1, plug-in cable between the PHC and the HSD power supply

Notes: see the HSD130 instruction manual and the PHC manual for all other cable connections. It will be necessary to determine the correct pin out to the CNC control, I/O connection. Initial height sensing and torch height control while cutting are controlled by the PHC.

1. Locate the HSD power supply and the PHC control module.



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

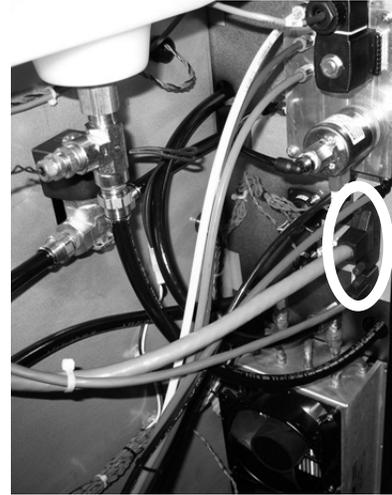


PLASMA INTERFACE KIT FOR HSD130 AND SENSOR PHC

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.

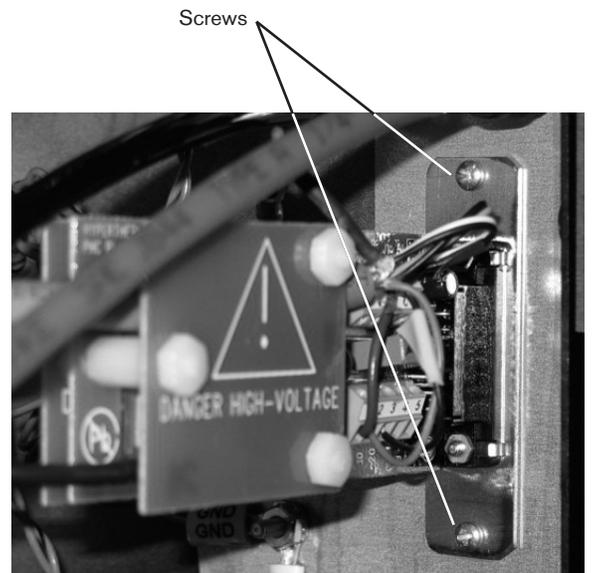
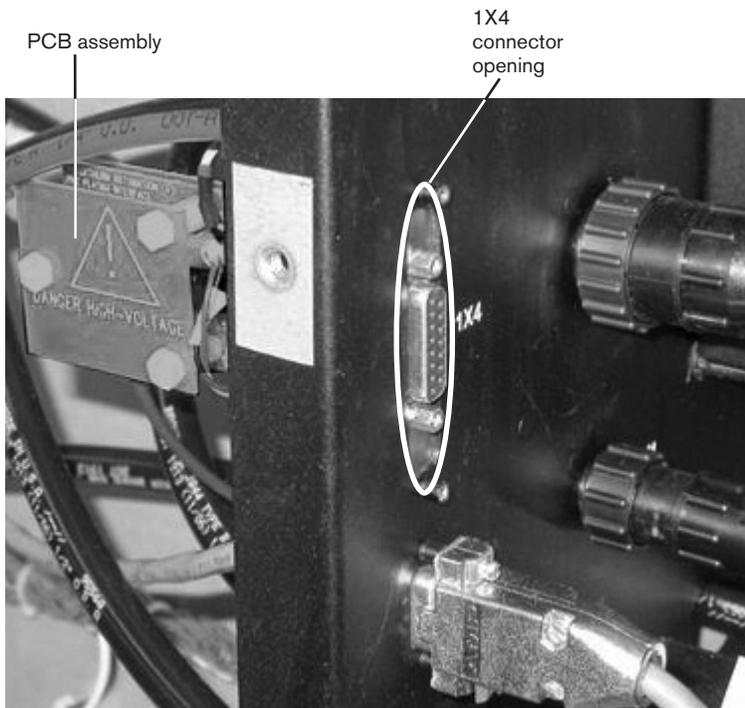


DB-37 connection on the control board



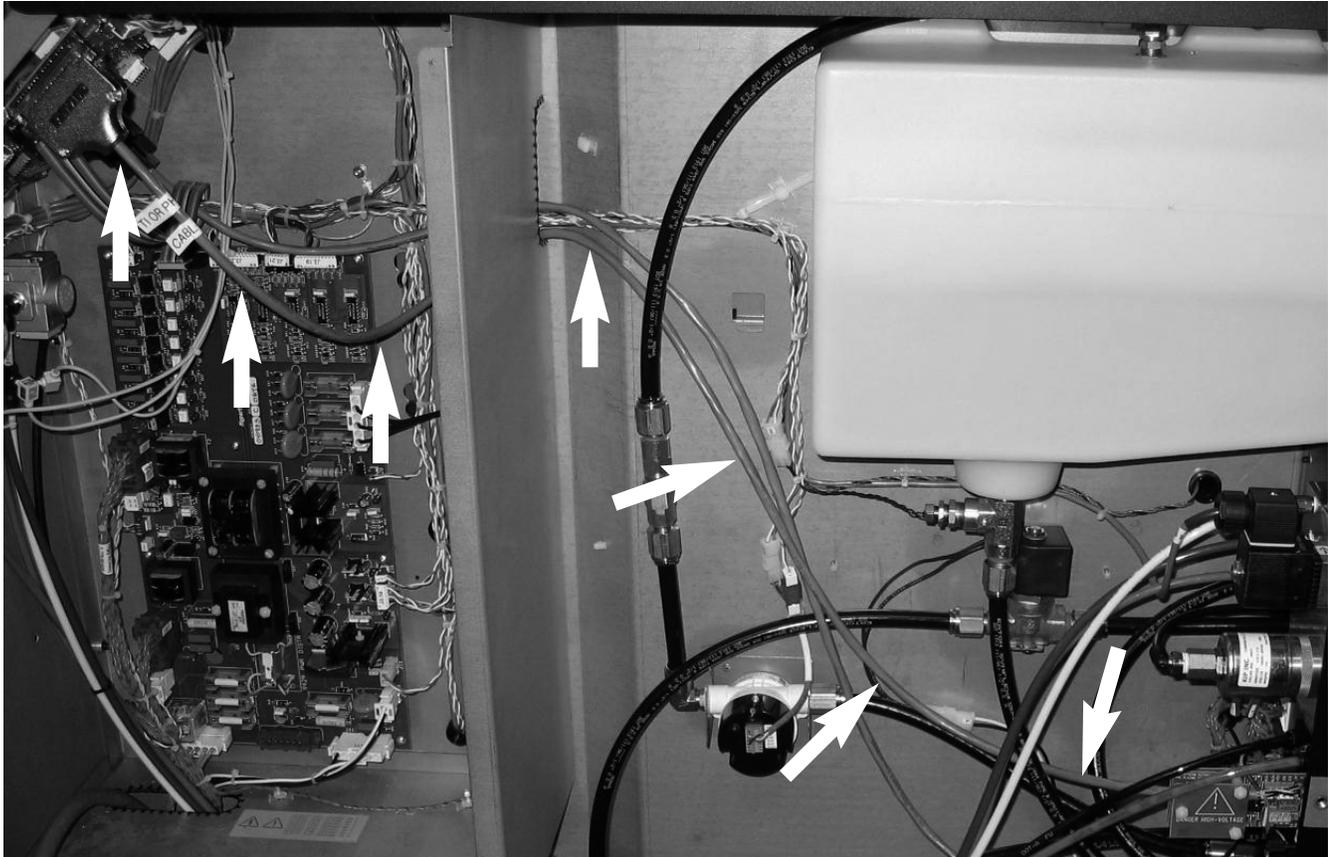
DB-37 connection on the rear panel of the power supply

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.

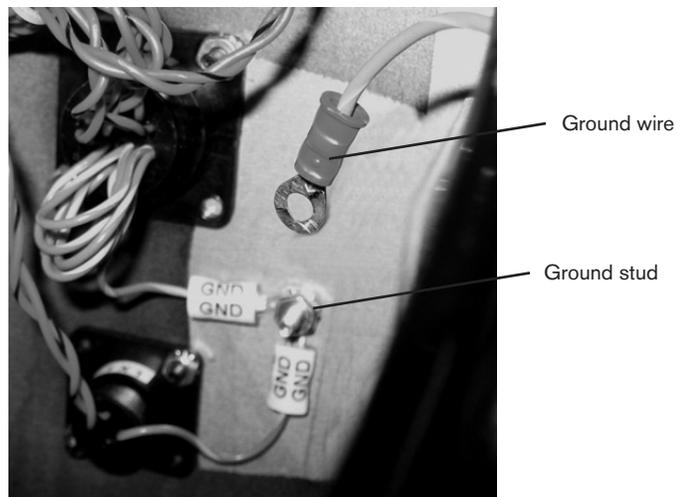


PLASMA INTERFACE KIT FOR HSD130 AND SENSOR PHC

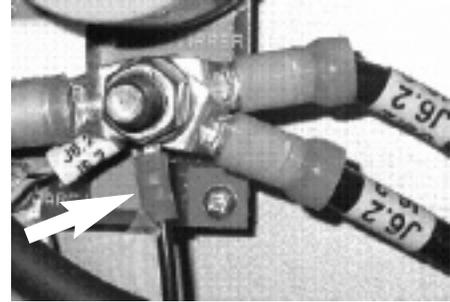
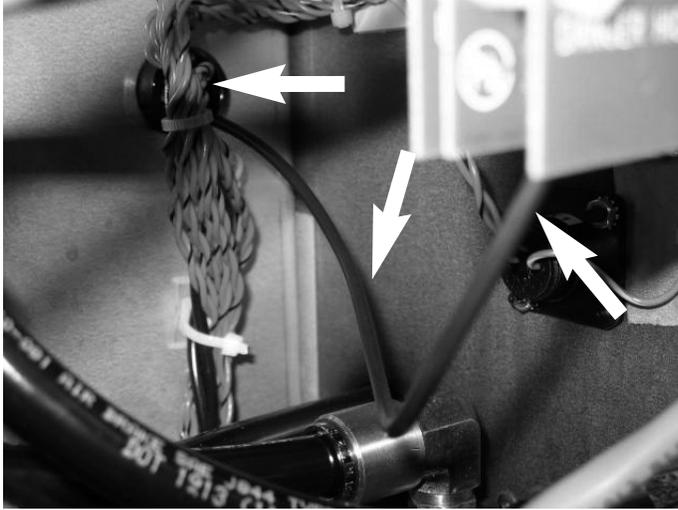
5. Route the cable that is attached to the PCB assembly through the power supply to the Control PCB and reconnect the DB-37 Connector.



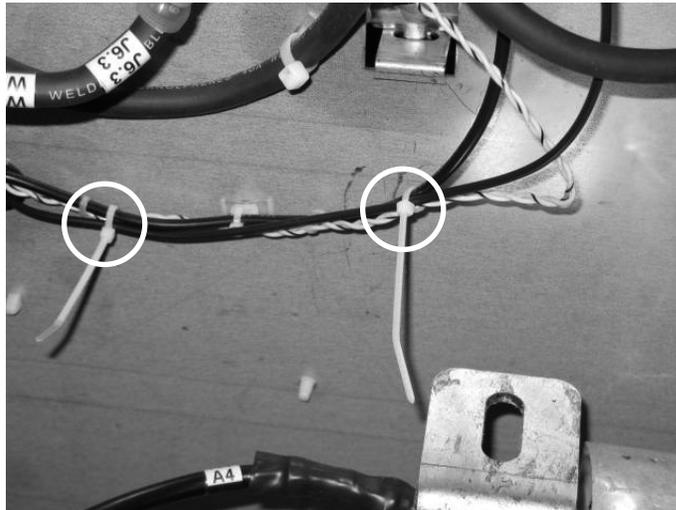
6. Connect the ground wire (GND) to the ground stud on the rear panel of the power supply.



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

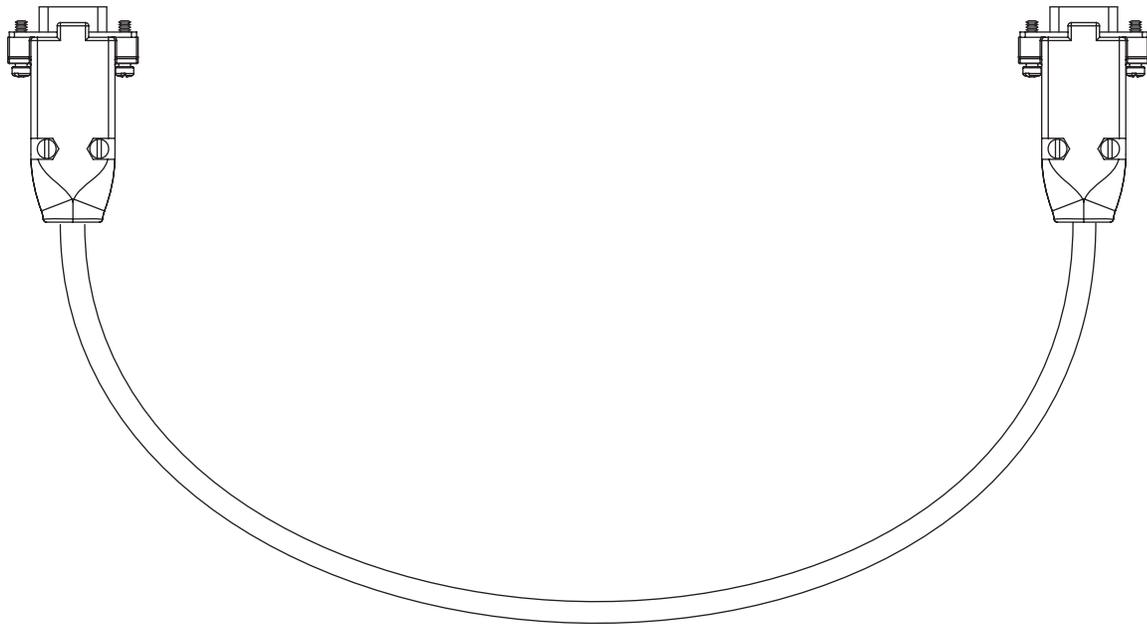
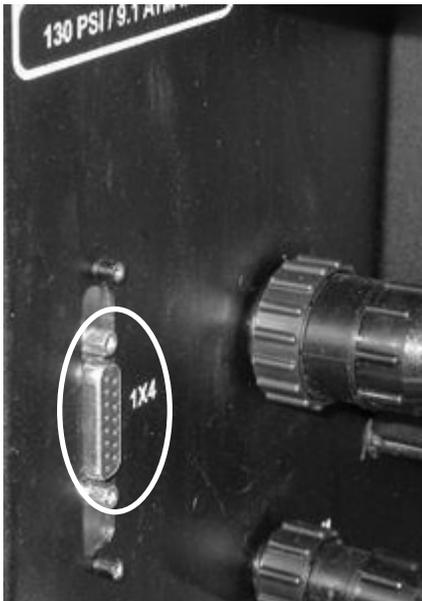


8. Use tie-wraps to bundle the wires. To avoid damaging wires, do not over tighten the tie-wraps.



PLASMA INTERFACE KIT FOR HSD130 AND SENSOR PHC

- Reinstall the 2 power supply side panels.
- Connect 1 end of the DB-15 cable to the 1X4 connector on the power supply, and the other end of the cable to the PS I/O connector on the Sensor PHC control module.



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