

Basic troubleshooting

The following table provides an overview of the most common problems that may arise when using the Powermax45 and explains how to solve them.

If you are unable to fix the problem by following this basic troubleshooting guide or if you need further assistance:

1. Call your Hypertherm distributor or authorized Hypertherm repair facility.
2. Call the nearest Hypertherm office listed in the front of this manual.

Problem	Solutions
The ON/OFF power switch is set to ON (I), but the power ON LED is not illuminated.	<ul style="list-style-type: none"> ▪ Verify that the power cord is plugged into the receptacle. ▪ Verify that the power is ON at the main power panel or at the line-disconnect switch box. ▪ Verify that the line voltage is not too low (more than 15% below the rated voltage).
The power ON LED is illuminated and the gas pressure LED is illuminated yellow and is above or below the center of the pressure bar.	<ul style="list-style-type: none"> ▪ Turn the amperage knob to the gas test position, then unlock the pressure regulator by pulling up on the knob. Turn it to adjust the pressure, then push it down to lock it. ▪ Verify that the gas supply line is connected to the power supply and the gas is turned on. ▪ Inspect the gas supply line for leaks and verify the incoming gas pressure.
The power ON LED is blinking.	<ul style="list-style-type: none"> ▪ The input line voltage is either too high or too low (a variance greater than $\pm 15\%$ of the rated voltage). Have an electrical technician check the incoming power. See the <i>Specifications</i> section and <i>Prepare the electrical power</i> in the <i>Power Supply Setup</i> section for more information.
The power ON LED blinks for approximately 10 seconds and then stops (480 V CSA power supplies only).	<ul style="list-style-type: none"> ▪ On rare occasions, toggling the power switch ON/OFF very quickly (a "quick reset") on 480 V CSA power supplies may cause the power ON LED light to flash for approximately 10 seconds. This flashing does not indicate a fault condition and will clear automatically. In such cases, you can safely continue to operate the torch while the LED is flashing.
The power ON LED is illuminated and the torch cap LED is illuminated.	<ul style="list-style-type: none"> ▪ Turn OFF the power supply. Verify that there are consumables installed. See <i>Install the consumables</i> in the <i>Torch Setup</i> section. ▪ If you have just installed the consumables, verify that the consumables are only finger-tight. Loosen them 1/8th of a turn and then restart the power supply. ▪ If the consumables appear to be installed correctly, the torch may be damaged. Contact your Hypertherm distributor or authorized repair facility.