

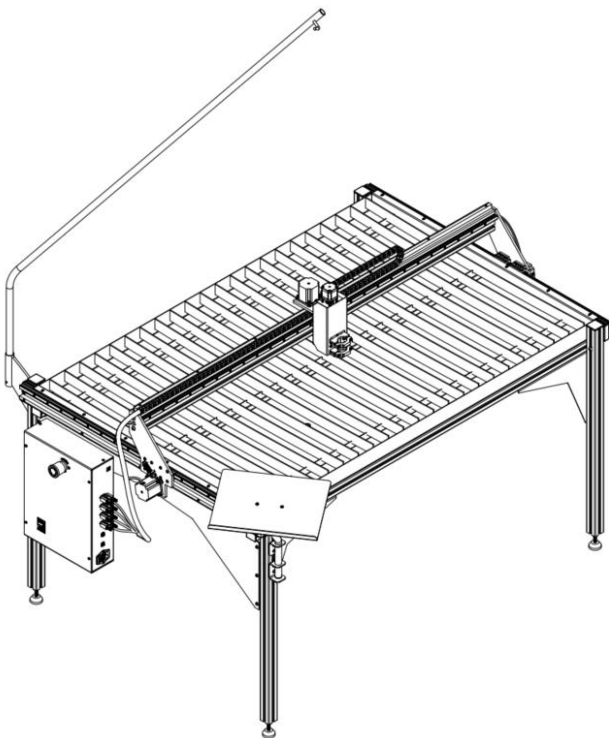
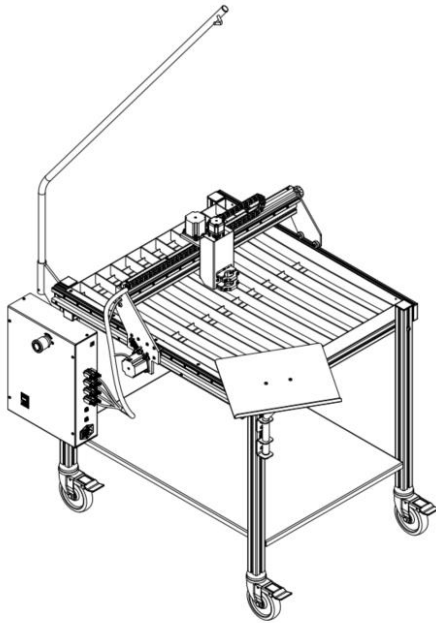
CE

ACROS

80/150

CNC Cutting Table

 PRITEC



Instruction
manual



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1. General information

Before using this machine, read and fully understand the operating instructions manual.

This manual contains important information regarding the proper installation, operation and maintenance of the equipment described herein. There are several risks of injury or property damage associated with using any CNC cutting table. Anyone who comes into contact with the installation, maintenance or operation of the CNC cutting table must be fully familiar with the contents of this manual. To protect yourself from personal injury or property damage, follow the directions and instructions in this manual.

Every PRITEC CNC cutting table is manufactured in accordance with the Machinery Directive 2006/42/EC. A manual including maintenance overview is supplied with every CNC cutting table. These must be properly stored and maintained.

Due to the continuous improvement of the equipment in view of quality, PRITEC reserves the right to change specifications of the equipment described in the manual.

1.1 Introduction

This manual will help you get started with your PRITEC ACROS. Read the manual carefully so that you can take full advantage of your cutting table and cut the most fantastic products.

1.2 How does the process work?

The table has a control program called Mach3 CNC controller. You can install this program on your laptop by following the steps in this guide. With this program you can "manually" control the machine with your laptop.

When you want to automatically cut a workpiece, you can load a G-code into the driver and then let it play.

1.3 What is G code?

G-code is a command used when programming a CNC program.

This G code is an instruction for the machine. The code has a structure with the letter G, followed by a number, for example G26. The number after the G has a meaning. The numbers 0 to 99 have a fixed meaning that is fixed in an ISO standard. A G-code tells the machine what to do, in which order, with which tool, in which place and with what speed and feed.

Not only G-codes are important in a CNC program. M codes are also used. These machine help codes are as important as the G codes themselves. A G-code is used when machining a workpiece, while M-codes are rather used as a complement to give the machine additional instructions, for example M03 or M05. These codes are used, among other things, to enable or disable the plasma cutter head. Using these codes is not the only important thing about a CNC program. The program largely relies on coordinates and values that determine the accuracy and correctness of a workpiece.



1. 4 How do I create G-code?

To create G-code you need a program with which you can create a 2D or 3D file. This file contains the geometry of the workpiece to be cut. In general, you can make this with 2D or 3D drawing software. Then you need a program to convert the geometry into a G-code that the machine can read. Sometimes both processes can be run with the same program. Check out our site for the possibilities <https://www.prinsentd.nl/support/>



2. Safety Precautions

2.1 Basic principle of safety in the workplace

Most accidents happen because safety regulations are not taken into account or because they are ignored. Safety equipment such as shields, safety glasses, dust masks, hearing protection, etc. reduce the risk of accidents. But even the best security measures do not protect against poor judgment, inattention or carelessness. Pay attention at all times in the workshop and use common sense. When something seems too dangerous, don't try it, but find a safer solution, even if it may take more time. Remember: Your personal safety is your responsibility.

The user of the machine must be sure of the following:

Persons who operate the machine have received instructions/training for this and have been made aware of the dangers and safety regulations.

The safety regulations are complied with and can preferably also be read at the workplace. For this reason, the manual is part of the machine and should be kept within easy reach of the machine at all times. When the machine is sold on, the manual must be handed over!

2.2 Basic safety regulations working with machines

1. Before using the machine, make sure you understand this manual. Failure to follow this instruction could result in serious personal injury, material damage and/or damage to the machine.
2. Read and understand all warnings in this manual and the warnings marked on the machine. Failure to follow these warnings could result in serious personal injury.
3. Replace warning labels if they are no longer readable or have been removed.
4. This machine is designed and intended for use by professionals and experienced staff. If you are not familiar with the use of the machine, do not use it until you have gained sufficient experience and knowledge.
5. Do not use this machine for any purpose other than that for which it is intended. Failure to do so or modifying the machine will void the warranty and the manufacturer will not be liable for any damage or injury resulting from this.
6. Always use ANSI approved safety glasses or face shield when operating this machine.
7. When using the machine, do not wear jewellery, loose clothing and/or a watch, as these can get caught in grabbing parts. Long hair should be tied up or put in a hairnet. Wearing anti-slip footwear or applying anti-slip strips to the floor is recommended.
8. Do not use this machine when you are tired or under the influence of alcohol/medicines/drugs.
9. Check that the main switch is in the 0 (OFF) position before connecting the machine to the power supply.
10. Never use this machine outdoors or expose it to rain and/or moisture.
11. Never use the machine in a hazardous working environment. Using power tools in humid environments or in the rain can cause electrocution.
12. Make sure the machine is properly grounded.
13. When using an extension cord, make sure it is in good condition and can handle the machine's current. An extension cord that is too light can cause loss of power and overheating. Refer to the EN 60204-1:2006 standard for the correct size. It depends on the length of the cord and the specifications of the machine.
14. When performing repairs or maintenance on the machine, the plug must be disconnected from the power supply .



15. Only use accessories and attachments prescribed by the manufacturer, the use of other accessories/attachments may cause damage to the machine and/or personal injury.
17. Remove materials, tools, keys and the like from the machine before using it.
18. Keep safety panels in place at all times when the machine is in use. If these are removed for maintenance work, transport, etc., they must be replaced before the machine is put into use again. Before use, check that all safety panels and/or guards are in place.
19. Do not force the workpiece and/or the machine. This could result in damage to the machine and/or personal injury.
20. If a defect occurs during machine start-up or use, the operator must stop the machine and report the defect to the workshop supervisor or the technical service.
21. When the machine is not in use, it must be switched off.
22. Follow the prescribed maintenance and inspection instructions at all times, which can be found in the user manual.
23. Make sure the machine is secured on a solid, stable surface.
24. Check the machine for defective parts before each use. Before using the machine, make sure that a damaged part is still in good working order and capable of performing its intended function. Check the alignment of moving parts, connection of moving parts, broken parts, assembly and other phenomena that may affect machine operation. In the event of a defective part or protection panel, the machine should be taken out of service until the affected part has been repaired or replaced, this should only be done by an authorized company/mechanic and defective parts should only be replaced with original PRITEC parts. parts, these are available from your PRITEC dealer.
25. Provide sufficient obligation and space around the workplace.
26. Keep the floor around the machine free of sharp materials, oil and grease.
27. Keep visitors at a safe distance from the workplace and keep children away.
28. Make your workshop "child proof" by working with padlocks on the main switches and by removing keys when the machine is not in use.
29. Concentrate completely on your work. Looking around, having conversations, etc. distract your attention, which could result in serious injury.
30. At all times, make sure that you have a firm footing and that you never overreach so that you do not fall into the machine or other moving parts.
31. Never overload the machine. Operate the machine at the correct speed and feed rate. Do not force the machine to perform a task for which it is not intended.
32. Carefully maintain your machine. Keep them clean and replace worn parts for the best and safest performance. Follow the instructions for cleaning, lubricating and replacing parts.
35. Switch off the machine before cleaning or when performing maintenance on the machine. Use a brush or compressed air to remove dust, chips, chips and dirt, not your hands.
36. Do not stand on the machine. If it falls over, serious injury may occur.
37. Never let the machine run unattended. Turn off the power and do not leave the machine until it has come to a complete standstill, otherwise unauthorized persons may be injured.
38. Remove loose objects and unnecessary workpieces from the work area before starting the machine.

2.3 Specific safety regulations for CNC cutting tables













1. Do not use the machine until it has been assembled and installed according to the instructions in this user manual.
2. If you are not familiar with/have never worked with a CNC cutting table before, please allow yourself to be instructed and/or guided by an experienced/specialized person.
3. Follow all technical requirements and prescribed electrical connections.
4. Use the guards and guards at all times, check beforehand that they are in place and functioning properly.
5. Keep fingers, hands and arms away from gears and other rotating parts.



6. Avoid strange handling and hand positions where unexpected slipping could lead to contact with the plasma head.
7. Never start the machine with the plasma head against the workpiece.
8. Use an extraction system.
9. Support long or wide workpieces with material supports/rollers.
10. Disconnect the machine from the power supply before adjusting settings, installing or removing accessories, or when performing maintenance or repair on the machine.
11. Unplug the machine from the power supply and clean the machine and work area before leaving it.
12. We recommend using the following Personal Protective Equipment (PPE): safety shoes, gloves and safety glasses.











2.4 Description of warning stickers




	<p>CAUTION: Place the CNC cutting table in a well-ventilated area and on a stable surface. Melting metals can cause unpleasant odors and smoke while cutting.</p>		<p>CAUTION: In case of emergency or short circuit, remove the plug from the socket.</p>
	<p>WARNING: HOT, DO NOT TOUCH The plasma cutter head and cut workpieces reach high temperatures during cutting. Make sure everything has cooled down before touching these parts again. Or use the right gloves and PPE for this .</p>		<p>Safety glasses required</p>
	<p>WARNING: MOVING PARTS Be careful of your fingers and other body parts when the cutting table is in operation. The moving parts of your PRITEC ACROS may cause damage. Do not touch the rotating parts of the cutting table when it is in use.</p>		<p>Safety shoes mandatory</p>
	<p>WARNING: Do not place the cutting table near combustible materials.</p>		<p>Gloves required</p>
	<p>CAUTION: Be careful with electrical voltage. The control box is powered with 220 volts AC and the output voltage is 24 volts DC.</p>		<p>Using Operating Instructions</p>
	<p>WARNING: STAY NEAR THE CNC CUTTING TABLE WHEN IT IS IN USE.</p>		<p>ATTENTION: The emergency stop is mounted on the control box, it must be within reach at all times during operation.</p>



3. Accessory Checklist

Description	Number of	
power cable	1	
USB cable	1	
Cable guide	1	
Cable retention straps	3	
Laptop support 2-piece + 2x M4x16 incl. nut and washer	1	
cutting strips ACROS 80 ACROS 150	10 22	
bracket holder (only applicable to ACROS 150)	1	
M6x20 bolts (only applicable to ACROS 150)	2	



M8x50 bolts (only applicable to ACROS 150)	4	
Swivel castors incl. M8x30 with rings (only applicable to ACROS 80)	4	
cover caps (only applicable to ACROS 150)	4	

4. Technical specifications

4.1 Machine specifications

	ACROS 80	ACROS 150
Table dimensions (LxWxH)	1060x940x1100mm	1880x1260x1150mm
Total weight	47 kg	109 kg
Cutting surface	646x710mm	1489x907mm
Nutrition	220V~50hz 360W	220V ~50hz 360W

4.2 Laptop specifications

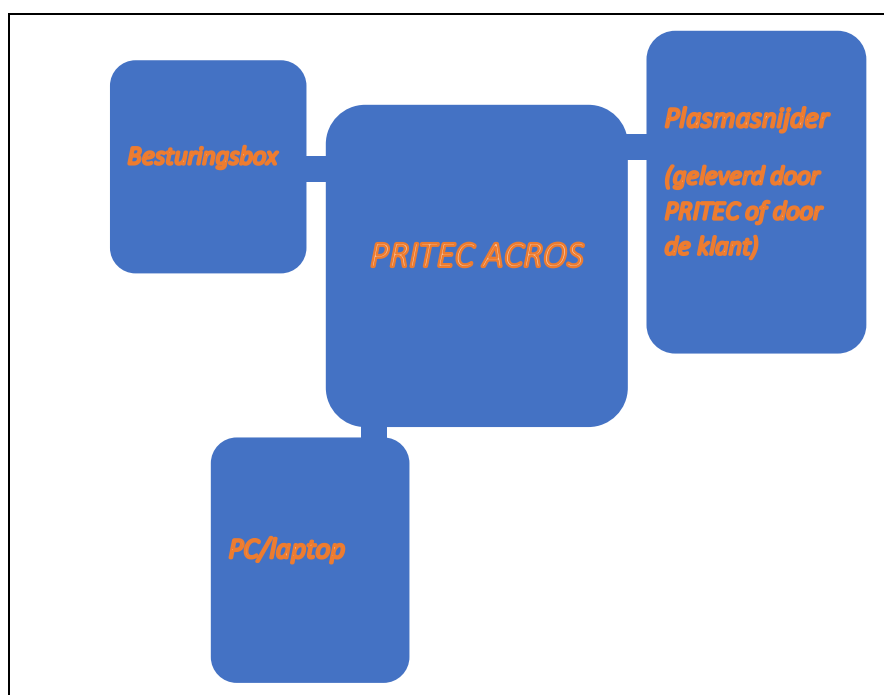
32-bit version of Windows 2000, Windows XP, Windows Vista, or Windows 7 Operating System
1GHz CPU .
512MB RAM.
Non-integrated video card with 32MB RAM
1 x USB



4.3 Air supply plasma cutter

Refer to the plasma cutter manual for air supply requirements. We recommend installing a water separator in the air supply for a better cutting result.

4.4 Machine layout



5. Machine Assembly

Tools needed for assembly:

- Allen key 3 and 5 mm
- Open-end wrench 13 mm 2x

Follow the instructions in the supplied assembly drawing.

Figuur 1



5.1 Transport and storage

Transporting material

When loading/unloading or transporting the equipment at the workplace, you must use suitable transport and lifting equipment (eg crane/forklift, truck). Ensure components are lifted and transported with care so as not to fall, taking into account package size, weight, center of gravity and fragile parts. Use a forklift or pallet truck to transport the package (Figure 1).

When the machine is out of the packaging, use a lifting sling or round sling to transport the machine (figure 2).

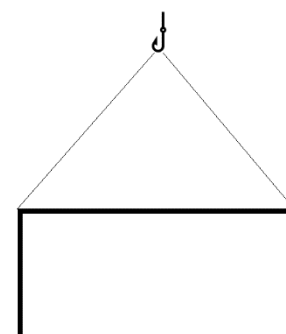
Storage and stacking of packages

Packages containing the machine should be stored in a covered area, out of direct sunlight and low humidity, at a temperature between -10°C and 40°C . Stack a maximum of 3 packages on top of each other.

unpacking

When the machine is delivered, immediately check the package for possible damage due to transport and storage. Check that the contents of the package are complete using the parts list and drawing. In case of damage during transport, the customer must immediately inform the transport company. Packages should be opened with attention to safety, keep a safe distance when opening straps and be careful that no parts fall out of the package when opening.

Figuur 2





6. Software installation

For this installation you need a laptop that has the right specifications to control the software. (see 4.2 minimum laptop specifications)

After installation, we recommend that you use the laptop power cord as the power source instead of the laptop battery when operating the ACROS.

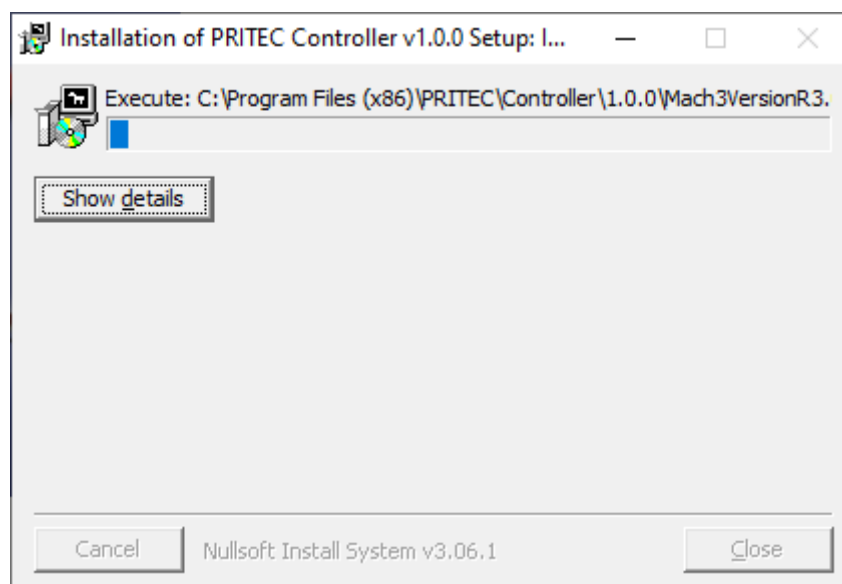
6.1 Installation software for control PRITEC ACROS

Download control software

The plasma table is controlled by so-called “control software”. The software is freely accessible and easy to download via the website. The latest version of the operating software is available at <https://www.pritec-automation.com/files/>. This page explains where and how you can download the software.

Run the installation

NB! Windows may ask to enter an administrator password. This is caused by the installer installing a *driver* to make the connection to the plasma cutting table. This *driver* is important to the operation of the plasma cutting table and it will not be able to communicate with the computer if it is not installed.



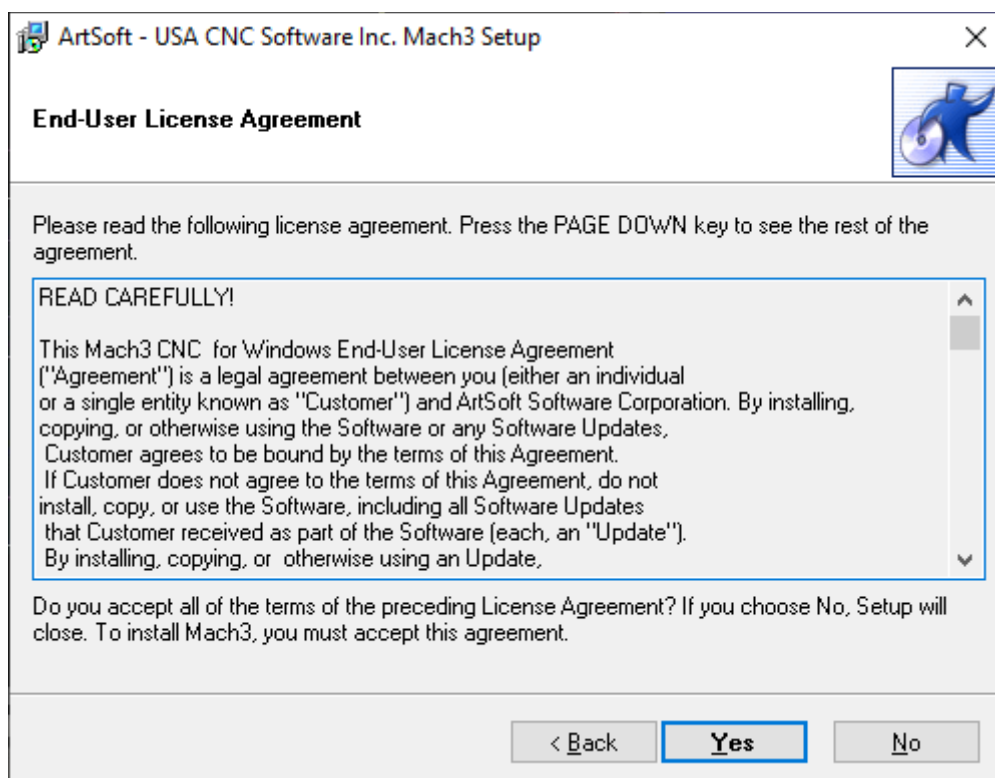
A screenshot of the installer starting up.

After this screen, the installation of the *Mach3* software will start. The installation of *Mach3* must be done step by step to ensure that the product works properly.

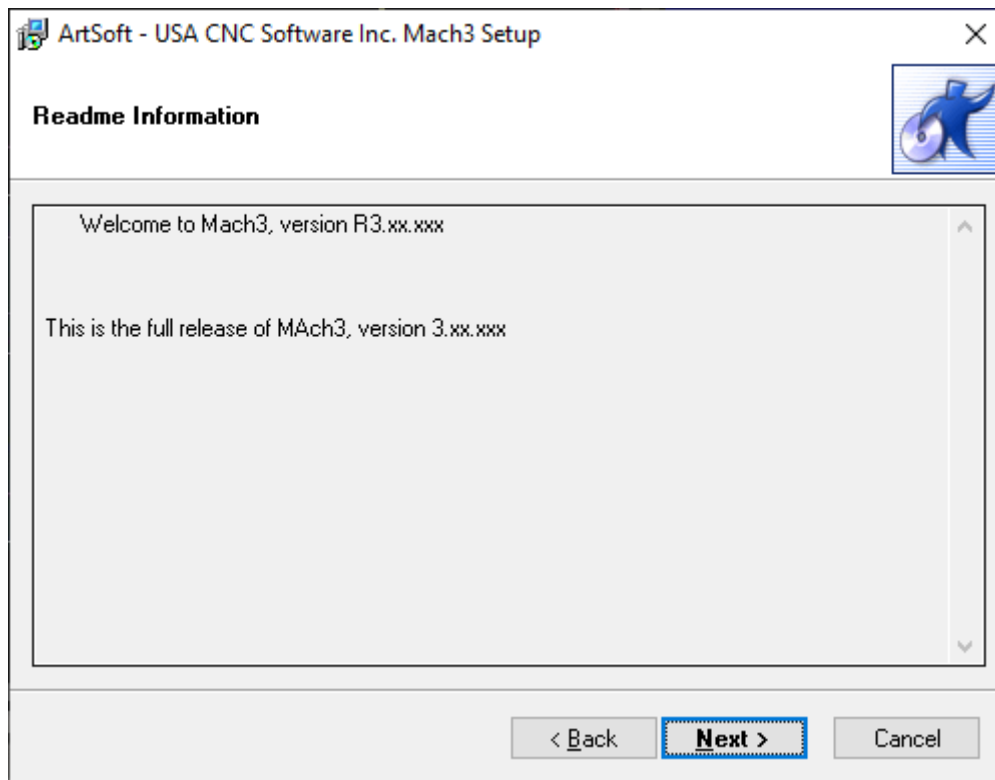


A screenshot of the Mach3 software installation welcome screen.

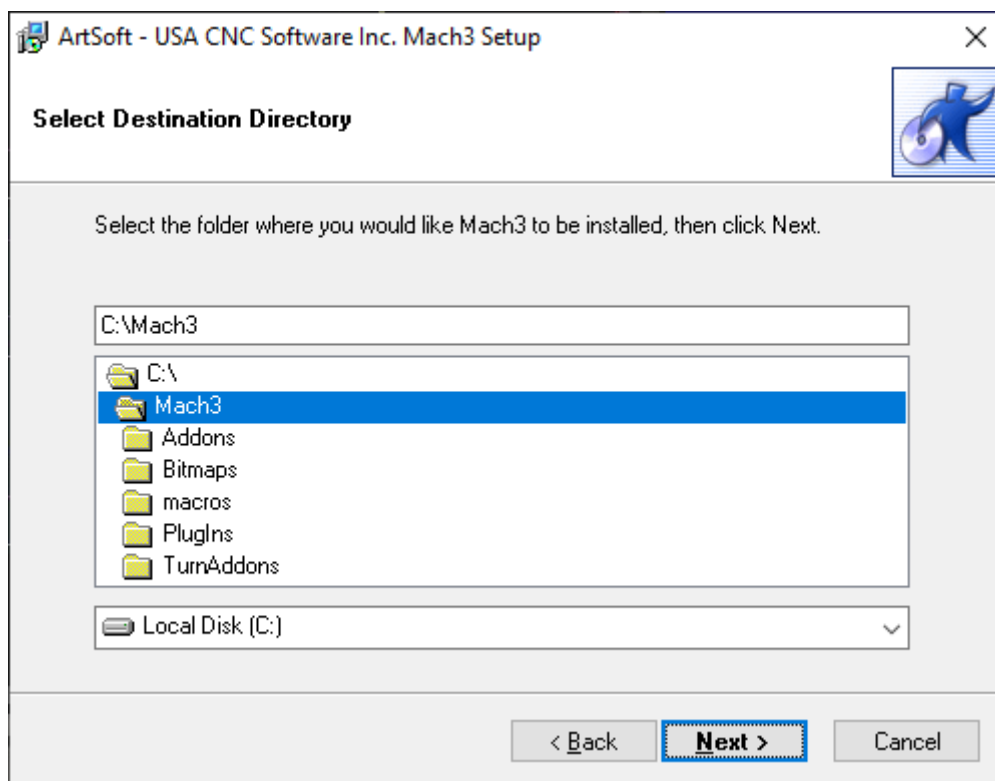
The installer recommends closing all Windows applications before the installation begins. Once this is done, **click Next**.



Read the following text carefully . Make sure the text is understood and then click **Yes** . If you don't agree, click **No** .



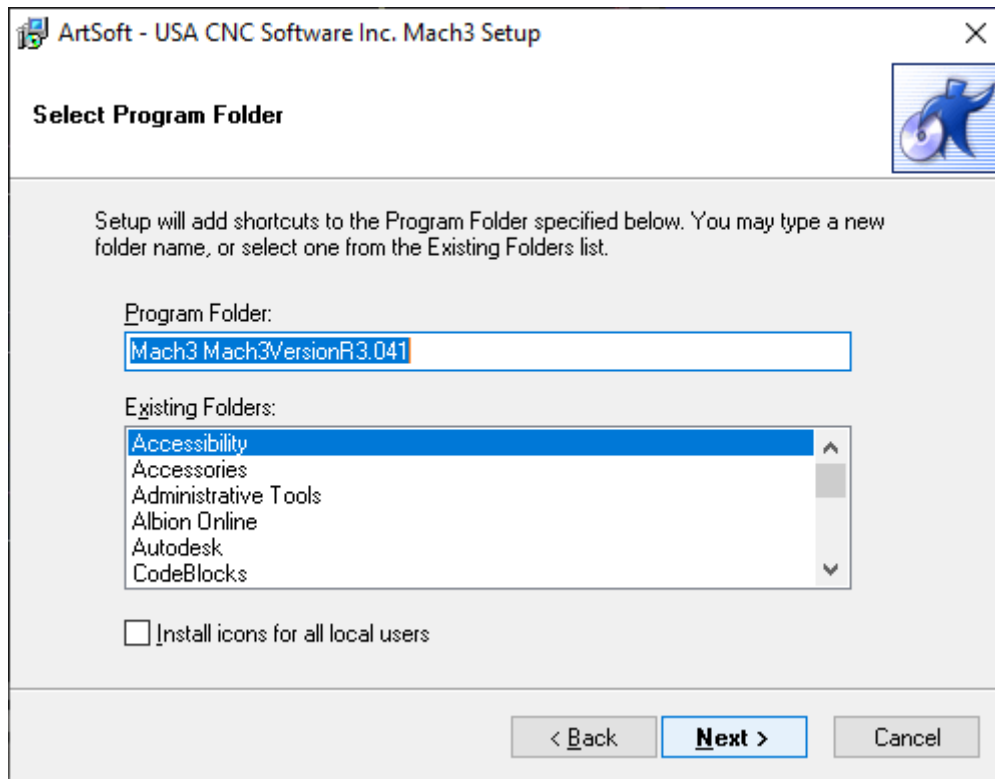
Click **Next** .



Attention ! Make sure Mach3 is always installed in C:\Mach3 . This is important for the correct installation of the program. This is because the installer assumes Mach3 is installed in C:\Mach3 for copying the profiles of the machines.

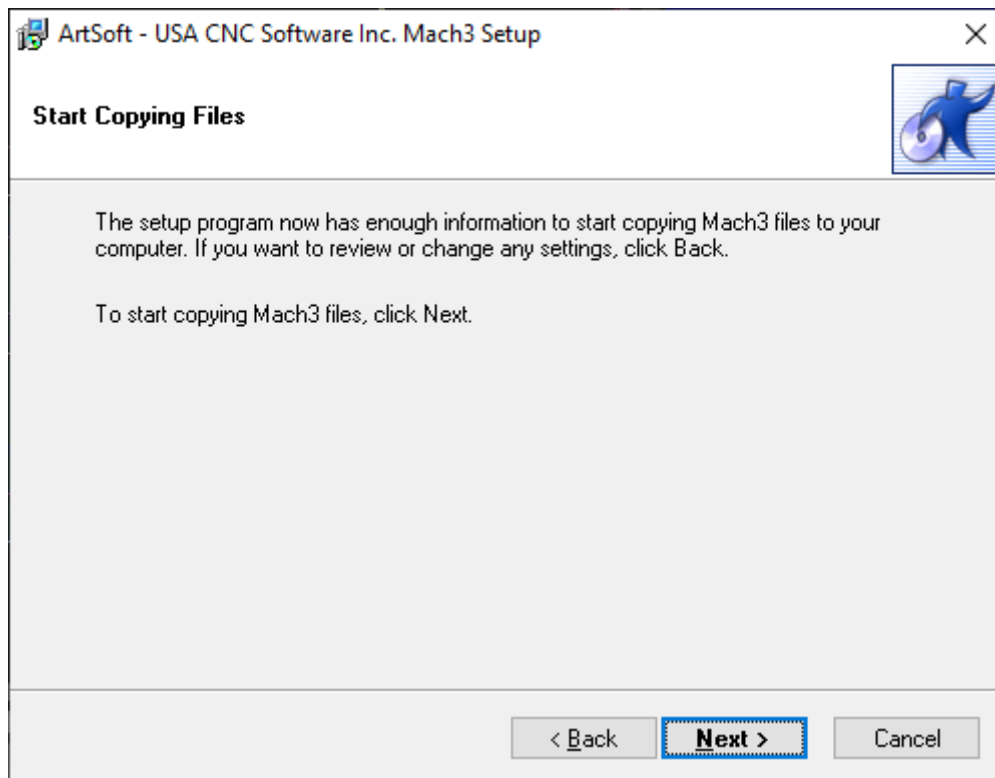


Click **Next** .

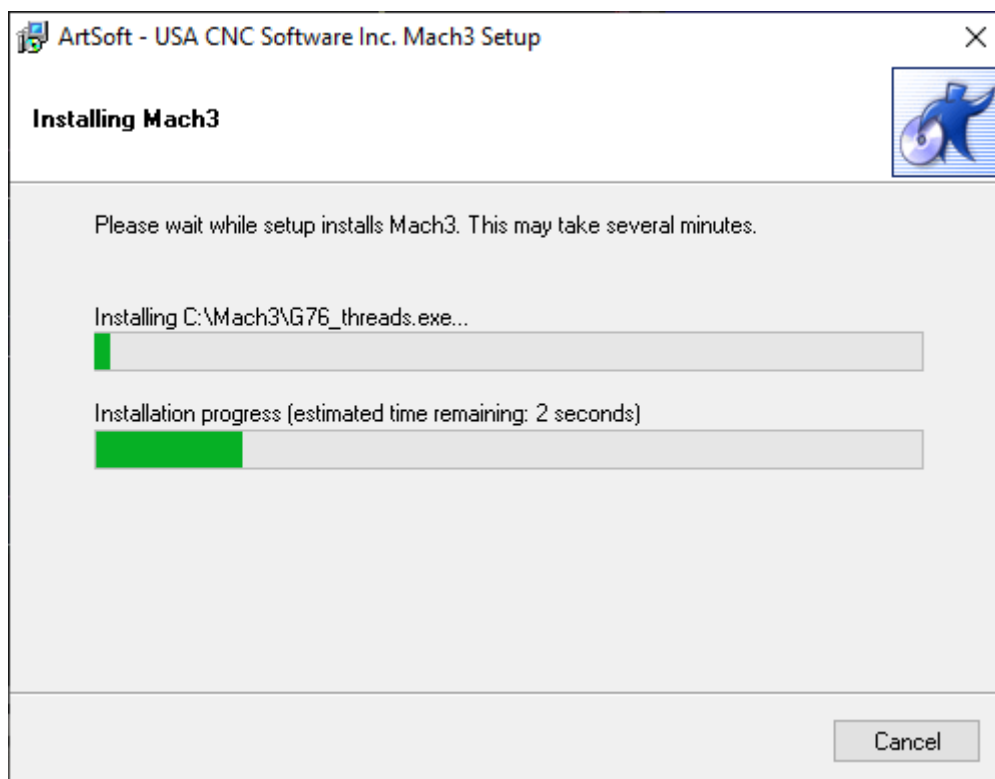


This screen is not important for the installation itself, but it can help keep your computer organized. You can enter whatever you want here.

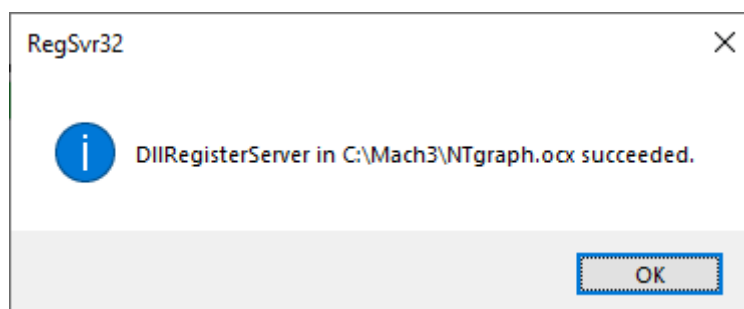
Click **Next** .



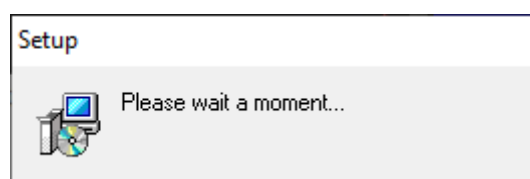
This is the last step before installing the software. Click **Next** .



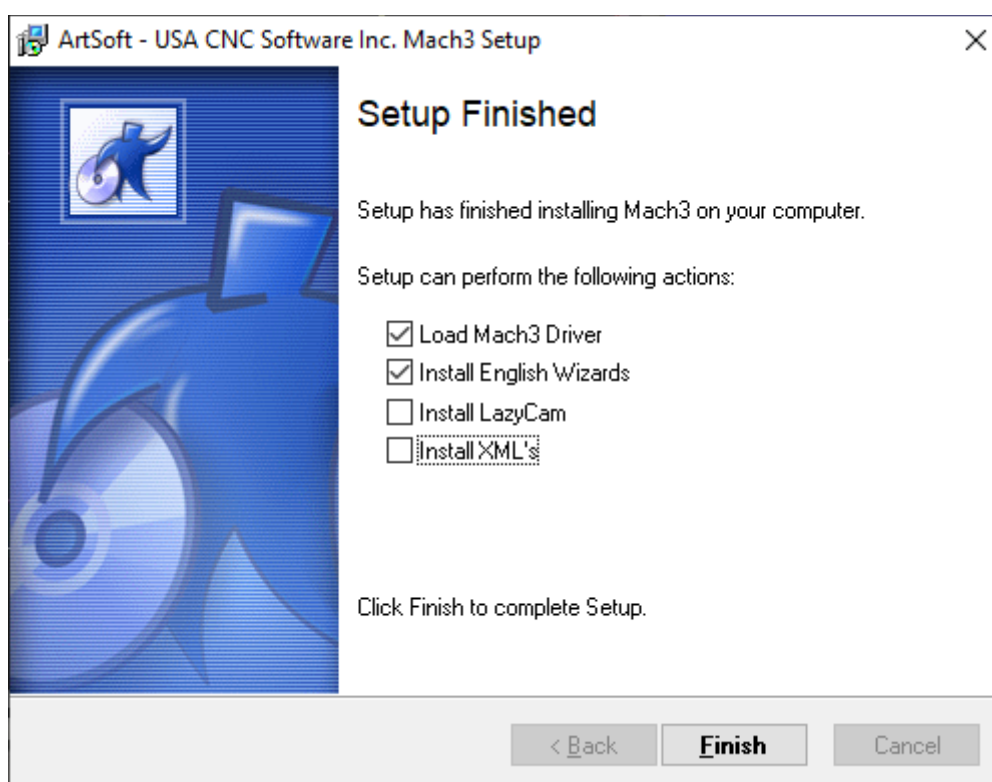
This screen shows which files are being copied. Usually the installation takes no more than three minutes. Do not close the program if it takes longer.



The installation notices that external components have been installed successfully. Click **OK**.

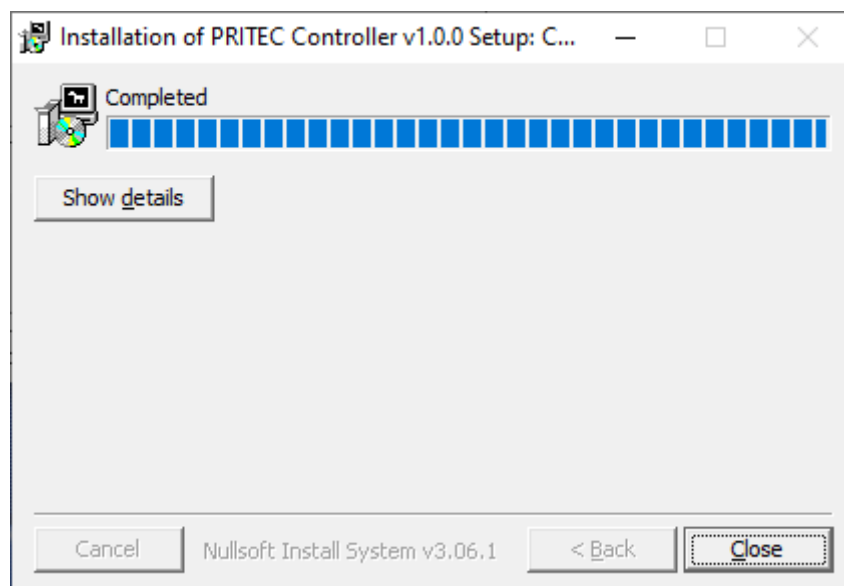
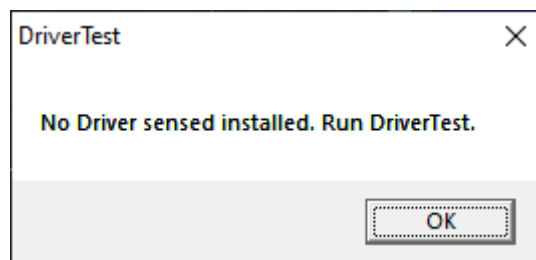


This last screen shows the completion of the installation. After a short moment of patience, you will automatically be taken to the next screen.



Mach3 installation is complete! This menu offers the possibility to install additional components for the program. It has been chosen here not to install any other profiles (*XMLs*) that come with the program and *LazyCam* is not installed either.

Load Mach3 driver is an option to directly check if the table can connect to the computer. If you just install the software, and the table is not currently connected to the computer, you will see the following screen. If the table is connected to the computer, the connection is tested.



This last screen confirms the completion of the installation. The profiles have been copied, shortcuts created and the program is ready to use. Click **Close**.

6.2 Installation software to write G-code

Generating a machine code (G-code) can be done by means of various programs. You may already have the right software for this. If not, look for the possibilities at <https://pritec-automatoin.com/support/>.

7. Startup

1. Connect the USB cable to the control box and to your laptop.
2. Plug the power cable into the control box and turn on the red switch.
3. Open Mach3 CNC Controller and after startup click on the blue RESET icon. Make sure the emergency stop is turned off. The ACROS can now be controlled using the arrow keys on your keyboard. The Tab key allows you to open a separate control panel if needed. When the soft limits are enabled, disable them the first time.



PAY ATTENTION! The ACROS has no limit switches. This means that the motors will not shut off when they reach the end of their table limit. To preserve the machine, we recommend not to overload or damage the motors and drive by trying to steer them beyond the limit.



Figuur 3

7.1 " Homing " (Table Limit)

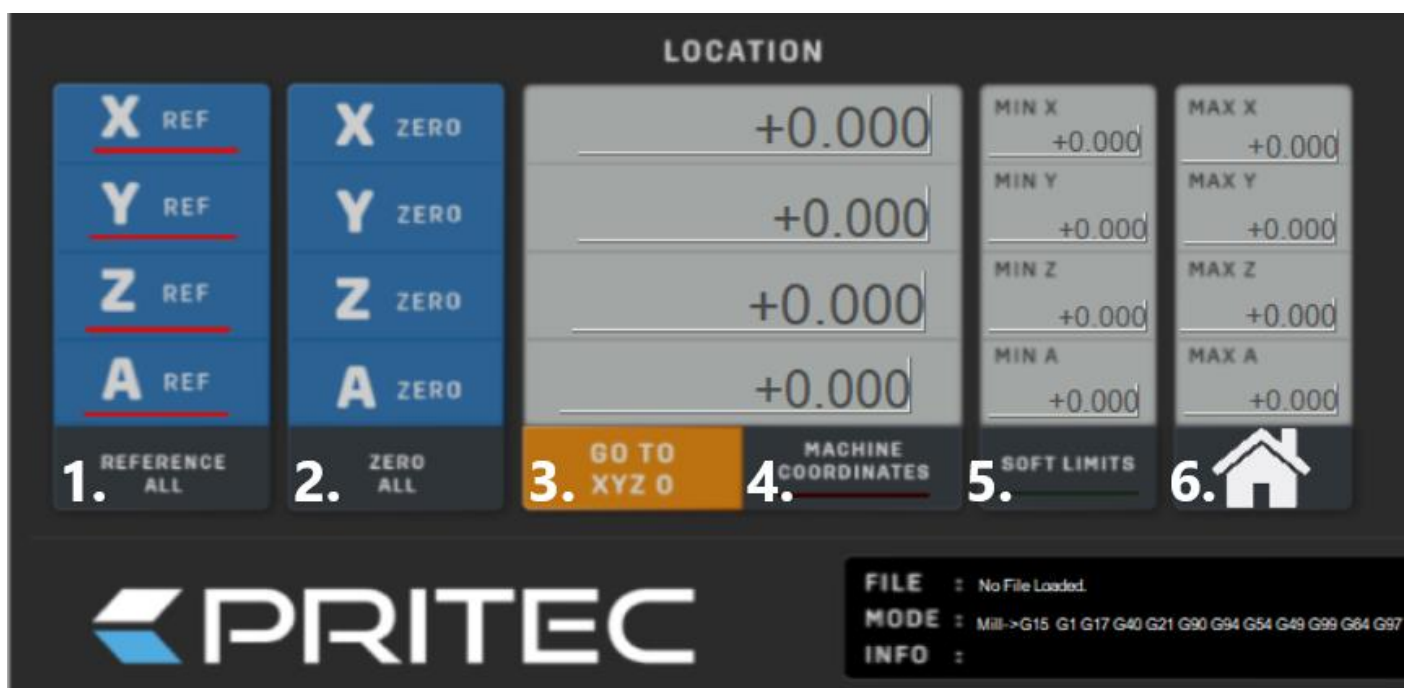
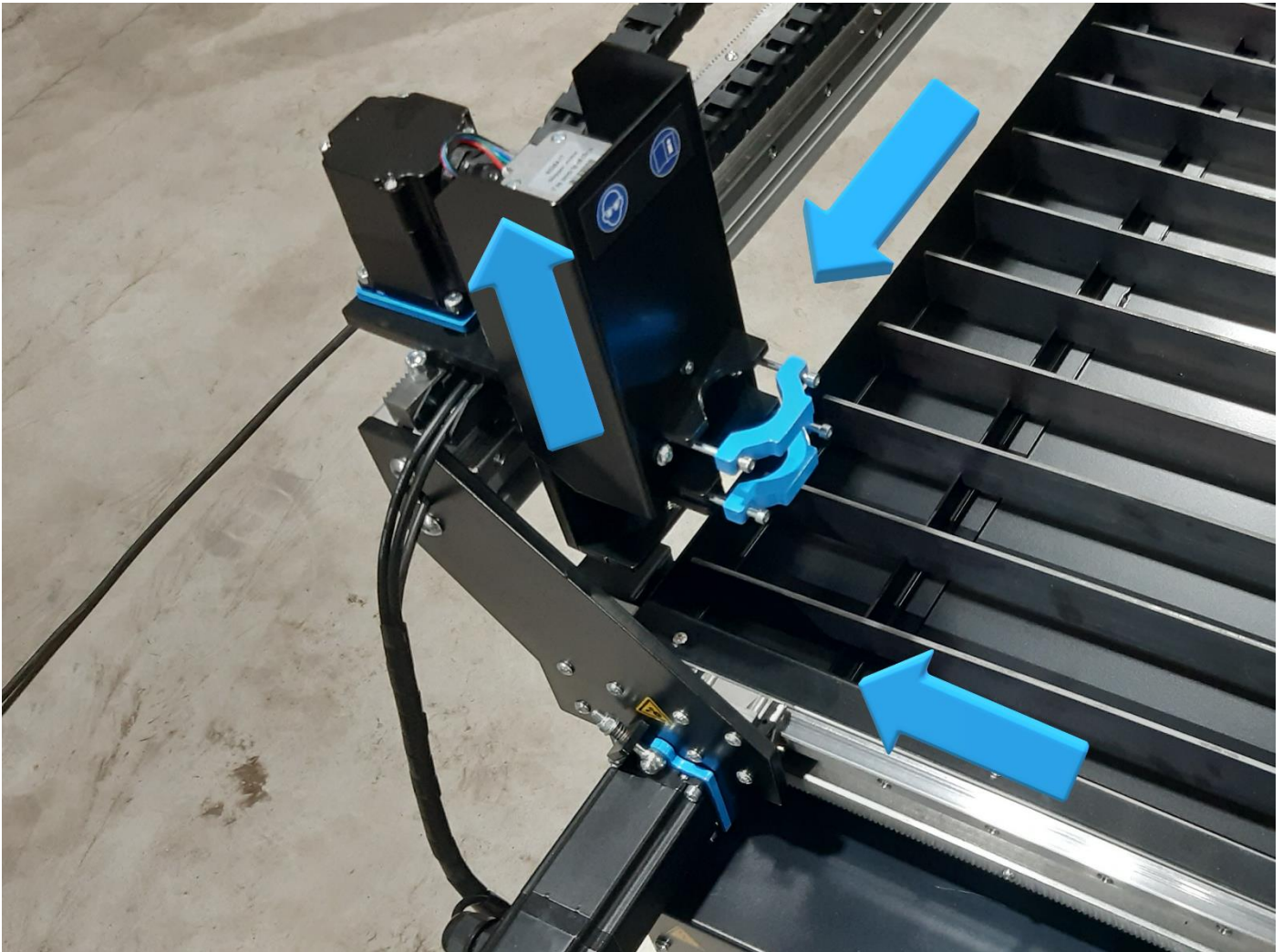


Figure 4

To work with the "soft limits" you must first create a "home" point. So that the plasma holder knows its position relative to the table area by means of coordinates.



1. Steer the plasma holder towards the rear corner of the table and the plasma holder in its highest position. This can be done mechanically (disable soft limits . See figure 4 number 5.) but to prevent possible damage, this can also be done manually by switching off the control box. This disengages the stepper motors and allows you to move the guides slowly. Then switch the control box back on and click reset.



2. Now click on the X,Y and Z REF at " location " (see figure 4 number 1.) or " reference all " the led indicators will now light up green and the coordinates will switch to zero. The "Home" location is now determined.
3. Enable the "soft limits " (see figure 4 number 5.) the led indicator will light up green.
4. If you now want to return to this position, you can click on the house symbol (see figure 4 number 6.)

For your information! Before switching off the system, it is recommended that the machine returns to its "home" position. When you start up the system again, after clicking reset, click on the X, Y and Z REF so that the LED indicators light up green again and the 'home position is determined again.



7.2 Set workpiece zero

When you create a g-code, a zero point (reference point) is created. This is the starting point of the process. You can set a zero at any point on the table.

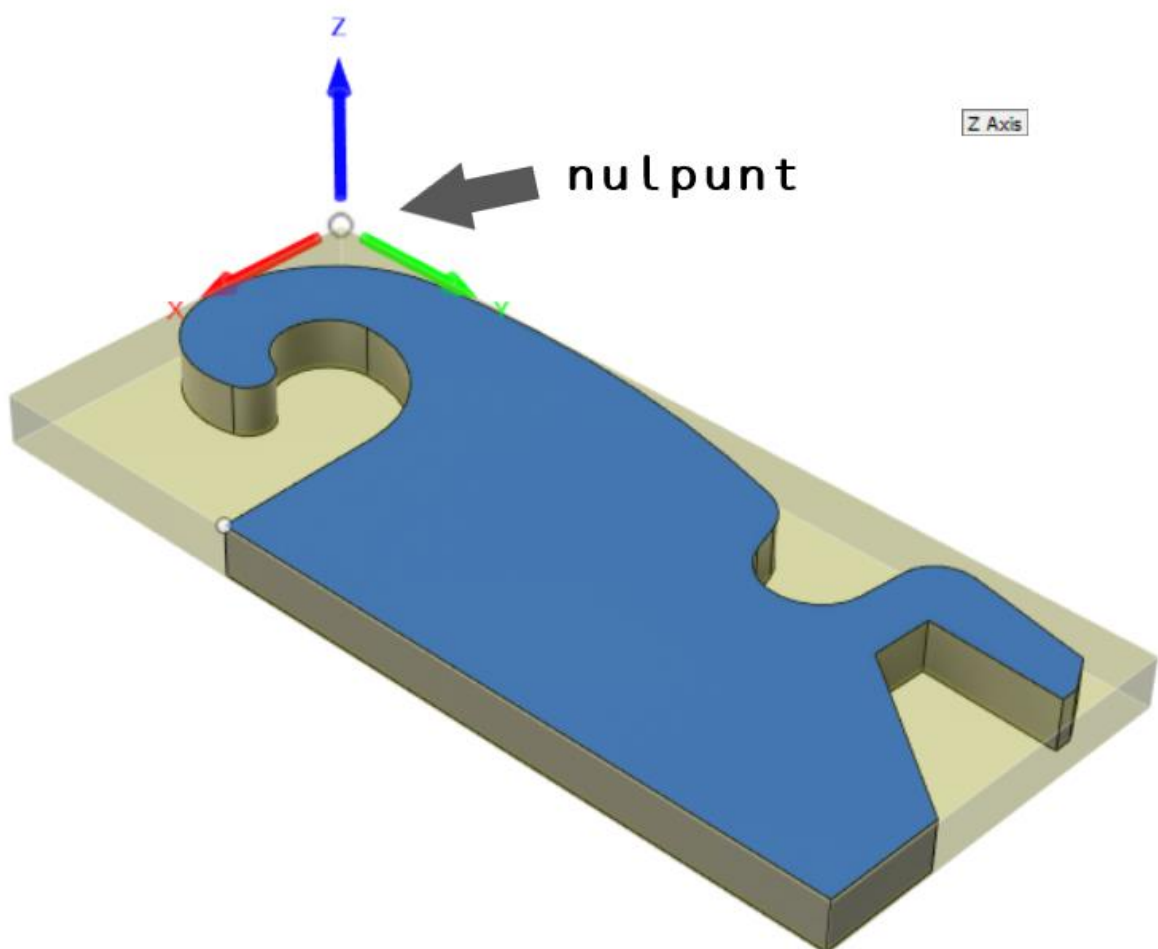


Figure 5 example zero point

1. Control the plasma head to the desired zero position
2. See figure 4 number 4. Make sure the red LED indicator is turned off so that the zero coordinates are visible. Not the machine coordinates.
3. Now click on the X,Y and Z ZERO (see figure 4 number 2.) or click on "zero all ". All three positions have now switched to zero. The zero position is now determined.
4. When you want to go back to this position click on "GO TO XYZ 0" (see figure 4 number 3.)



NB! The Z-axis determines its zero position over and over during the "probe" process. This means that if the "probe" switch is actuated while tapping the workpiece, the Z position will change to zero. To avoid crashing into an obstacle while automatically returning to the zero positions, first steer the Z axis to a safe height and create a new zero point there by clicking "Z ZERO" before pressing "GO TO XYZ 0" click.

7.3 Testing

PAY ATTENTION! Make sure the table is level before you start testing.

1. Make sure the air compressor and plasma cutter are **turned off**.
2. Open the file "testing" of the downloaded software (workpiece size 100x100 mm)
3. Place a plate on the table.
4. Steer the machine to the desired position where you want to start cutting (see chapter 7.2). Make sure there is enough space. To be safe, steer towards the center of the plate so that at least 150 mm is available on all sides.
5. "ZERO" the X, Y and Z axis by clicking on the blue icons (the red lamp indication will turn green). "ZERO" is a reference point so that the machine knows its position. You can set this anywhere you want. Make sure that you set this point in the correct position because of the size of the workpiece to be cut out. You must prevent the machine from trying to cut beyond its table limit.
6. Press the play icon. The machine will now play the G-code file.
7. If this goes without complications, proceed to Chapter 9.

9. Torch Height Control (THC)

The THC works as follows. A voltage is measured between the plus and minus pole of the plasma cutter through the cable you install from the control box to the plasma cutter. This voltage will change as the voltage of the arc between the plasma head and the workpiece increases or decreases. Once correctly set, the THC will respond by turning the Z-axis up or down. As a result, the machine will continue to follow any bent plate so that the plasma head does not come into contact with the workpiece. All this ensures a better cutting result.

With thicker plates it is not always necessary to use the THC because it will not warp quickly. If desired, you can disconnect the THC control cable from the control box, so that the THC controller does not receive any values and will therefore not respond.

9.1 Settings

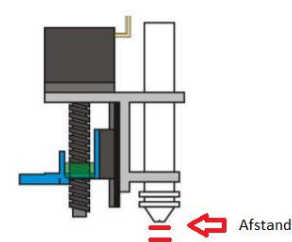
The Proma SD is set with factory default settings. After the correct connection, it can be controlled by most plasma cutters.

The moment you switch on the control box, the display of the THC will show an "animated" "THC" message. Then a flashing voltage value appears for one second. The controller then undergoes an automatic calibration.



Once the controller is ready for use, the display will show three dashes as shown in the third image above.

When you then press and hold the "up/down" arrows simultaneously for a few seconds, you will enter the voltage settings. Changing this value with the arrows adjusts the height that the controller should hold between the plasma head and the workpiece. If you briefly press the arrows simultaneously again, it will hold the set value. (see chapter 9.2)



Figuur 3

To change the other parameters as required, hold down both buttons until the correct parameter appears on the display. Then release both buttons when the parameter whose values you want to change appears. You can adjust the values using the "up/down" arrows.

The different parameters:



"**SPE**" (**SPEED**) - This parameter controls the speed of Z-axis movement during cutting (clock frequency).



"**d-t**" (**delay time**) – delay time. Allows you to set the response time. This is the number of seconds the controller must wait after receiving a signal to move the Z-axis up or down. This is variable from 0.1 - 9.9 sec. factory setting is 0.5 sec.



"**H-V**" (**High Voltage**) – Value of the no-load voltage of the plasma cutter. Cutting arc 50-300 V. Defaults to 200 V.



" **tSt** " (**test**) – Simulation of controller operation. The system simulates a voltage measurement (up and down) allowing operation to be tested.



"**dir**" (**direction**) – Allows the rotation direction to be reversed when the Z axis rotates in the wrong direction.



When the plasma cutter is switched on, the display of the THC shows the measured voltage values.

9.2 Determining voltage THC

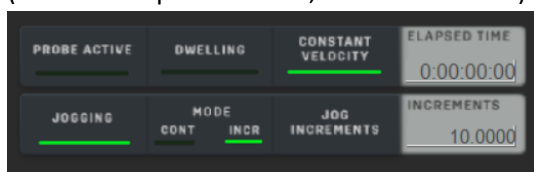
As mentioned before, you can cut without THC if you wish by disconnecting the signal cable.

If you do want to work with the THC, the voltage to be set will depend on the cutting speed and the material to be cut (thickness, strength, etc.).

You can determine the voltage to be set by going through the following steps. If you note the measured values, you only need to measure them once per material type and thickness. This way you can reset the THC controller to the noted value next time.

Option 1

1. Use the PgUp and PgDn keys to set the height of the Z-axis to a distance of approximately 2mm. For example, place a 2 mm object between the plasma head and the workpiece (indicated in chapter **9.1 Settings, figure 3**).
2. Disconnect the motor cable at the Z-axis control box so that the THC controller will not drive the Z-axis motor.
3. Set "MODE" to the "INCR" position and click on the "JOG INCREMENTS" to select 100,000 (100mm) length (in the example below 10,000 is indicated)



4. Make sure that the plasma cutter and air compressor are now on.
5. Press the "TORCH" icon and immediately after that the desired arrow key depending on the direction you want to cut. The plasma cutter will turn on and cut a line.
6. Note the value that appears on the THC controller display during cutting. This is the voltage of the circulating circuit between the plus and minus terminals of the plasma cutter.
7. Set this voltage value on the THC controller (indicated in chapter **9.1 Settings**).
8. If the cutting speed is not correct, you can adjust it at "FEED" by means of the "FEED RATE"
9. Reconnect the Z-axis motor cable.

9.3 THC connection

The Prima THC controller has 2 connection options.

1. For plasma cutters with a voltage divider . This divides the voltage with a ratio of 1:50, resulting in a lower control current voltage from the plasma cutter to the control box (max. 10V DC).
2. For plasma cutters without voltage divider . These have a direct connection to the plus and minus pole of 1:1 (max. 300V DC)

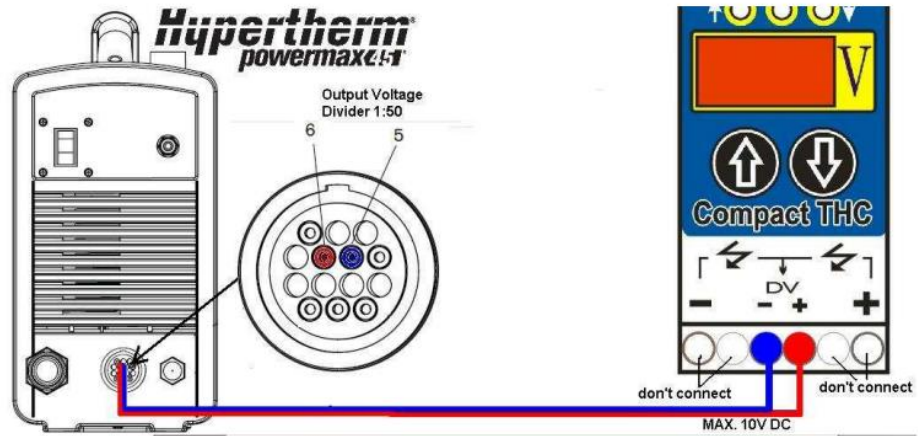
These connection options can be changed in the control box with the Prima controller (see images below), which is supplied ex works with the correct connection for the ordered plasma cutter. You can check this by looking into the control box from below through the cooling slots.

- **Jasic Cut60 has a 1:50 "voltage divider " connection.**
- **HeroCut Cut55i has a 1:1 connection.**

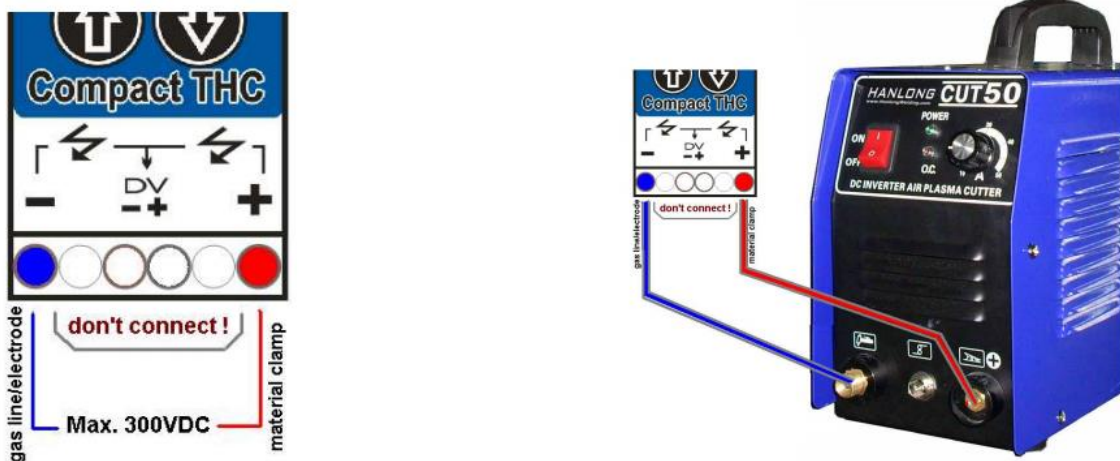


When connecting your own plasma cutter, please refer to the manual of the relevant machine.

Connection as described in point 1.

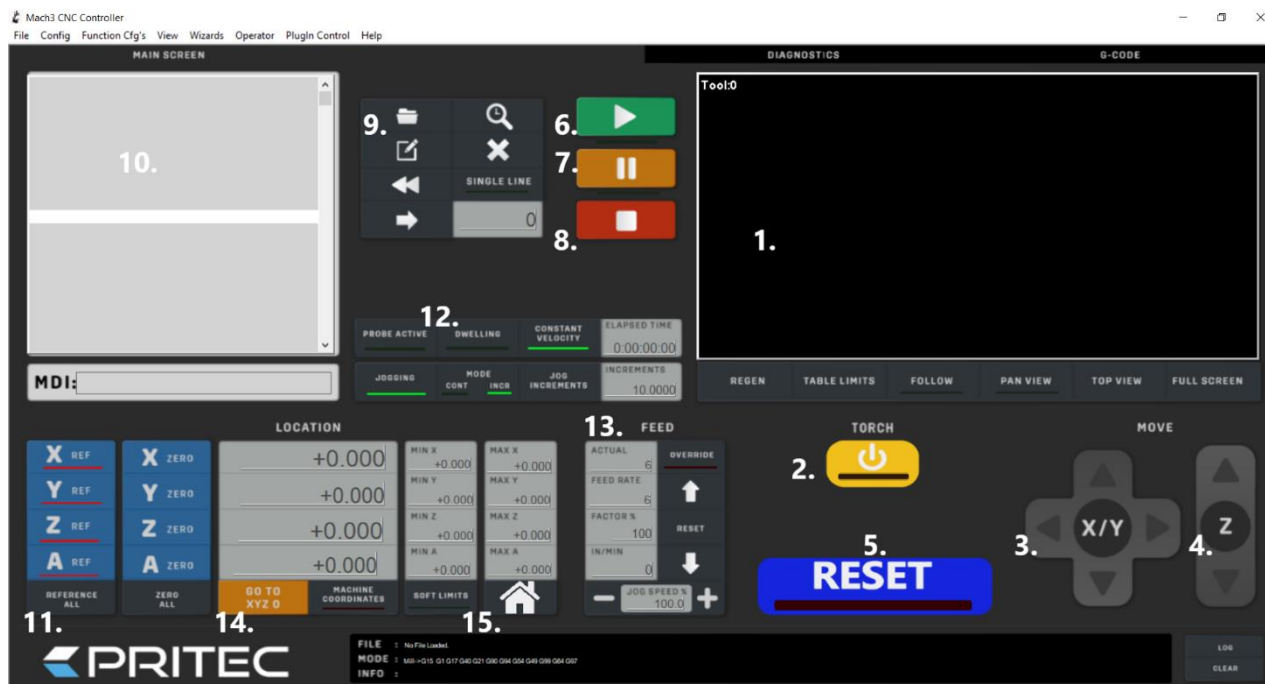


Connection as described in point 2.





10. Control panel (basic elements)



1. **Cut path display** - This shows the cut path of the loaded G-code file.
2. **"TORCH" On/Off** - Turns the plasma cutter arc on and off.
3. **"JOG" controller X/Y** – By clicking on the arrows you can control the X and Y axes.
4. **"JOG" controller Z** – By clicking on the arrows you can control the Z axis.
5. **"RESET"** – To unlock, stop or reset the system.
6. **"PLAY"** – Start playing the loaded G-code file.
7. **"PAUSE"** – Allows you to pause the cutting process and then resume it by clicking " play ".
8. **"STOP"** – Stops the cutting process. By clicking on " play " again, the cutting process starts again from the beginning.
9. **Open G-code file** – Opens the desired G-code file.
10. **G-code display** – The G-code is displayed here line by line.
11. **"HOME"** – Zeroes the X, Y and Z axes to create a "HOME" point.
12. **"MODE"** – In this menu you can switch between continuous (CONT) and step mode (INCR). When you enable continuous mode, you can control the X, Y or Z axis continuously. In step mode, the X, Y or Z axis will move to the set "INCREMENTS" value per actuation.
13. **"FEED"** – Here you can control the speed or manually override it by clicking on the arrows. When you click on the reset button between the arrows, the original set value will reappear.
14. **"SOFT LIMITS"** – When you have determined the "HOME" position of the machine and then enable this function, the machine will not go beyond the set table margins.
15. **"GO HOME"** When you have determined the correct "HOME" position, and the soft limits are enabled, by clicking on the icon you can automatically send the machine to its "HOME" position. (as described in 7.1 Homing)



11. Maintenance overview

The following maintenance measures should be carried out on a regular basis:

- Clean and oil the guide rail and rack.
- Oil the conductors.
- Remove built-up melt parts from the cutting strips.
- Empty and clean the water container.
- Clean and oil the Z-axis spindle.

12. Problem Detection

12.1 The machine does not turn on

- Check the power cable of the control box .
- Check that the control box switch is turned on.
- Check the fuse at the power input of the control box .

12.2 Control does not work

- Check whether the emergency stop is activated.
- When the soft limits are enabled, they may have been reached or the 0/reference point may not be set correctly.
- Check that the "FEED RATE" is not set too low.

12.3 Plasma cutter does not cut through the material

If the plasma cutter does not provide a good cutting quality, this can be due to the following reasons:

- Check that the negative terminal of the plasma cutter makes good contact with the workpiece to be cut.
- The material is too thick to cut through.
- The distance between the workpiece and the plasma cutter head is too large.
- The cutting speed is too high.
- The plasma cutter amps are not set correctly.
- Plasma nozzle is worn or incorrect.

13. Warranty

- The warranty comes into effect on the date stated on the purchase invoice and is valid for 12 months.
- The warranty is not transferable without written approval from your supplier.
- No warranty claim can be made without a purchase invoice.
- Warranty only applies if the product is used in accordance with the supplied instructions for use and only for the purpose for which it was designed.



- The warranty does not cover damage caused by incorrect construction, installation, use, cleaning, use of cleaning agents, maintenance or repair.
- No changes may be made to the product.
- The warranty does not apply in case of improper use.
- Any shipping costs are not covered by the warranty
- Repairs should only be made by your supplier. Any repair(s) performed by third parties will invalidate the warranty claim.
- Repair during the warranty period will not extend the validity. However, a three-month warranty is provided on the repair should the regular warranty period expire.
- Any maintenance work to be carried out, described in the operating instructions, must be carried out in good time.
- For warranty, you can only contact the point of sale where you purchased the item.



EC - Declaration of Conformity

Manufacturer

Trade name

PRITEC

Address data

Kiefteweg 11, 7121 LX Aalten, Netherlands

Product

Product name



PRITEC

Description

CNC cutting table

Model / Serial Numbers

ACROS 80

ACROS 150

Applied guidelines

2006/42/EC - Machinery Directive

2014/35/EU - Low Voltage

Declaration

We hereby declare that the above product (series) complies with the directives / standards stated in this declaration.

CE responsible:

P. Prinsen

Date:

10-11-2020

PRITEC

Kiefteweg 11

7121 LX Aalten

Phone : +31543722292

E-mail: info@pritec-automation.com

Website: www.pritec-automation.com

Signature