

SeriesOne Site Preparation Guide

This guide will help you prepare for the arrival of your new Trucut SeriesOne plasma cutting machine.

- (1) Run power to the site for the plasma power supply. Hypertherm PowerMax 45/65/85 machines can be wired to single or 3 phase, high or low voltage. PowerMax 105 machines can be wired to high or low voltage but it **MUST** be 3 phase. PowerMax 125 machines Can **ONLY** be connected to 480/600 3 phase. Consult the literature for your specific model for current requirements. Operator manuals can be downloads from our website. Go to www.trucutcnc.com then click Support -> Operator Manuals and choose your model.
- (2) Run power for the plasma table control and PC. This should be a 20A 110/120V circuit. Run a separate line from the breaker box. Do not just tap one leg of the plasma power circuit.
- (3) Install a ground rod near the rear of the machine. If you're not sure where that will be, just have an 8' ground rod on hand and a means of installing it. If the machine is near an outside wall, the ground rod can be driven into the ground outside with a 6ga solid copper wire running inside and connecting to the machine frame. If you are not near an outside wall, you will have to drill through the concrete floor and drive the ground rod there. **DO NOT SKIP THIS STEP. See the machine grounding diagram at the end of this guide.**
- (4) Water tables will require a means of adding water to the table. This can be a hose or a plumbed line right to the site. Water pans have a drain port in the bottom. This port is 1-1/2 pipe thread. You can install a manual valve there or an electric solenoid valve. You will need to configure a drain. Some plumb a drain line and some just attach a hose when the table needs draining. An 1-1/2 pool filter discharge hose works well.
- (5) Downdraft tables will need to be vented outside. We suggest facing the back of the table towards an outside wall and running your exhaust duct straight out the wall.
- (6) Support is handled via a remote connection, which requires an internet connection. All machines shipped after 5/20/2014 come with a WiFi network adapter and DO NOT have a spare wired Ethernet port. Most machines prior to that have a spare Ethernet port. For a WiFi connection all you need is a WiFi router within range of the machine. For a wired connection, you need to run a cable to the machine. **Again, all machines shipped after 5/20/2014 are set with WiFi ONLY.**
- (7) The operator manual for the SeriesOne Machines are on line at our website. Click Support -> Operator Manuals -> SeriesOne Plasma Table. We suggest you go through the manual and familiarize yourself with the controls.
- (8) Before your machine arrives, download and print the machine setup guide. It is the top link you will find when you open the SeriesOne operator manual. The setup guide walks you through setting up the machine and making your first cuts.

Grounding Diagram

