

EX-TRACK[®] MA-1

EX-TRACK[®] MA-2

Portable Flame Cutting Machine

Operating Instructions - EX-0-902-003/N-23778 -CE

Revision 1, 8th November, 2023

THERMACUT[®]
THE CUTTING COMPANY[®]

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1 Identification

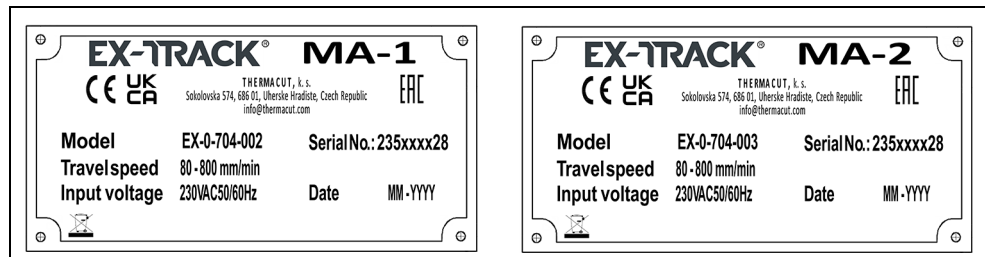
The EX-TRACK[®] MA-1/MA-2 is a portable gas cutter for cutting stripes or circles. The EX-TRACK[®] MA-1/MA-2 is equipped for straight line, bevel, and optional circle cutting. It has to be operated only with original consumables and maintenance parts. This documentation exclusively describes the EX-TRACK[®] MA-1/MA-2 gas cutter.

1.1 Labeling

This product fulfills the requirements that apply to the market to which it has been introduced. Corresponding marking has been affixed to the product.

1.2 Identification plates

Fig. 1 EX-TRACK[®] MA-1/MA-2 identification plate



The EX-TRACK[®] MA-1/MA-2 is labeled by means of an identification plate on the housing.

- For inquiries, please have on hand the order and serial number as seen on the identification plate.

1.3 Signs and symbols used

The following signs and symbols are used:

- General instructions.
- 1** Action(s) to be carried out in succession.
- Lists.
- ⇒ Cross-reference symbol refers to detailed, supplementary or further information.
- A** Caption, item description.

1.4 Classification of the warnings

The warnings are divided into four different categories and are indicated prior to potentially dangerous work steps. The following signal words are used depending on the type of hazard:

DANGER

Describes an imminent threatening danger. If not avoided, it may cause severe injury or death.

WARNING

Describes a potentially dangerous situation. If not avoided, this may result in serious injury or death.

CAUTION

Describes a potentially harmful situation. If not avoided, this may result in slight or minor injury.

NOTICE

Describes the risk of impairing work results or material damage and indicates irreparable damage to the device or equipment.

2 Safety

This chapter warns of potential hazards that should be kept in mind to operate the product safely. Non-observance of the safety instructions may result in risks to the life and health of personnel, environmental damage, or material damage.

2.1 Designated use

The EX-TRACK® MA-1/MA-2 may be used only for the purpose and manner described. Any other use is considered improper and will lead to loss of warranty. Unauthorized modifications or changes to enhance the performance are not permitted and will lead to loss of warranty.

- Do not exceed the maximum load specifications as defined by the document supplied. Overloads lead to destruction.
- Do not make any modifications or changes to this product.
- Do not use or store the EX-TRACK® MA-1/MA-2 in wet conditions or environments.
- Do not use the EX-TRACK® MA-1/MA-2 for other purposes than the intended.

2.2 Obligations of the operator

- Ensure that only qualified personnel are permitted to work on the EX-TRACK[®] MA-1/MA-2.

Authorized personnel are:

- those who are familiar with the basic regulations on occupational safety and accident prevention;
 - those who have been trained accordingly;
 - those who have the license for gas welding;
 - those who have the diploma of the training course on gas welding;
 - those who have the qualification certificate issued by the Ministry of Labor;
 - those who have read and understood these operating instructions;
 - those who are able to recognize possible risks because of their special training, knowledge, and experience.
- Keep untrained persons out of the work area.
 - Each time the EX-TRACK[®] MA-1/MA-2 is opened, have Thermacut[®] or another authorized specialist perform a safety inspection in accordance with IEC 60974 Part 4: "Periodic inspection and testing".

2.3 Product-specific safety instructions

- Do not operate the EX-TRACK[®] MA-1/MA-2 when the housing is open.
- Only disassemble the EX-TRACK[®] MA-1/MA-2 for maintenance and inspection purposes.
- The EX-TRACK[®] MA-1/MA-2 is made from alloy. Do not drop it or subject it to heavy pressure.
- Mount and position the EX-TRACK[®] MA-1/MA-2 correctly.
- Do not damage or deform the rails.
- Always check the correct and free motion of the EX-TRACK[®] MA-1/MA-2 before starting the cutting operation.
- Make sure to put the change-over switch into neutral or stop position before reversing the running direction of the EX-TRACK[®] MA-1/MA-2.
- Only reverse the direction after the EX-TRACK[®] MA-1/MA-2 has stopped.
- Always turn the power off when not in use.
- Do not open any valves by force.
- Do not move the EX-TRACK[®] MA-1/MA-2 while the pre-heat flame is on.
- Do not insert hands into rotary or moving sections.
- Do not insert hands between the rails.
- Do not place your hands near the guide wheel, below the EX-TRACK[®] MA-1/MA-2 or between the heat shield and the steel plate when in operation.
- The surface, the torch, tip, and shield become very hot. Do not touch!
- Always carry the EX-TRACK[®] MA-1/MA-2 holding the handle

2.4 Safety instructions for the cutter

- Ensure that the hoses are not damaged, for example, by being driven over, crushed, or torn.
- Check the hoses for damage and wear at regular intervals.
- Bundle together the hose and cable with a tape, and place them on the opposite side of the flame so as to avoid damage by spatter, or dross.
- If it is necessary to replace the input power cable or hoses, only models indicated by the manufacturer may be used.
- Place the torch on the torch holder before igniting.

2.5 Safety instructions for cutting

- Cutting may cause damage to the eyes, skin, and hearing. Note that other hazards may arise when the EX-TRACK® MA-1/MA-2 is used with other cutting components. Therefore, always wear the prescribed personal protective equipment as defined by local regulations and laws.
- All metal vapors, especially lead, cadmium, copper, and beryllium, are harmful. Ensure sufficient ventilation or extraction. Do not exceed the current occupational exposure limits (OELs).
- Ensure sufficient ventilation for gas cutting in order to prevent the air from being polluted.
- Adhere to the general fire protection regulations and remove flammable materials from the vicinity of the cutting work area prior to starting work. Provide appropriate fire extinguishing equipment in the workplace.
- Do not cut sealed containers or pressurized cylinders.
- Do not use defective or contaminated pressure regulators.
- Check for any leakage of gas from the distributor, the hoses, or the torch.

2.6 Personal protective equipment

- Wear your personal protective equipment (PPE).
- Ensure that others in close proximity are also wearing personal protective equipment.

Personal protective equipment consists of protective clothing, safety goggles, face protection, ear protectors, protective gloves, and safety shoes.

2.7 Emergency information

- In the event of an emergency, immediately disconnect the following supplies:
 - Pre-heating oxygen supply
 - Fuel gas supply
 - Cutting oxygen supply

3 Scope of delivery

The following components are included in the scope of supply:

3.1 EX-TRACK® MA-1:

- 1 x EX-TRACK® MA-1
- 1 x Torch holder assembly
- 1 x Fuel gas nut
- 1 x Oxygen gas nut
- 3 x Oxy-fuel tip
- 2 x Open wrench
- 1 x MA-1 cutting torch and gas circuit assembly
- 1 x Rack holder
- 1 x Horizontal gear rack
- 2 x Hose nipple

3.2 EX-TRACK® MA-2:

- 1 x EX-TRACK® MA-2
- 1 x Horizontal gear rack (longer)
- 2 x Torch holder assembly
- 1 x Fuel gas nut
- 1 x Oxygen gas nut
- 6 x Oxy-fuel tip
- 2 x Open wrench
- 1 x Stabilization bar
- 1 x Stabilization weight
- 1 x MA-2 cutting torch and gas circuit assembly
- 1 x Rack holder
- 2 x Hose nipple

The order data and ID numbers for the equipment parts and consumables can be found in this manual.

⇒ 14 Parts list and exploded views EX-TRACK®MA-1 and MA-2 on page EN-23

➤ For more information about points of contact, consultation, and orders, visit www.ex-track.com.

Although the items delivered are carefully checked and packaged, it is not possible to fully rule out the risk of transport damage.

Goods-in inspection

- Check for order completeness by checking the delivery note.
- Check the delivered goods for damage (visual inspection).

Claim process

- If goods are damaged, notify the final carrier immediately.
- Keep the packaging for possible inspection by the carrier.

Returns

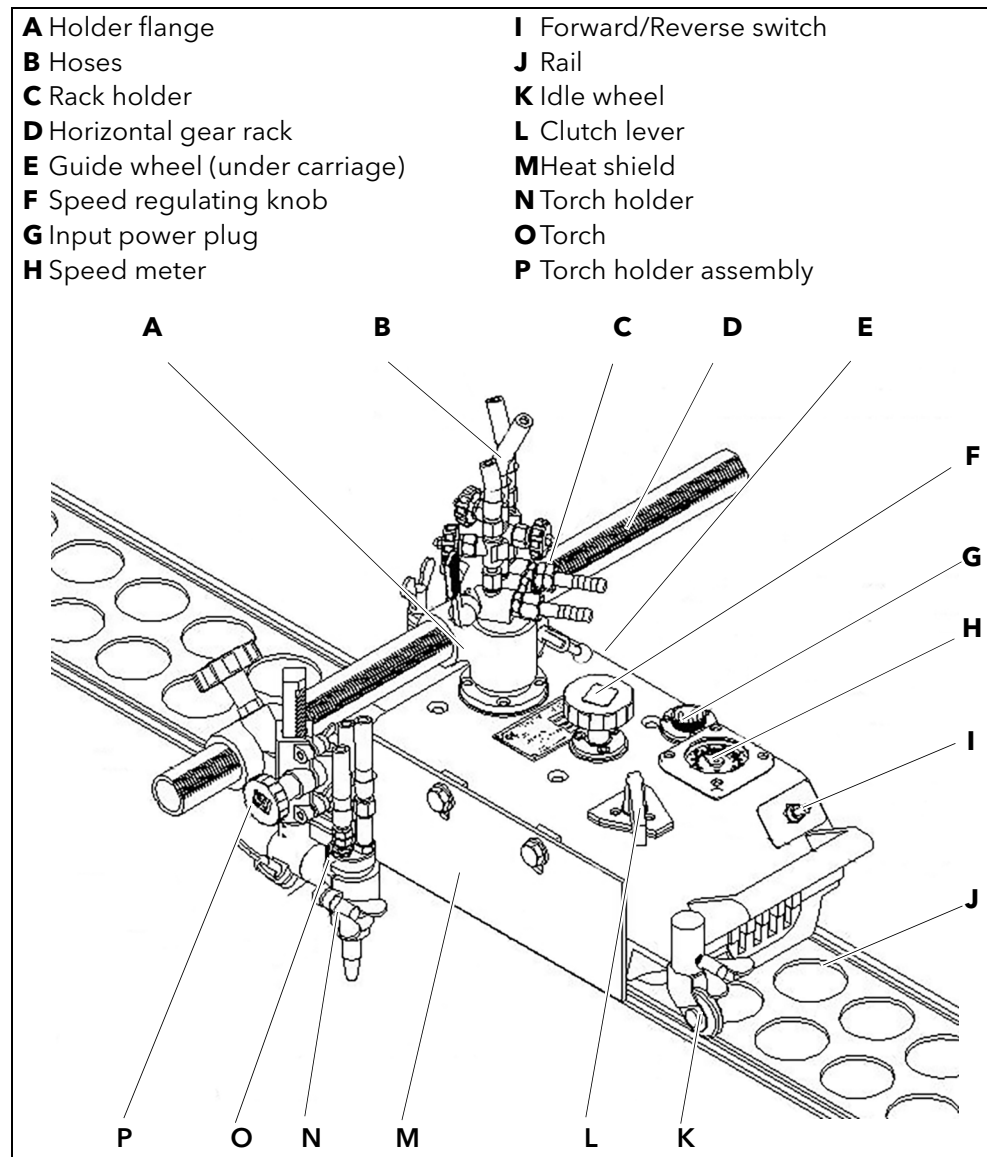
- Use original packaging and packing material for returns.
- If you have questions concerning the packaging or how to secure the EX-TRACK® MA-1/MA-2, contact your supplier, carrier, or transport company.

4 Product description

4.1 Assembly and use

The pipe cutter consists of the following components:

Fig. 2 Control elements and connections



Hoses (B)	For the connection to oxygen (blue) and fuel gas (red).
Rack holder (C)	Used to hold the horizontal gear rack.
Horizontal gear rack (D)	Used to hold the torch holder assembly.
Guide wheel (E)	Guides the EX-TRACK [®] MA-1/MA-2 along the rail.
Speed regulating knob (F)	Adjusts the traveling speed of the EX-TRACK [®] MA-1/MA-2.
Input power plug (G)	For the connection to the input power supply.
Speed meter (H)	Shows the speed the EX-TRACK [®] MA-1/MA-2 is traveling at.

Forward/Reverse switch (I)	Adjusts the direction in which the EX-TRACK® MA-1/MA-2 travels. The neutral position is the stop position.
Rail (J)	Guides the EX-TRACK® MA-1/MA-2 along the intended cut.
Idle wheel (K)	Holds the EX-TRACK® MA-1/MA-2 on the rails.
Clutch lever (L)	Engages the clutch to start the EX-TRACK® MA-1/MA-2.
Heat shield (M)	Protects against sparks and heat.
Torch holder (O)	Holds the torch.
Torch (O)	Torch installed in the torch holder.

4.2 Technical data

Table 1 Power supply specifications

Weight [kg]	10
Dimensions [mm]	440 x 205 x 125
Wheel distance [mm]	160
Type of operation	manual
Input power	230 V AC
Reduction gear	Double cone system
Cutting speed	80 mm / min. to 800 mm / min. (50 Hz)
Cutting edge shape	I- and V-shape (45)
Cutting thickness [mm]	10 to 60 (using tips GO3 - #1, 2, 3)
Motor performance	1500 r.p.m. / 1800 r.p.m. (9 W/10 W)

Table 2 Ambient conditions for transport and storage

Ambient temperature	-20 °C to +55 °C
Relative humidity	< 50 % at +40 °C < 90 % at +20 °C

Table 3 Ambient conditions for operation

Ambient temperature	-10 °C to +40 °C
Relative humidity	< 50 % at +40 °C < 90 % at +20 °C

5 Transport and positioning

⚠ WARNING

Risk of injury due to improper transport and installation

Improper transport and installation can cause the EX-TRACK® MA-1/MA-2 to tip or fall. This may result in injury.

- Wear your personal protective equipment.
- Ensure that all supply lines and cables do not encroach into the area in which employees are working.
- Note the weight of the EX-TRACK® MA-1/MA-2 when lifting it.
 - ⇒ 4.2 Technical data on page EN-11
- Avoid abrupt lifting and setting down.
- Do not lift the EX-TRACK® MA-1/MA-2 over individuals or other devices.

NOTICE

Risk of material damage due to improper transport and installation

The EX-TRACK® MA-1/MA-2 is made from aluminum alloy. Improper transport or installation can therefore cause material and irreparable damage.

- Protect the EX-TRACK® MA-1/MA-2 against weather conditions, such as rain and direct sunlight.
- Do not drop the EX-TRACK® MA-1/MA-2.
- Do not drop anything on the EX-TRACK® MA-1/MA-2.
- Protect the EX-TRACK® MA-1/MA-2 from spatter when cutting.
- Use the EX-TRACK® MA-1/MA-2 only in dry, clean, and well-ventilated rooms.
- Always carry the EX-TRACK® MA-1/MA-2 by the handle.

6 Setting up the EX-TRACK® MA-1/MA-2

All references to parts refer to figure 2 in this document.

- 1** Fix the rack holder **(C)** to the holder flange **(A)**.
- 2** Insert horizontal gear rack **(D)** into rack holder **(C)**.
- 3** Fasten horizontal gear rack **(D)** with butterfly nut.
- 4** Slide torch holder assembly **(O)** onto horizontal gear rack **(D)**.
- 5** Fasten distributor and hoses **(B)**.
- 6** Insert both into holder flange **(A)**.
- 7** Fasten torch **(O)** to hoses **(B)**.
- 8** Insert both into torch holder **(M)**.
- 9** Connect input power cable to the input power plug **(F)**.

6.1 Connecting to the gas supply

⚠ WARNING

Risk of injury due to explosion

The use of defective or damaged gas cylinders or hoses can cause explosions. This can result in injury.

- Never use defective or leaking cylinders.
- Never use defective or leaking hoses.
- Use cylinders only for the purpose specified.
- Install cylinders in a place free from heat and open flame.
- Never cut pressurized cylinders or hermetically sealed containers.
- Ensure sufficient ventilation.

- 1 Connect blue hose to oxygen outlet.
- 2 Connect red hose to fuel gas outlet.
- 3 Connect torch to hoses.

6.2 Connecting the torch tip

NOTICE

Risk of material damage

If the tip is tightened too much, it will heat up during operation and become difficult to remove. Damage to the tip will lead to backfire.

- Do not overtighten the tip.
- Avoid damage to the tip.

- 1 Select a suitable tip.
⇒ 15 Cutting data on page EN-34
- 2 Insert the tip.
- 3 Fasten the tip using the two wrenches.

7 Operating the EX-TRACK® MA-1/MA-2

⚠ WARNING

Risk of injury or damage due to backfire

Backfires may cause serious accidents or fire. Backfires are caused by improper gas pressure.

- When a backfire occurs, you should find the cause.
- Inspect and maintain the EX-TRACK® MA-1/MA-2 correctly before using again.
- The followings are causes of backfire:
 - Improper gas pressure adjustment.
 - Overheated tip.
 - Dross clogging in tip
 - Damages to the tapered section of tip or torch

NOTICE

Material damage due to flashback

Flashbacks can cause fire and damage to the EX-TRACK® MA-1/MA-2. If there is a hissing sound in the torch, proceed as follows:

- Close the pre-heating oxygen valve.
- Close the fuel gas valve.
- Close the cutting oxygen valve.

⚠ WARNING

Risk of injury or damage if Forward/Reverse switch is not in NEUTRAL position

The EX-TRACK® MA-1/MA-2 starts immediately in forward or reverse direction if the switch is not set to NEUTRAL.

- Make sure to set the switch to NEUTRAL before turning on the power.
- Always set the switch to NEUTRAL before changing the cutting direction.

⚠ WARNING

Risk of material damage if clutch is not properly engaged

Serious material damage can occur if the clutch is not properly engaged and is left sliding.

- Check to be sure the clutch is properly engaged.

NOTICE

Bad cutting quality due to improper gas setting

A disorderly oxygen flow will have a serious negative impact on the cutting surface.

- Close the pre-heating oxygen and fuel gas valve.

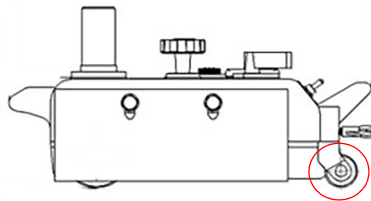
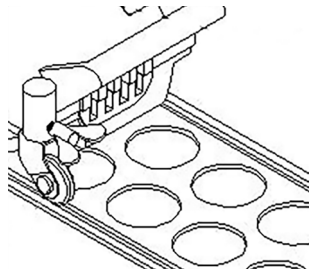
7.1 Positioning the EX-TRACK® MA-1/MA-2

⚠ WARNING

Risk of crushing

Improper assembly and disassembly of components can result in crushing of limbs.

- Do not reach into the hazardous areas.
- Do not catch your hands between the rails.
- Check and wear your personal protective equipment.



- 1** Align the rail parallel to the planned cut.
- 2** Position the torch approx. 80 mm from the device heat shield.
- 3** Move the entire assembly incl. rail so that the torch is in cutting position.
 - Use extension rails if required.
- 4** Lock the guide wheel by tightening the thumb screw.

7.2 Cutting

- 1** Adjust the gas pressure as specified in the cutting data.
- 2** Switch on the EX-TRACK® MA-1/MA-2.
- 3** Open the fuel gas valve 1/4 turn.
- 4** Open the pre-heating oxygen valve 1/2 turn.
- 5** Light the torch with an igniter.
- 6** Gradually open the pre-heating oxygen valve until the standard flame shows a white cone.
- 7** Open the cutting oxygen valve fully.
- 8** Re-adjust the flame so it shows an orderly flow.
- 9** Lower the tip to the cutting line with a distance of 8 to 10 mm between workpiece and torch.
- 10** Switch the Forward/Reverse switch (**H**) to the desired direction and start cutting.

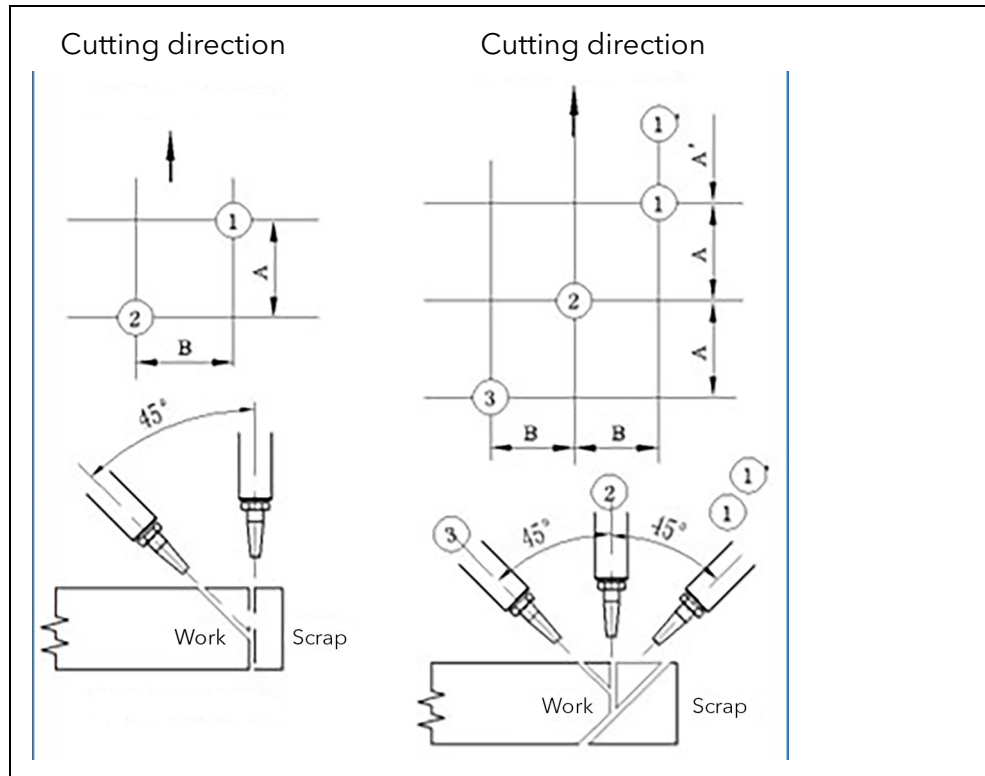
7.3 Bevel cutting

- 1** Adjust the gas pressure as specified in the cutting data.
- 2** Angle the torch in order to reach the desired bevel cut.
- 3** Switch on the EX-TRACK® MA-1/MA-2.
- 4** Open the fuel gas valve 1/4 turn.
- 5** Open the pre-heating oxygen valve 1/2 turn.
- 6** Light the torch with an igniter.
- 7** Gradually open the pre-heating oxygen valve until the standard flame shows a white cone.

- 8 Open the cutting oxygen valve fully.
- 9 Re-adjust the flame so it shows an orderly flow.
- 10 Lower the tip to the cutting line with a distance of 8 to 10 mm between workpiece and torch.
- 11 Switch the Forward/Reverse switch (**H**) to the desired direction and start cutting.

The torch can be inclined from 0° to 60° in increments of 5°.

If bevel cutting of 30° is required, decrease the cutting speed by about 5 %.

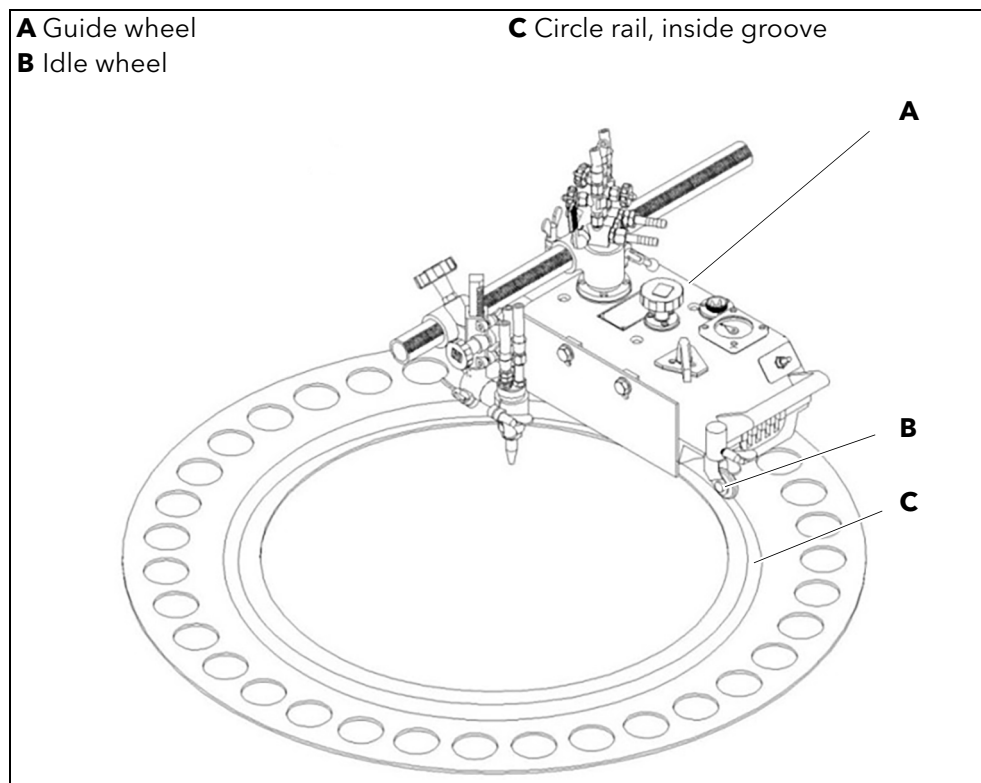


➤ Select the tips for bevel cutting as shown below.

7.4 Circle cutting

For circle cutting use circle rail.

7.4.1 Cutting with circle rail



- 1 Align the idle wheel (B) to the inside groove of the rail (C)
- 2 Align the guide wheel (A) to the outside groove of the rail.
- 3 Free the guide wheel (A) and fix it in the correct position so it follows the outside groove.
- 4 Proceed as with normal cutting.

⇒ 7.2 Cutting on page EN-15

Depending on the circle size the torch can be mounted on both sides of the EX-TRACK® MA-1/MA-2.

Cutting capacity: Ø40 to 360 and Ø770 to 1150 mm.

7.5 Stopping the cutting process

⚠ CAUTION

Risk of injury due to hot parts

Parts may still be hot after the gas post-flow period ends. People are at a risk of burns.

- Wear your personal protective equipment.
- Allow the cutting torch to cool down for 5 to 10 minutes before touching the parts.

- 1 Close the cutting oxygen valve.
- 2 Turn the switch to OFF.
- 3 Close the fuel gas valve.

The pre-heat oxygen jet is at right angles to the cutting surface.

- 4 Close the fuel gas valve.

8 Decommissioning

- 1 Disconnect the EX-TRACK[®] MA-1/MA-2 from the oxygen supply.
- 2 Disconnect the EX-TRACK[®] MA-1/MA-2 from the fuel gas supply.

9 Maintenance and cleaning

Scheduled maintenance and cleaning are prerequisites for a long service life and trouble-free operation. The maintenance cycle is determined by the work environment and the EX-TRACK[®] MA-1/MA-2's maintenance intervals. If it is operated for more than eight hours a day, the maintenance intervals should be changed as needed. Always observe the provisions of EN 60974-4 Inspection and testing, as well as any local laws and regulations.

⚠ CAUTION

Fire hazard due to contamination

Dust deposits inside the EX-TRACK[®] MA-1/MA-2 can lead to a reduction in insulation. This can cause short circuits or fires.

- Clean the EX-TRACK[®] MA-1/MA-2 annually with dried compressed air to remove dust and cutting fume residue.

9.1 Maintenance and cleaning intervals

The specified intervals are standard values and refer to single-shift operation. We recommend recording the inspections. The date of the inspection, the detected defects and the name of the inspector should be documented.

Daily/every 6 hours of cutting	➤ Clean the body with a clean cloth.
	➤ Brush dirt from rack and pipe arm.
	➤ Lubricate the shaft of the idle wheel with machine oil.
	➤ Check the consumables for wear.
Monthly	➤ Clean the outer surface of the guide wheel and the idle wheel with an oily cloth.
	➤ Lubricate the shafts of the speed regulating knob and the clutch lever with machine oil.
	➤ Measure the insulation resistance between the EX-TRACK [®] MA-1/MA-2's body and the input power plug. The reading must be above MΩ.
	➤ Remove the bottom cover and clean the inside electric components.
	➤ Remove the glass cover and clean the speed meter.

Every 3 months or 2000 hours	➤ Check the EX-TRACK® MA-1/MA-2 for signs of cracks and exposed wires.
	➤ Check the gas hose, filter elements, and connections for leaks.
	➤ Separate the reduction units from the motor and clean the gear box with cleaning oil.
	➤ Wipe the motor desk and ring cone with an oily cloth.
	➤ Replace worn parts.
Annually and after each time the housing is opened	➤ Have a safety inspection performed in accordance with IEC 60974 Part 4: "Periodic inspection and testing" by an authorized specialist.

10 Faults and troubleshooting

10.1 Motor does not run and carriage does not move

Possible cause	Measures	Troubleshooting
No electric power.	Check power circuit.	➤ Ensure good connection.
Broken input power cable.	Use a circuit tester and check the input power cable.	➤ Repair or replace the input power cable.
Defective input power plug.	Check the wire soldering.	➤ Solder the wire.
Defective switch.	Remove the connector and test each terminal with a tester.	➤ Replace the defective switch.
Defective condenser.	Check the condenser with a tester.	➤ Replace the defective condenser.
Bad connection.	Check soldering.	➤ Solder the bad connection.
Broken lead wire.	Test each lead with a tester.	➤ Replace defective lead.
Bad motor winding.	If all above test results are normal, a defective motor could be the problem.	➤ Repair or replace the motor.

10.2 Motor runs but carriage does not move

Possible cause	Measures	Troubleshooting
Faulty clutch	Remove the holder flange and check the connection of the connecting bar and the screw of the clutch lever.	➤ Reconnect the connecting bar and the screw of the clutch lever.
Slippery desk	Check the spring or desk for grease.	➤ Replace the spring. ➤ Clean the desk.

10.3 Carriage faults

Possible cause	Measures	Troubleshooting
Defective speed meter.	Belt or needle slipped due to loose needle screw.	<ul style="list-style-type: none"> ➤ Set the speed adjustment knob to "Low" and set the needle to the lowest scale. ➤ Tighten screw.
Speed control cannot be adjusted.	Slip of pinion. Defective gear and knock pin.	<ul style="list-style-type: none"> ➤ Repair or replace pinion and/or gear and knock pin.
Vibrations and noise.	Foreign matter caught in gear.	<ul style="list-style-type: none"> ➤ Remove foreign matter. ➤ Repair or replace gear.
	Gear worn.	<ul style="list-style-type: none"> ➤ Replace gear.
	Defective motor.	<ul style="list-style-type: none"> ➤ Repair or replace motor.
	Clutch key worn or damaged.	<ul style="list-style-type: none"> ➤ Replace clutch key.
Clutch disk does not engage.	Snap-ring of the clutch pin is off.	<ul style="list-style-type: none"> ➤ Replace the snap-ring.
Knocking	Gear worn.	<ul style="list-style-type: none"> ➤ Replace worn gear.
	Defective clutch pin.	<ul style="list-style-type: none"> ➤ Replace defective pin.
	Clutch key worn.	<ul style="list-style-type: none"> ➤ Repair or replace worn clutch key.
	Loose shaft or drive wheel.	<ul style="list-style-type: none"> ➤ Repair or replace shaft or drive wheel.
	Worn or damaged cone.	<ul style="list-style-type: none"> ➤ Replace the cone.
	Heat shield touches the work surface or rail.	<ul style="list-style-type: none"> ➤ Adjust heat shield.
	Damaged rail.	<ul style="list-style-type: none"> ➤ Repair or replace rail.
	Foreign object on rail.	<ul style="list-style-type: none"> ➤ Remove object and/or clean rail.
	Hoses or cables interfere with carriage movement.	<ul style="list-style-type: none"> ➤ Tie hoses and cables together with tape and place them outside the work area.
	Defective idle wheel unit.	<ul style="list-style-type: none"> ➤ Repair or replace idle wheel unit.
	Foreign matter attached to guide or idle wheel.	<ul style="list-style-type: none"> ➤ Remove foreign matter.
Guide and/or idle wheel damaged.	<ul style="list-style-type: none"> ➤ Repair or replace wheels. 	

11 Disposal



Equipment marked with this symbol is covered by European Directive 2012/19/EU on waste electrical and electronic equipment (WEEE).

- Do not dispose of electrical and electronic equipment with household waste.
- Disassemble electrical equipment prior to proper disposal.
 - ⇒ 11 Disposal on page EN-21
- Collect electrical components separately and recycle in an environmentally responsible manner.
- Observe local regulations, laws, provisions, standards and guidelines.
- Please consult the responsible local authority for information about collection and return of electrical devices.

11.1 Disposal of materials

This product is mainly made of metallic materials that can be melted in steel and iron works and are thus almost infinitely recyclable. The plastic materials used are labeled in preparation for their sorting and separation for later recycling.

11.2 Disposal of consumables

Oil, greases and cleaning agents must not contaminate the ground or enter the sewage system. These substances must be stored, transported, and disposed of in suitable containers. Observe the relevant local regulations and disposal instructions in the safety data sheets specified by the manufacturer of the consumables. Contaminated cleaning tools (brushes, rags, etc.) must also be disposed of in accordance with the information provided by the consumables' manufacturer.

- Observe the relevant local regulations and disposal instructions in the safety data sheets specified by the manufacturer of the consumables.

11.3 Packaging

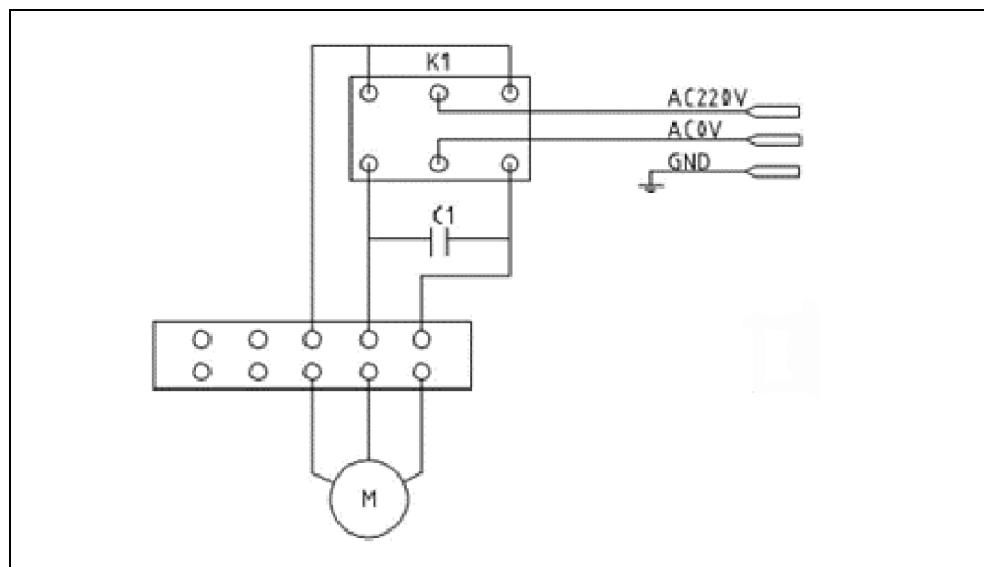
Thermacut® has reduced the packaging to the necessary minimum. The ability to recycle packaging materials is always considered during their selection.

12 Warranty

This warranty statement is an integral part of the Terms and Conditions ("T&C") of ThermoCut® (hereinafter "Seller") and applies to deliveries of goods under the contract concluded between the Seller and the other party to the contract as the recipient of the goods (hereinafter "Buyer"); the terms used herein have the same meaning as attributed to them in the T&C.

- 1 The Seller warrants to the Buyer that during the warranty period specified below, the goods delivered under the contract shall retain the properties specified in the technical data sheet for the goods available on the Seller's websites at the time the binding offer is sent (Section 2.2 of the T&C), otherwise in the quality and design suitable for the purpose resulting from the contract, otherwise for the usual purpose.
- 2 The period begins on the day of delivery of the goods to the buyer (Section 5.1, 5.2 of the T&C).
- 3 For the notification (claim) of warranty defects, the assertion of rights arising from the defective performance and other rights and obligations of the Seller and the Buyer, Section 3.4 ff and the following provisions of the T&C apply.
- 4 The warranty period is:
 - One (1) year for EX-TRACK® brand power supplies.
 - One (1) year for cutting torches and cable assemblies
- 5 The warranty does not cover normal wear and tear of the goods or their parts as a result of their use, such as nozzles, electrodes, shields, O-rings, vortex rings, etc.
- 6 The Seller shall not be liable for damage to the goods caused by the Buyer or third parties as a result of incorrect or improper handling of the goods (in particular repair or modification by persons not authorized by the Seller) or their installation, improper use of the goods or insufficient maintenance, in particular use of the goods for a purpose other than the specified purpose or other non-compliance with the operating instructions, use of excessive force or use of unauthorized goods.

13 Wiring diagram



**14 Parts list and exploded views
EX-TRACK® MA-1 and MA-2**

Fig. 3 Exploded view EX-TRACK® MA-1, upper and middle part

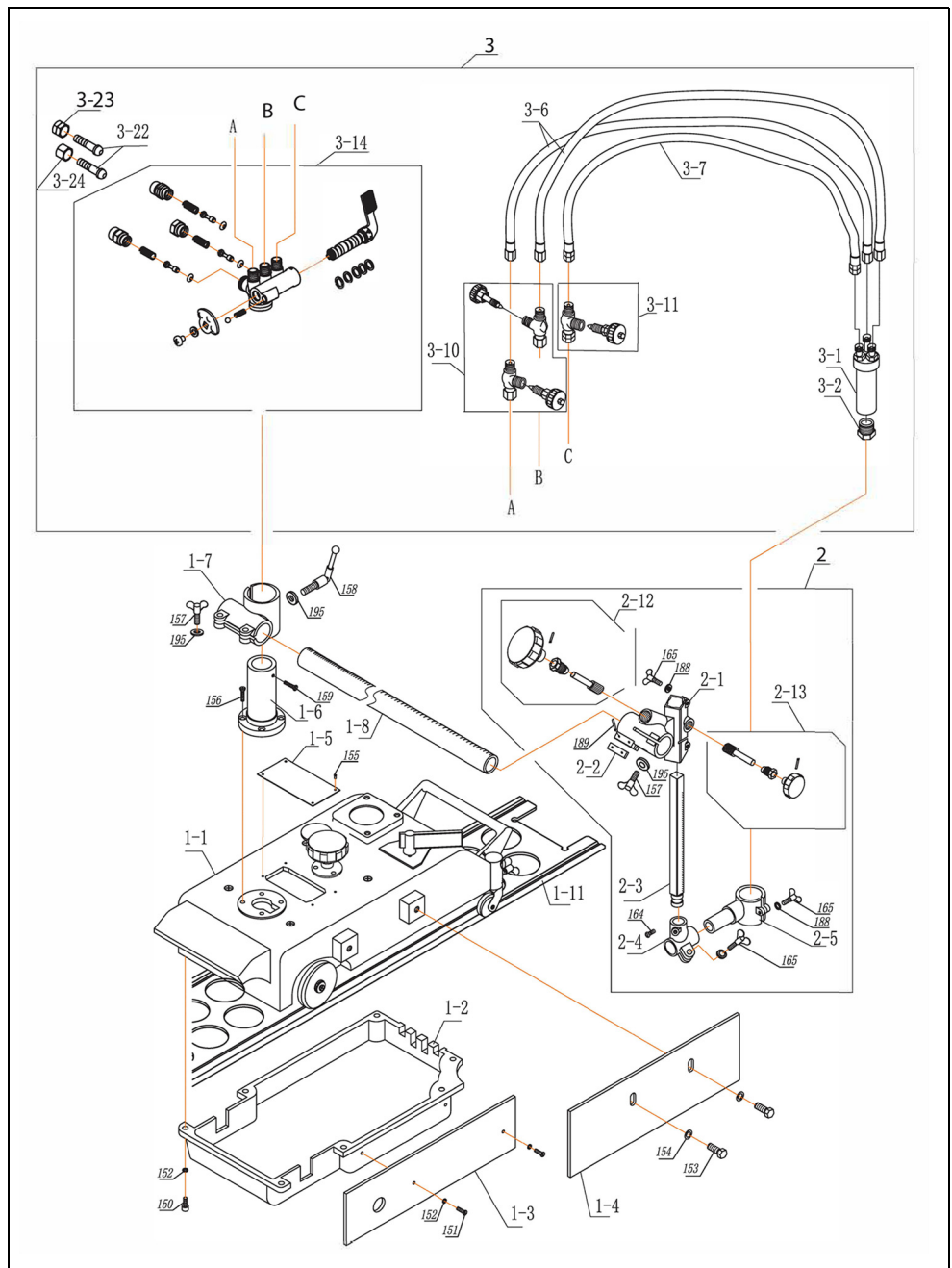


Fig. 4 Exploded view EX-TRACK® MA-1, middle and lower part

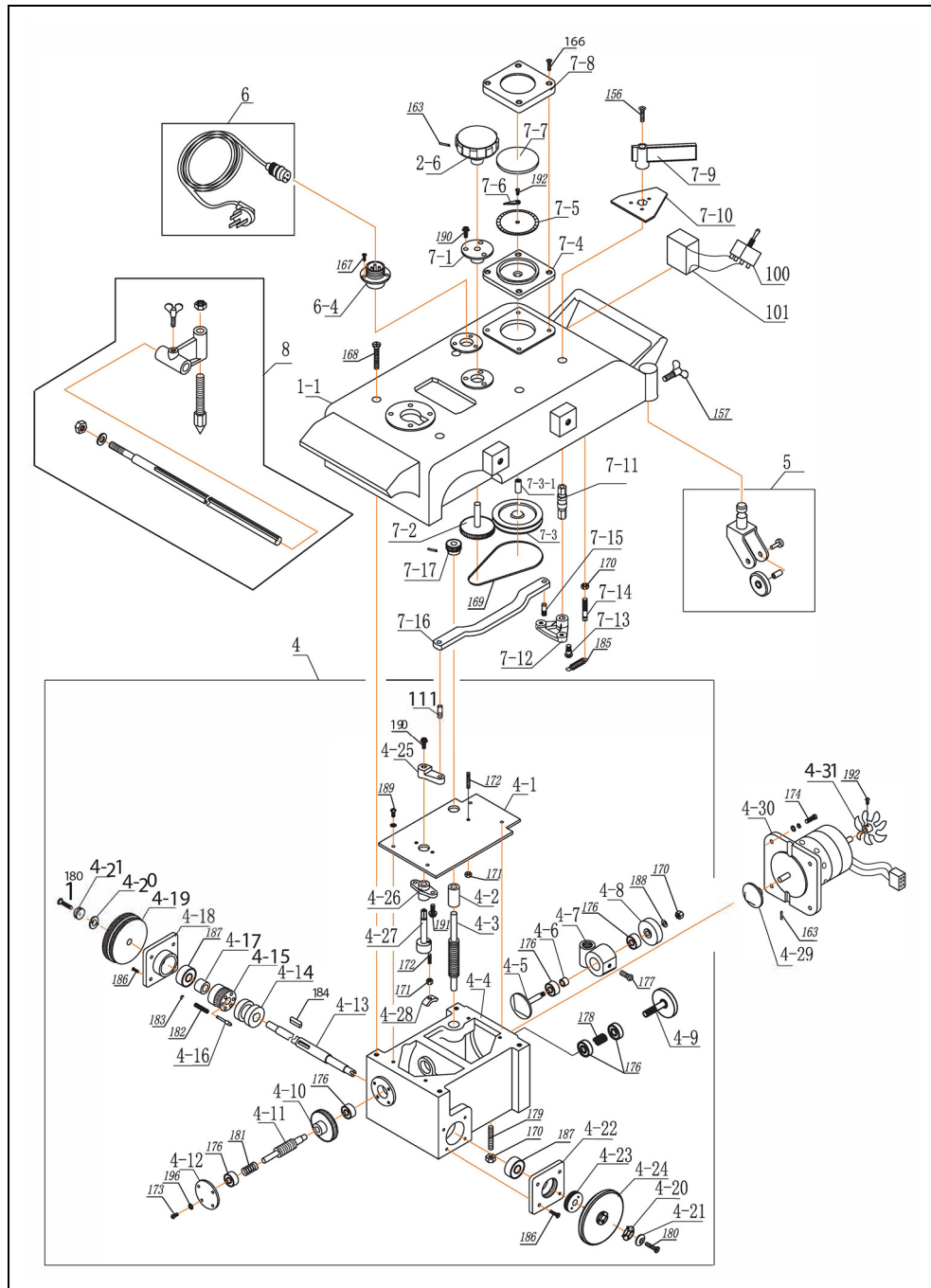


Table 4 Parts list EX-TRACK® MA-1

Ref. no.	Position	Description	pcs./machine
EX-0-718-000	1-0	Main device	1
EX-0-718-001	1-1	Main top cover	1
EX-0-718-002	1-2	Main bottom cover	1
EX-0-718-003	1-3	Secondary heat shield	1
EX-0-718-004	1-4	Main heat shield	1
EX-0-718-005	1-5	Identification plate	1
EX-0-718-006	1-6	Holder flange	1
EX-0-718-007	1-7	Rack holder	1
EX-0-718-008	1-8	Horizontal gear rack	1
EX-0-704-101	1-11	Rail 1.8 m	1
EX-0-704-102	1-12	Circular rail	1
EX-0-718-009	2	Torch holder assembly	1
EX-0-718-010	2-1	Clamp connector	1
EX-0-718-011	2-2	Adaptor	1
EX-0-718-012	2-3	Cutting torch rack	1
EX-0-718-013	2-4	Bottom torch holder - left side	1
EX-0-718-014	2-5	Bottom torch holder - right side	1
EX-0-718-015	2-6	Speed regulating knob	2
EX-0-718-016	2-12	Tension knob assembly	1
EX-0-718-017	2-13	Tension knob assembly	1
EX-0-718-018	3	Cutting torch and gas circuit assembly	1
EX-0-718-019	3-1	Cutting torch MA-1/MA-2	1
EX-0-718-020	3-2	Cutting nozzle nut MA-1/MA-2	1
EX-0-718-021	3-6	Oxygen hoses blue (B-preheat)	2
EX-0-718-022	3-7	Fuel gas hose	1
EX-0-708-014	3-10	Oxygen valve (UNF 9/16"-18)	2
EX-0-708-012	3-11	Fuel gas valve (UNF 9/16"-18LH)	1
EX-0-718-023	3-14	Gas distributor assembly	1
EX-0-718-024	3-22	Hose nipple	2
EX-0-718-025	3-23	Fuel gas nut	1
EX-0-718-026	3-24	Oxygen gas nut	1
EX-0-718-027	4	Reduction box assembly	1
EX-0-718-028	4-1	Reduction box cover	1
EX-0-718-029	4-2	Copper bushing	1
EX-0-718-030	4-3	Speed regulating screw	1
EX-0-718-031	4-4	Reduction box	1
EX-0-718-032	4-5	Cone wheel	1
EX-0-718-033	4-6	Drive wheel sleeve	1
EX-0-718-034	4-7	Drive wheel seat	1
EX-0-718-035	4-8	Passive friction wheel	1
EX-0-718-036	4-9	Drive gear	1

Table 4 Parts list EX-TRACK® MA-1

Ref. no.	Position	Description	pcs./machine
EX-0-718-037	4-10	Big drive gear	1
EX-0-718-038	4-11	Driving worm gear	1
EX-0-718-039	4-12	Bearing cover	1
EX-0-718-040	4-13	Main axis	1
EX-0-718-041	4-14	Clutch	1
EX-0-718-042	4-15	Clutch worm gear	1
EX-0-718-043	4-16	Clutch pin	6
EX-0-718-044	4-17	Bearing bushing	1
EX-0-718-045	4-18	Fixed bearing seat	1
EX-0-718-046	4-19	Knurled guide wheel	1
EX-0-718-047	4-20	Lock washer	2
EX-0-718-048	4-21	Big wheel bung	2
EX-0-718-049	4-22	Adjustable bearing seat	1
EX-0-718-050	4-23	Adjustable bearing cover	1
EX-0-718-051	4-24	Bevel wheel	1
EX-0-718-052	4-25	Connection rod block	1
EX-0-718-053	4-26	Permanent seat	1
EX-0-718-054	4-27	Activator rotating shaft	1
EX-0-718-055	4-28	Clutch activator	1
EX-0-718-056	4-29	Motor friction wheel	1
EX-0-718-057	4-30	Motor	1
EX-0-718-058	4-31	Motor cooling fan	1
EX-0-718-059	5	Castor wheel assembly	1
EX-0-718-060	6	Power cord assembly	1
EX-0-718-061	6-4	Socket connector	1
EX-0-718-062	7-1	Speed control handwheel seat	1
EX-0-718-063	7-2	Speed belt gear	1
EX-0-718-064	7-3	Speed regulating belt wheel	1
EX-0-718-065	7-3-1	Speed regulating belt axle	1
EX-0-718-066	7-4	Dial holder	1
EX-0-718-067	7-5	Speed indicator dial	1
EX-0-718-068	7-6	Speed meter needle	1
EX-0-718-069	7-7	Glass cover	1
EX-0-718-070	7-8	Lense cover	1
EX-0-718-071	7-9	Clutch handle	1
EX-0-718-072	7-10	Base of clutch handle	1
EX-0-718-073	7-11	Shaft	1
EX-0-718-074	7-12	Motion transfer base	1
EX-0-718-075	7-13	Big spring screw	1
EX-0-718-076	7-14	Spring screw	1
EX-0-718-077	7-15	Screw pin	1
EX-0-718-078	7-16	Clutch connecting arm	1
EX-0-718-079	7-17	Gear	1

Table 4 Parts list EX-TRACK® MA-1

Ref. no.	Position	Description	pcs./machine
EX-0-718-080	8	Optional accessory	1
EX-0-718-081	100	On/off switch	1
EX-0-718-082	101	Switch box	1
EX-0-718-083	111	Screw pin	1
EX-0-718-084	150	M5x12 hexagon socket head cap screw	7
EX-0-718-085	151	M5x12 cylindrical head screw	2
EX-0-718-086	152	Ø5 mm flat washer	9
EX-0-718-087	153	M10x20 bolt	2
EX-0-718-088	154	Ø10 mm flat washer	2
EX-0-718-089	155	Ø2.5 mm rivet	5
EX-0-718-090	156	M5x16 countersunk screw	4
EX-0-718-091	157	M8x16 butterfly screw	5
EX-0-718-092	158	M8x18 ball handle lever	1
EX-0-718-093	159	M4x12 cylindrical head screw	1
EX-0-718-094	163	Ø2.5x18 mm elastic cylindrical pin	4
EX-0-718-095	164	M5x8 cylindrical head screw	1
EX-0-718-096	165	M6x22 butterfly screw	3
EX-0-718-097	166	M4x12 semi-countersunk head screw	2
EX-0-718-098	167	M3x8 countersunk screw	1
EX-0-718-099	168	M6x30 countersunk screw	4
EX-0-718-100	169	3x280 drive belt	1
EX-0-718-101	170	M6 Nut	1
EX-0-718-102	171	M5 Nut	1
EX-0-718-103	172	M5x25 set screw	1
EX-0-718-104	173	M4x6 cylindrical head screw	4
EX-0-718-105	174	M4x12 cylindrical head screw	4
EX-0-718-106	176	608 bearing	6
EX-0-718-107	177	M6x14 cylindrical head screw	1
EX-0-718-108	178	Ø12 mm spring	1
EX-0-718-109	179	M6x16 fix screw	1
EX-0-718-110	180	M5x12 countersunk screw	3
EX-0-718-111	181	Ø15x15 mm spring	1
EX-0-718-112	182	Ø4x20 mm spring	6
EX-0-718-113	183	Ø4 mm retaining clip	6
EX-0-718-114	184	5x5x25 flat key	1
EX-0-718-115	185	Ø10x28 mm tension spring	1
EX-0-718-116	186	M4x12 countersunk screw	11
EX-0-718-117	187	6201 bearing	2
EX-0-718-118	188	Ø6 mm flat washer	1
EX-0-718-119	189	Ø5x1.8 mm O-ring	6
EX-0-718-120	190	Ø12x2.5 mm flat washer	2

Table 4 Parts list EX-TRACK® MA-1

Ref. no.	Position	Description	pcs./machine
EX-0-718-121	191	Ø8.5x1.2x17 mm valve needle spring	6
EX-0-718-122	192	Ø6 mm steel ball	2
EX-0-718-123	194	16x2.5 O-ring	10
EX-0-718-124	195	M6x8 cap head bolt	2
EX-0-718-125	196	Ø4 mm flat washer	4

Fig. 5 Exploded view EX-TRACK[®] MA-2, upper and middle part

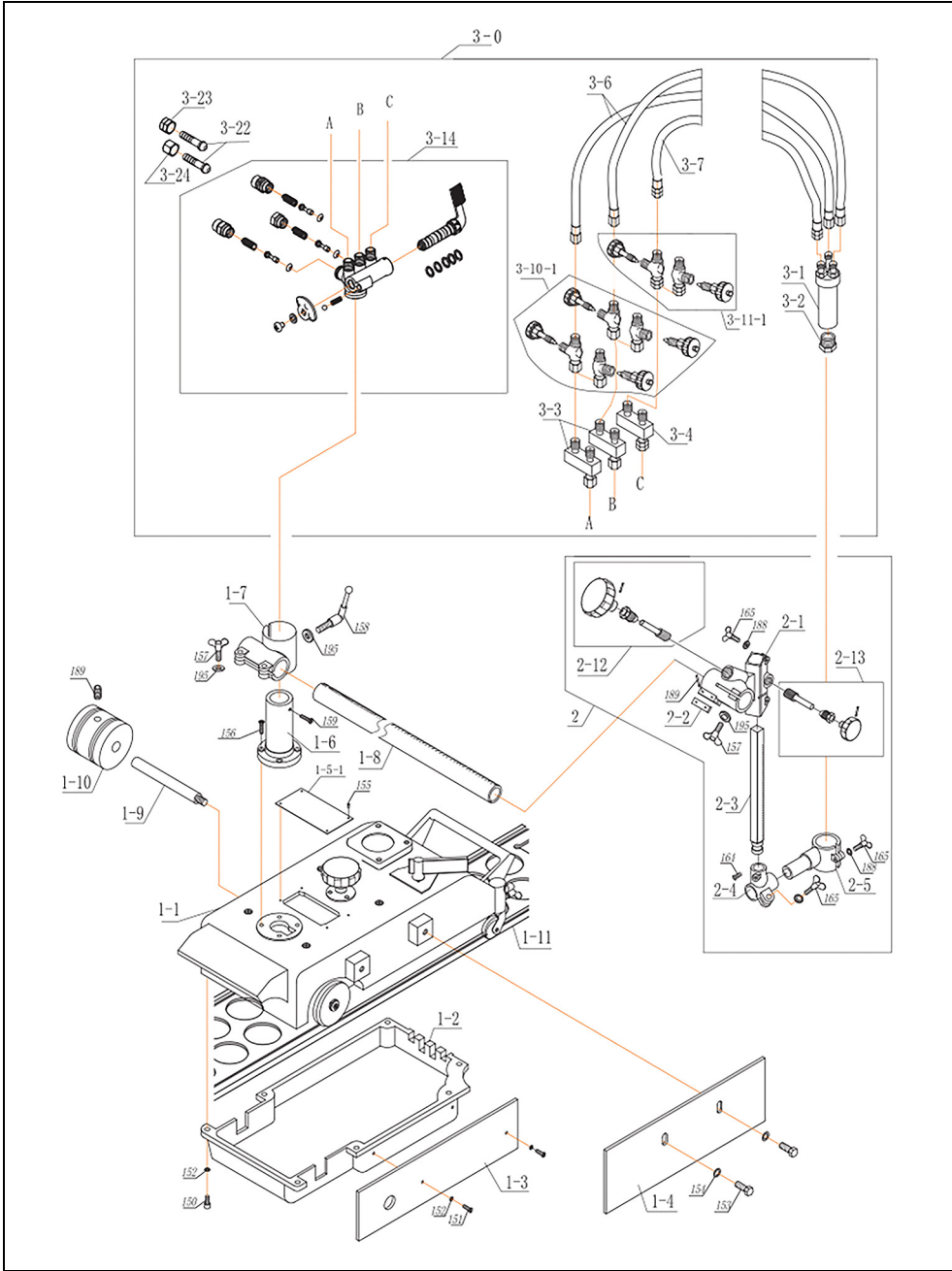


Fig. 6 Exploded view EX-TRACK® MA-2, middle and lower part

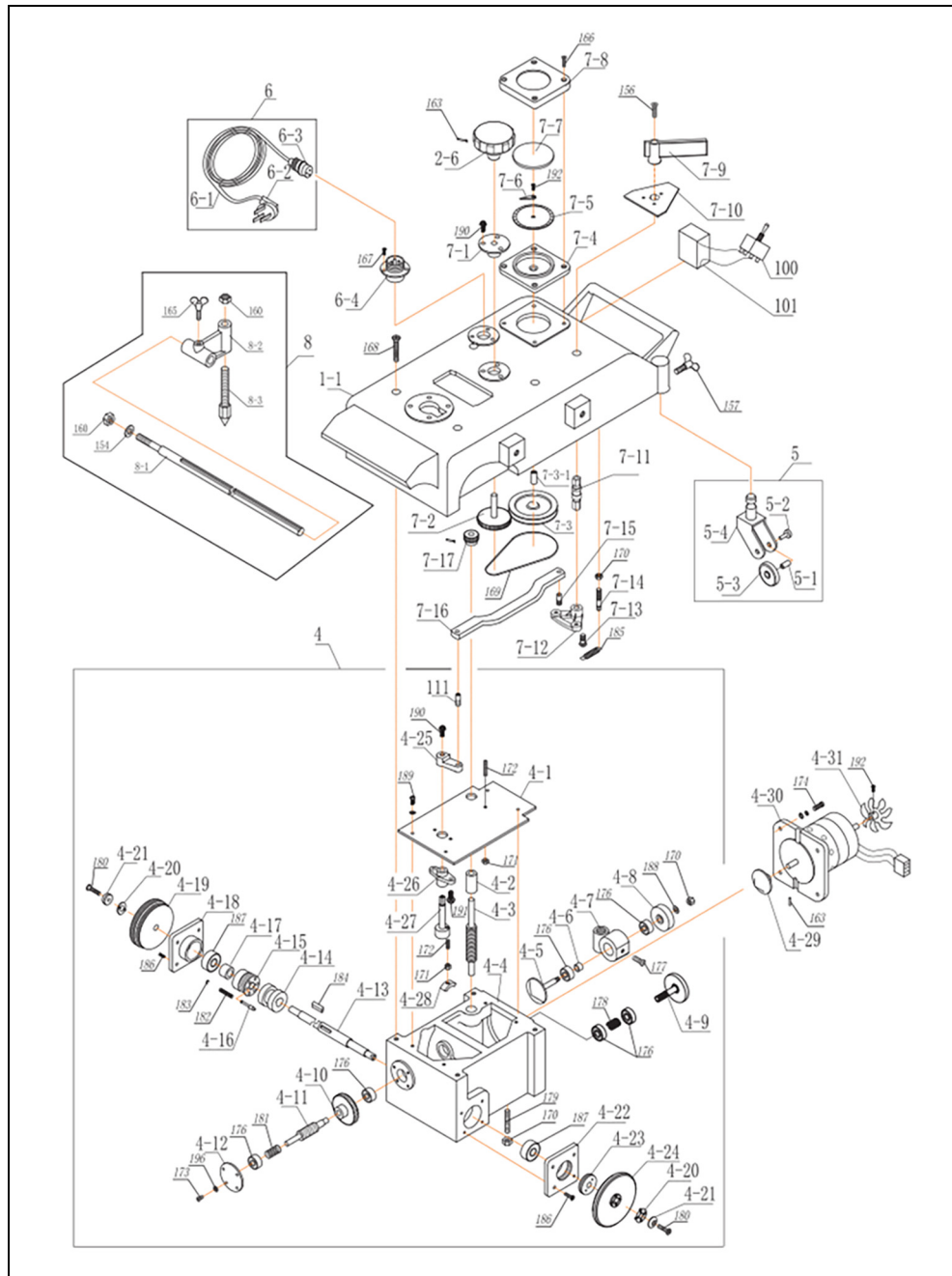


Table 5 Parts list EX-TRACK® MA-2

Ref. no.	Position	Description	pcs./machine
EX-0-718-000	1-0	Main device	1
EX-0-718-001	1-1	Main top cover	1
EX-0-718-002	1-2	Main bottom cover	1
EX-0-718-003	1-3	Secondary heat shield	1
EX-0-718-004	1-4	Main heat shield	1
EX-0-718-126	1-5-1	Identification plate	1
EX-0-718-006	1-6	Holder flange	1
EX-0-718-007	1-7	Rack holder	1
EX-0-718-127	1-8	Longer horizontal gear rack	1
EX-0-718-128	1-9	Stabilization bar	1
EX-0-718-129	1-10	Stabilization weight/wheel	1
EX-0-704-101	1-11	Rail 1.8 m	1
EX-0-704-102	1-12	Circular rail	1
EX-0-718-009	2	Torch holder assembly	2
EX-0-718-010	2-1	Clamp connector	1
EX-0-718-011	2-2	Adaptor	1
EX-0-718-012	2-3	Cutting torch rack	1
EX-0-718-013	2-4	Bottom torch holder - left side	1
EX-0-718-014	2-5	Bottom torch holder - right side	1
EX-0-718-015	2-6	Speed regulating knob	2
EX-0-718-016	2-12	Tension knob assembly	1
EX-0-718-017	2-13	Tension knob assembly	1
EX-0-718-130	3-0	MA-2 Cutting torch and gas circuit assembly	1
EX-0-718-019	3-1	Cutting torch MA-1/MA-2	1
EX-0-718-020	3-2	Cutting nozzle nut MA-1/MA-2	1
EX-0-718-131	3-3	Gas divider for two torches - oxygen	2
EX-0-718-132	3-4	Gas divider for two torches - fuel gas	1
EX-0-718-021	3-6	Oxygen hoses blue (B-preheat)	2
EX-0-718-022	3-7	Fuel gas hose	1
EX-0-708-014	3-10-1	Oxygen valve (UNF 9/16"-18)	4
EX-0-708-012	3-11-1	Fuel gas valve (UNF 9/16"-18LH)	2
EX-0-718-023	3-14	Gas distributor assembly	1
EX-0-718-024	3-22	Hose nipple	2
EX-0-718-025	3-23	Fuel gas nut	1
EX-0-718-026	3-24	Oxygen gas nut	1
EX-0-718-027	4	Reduction box assembly	1
EX-0-718-028	4-1	Reduction box cover	1
EX-0-718-029	4-2	Copper bushing	1
EX-0-718-030	4-3	Speed regulating screw	1

Table 5 Parts list EX-TRACK® MA-2

Ref. no.	Position	Description	pcs./machine
EX-0-718-031	4-4	Reduction box	1
EX-0-718-032	4-5	Cone wheel	1
EX-0-718-033	4-6	Drive wheel sleeve	1
EX-0-718-034	4-7	Drive wheel seat	1
EX-0-718-035	4-8	Passive friction wheel	1
EX-0-718-036	4-9	Drive gear	1
EX-0-718-037	4-10	Big drive gear	1
EX-0-718-038	4-11	Driving worm gear	1
EX-0-718-039	4-12	Bearing cover	1
EX-0-718-040	4-13	Main axis	1
EX-0-718-041	4-14	Clutch	1
EX-0-718-042	4-15	Clutch worm gear	1
EX-0-718-043	4-16	Clutch pin	6
EX-0-718-044	4-17	Bearing bushing	1
EX-0-718-045	4-18	Fixed bearing seat	1
EX-0-718-046	4-19	Knurled guide wheel	1
EX-0-718-047	4-20	Lock washer	2
EX-0-718-048	4-21	Big wheel bung	2
EX-0-718-049	4-22	Adjustable bearing seat	1
EX-0-718-050	4-23	Adjustable bearing cover	1
EX-0-718-051	4-24	Bevel wheel	1
EX-0-718-052	4-25	Connection rod block	1
EX-0-718-053	4-26	Permanent seat	1
EX-0-718-054	4-27	Activator rotating shaft	1
EX-0-718-055	4-28	Clutch activator	1
EX-0-718-056	4-29	Motor friction wheel	1
EX-0-718-057	4-30	Motor	1
EX-0-718-058	4-31	Motor cooling fan	1
EX-0-718-059	5	Castor wheel assembly	1
EX-0-718-060	6	Power cord assembly	1
EX-0-718-061	6-4	Socket connector	1
EX-0-718-062	7-1	Speed control handwheel seat	1
EX-0-718-063	7-2	Speed belt gear	1
EX-0-718-064	7-3	Speed regulating belt wheel	1
EX-0-718-065	7-3-1	Speed regulating belt axle	1
EX-0-718-066	7-4	Dial holder	1
EX-0-718-067	7-5	Speed indicator dial	1
EX-0-718-068	7-6	Speed meter needle	1
EX-0-718-069	7-7	Glass cover	1
EX-0-718-070	7-8	Lense cover	1
EX-0-718-071	7-9	Clutch handle	1
EX-0-718-072	7-10	Base of clutch handle	1
EX-0-718-073	7-11	Shaft	1

Table 5 Parts list EX-TRACK® MA-2

Ref. no.	Position	Description	pcs./machine
EX-0-718-074	7-12	Motion transfer base	1
EX-0-718-075	7-13	Big spring screw	1
EX-0-718-076	7-14	Spring screw	1
EX-0-718-077	7-15	Screw pin	1
EX-0-718-078	7-16	Clutch connecting arm	1
EX-0-718-079	7-17	Gear	1
EX-0-718-080	8	Optional accessory	1
EX-0-718-081	100	On/off switch	1
EX-0-718-082	101	Switch box	1
EX-0-718-083	111	Screw pin	1
EX-0-718-084	150	M5x12 hexagon socket head cap screw	7
EX-0-718-085	151	M5x12 cylindrical head screw	2
EX-0-718-086	152	Ø5 mm flat washer	9
EX-0-718-087	153	M10x20 bolt	2
EX-0-718-088	154	Ø10 mm flat washer	2
EX-0-718-089	155	Ø2.5 mm rivet	5
EX-0-718-090	156	M5x16 countersunk screw	4
EX-0-718-091	157	M8x16 butterfly screw	5
EX-0-718-092	158	M8x18 ball handle lever	1
EX-0-718-093	159	M4x12 cylindrical head screw	1
EX-0-718-094	163	Ø2.5x18 mm elastic cylindrical pin	4
EX-0-718-095	164	M5x8 cylindrical head screw	1
EX-0-718-096	165	M6x22 butterfly screw	3
EX-0-718-097	166	M4x12 semi-countersunk head screw	2
EX-0-718-098	167	M3x8 countersunk screw	1
EX-0-718-099	168	M6x30 countersunk screw	4
EX-0-718-100	169	3x280 drive belt	1
EX-0-718-101	170	M6 Nut	1
EX-0-718-102	171	M5 Nut	1
EX-0-718-103	172	M5x25 set screw	1
EX-0-718-104	173	M4x6 cylindrical head screw	4
EX-0-718-105	174	M4x12 cylindrical head screw	4
EX-0-718-106	176	608 bearing	6
EX-0-718-107	177	M6x14 cylindrical head screw	1
EX-0-718-108	178	Ø12 mm spring	1
EX-0-718-109	179	M6x16 fix screw	1
EX-0-718-110	180	M5x12 countersunk screw	3
EX-0-718-111	181	Ø15x15 mm spring	1
EX-0-718-112	182	Ø4x20 mm spring	6
EX-0-718-113	183	Ø4 mm retaining clip	6
EX-0-718-114	184	5x5x25 flat key	1

Table 5 Parts list EX-TRACK® MA-2

Ref. no.	Position	Description	pcs./machine
EX-0-718-115	185	Ø10x28 mm tension spring	1
EX-0-718-116	186	M4x12 countersunk screw	11
EX-0-718-117	187	6201 bearing	2
EX-0-718-118	188	Ø6 mm flat washer	1
EX-0-718-119	189	Ø5x1.8 mm O-ring	6
EX-0-718-120	190	Ø12x2.5 mm flat washer	2
EX-0-718-121	191	Ø8.5x1.2x17 mm valve needle spring	6
EX-0-718-122	192	Ø6 steel ball	2
EX-0-718-123	194	16x2.5 O-ring	10
EX-0-718-124	195	M6x8 cap head bolt	2
EX-0-718-125	196	Ø4 flat washer	4

For more information about accessories, visit our website:
www.ex-track.com.

15 Cutting data

- All pressure specifications are torch inlet pressures.
- Oxygen purity is minimum 99.7 %, propane is minimum JIS grade 3.
- The cut charts are a guide for the operator. Due to the varying types and quality of steel, climatic/ atmospheric conditions, it is advisable to make the relevant setting and adjustments to suit the work in hand.

Part no.	Nozzle type	Workpiece thickness [mm]	Torch height [mm]	Pressure [bar]			Consumption [NI/h]			Cutting speed [mm/min]
				Preheat O ²	Cutting O ²	Fuel gas (propane)	Preheat O ²	Cutting O ²	Fuel gas (propane)	
EX-0-708-017	00	1 - 5	8 - 10	1.5	2.0	0.2	1180	1200	310	750 - 550
EX-0-708-018	0	5 - 10	8 - 10	1.5	2.3	0.2	1180	1200	310	600 - 450
EX-0-708-019	1	10 - 20	8 - 10	1.5	2.5	0.2	1370	2300	310	480 - 380
EX-0-708-020	2	20 - 35	8 - 10	1.5	3.0	0.25	1370	4300	360	400 - 320
EX-0-708-021	3	35 - 60	8 - 10	1.5	3.5	0.3	1860	6500	490	350 - 280
EX-0-708-022	4	60 - 90	8 - 10	1.5	4.5	0.3	1860	11000	490	300 - 240

16 Ordering number

Table 6 Ordering numbers

Part no.	Item
EX-0-704-002	EX-TRACK MA-1/240 V AC/CE/1-OXY/straight cutter
EX-0-704-003	EX-TRACK MA-2/240 V AC/CE/2-OXY/straight cutter

ADDRESSES AND CONTACTS

EUROPE

CZECH REPUBLIC

THERMACUT, k.s.
Headquarters and Production
Sokolovská 574, Mařatice
686 01, Uherské Hradiště
Tel.: +420 572 420 411
Fax: +420 572 420 420
IČ: 46963715 / DIČ: CZ46963715
E-mail: info@thermacut.cz
reditelstvi@thermacut.cz
www.thermacut.cz

CZECH REPUBLIC

THERMACUT, k.s.
Central Sales Department
Dukelská 76A
742 42 Šenov u Nového Jičína
Tel.: +420 556 423 418, 440
E-mail: sales@thermacut.cz
obchod@thermacut.cz
www.thermacut.cz

GERMANY

THERMACUT GmbH
Am Rübgarten 2
D-57299 Burbach
Tel.: +49 (0)2736 29 49 11-0
Fax.: +49 (0)2736 29 49 11-77
E-mail: info@thermacut.de
www.thermacut.de

CROATIA

THERMACUT CROATIA d.o.o.
Petra Preradovića 21
532 70 Senj
Tel.: +385 53 882 622
E-mail: thermacut@gs.t-com.hr
www.thermacut.hr

POLAND

THERMACUT-POLAND SP. Z O.O.
ul. Stawowa 20
43-400 Cieszyn
POLAND
Tel.: +48 33 852 13 34
E-mail: thermacut@thermacut.pl
www.thermacut.pl

FRANCE

THERMACUT FRANCE
6 Rue des Frères Lumière
67201 Eckbolsheim
Tel.: +33 3 88 76 58 75
E-mail: thermacut@thermacut.fr
www.thermacut.net

ROMANIA

THERMACUT ROMANIA SRL
B-dul 1 Decembrie 1918
nr. 127A
540445 Targu Mures,
Jud. Mures
Tel.: +40 265 263 205
Fax.: +40 265 250 317
E-mail: office@thermacut.ro
www.thermacut.ro

RUSSIA

ООО "ТЕРМАКАТ"
454048 Г. ЧЕЛЯБИНСК
УЛ. КИРОВОГРАДСКАЯ Д.2
ТЕЛ./Ф АКС: +7 351 211 08 15
ФИЛИАЛЫ
129343 Г. МОСКВА
УЛ. УРЖУМСКАЯ Д.4
ТЕЛ.: +7 495 778 42 10
630032 Г. НОВОСИБИРСК
УЛ. СТАНЦИОННАЯ 60/1, ОФ ИС 116
ТЕЛ.: +7 383 375 07 90
E-mail: info@thermacut.ru
www.thermacut.ru

UKRAINE

ООО "Термакат Украина ГмбХ"
ул. Петропавловская 24
С. ПЕТРОПАВЛОВСКАЯ БОРЩАГОВКА
КИЕВО-СВЯТОШИНСКИЙ Р-Н 08130
Тел./факс: +380 44 403 16 99
+380 50 336 33 91
E-mail: info@thermacut.ua
www.thermacut.ua

GREAT BRITAIN

Abicor Binzel UK Ltd.
Binzel House,
Mill Lane
Winwick Quay
Warrington,
WA2 8UA, Cheshire
Tel.: +44 1925 653944
Fax.: +44 1925 654861
E-mail: info@abimail.co.uk
www.thermacut.net

NORWAY

Binzel Norge AS
Industrievæien 6
N-3300 Hokksund
Tel.: 0047-32 25 19 90
E-mail: post@binzel.no
www.thermacut.net

SWEDEN

Alexander Binzel AB
Ringugnsgatan 4
SE-216 16 Limhamn
Tel.: 0046-40 6 991 750
Fax: 0046-40 6 991 770
E-mail: order@binzel.se
www.thermacut.net

FINLAND

ABICOR BINZEL Finland Oy
Kartanontie 53
28430 Pori
Tel.: +358 2 634 4600
Fax.: +358 2 634 4650
E-mail: info@binzel.fi
www.thermacut.net

DENMARK

Abicor Binzel A/S Denmark
Ringugnsgatan 4
SE-216 16 Limhamn
Tel.: 0045-43621633
Fax.: 0045-43622324
E-mail: ac@binzel.se,
ket@binzel.se
www.thermacut.net

BELARUS

IOOO „ABICOR BINZEL Technics“
ul. Timirjazeva 97-10
BY-220020 Minsk
Tel.: +375 29 5 800 300
E-mail: info@thermacut.by
www.thermacut.by

SLOVAKIA

THERMACUT SLOVAKIA, s.r.o.
Priemysel'ná ulica 1239
931 01 Šamorín
Tel.: +421 31 591 0121
+421 903 644 954
E-mail: obchod@thermacut.sk
www.thermacut.sk

ASIA

Türkiye

ABICOR BINZEL Kaynak Teknik
Ticaret LTD. STI.
Girne Mah. Irmak Sok. Küçükalyi İş
Merkezi
E Blok No:72-6E PK:34852
Maltepe Istanbul Türkiye
Tel.: +90 (216) 367 90 00
Fax: +90 (216) 367 90 14
E-mail: satisdestek@binzel-
abicor.com.tr
www.thermacuttr.com

INDIA

ABICOR BINZEL TECHNOWELD PVT
LTD
SNo: 297, Indo German Technology
park
Village: Urawade
Taluka: Mulshi
District: Pune-412 115
Tel.:020-66743914, 020-39502691
E-mail: commercial@abicor-india.com
www.thermacut.net

KAZAKHSTAN

ABICOR BINZEL CENTRAL ASIA
АЛМАТЫ
УЛ. ЕГИЗБАЕВА 52, 050046.
Тел.+ 7 777 826 42 42
+ 7 717 262 57 30
E-mail: info@thermacut.com.kz
www.thermacut.kz

VIETNAM

MNT Industries Vietnam Co Ltd
No. 17, Street 34, Binh Tri Dong B Ward,
Binh Tan District; Hochiminh City
Phone: 0084-903 858 001
E-mail: ezio.minh@mnt.com.vn
www.thermacut.net

SOUTH KOREA

Abicor Binzel Korea Ltd.
#A-101, 263, Gaejwa-ro
Guemjeong-gu
Busan
Tel.: 0082 (31) 732 6065 / 6066 / 6067
Fax: 0082 (31) 732 6064
E-mail: don.kim@binzel.kr
www.thermacut.net

JAPAN

Thermacut Japan Ltd.
3F Shin-Osaka Hankyu Building
1-1-1, Miyahara, Yodogawa-ku, Osaka
532-0003 Japan
Mob.: +81 (0)80 4738 9752
Tel.: +81 (0)6 7662 8857
Fax: +81 (0)6 7635 7498
E-mail: s.miura@thermacut.jp

UNITED ARAB EMIRATES

ABICOR BINZEL MIDDLE EAST FZE
P.O Box: 86026, WFZ-04/27
RAKIA Freezone, Jazeera al Hamra
Ras al Kaimah, United Arab Emirates
Tel.: +971 (7) 2432355
+971 50 377 1348
Fax: +971 (7) 2432356
E-mail: info@binzel-abicor.ae
www.thermacut.ae

Revision history

You can find the latest version of the operator manual on our website:
www.ex-track.com.



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