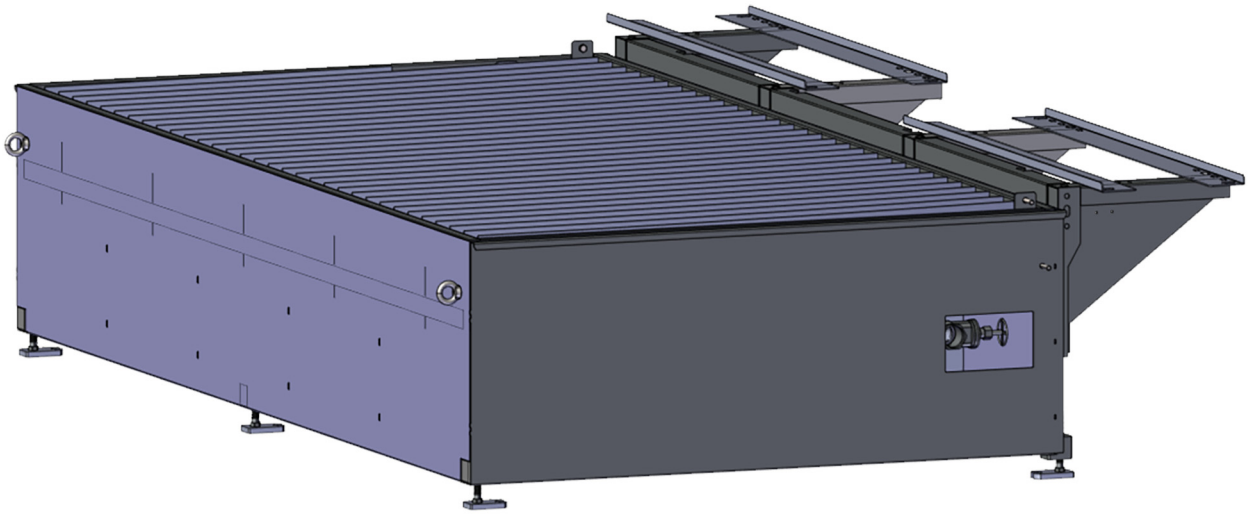


Water cutting table
CT-PORW

Operating instructions – EX-0-714-011 – CE

Edition 1, March 27, 2024

THERMACUT®
THE CUTTING COMPANY®

Table of contents

1 Identification

The water cutting table from the CT-PORW series is a stationary solution for plasma cutting and flame cutting metal. Cut particles and slag generated during the cutting processes are collected and bound in the water. This reduces emissions.

The water cutting table must only be operated using original Thermacut® spare parts. These operating instructions describe only the CT-PORW water cutting table.

When used in these operating instructions, the terms “product” and “table” always refer to the CT-PORW water cutting table.

1.1 Marking

This product fulfills the requirements that apply to the market to which it has been introduced. A corresponding marking has been affixed to the product, if required.

1.2 Nameplate

Fig. 1 CT-PORW identification plate

The product is labeled by means of an identification plate.

➢ For inquiries, please have at hand the product type, product number, and year of construction as indicated on the identification plate.

1.3 Signs and symbols used

The following signs and symbols are used in the operating instructions:

➢ General instructions.

1 Steps to be carried out in succession.

– Lists.

⇨ Cross-reference symbol indicating detailed, supplementary, or further information.

A Caption, item description.

1.4 Classification of the warnings

The warnings used in the operating instructions are divided into four different levels and shown prior to potentially dangerous work steps. Depending on the type of danger, the following signal words will be used:

⚠ DANGER

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

⚠ WARNING

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

⚠ CAUTION

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

NOTICE

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

2 Safety

This chapter provides basic safety instructions and warnings about residual hazards that should be kept in mind in order to operate the product safely. Non-observance of the safety instructions may result in risks to the life and health of personnel as well as cause environmental or material damage.

2.1 Designated use

The product described in these operating instructions may be used only for the purpose and in the manner described in these operating instructions.

The product is a stationary solution for plasma cutting or flame cutting metal and steels with a nickel and chrome alloy content of less than 30%. Cut particles and slag generated during the cutting processes are collected and bound in the water. This reduces emissions. Any other use is considered improper. Unauthorized modifications or changes to enhance the performance are not permitted.

- Do not exceed the maximum load data specified in the documentation. Excessive loads lead to irreparable damage.
- Do not make any structural modifications to the product.
- Use the product only in a closed environment.
- Do not store or use the product outdoors where it is wet.
- When storing outdoors, use suitable protection against the weather conditions.

2.2 Responsibilities of the user

- Ensure that only suitably qualified personnel perform work on the product or system.

  Suitably qualified personnel are:

  – those who are familiar with the basic regulations on occupational safety and accident prevention;
  – those who have been instructed on how to handle the product;
  – those who have read and understood these operating instructions;
  – those who have been trained accordingly;
  – those who are able to recognize possible risks because of their special training, knowledge, and experience.
- Keep non-suitably qualified people out of the work area.

2.3 Warning and information signs

The following warning, notice and mandatory signs can be found on the product:

➢ Wear a respiratory mask.

➢ Wear your personal protective clothing.

➢ Wear protective gloves.

➢ Wear safety shoes.

➢ Wear ear protection.

➢ Wear safety goggles.

➢ Read and observe the operating instructions.

Entering the table is forbidden.

Warning against hot surfaces.

Warning against risk of slipping.

➢ Ensure a dry and clean base in the room where the device is to be installed.

These markings must always be legible. They may not be covered, obscured, painted over, or removed.

2.4 Basic safety instructions

The product has been developed and manufactured in accordance with the latest technology and recognized safety standards and directives. Due to the product design, unavoidable technical residual risks exist to the user, third parties, products, and other material property. The manufacturer will accept no liability for damage caused by non-observance of the documentation.

- Please read the documentation carefully before using the product for the first time and comply with the instructions contained.
- Only operate the product in technically perfect condition and ensure compliance with all documentation.
- Read the documentation carefully before carrying out specific work, for example commissioning, operation, transport, or maintenance.
- Use suitable means to protect yourself and bystanders from the hazards listed in the documentation.
- Store the documentation within easy reach of the product for reference and enclose all documents when passing on the product.
- Consult the documentation on the additional cutting components.
- Observe the local accident prevention regulations.
- Only trained specialists should commission, operate, and service the device. Qualified personnel are persons who, based on their special training, knowledge, experience and due to their knowledge of the relevant standards, are able to assess the tasks assigned to them and identify possible dangers.
- Keep the work area in order. Ensure good lighting of the work area.
- Switch off the power, gas, and compressed air supplies and unplug the mains plug for the entire duration of servicing, maintenance, and repair work.
- For disposal, observe the local regulations, laws, provisions, standards, and directives.

2.5 Product-specific safety instructions

⚠ WARNING

Risk of explosion due to the production of oxyhydrogen

If process gases that contain hydrogen are used for plasma cutting in conjunction with water, highly explosive oxyhydrogen can be produced. This may result in serious injuries.

- ➢ Ensure that the hydrogen can rise up unhindered.
- ➢ Ensure that the control system is placed outside the cutting table area once cutting is complete so that no hydrogen or oxyhydrogen can collect in cavities.
- ➢ Ensure that no hydrogen can collect under the workpiece on the cutting grid.

⚠ WARNING

Health risk caused by inhaling harmful dust

The product contains harmful dust that can collect on surfaces and penetrate the ambient air as of the first use. It can damage the respiratory tract when inhaled.

- ➢ Check and wear your personal protective equipment.
- ➢ Use the product only in rooms with sufficient ventilation.
- ➢ Ensure that all seals on the product are free from dirt and debris.
- ➢ Immediately remove dust deposits from the environment with a dust class H industrial vacuum cleaner or a damp cloth.

2.6 Personal protective equipment

- ➢ Do not wear loose fitting clothing or jewelry.
- ➢ Use a hair net for long hair.
- ➢ 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 helmet, safety goggles, a class P3 respiratory mask, class S1 and higher protective gloves and safety shoes.

3 Scope of delivery

The following components are included in the scope of delivery:

– 1× CT-PORW water cutting table

– 4× mounting adapter plates

– 1× operating instructions

➢ Order the equipment parts and wear parts separately.

➢ The order data and ID numbers for the equipment parts and consumables can be found in the current catalog.

➢ For more information about points of contact, consultation, and orders, please visit *www.thermacut.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

➢ Use the delivery note to check that everything has been delivered.

➢ Check the delivery for damage (visual inspection).

Complaints

➢ If goods are damaged, contact the final carrier.

➢ Keep the packaging for possible checks by the carrier.

Returns

➢ Use the original packaging and packing material for returns.

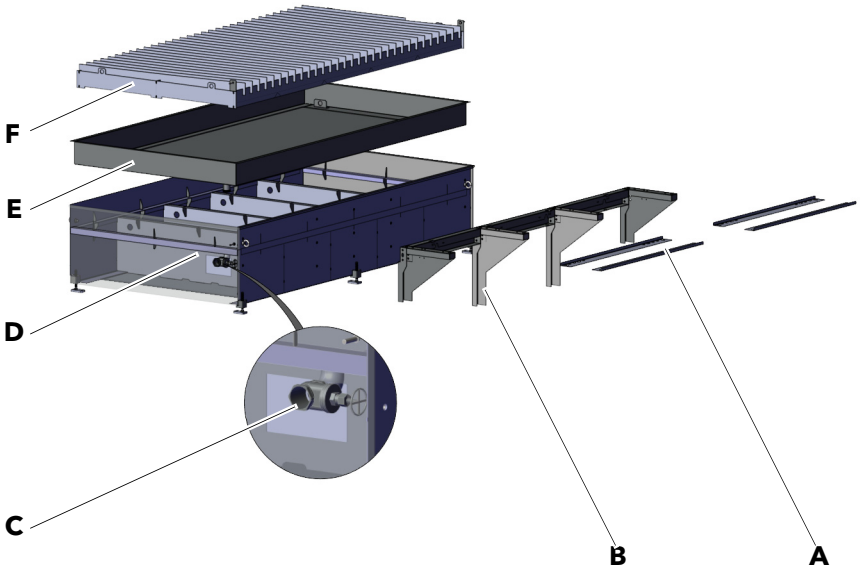
➢ If you have questions concerning packaging and safety during shipment, contact your supplier, carrier, or transport company.

4 Product description

4.1 Structure and function

Fig. 2 Structure

A Mounting adapter plate
B Console
C Water drain valve
D Cutting table body
E Water tank
F Cutting grid



The water cutting table acts as a substructure or base for cutting gantries in the field of plasma cutting and flame cutting. During thermal cutting processes, cut particles and slag are produced, which are collected and bound in the water tank. The wastewater can be released via a water drain valve.

4.2 Technical data

4.2.1 Ambient conditions

Tab. 1 Ambient conditions for transport and storage

Ambient temperature	−10°C to +40°C
Relative humidity	80% non-condensing

Tab. 2 Ambient conditions for operation

Ambient temperature	+10°C to +40°C
Relative humidity	70% non-condensing

4.2.2 Product data

Tab. 3 Product data

Product	**CT-PORW**
Electrical power supply	None
Dimensions (L × W × H)	1680 × 3245 × 641 mm
Max. cutting area	1500 × 3000 mm
Weight	830 kg
Capacity **Water tank**	1000 l
Recommended max. water fill level for operation	20 mm below the lower edge of the workpiece (max. 800 l)
Max. sheet thickness	40 mm
Max. load	400 kg/m²
	1500 kg with even weight distribution across the entire area (1.5 × 3 m)

5 Transport and installation

⚠ WARNING

Risk of injury due to improper transport and installation

Improper transport and installation can cause the product to tip or fall over. This may result in serious injuries.

➢Check and wear your personal protective equipment.
➢Ensure that all supply lines do not encroach into the area in which employees are working.
➢Place the product on a suitable base (flat, solid, dry) on which it will not topple over.
➢Note the weight of the product when lifting it.
⇨ 4.2 Technical data on page EN-11
➢Use a lifting tool with suitable slings when transporting and positioning the product.
➢Avoid abrupt lifting and setting down.
➢Do not lift the product over persons or other products.
➢Send bystanders out of the danger zone.
➢At least two people should work together to mount the product.

NOTICE

Risk of material damage due to improper transport and installation

Improper transport or installation can cause the product to tip or fall over. This can result in material damage and irreparable damage to the product.

➢Protect the product against weather conditions, such as rain and direct sunlight.
➢Ensure that the product does not make contact if you pass over edging.
➢Use the product only in dry, clean and well-ventilated rooms.
➢Maintain a minimum distance of 1 m from the wall when installing the product to ensure that the product has sufficient ventilation.
➢At least two people should work together to mount the product.
➢Only transport the water tank when empty.

NOTICE

Material damage due to forklifts/pallet trucks driving under the product improperly

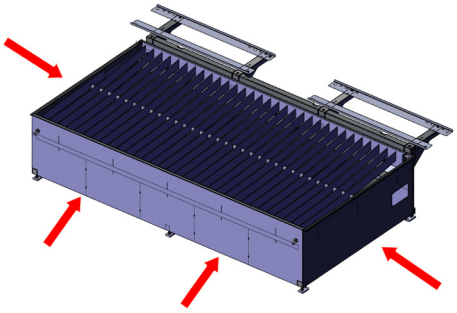
If the forklift/pallet truck drives too far under the product, it can be damaged.

➢Drive under the product carefully and only until the forklift/pallet truck cannot go any further.

The product can be transported with a forklift, pallet truck or crane.

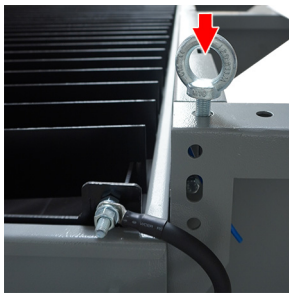
➢ When transporting the product with a forklift/pallet truck, note the amount of space required by the vehicle.
➢ If there is not enough space at the installation site to transport the product with a forklift/pallet truck, use a crane instead.
➢ If the water tank contains water, release this via the water drain valve.
⇨ 8.2 Emptying and cleaning the water tank on page EN-22

5.1 Transporting with a forklift/pallet truck



1 Drive a forklift or pallet truck with a suitable fork length all the way under the water cutting table.
2 Transport to a suitable installation site.

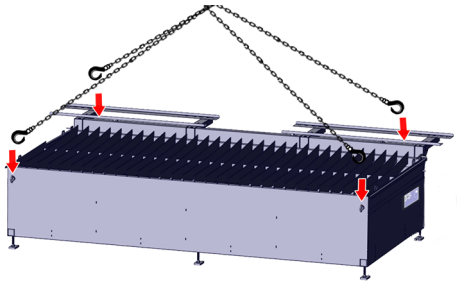
5.2 Transporting by crane



1 Attach the transport lugs (2×) to the top of the water cutting table.

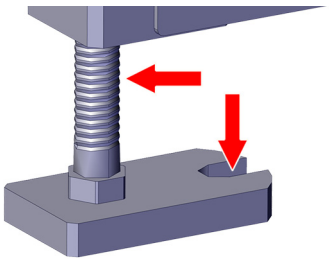
2 Attach the transport lugs (2×) to the sides of the water cutting table.

The set-up tasks described below must only be carried out using suitable and approved slings (e.g. ropes, chains, belts). The slings must only be attached to the specially designated crane lugs or transport loops on the water cutting table.



3 Attach the slings to the transport lugs on the water cutting table.
4 Use a lifting tool to lift the water cutting table.
5 Transport to a suitable installation site but do not set down yet.

5.3 Positioning the water cutting table



1 Once the water cutting table is in a suitable position, use the adjusting screws on the bottom to level it.
Correct levelling is crucial for optimal cutting quality and trouble-free operation.

Optional (material is not included in the scope of delivery):

2 Mark drill holes (6×) on the floor.

3 To ensure free access to the marks, temporarily move the water cutting table.

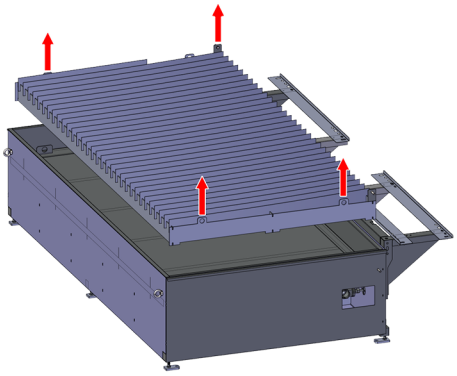
4 Use a percussion drill to drill the holes (6×) on the markings. Observe the manufacturer's instructions for the attachment means.

5 Insert nail plugs (6×) in the drill holes. Balance any unevenness by appropriate means.

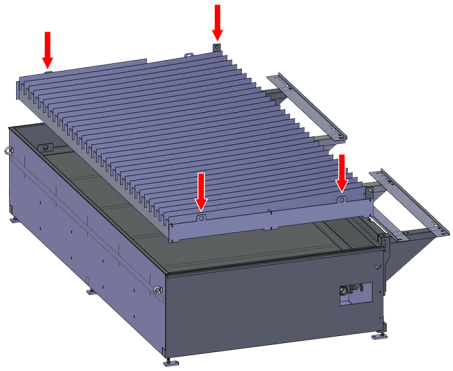
6 Move the water cutting table back into position and screw it to the ground at the attachment holes.

Other accessories (e.g. the mounting adapter plates) can optionally be located below the cutting grid during commissioning.

➢ Perform the following steps to remove the accessories:



7 Use suitable slings and the specially designated lugs to lift off the cutting grid.



8 Remove the accessories.

9 Check the cleanliness of the support points for the cutting grid's frame.

10 Put the cutting grid in place, ensuring that it sits straight on the support points.

6 Commissioning

6.1 Filling the water tank

⚠ CAUTION

Risk of slipping due to water escaping into the installation area
If the water drain valve is not firmly sealed, water can escape into the installation area causing people to slip and injure themselves.
➢Before filling the water tank, ensure that the water drain valve is firmly sealed (turned to the right).

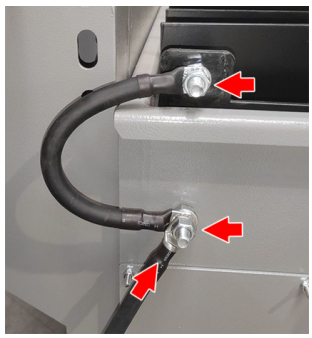
➢ Fill the water tank with water (e.g. using a water hose). We recommend that the water level should stop 20 mm below the lower edge of the workpiece to be cut and that the maximum fill volume of 800 l is not exceeded.

6.2 Establishing equipotential bonding

⚠ WARNING

Electric shock due to defective cables
The use of damaged or improperly installed cables may result in a potentially fatal electric shock.
➢Check all live cables and connections for proper installation and damage.
➢Have any damaged, deformed, or worn parts replaced by a qualified electrician only.
➢Allow only an electrician or a trained individual to establish equipotential bonding.

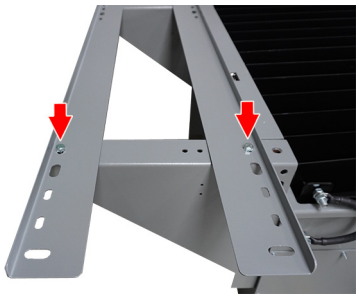
To protect electronic components against negative impacts owing to parasitic electric currents, equipotential bonding must be provided on every water cutting table and on cutting units. We recommend using a 70 mm² cable to ground the table.



1 Loosen and remove a serrated washer and a nut using socket wrench AF 19 on the side of the table.
2 Position ground cables (2×) on both sides on the threaded bolts.
3 Attach the ground cables to the threaded bolts using serrated washers and nuts.
4 Establish equipotential bonding to the hall (on the customer side, not included in the scope of delivery).

6.3 Attaching the mounting adapter plates for the EX-TRACK CNC

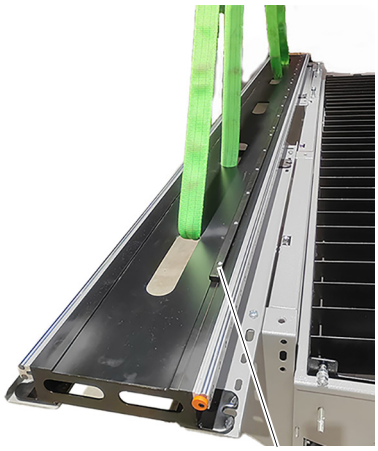
The visual direction for attachment is from the front of the table toward the water drain. This results in the terms “front” and “rear mounting plate”.



1. Position the mounting adapter plates (4×) on the down draft table’s console.
2. Position the front mounting adapter plate so the final small slot on the rail lines up with the outer hole pattern on the console.
3. Use M10 screws (4×) and an AF 17 Allen key to secure the mounting adapter plate to the console.
4. Hand-tighten the screws only so the plate position can still be adjusted later on.

5. Position the rear mounting adapter plate so the third to last slot lines up with the outer hole pattern on the console.
6. Use M10 screws (2×) and an AF 17 Allen key to secure the mounting adapter plate to the console.
7. Hand-tighten the screws only so the position of the mounting adapter plate can still be adjusted later on.

6.4 Attaching the rail for the EX-TRACK CNC (optional)



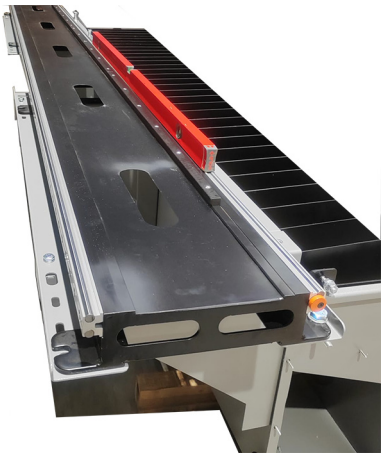
Gear rack

1 Use a suitable lifting device to carefully position the rail on the mounting adapter plates.

2 Ensure that the gear rack sits on the inside!

3 Use the M16 screws (8×) to secure the rail to the mounting adapter plates.

Only hand-tighten the screws.

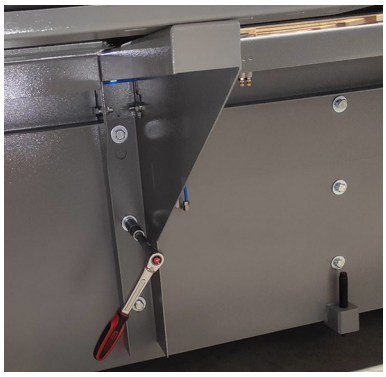


4 Check the height alignment along the mounting adapter plates.

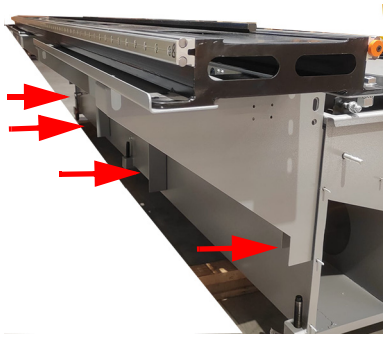
5 Use a spirit level to check the alignment and leveling.

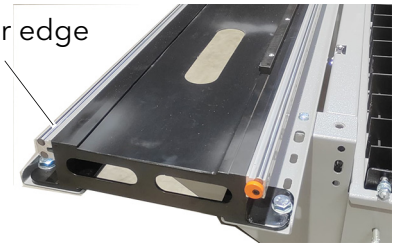
Please note that the down draft table must already have been leveled.

⇨ 5.3 Positioning the water cutting table on page EN-14

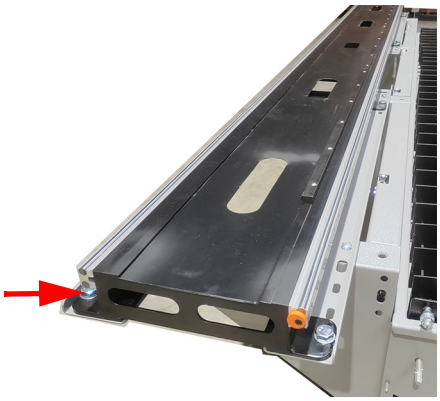


6 If necessary, use an AF 24 wrench to loosen the console screws on the table and align the height.





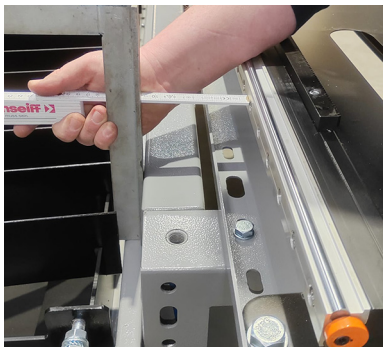
7 Position the two outer edges of the mounting adapter plates flush with the front of the consoles and tighten the M10 screws with an AF 17 wrench.



8 Position the rail parallel to the table body.

9 To this end, use a measuring aid (e.g. folding ruler) to measure the distance from the inside of the table to the rail's guide rail at both the start and end of the table.

10 Firmly screw the M16 screws on the left side of the rail to the outer edge of the mounting adapter plate.



11 Remeasure the distance between the inner side of the rail and the table.

When measuring, always work from the outer edge of the table to the inside of the rail.

12 Visually align the inner edge of the mounting adapter plates with the console and the rail.

13 Securely attach the plates to the console using the M10 screws and an AF 17 wrench and to the rail using the M16 screws and an AF 24 wrench.

Further information about the EX-TRACK® CNC can be found in the EX-TRACK® CNC operating instructions.

7 Operation

⚠ WARNING

Risk of burns due to hot surfaces, flying sparks and glowing slag

Sparks and glowing slag are produced during thermal cutting processes. The surfaces of the product and the workpiece can get extremely hot. This poses a risk of burns.

➢Check and wear your personal protective equipment.

➢If parts fall into the water when cut during operation, allow the water to cool before retrieving them.

⚠ WARNING

Health risk caused by inhaling harmful cutting fumes

Cutting processes produce fumes with harmful dust particles, which settle on surfaces and can be released into the ambient air. It can damage the respiratory tract when inhaled.

➢Check and wear your personal protective equipment.

➢Use the product only in rooms with sufficient ventilation.

➢Use a suitable extraction system to extract cutting fumes that are not bound in the water.

⚠ WARNING

Health risk caused by inhaling harmful dust

The product contains harmful dust that can collect on surfaces and penetrate the ambient air as of the first use. It can damage the respiratory tract when inhaled.

➢Check and wear your personal protective equipment.

➢Use the product only in rooms with sufficient ventilation.

➢Ensure that all seals on the product are free from dirt and debris.

➢Immediately remove dust deposits from the environment with a dust class H industrial vacuum cleaner or a damp cloth.

⚠ CAUTION

Risk of slipping due to water escaping into the installation area

If the water drain valve is not firmly sealed, water can escape into the installation area causing people to slip and injure themselves.

➢Before filling the water tank, ensure that the water drain valve is firmly sealed (turned to the right).

➢ Check the fill level of the water tank before and during the cutting process and top up the water if required.

8 Maintenance and cleaning

Scheduled maintenance and cleaning are prerequisites for a long service life and trouble-free operation. If the product is operated for more than 8 hours a day, the maintenance intervals should be changed as needed. We recommend recording the inspections.

⚠ WARNING

Health risk caused by inhaling harmful cutting fumes

Cutting processes produce fumes with harmful dust particles, which settle on surfaces and can be released into the ambient air. It can damage the respiratory tract when inhaled.

- ➢Check and wear your personal protective equipment.
- ➢Use the product only in rooms with sufficient ventilation.
- ➢Ensure that all seals on the product are free from dirt and debris.
- ➢After cleaning and maintenance work, check all threaded fittings for a tight fit, leaks, chafing abrasion points. Tighten any threaded fittings that have been loosened. Rectify any identified defects immediately.
- ➢Immediately remove dust deposits from the environment with a dust class H industrial vacuum cleaner or a damp cloth.

⚠ WARNING

Risk of crushing

Limbs can be crushed if product components are improperly installed or uninstalled.

- ➢Keep your hands out of the danger zone.
- ➢Check and wear your personal protective equipment.

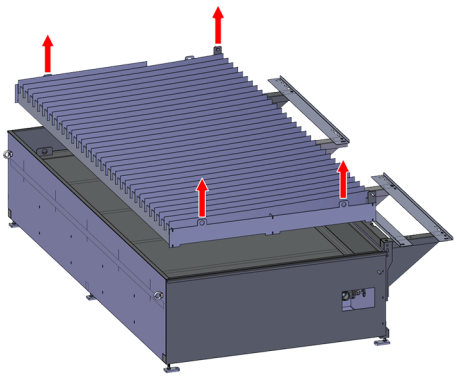
8.1 Maintenance and cleaning intervals

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 must be observed.

Daily	➢ Check the water level in the water tank.
	➢ Check the amount of slag in the water tank.
Weekly	➢ Check product for visible damage.
	➢ Check the ground cables to ensure that they are securely connected and not damaged, and replace them if necessary.
	➢ Check that the water drain valve does not leak.
Yearly	➢ Check the unit's ground connections for damage.
Yearly or if required	➢ Remove the water tank.
	⇨ 8.3 Removing the water tank on page EN-24

Empty and clean the water tank if required and in all events if its slag content reaches 50%.	➢ ⇨ 8.2 Emptying and cleaning the water tank on page EN-22
If required	➢ Replace the slats. ⇨ 11 Spare parts and consumables list on page EN-28

8.2 Emptying and cleaning the water tank



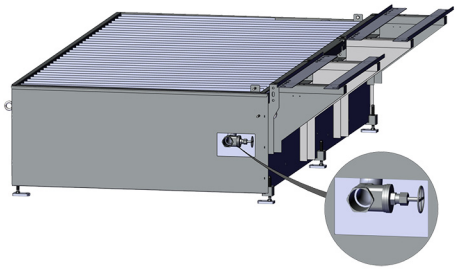
1 Remove the ground cable on both sides.

⇨ 6.2 Establishing equipotential bonding on page EN-16

2 Use suitable slings and the specially designated lugs to lift off the cutting grid.

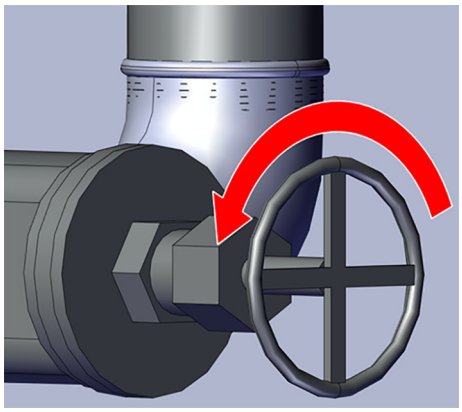
3 Use suitable aids (e.g. a shovel) to remove the slag and dispose of it in line with local regulations.

⇨ 10 Disposal on page EN-27



4 Attach the hose (provided by the customer, not included with the product) to the thread on the water drain valve. Alternatively, place a sufficiently large collection receptacle under the water drain valve.

Depending on local and official regulations, it may be possible to discharge the water into the sewage system or all of the water may have to be collected and properly disposed of.



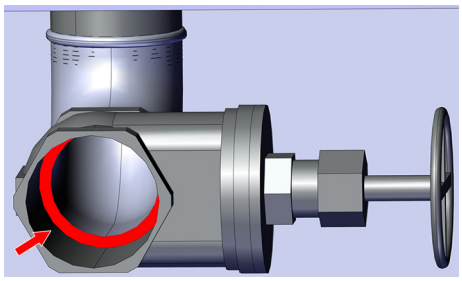
5 Turn the wheel all the way to the left to open the water drain valve.

6 Discharge the water into the sewage system or fully collect and properly dispose of it depending on local and official regulations.

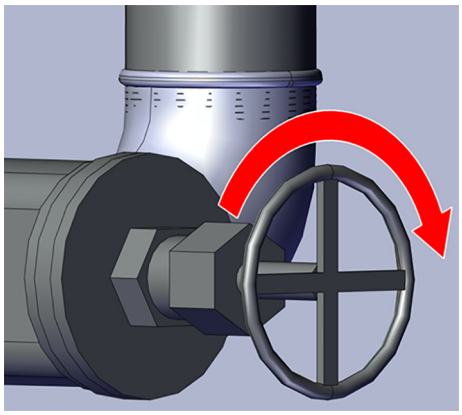
⇨ 10 Disposal on page EN-27

7 Thoroughly rinse the water tank (e.g. using a water hose).

8 Disconnect the hose provided by the customer from the thread on the water drain valve.



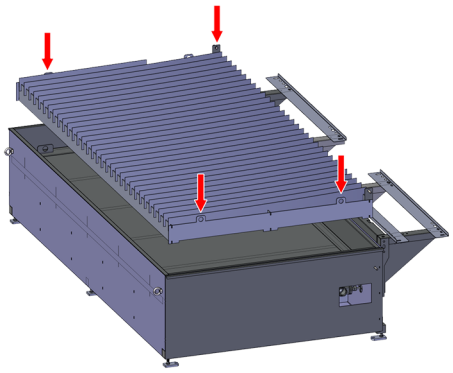
9 Use water or a damp cloth to clean any sealing surfaces behind the water hose's screw thread.



10 Turn the wheel all the way to the right to close the water drain valve.

11 Fill the water tank with water.

⇨ 6.1 Filling the water tank on page EN-16



12 Check the cleanliness of the support points for the cutting grid's frame.

13 Put the cutting grid in place, ensuring that it sits straight on the support points.

14 Connect the ground cables on both sides.

⇨ 6.2 Establishing equipotential bonding on page EN-16

8.3 Removing the water tank

NOTICE

Risk of material damage due to improperly transporting and setting down the water tank

The water tank, water drain valve and connections on the customer side can be damaged by improper transportation or setting down. This can result in material and irreparable damage.

➢Only transport the water tank when empty.

➢Remove the cutting grid prior to transportation as the water tank can otherwise be damaged.

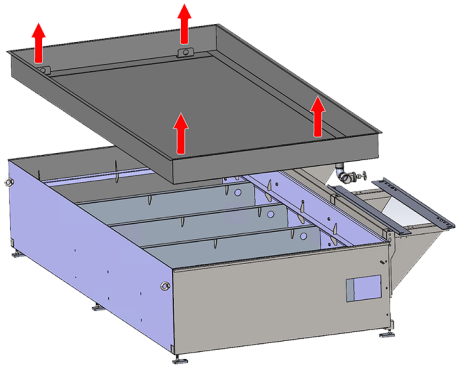
➢Remove any customer side connections to the water drain valve prior to transportation.

➢When setting down the water tank, ensure that the water drain valve is not damaged.

The water tank can be fully removed in order to be thoroughly cleaned, in the event of it leaking or if the water drain valve is faulty.

1 Empty and clean the water tank.

⇨ 8.2 Emptying and cleaning the water tank on page EN-22

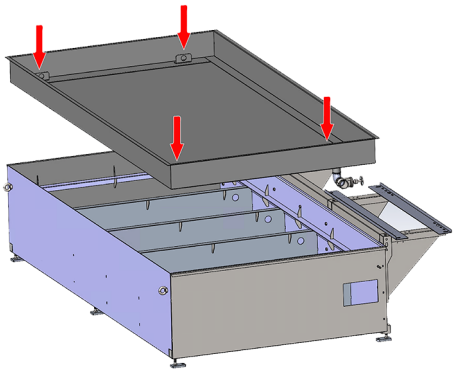


2 Use suitable slings and the specially designated lugs to lift off the water tank.

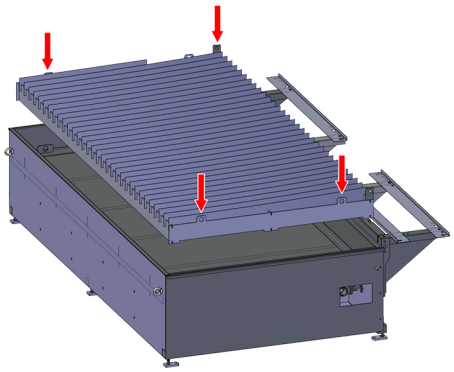
3 Set the water tank down, taking care not to damage the water drain valve.

4 Thoroughly clean the water tank.

5 Use water or a damp cloth to clean the insides of the water cutting table.



6 Insert the water tank.



7 Check the cleanliness of the support points for the cutting grid's frame.

8 Put the cutting grid in place, ensuring that it sits straight on the support points.

9 Connect the ground cables on both sides.

⇨ 6.2 Establishing equipotential bonding on page EN-16

9 Faults and troubleshooting

⚠ WARNING

Health risk caused by inhaling harmful cutting fumes

Cutting processes produce fumes with harmful dust particles, which settle on surfaces and can be released into the ambient air. It can damage the respiratory tract when inhaled.

- ➢Check and wear your personal protective equipment.
- ➢Use the product only in rooms with sufficient ventilation.
- ➢Ensure that all seals on the product are free from dirt and debris.
- ➢Immediately remove dust deposits from the environment with a dust class H industrial vacuum cleaner or a damp cloth.

- ➢ Observe the documentation for the cutting components.
- ➢ Contact your retailer or Thermacut® in the event of questions or problems.

Tab. 4 Faults and troubleshooting

Fault	Cause	Troubleshooting
Plasma device does not ignite	Insufficient ground connection to the cutting machine.	➢ Check the ground cable.
	Coating of the table cover (especially in new condition) insulated from the plate to be cut.	➢ Scrape off paint from the covers using a steel plate or rub it away using a roughing or twisted knot brush.
Paint burnt onto the outside of the table	Too high cutting capacity.	➢ Check the set power range.
	The plate is positioned with the cutting edge too close to the outer edge of the table.	➢ Check the position of the plate to be cut to the outer edge.
	A phase cut outward heats up the table's outer plate.	➢ Observe a sufficient distance outward during phase cutting.
Water droplet formation on the valve/ leak/water running into the installation area	The water drain valve is open.	➢ Close the water drain valve.
	The water drain valve is not watertight.	➢ Clean the sealing surface on the water drain valve. ➢ If the fault persists, contact the Thermacut® service team.
	The water tank is leaking.	➢ Contact the Thermacut® service team.
	The water tank is not watertight.	➢ Contact the Thermacut® service team.
High levels of smoke produced during operation	The water fill level in the water tank is too low.	➢ Check the water's fill level. ➢ Top up the water if necessary.
The water is not released during emptying despite the water drain valve being open	The water drain is blocked.	➢ Remove slag. ➢ Check the water drain for blockage.

10 Disposal

10.1 Disposal of slag

Slag is metal waste and subject to special waste regulations. It must not be disposed of with normal household waste.

➢ Observe the local and official regulations.

10.2 Disposal of wastewater

Depending on the local regulations, wastewater must not be released into the sewage system.

➢ Observe the local regulations and instructions on the disposal of wastewater.

10.3 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.

10.4 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. 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.

The disposal of dust collecting bags and disposal bags is subject to special waste regulations. The dust must not enter sewage systems or be disposed of together with normal household waste.

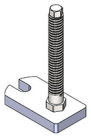
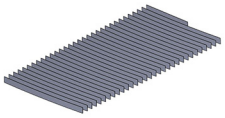
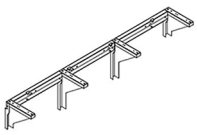
➢ Observe the local and official regulations.

10.5 Packaging

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

11 Spare parts and consumables list

Tab. 5 Spare parts and consumables list

Item	Item description	Item number
	Adjustable foot, 1×	EX-0-713-035
	Slat set for the water cutting table 1600 × 3200	EX-0-713-031
	Stopcock, 2"	EX-0-713-032
	Bracket for portable cutting machine, 4×	EX-0-713-033
	Mounting adapter plates, 4×	EX-0-713-034

12 Warranty

This product is an original Thermacut® product. Thermacut® guarantees correct manufacture and assumes a factory production and function warranty for this product upon delivery, which is in line with the latest technology and current regulations. If Thermacut® is responsible for a defect that is present, Thermacut® is obliged to remedy the defect or deliver a replacement at its own cost and its own discretion. The warranty covers manufacturing faults, but not damage resulting from natural wear and tear, overloading or improper use. The warranty period is defined in the General Terms and Conditions. Exceptions in the case of specific products are regulated separately. Warranty will also be rendered invalid if spare and consumables are used that are not original Thermacut® parts and if the product has been repaired improperly by the user or a third party.

Consumables are excluded in general from the warranty. In addition, Thermacut® is not liable for damage caused by using our products. Questions about warranty and service can be addressed to the manufacturer or our distributors. For more information, visit *www.thermacut.com*.

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www.thermacut.com.

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THE CUTTING COMPANY®

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