RAMS PLASMA MACHINE SETUP REQUIREMENTS

1. Inspection and Rigging- Prior to unloading the machine, thoroughly inspect for any damage, the machine comes skidded and wrapped in white shrink wrap if you accept the machine with any visible damage (punctures, rips, etc.) then you are assuming liability. All machines are shipped on a flatbed or on an enclosed trailer. It is the customer's responsibility to have the machine unloaded, rigged into position and leveled.

2. Training- Training will be conducted at the RAMS/Horizon facility. Two primary operators are recommended to arrive at training. RAMS will provide airfare for 2, hotel accommodations and lunch both days.

3. Grounding and Electrical- **Grounding is important**. A ½" copper grounding rod required, installation by an electrician is recommended, this will need to be installed prior to operation. Connect the ground rod to the table with at least an 8ga wire. Proper grounding is essential for proper machine operation to reduce the negative effects of radio frequency interference caused by the torch. **Must be within the specifications detailed above or the warranty will be VOID.**

An electrical disconnect near the left end of the table with slow blow fuses or a breaker is required. If you use a breaker use one that can handle the inrush current similar to an AC motor. A clean 110/120 outlet in the same area is required for the computer and motion control.

4. Air Requirements- you need to maintain at least 80 psi for the table to function properly. A 7.2 cfm 2 stage compressor with a 30 gal tank for just the table is required. The air must be clean, dry and oil free. Good quality air will increase the life of your consumables and the torch.

5. Exhaust Requirements- You need an exhaust fan of near 5,000 cfm 1" static pressure similar to Grainger 7HP74, or a roof exhaust style. A squirrel cage style will not work because it cannot handle the static pressure to exhaust the smoke. We provide a 110 v low amperage relay to excite your fan relay to turn on and off right from the computer program.

6. Internet Requirements- An internet connection would only be necessary if problems arise, this will allow RAMS and Shop Data to troubleshoot via the internet. If any problems arise with your SDS software contact Shop Data direct at (972)494-2719, anything else contact RAMS at (888) 326-6481.

*If the site requirements are not met then the standard rate of $1,250.00 a day plus travel and expenses will apply on the visit.

IF YOU AGREE TO THESE SET UP REQUIREMENTS, PLEASE SIGN AND DATE BELOW.

NAME: _____   Company: _____

Signature: _____   Date: _____