PCM-500i

PLASMA CUTTING
CONSOLE/POWER SOURCES

with CE Compliances
220 V, 50 Hz, 1-Phase
220 V, 50 Hz, 3-Phase
400 V, 50 Hz, 3-Phase

Service Manual
WARNING

ARC WELDING AND CUTTING CAN BE INJURIOUS TO YOURSELF AND OTHERS. TAKE PRECAUTIONS WHEN WELDING. ASK FOR YOUR EMPLOYER’S SAFETY PRACTICES WHICH SHOULD BE BASED ON MANUFACTURERS’ HAZARD DATA.

ELECTRIC SHOCK - Can kill
- Install and earth the welding unit in accordance with applicable standards.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from earth and the workpiece.
- Ensure your working stance is safe.

FUMES AND GASES - Can be dangerous to health
- Keep your head out of the fumes
- Use ventilation, extraction at the arc, or both, to keep fumes and gases from your breathing zone and the general area.

ARC RAYS - Can injure eyes and burn skin.
- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.

FIRE HAZARD
- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby.

NOISE - Excessive noise can damage hearing
- Protect your ears. Use ear defenders or other hearing protection
- Warn bystanders of the risk.

MALFUNCTION - Call for expert assistance in the event of malfunction.

READ AND UNDERSTAND THE INSTRUCTION MANUAL BEFORE INSTALLING OR OPERATING.

PROTECT YOURSELF AND OTHERS!

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CAUTION

Maintenance and Repair work should be performed by an experienced person, and electrical work only by a trained electrician. Do not permit untrained persons to inspect, clean, or repair equipment. Use only recommended replacement parts.

For installation and operation instructions, see 558000-879 (F-15-417).
### Table 1-1. PCM-500i Specifications

<table>
<thead>
<tr>
<th>Spec</th>
<th>40% Duty Cycle*</th>
<th>35 A @ 120 V dc</th>
</tr>
</thead>
<tbody>
<tr>
<td>Output Current Range</td>
<td>60% Duty Cycle*</td>
<td>30 A @ 120 V dc</td>
</tr>
<tr>
<td></td>
<td>100% Duty Cycle*</td>
<td>22 A @ 120 V dc</td>
</tr>
<tr>
<td>Open Circuit Voltage</td>
<td></td>
<td>265 V dc Nominal</td>
</tr>
<tr>
<td>Rated Primary Input @ 35 A @ 120 VDC Output</td>
<td>200 VAC, 1-Phase</td>
<td>30/25 A, 50/60 Hz</td>
</tr>
<tr>
<td></td>
<td>220 VAC, 3-Phase</td>
<td>14 A/Phase, 50/60 Hz</td>
</tr>
<tr>
<td></td>
<td>380/415 VAC, 3-Phase</td>
<td>8/7.5 A/Phase, 50/60 Hz</td>
</tr>
<tr>
<td>Power Factor @ 35 Amperes Output</td>
<td></td>
<td>81% (1-Phase)/94% (3-Phase)</td>
</tr>
<tr>
<td>Efficiency @ 35 Amperes Output</td>
<td></td>
<td>90% (Typical)</td>
</tr>
<tr>
<td>Current Capacity</td>
<td>PT-31XL</td>
<td>50 A DCSP</td>
</tr>
<tr>
<td>Air Requirements</td>
<td>PT-31XL</td>
<td>120l/min at 5.5 bar</td>
</tr>
<tr>
<td>Dimensions of PCM-500i</td>
<td></td>
<td>Length 490mm</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Height 452mm**</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Width 218mm</td>
</tr>
<tr>
<td>Weight (less torch, work cable)</td>
<td></td>
<td>23 kg</td>
</tr>
</tbody>
</table>

*Duty cycle is based on a 10-minute period; therefore, a 40% duty cycle means the machine may operate for 4 minutes with a cool down period of 6 minutes; a 60% duty cycle means the machine may operate for 6 minutes with a cool down period of 4 minutes; a 100% duty cycle means the machine may operate continuously.

**Includes 56 mm high handle.
2.1 GENERAL

CAUTION

If this equipment does not operate properly, stop work immediately and investigate the cause of the malfunction. Maintenance work must be performed by an experienced person, and electrical work by a trained electrician. Do not permit untrained persons to inspect, clean, or repair this equipment. Use only recommended replacement parts.

WARNING

Be sure that the wall disconnect switch or wall circuit breaker is open before attempting any inspection or work inside of the PCM-500i.

2.2 INSPECTION AND CLEANING

Frequent inspection and cleaning of the PCM-500i is recommended for safety and proper operation. Some suggestions for inspecting and cleaning are as follows:

A. Check work cable to workpiece connection.

B. Check safety earth ground at workpiece and at power source chassis.

C. Check heat shield on torch. It should be replaced if damaged.

D. Check the torch electrode and cutting nozzle for wear on a daily basis. Remove spatter or replace if necessary.

E. Make sure cable and hoses are not damaged or kinked.

F. Make sure all fittings and ground connections are tight.

CAUTION

Water or oil occasionally accumulates in compressed air lines. Be sure to direct the first blast of air away from the equipment to avoid damage to the PCM-500i.

H. With all input power disconnected, and wearing proper eye and face protection, blow out the inside of the PCM-500i using low-pressure dry compressed air.

2.3 FLOW SWITCH (FIGURE 2-1)

When excessive contamination is found in the air, the flow switch (FS) should be removed, disassembled and cleaned as follows:

A. Ensure the system is shut down and there is no trapped air under pressure in the piping.

B. Remove the piston plug.

C. Remove the spring (FS-4 only). Use care when handling spring to prevent distortion.

D. Remove the piston.

E. Clean all parts with cleaning agent.

NOTE

Ensure cleaning agent does not contain solvents which can degrade polysulfone. Warm water and detergent is recommended for cleaning. Allow all parts to dry thoroughly before reassembly.

Reassemble the flow switch in reverse order.

Figure 2-1. Disassembly / Assembly of Flow Switch
3.1 TROUBLESHOOTING

**WARNING**

ELECTRIC SHOCK CAN KILL! Be sure that all primary power to the machine has been externally disconnected. Open the line (wall) disconnect switch or circuit breaker before attempting inspection or work inside of the power source.

Check the problem against the symptoms in the following troubleshooting guide. The remedy may be quite simple. If the cause cannot be quickly located, shut off the input power, open up the unit, and perform a simple visual inspection of all the components and wiring. Check for secure terminal connections, loose or burned wiring or components, bulged or leaking capacitors, or any other sign of damage or discoloration.

The cause of control malfunctions can be found by referring to the sequence of operations and electrical schematic diagram (Figure 3-1) and checking the various components. A volt-ohmmeter will be necessary for some of these checks.

**WARNING**

Voltages in plasma cutting equipment are high enough to cause serious injury or possibly death. Be particularly careful around equipment when the covers are removed.

**NOTE**

Before checking voltages in the circuit, disconnect the power from the high frequency generator to avoid damaging your voltmeter.

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3.2 TROUBLESHOOTING GUIDE

**A. Difficult Starting.**
- Change electrode
- Change nozzle
- Check for good, clean connection of work lead to workpiece
- Check air pressure (4.5 - 5.2 bar)
- Check torch power cable for continuity

<table>
<thead>
<tr>
<th>Depress torch switch. After 2 seconds, is there a pilot arc?</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Yes</strong></td>
</tr>
<tr>
<td>Repair power source</td>
</tr>
<tr>
<td><strong>No</strong></td>
</tr>
<tr>
<td>Repair/replace high frequency unit</td>
</tr>
</tbody>
</table>
B. No Air

Is air hose connected?
Yes

Is air adjusted to 4.5 - 5.2 bar?
Yes

Does air come on with air check switch?
Yes

Check continuity of torch switch
OK

 Repair power source

No

Connect

Adjust

• No electrode in torch
• No valve pin in torch
• Replace electrode
• Replace valve pin

Replace torch switch
C. Air does not shut off

Is air check switch OFF?

Yes  No

Turn switch OFF

Does arc start when nozzle contacts work without depressing torch switch?

Yes  No

Check for short in torch switch

Does air flow even when PCM-500i power switch is OFF?

Yes  No

Replace solenoid valve  Repair power source
D. White "Power" light not energized.

- Is main 220 or 400 volt switch ON?
  - Yes
  - No → Turn on main disconnect
- Is plug in receptacle?
  - Yes
  - No → Insert plug in receptacle
- Is cooling fan turning?
  - Yes
  - No → Replace pilot light
  - Replace pilot light
- Check voltage at receptacle and input power line
  - Yes
  - No → Check main fuses
  - Faulty power switch on PCM-500i
E. Amber "FAULT" light ON.

- Fault light will energize if input voltage goes below or above ±15% of units input rating. The light will not turn OFF even when correct voltage is restored. Reset by placing PCM-500i power switch OFF and then ON again.

NOTE: When in LOCK-IN mode, the FAULT light will turn on during second "trigger". This does not affect performance. Turn off.
3.3 SEQUENCE OF OPERATION

A. LOCK-IN "OFF" position

NOTES:

1. When the torch switch is pushed during postflow period, the postflow and preflow times are canceled, and the HF is energized immediately.

2. When the amber fault pilot light comes on, cutting operation should be stopped. The postflow time starts from the moment the torch switch is released.
NOTES:

1. When the torch switch is pushed during postflow period, the postflow and preflow times are canceled, and the HF is energized immediately.

2. When the amber fault pilot light comes on, cutting operation should be stopped. The postflow time starts from the moment the torch switch is released.

3. FAULT pilot light is on during second "turn-off" trigger only. This does not affect performance in any way.
Figure 3-1. Schematic Diagram PCM-500i, 220 Vac, 50/60 Hz, 1-Phase
Figure 3-2. Wiring Diagram - PCM-500i 220 Vac, 50/60 Hz, 1-Phase (Sheet 1 of 2)
Figure 3-2. Wiring Diagram - PCM-500i 220 Vac, 50/60 Hz, 1-Phase (Sheet 2 of 2)
Figure 3-3. Schematic Diagram - PCM-500i 220 Vac, 50/60 Hz, 3-Phase
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Figure 3-6. Wiring Diagram - PCM-500i 380/415 Vac, 50/60 Hz, 3-Phase (Sheet 1 of 2)
Figure 3-6. Wiring Diagram - PCM-500i 380/415 Vac, 50/60 Hz, 3-Phase (Sheet 2 of 2)
4.1 GENERAL

Replacement Parts are illustrated on the following figures. When ordering replacement parts, order by part number and part name, as illustrated on the figure.

Always provide the series or serial number of the unit on which the parts will be used. The serial number is stamped on the unit nameplate.

4.2 ORDERING

To assure proper operation, it is recommended that only genuine ESAB parts and products be used with this equipment. The use of non-ESAB parts may void your warranty.
### Figure 4-1. Front View, PCM-500i

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>QTY.</th>
<th>PART No.</th>
<th>DESCRIPTION</th>
<th>CIRCUIT SYMBOL</th>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>558000590</td>
<td>CHASSIS</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>558000372</td>
<td>POTENTIOMETER 10K 2W</td>
<td>R1</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>558000373</td>
<td>KNOB</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>558000591</td>
<td>COVER TOP</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>558000562</td>
<td>WARNING LABEL</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>1</td>
<td>558000592</td>
<td>HANDLE (Screws and Lockwashers included)</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>558000385</td>
<td>SWITCH TOGGLE DPDT 2POS 15A</td>
<td>S1</td>
</tr>
<tr>
<td>8</td>
<td>1</td>
<td>558000384</td>
<td>LAMP, WHITE</td>
<td>PL2</td>
</tr>
<tr>
<td>9</td>
<td>1</td>
<td>558000383</td>
<td>LAMP, YELLOW</td>
<td>PL1</td>
</tr>
<tr>
<td>10</td>
<td>2</td>
<td>558000593</td>
<td>GROMMET 1.5&quot; ID</td>
<td></td>
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<tr>
<td>11</td>
<td>1</td>
<td>558000594</td>
<td>GAUGE PRESSURE</td>
<td></td>
</tr>
<tr>
<td>12</td>
<td>1</td>
<td>558000698</td>
<td>SWITCH TOGGLE SPST 2 POS 15A</td>
<td>S2</td>
</tr>
<tr>
<td>13</td>
<td>1</td>
<td>558000178</td>
<td>STRAIN RELIEF</td>
<td></td>
</tr>
<tr>
<td>14</td>
<td>2</td>
<td>558000596</td>
<td>SWITCH SEAL</td>
<td></td>
</tr>
<tr>
<td>15</td>
<td>4</td>
<td>558000552</td>
<td>FOOT</td>
<td></td>
</tr>
<tr>
<td>16</td>
<td>1</td>
<td>558000597</td>
<td>ACCESS DOOR</td>
<td></td>
</tr>
<tr>
<td>17</td>
<td>1</td>
<td>558000536</td>
<td>WARNING LABEL</td>
<td></td>
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<td>18</td>
<td>2</td>
<td>558000132</td>
<td>LABEL</td>
<td></td>
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<tr>
<td>19</td>
<td>1</td>
<td>558000599</td>
<td>WARNING LABEL, HI-VOLTAGE</td>
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</tr>
</tbody>
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Figure 4-2. Right Side View, PCM-500i

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>QTY.</th>
<th>PART NO.</th>
<th>DESCRIPTION</th>
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<tbody>
<tr>
<td>31</td>
<td>1</td>
<td>558000467</td>
<td>HI VOLTAGE TRANSFORMER</td>
<td>T5</td>
</tr>
<tr>
<td>32</td>
<td>1</td>
<td>558000600</td>
<td>TERMINAL BLOCK 2 POS</td>
<td>TB1</td>
</tr>
<tr>
<td>33</td>
<td>1</td>
<td>558000601</td>
<td>CAPACITOR 0.1µf 250 VAC</td>
<td>C9</td>
</tr>
<tr>
<td>34</td>
<td>2</td>
<td>558000602</td>
<td>CAPACITOR 0.01µf 1 KV</td>
<td>C11, C12</td>
</tr>
<tr>
<td>35</td>
<td>2</td>
<td>558000603</td>
<td>SNAP BUSHING</td>
<td></td>
</tr>
<tr>
<td>36</td>
<td>1</td>
<td>558000604</td>
<td>CONTROL TRANSFORMER</td>
<td>T2</td>
</tr>
<tr>
<td>37</td>
<td>1</td>
<td>55800388</td>
<td>FAN AC AXIAL</td>
<td>M1</td>
</tr>
<tr>
<td>38</td>
<td>1</td>
<td>55800605</td>
<td>AIR LINE FILTER REGULATOR</td>
<td></td>
</tr>
<tr>
<td>39</td>
<td>1</td>
<td>55800606</td>
<td>INDUCTOR POWER FACTOR CORRECTION</td>
<td>L2</td>
</tr>
<tr>
<td>40</td>
<td>1</td>
<td>55800584</td>
<td>GROMMET .63&quot; ID</td>
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<tr>
<td>41</td>
<td>1</td>
<td>55800607</td>
<td>MAIN TRANSFORMER</td>
<td>T1</td>
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<td>42</td>
<td>1</td>
<td>55800406</td>
<td>INDUCTOR OUTPUT</td>
<td>L1</td>
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<td>43</td>
<td>1</td>
<td>55800608</td>
<td>WORK CABLE 25 FT includes CLAMP 13730862</td>
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<tr>
<td>44</td>
<td>1</td>
<td>55800380</td>
<td>RECEPTACLE, TWIST LOCK MIDGET</td>
<td>J1</td>
</tr>
<tr>
<td>45</td>
<td>1</td>
<td>55800609</td>
<td>OUTPUT TERMINAL BOARD</td>
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<tr>
<td>46</td>
<td>1</td>
<td>55800523</td>
<td>ADAPTOR B/A 1/4 NPTM BULKHEAD</td>
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<tr>
<td>47</td>
<td>1</td>
<td>55800403</td>
<td>REACTOR HI FREQ</td>
<td>T3</td>
</tr>
<tr>
<td>48</td>
<td>1</td>
<td>55800610</td>
<td>SPARK GAP ASS'Y includes (2) POINT 32931</td>
<td>SG</td>
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<tr>
<td>49</td>
<td>1</td>
<td>55800517</td>
<td>STANDOFF</td>
<td>TB2</td>
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<tr>
<td>50</td>
<td>2</td>
<td>55800611</td>
<td>CAPACITOR 2500µf 15 KV</td>
<td></td>
</tr>
<tr>
<td>51</td>
<td>1</td>
<td>55800612</td>
<td>3%, 3-PH LINE REACTOR, 8A/PH (400 V)</td>
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<tr>
<td>52</td>
<td>1</td>
<td>55800613</td>
<td>1.5%, 3-PH LINE REACTOR, 12A/PH (220 V/3 PH)</td>
<td></td>
</tr>
<tr>
<td>52*</td>
<td>1</td>
<td>55800521</td>
<td>CAPACITOR 0.047µf, 660 V</td>
<td>C23</td>
</tr>
</tbody>
</table>

* Not shown. See Wiring Diagram for location.
220 V, 1 Phase Power Source illustrated.
### REPLACEMENT PARTS

#### ITEM NO. | QTY. REQ. | PART NO. | DESCRIPTION | CIRCUIT SYMBOL
---|---|---|---|---
61 | 5 | 558000405 | CAPACITOR 0.01µF 1KV | C5, 6, 7, 8, 10
63 | 2 | 558000614 | SNAP BUSHING |  
64 | 1 | 558000615 | HEATSINK |  
65 | 2 | 558000616 | GROMMET 2.12" ID |  
66 | 2 | 558000617 | CAPACITOR 1000µF 400 VDC | C1, C2
67 | 4 | 558000618 | RESISTOR 50K 12W (220 V) | R2
   | 2 | 558000578 | RESISTOR 10K 20W (400 V) | R2, R15
68 | 2 | 558000619 | IGBT 50 A 600 V (PAD 951190) (220 V) | Q1, Q2
   | 1 | 558000620 | DUAL MODULE IGBT 75 A 1200 V (includes PAD 951190) (400 V) | Q1
69 | 2 | 558000621 | PC BOARD IGBT DRIVER (220 V) | PCB2, PCB3
   | 1 | 558000622 | PC BOARD IGBT DRIVER (400 V) | PCB3
70 | 2 | 558000623 | BUSBAR (230 V) |  
   | 1 | 558000624 | BUSBAR (400 V) |  
71 | 2 | 558000625 | CAPACITOR 1µF 600 VDC (220 V) | C15, C16
   | 1 | 558000626 | CAPACITOR 0.5µF 1200 VDC (400 V) | C22
72 | 1 | 558000627 | CAPACITOR 1µF 630 VDC (220 V) | C3
   | 2 | 558000628 | CAPACITOR 1µF 630 VDC (400 V) | C3, C15
73 | 1 | 558000629 | THERMAL SWITCH D/T 176 15 A 120 V | TS1
74 | 1 | 558000630 | CAPACITOR 0.22µF 1KV | C19
75 | 1 | 558000631 | MODULE INPUT BRIDGE 50 A (includes PAD 951191) | IBR
76 | 2 | 558000632 | RESISTOR 50 W 10 OHM (PAD 951194) | R7, R10
77 | 1 | 558000633 | CURRENT TRANSFORMER | T4
78 | 1 | 558000634 | CAPACITOR 20µF 400 VDC | C4
79 | 1 | 558000635 | RESISTOR 39 K 2 W | R9
80 | 1 | 558000636 | FLOW SWITCH 0.25 GPM SPST | FS
81 | 4 | 558000637 | RESISTOR 20 OHM 25 W (PAD 951193) | R3, 4, 5, 6
82 | 1 | 558000638 | SOLENOID VALVE 1/4 NPT 24 VAC | SOL1
83 | 1 | 558000639 | ZENER DIODE 60 V 75 mA | ZD1
84 | 1 | 558000640 | OUTPUT BRIDGE MODULE (includes PAD 951192) | D1
85 | 1 | 558000641 | PC BOARD ASSY'S START UP (hidden) | PCB5
86 | 1 | 558000642 | TERMINAL LUG GROUND (hidden) | GND1
87 | 1 | 558000643 | EMI FILTER | FN1
88 | 3 | 558000644 | VARISTOR METAL OXIDE 510 (400 V) | MOV 1, 2, 3

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**Figure 4-3. Left Side View, PCM-500i**
## Figure 4-4. Top and Rear View, PCM-500i

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>QTY. REQ.</th>
<th>PART NO.</th>
<th>DESCRIPTION</th>
<th>CIRCUIT SYMBOL</th>
</tr>
</thead>
<tbody>
<tr>
<td>101</td>
<td>2</td>
<td>5580000584</td>
<td>GROMMET 0.63 ID</td>
<td></td>
</tr>
<tr>
<td>102</td>
<td>2</td>
<td>5580000585</td>
<td>CAPACITOR 0.22µF 250 VAC</td>
<td>C17, C18</td>
</tr>
<tr>
<td>103</td>
<td>1</td>
<td>5580000396</td>
<td>PC BOARD SHUNT</td>
<td>PCB4</td>
</tr>
<tr>
<td>104</td>
<td>1</td>
<td>5580000586</td>
<td>PC BOARD ASS’Y CONTROL (220 V)</td>
<td>PCB1</td>
</tr>
<tr>
<td>104</td>
<td>1</td>
<td>5580000587</td>
<td>PC BOARD ASS’Y CONTROL (400 V)</td>
<td>PCB1</td>
</tr>
<tr>
<td>107</td>
<td>1</td>
<td>5580000534</td>
<td>ADAPTOR, AIR-WATER</td>
<td></td>
</tr>
<tr>
<td>110</td>
<td>1</td>
<td>5580000588</td>
<td>CIRCUIT BREAKER 40 A (220 V, 1 ph)</td>
<td>CB1</td>
</tr>
<tr>
<td></td>
<td>1</td>
<td>5580000589</td>
<td>CIRCUIT BREAKER 20 A (3 PH)</td>
<td>CB1</td>
</tr>
<tr>
<td>113</td>
<td>1</td>
<td>5580000686</td>
<td>FUSE 3A 600VAC FAST ACTING</td>
<td>F1</td>
</tr>
<tr>
<td>115</td>
<td>1</td>
<td>5580000537</td>
<td>STRAIN RELIEF</td>
<td></td>
</tr>
<tr>
<td>116</td>
<td>1</td>
<td>5580000620</td>
<td>CABLE INPUT POWER, 10 FT</td>
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<td>117</td>
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