

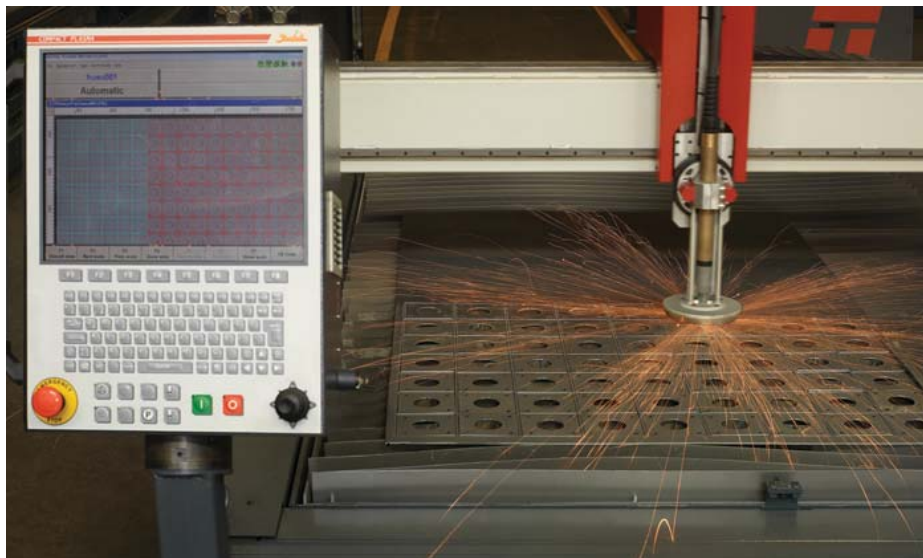
BPH Compact Plazma Kesim Sistemi

Compact Plasma Cutting System



Havalandırmacı ve hafif kesimler için küçük ama dayanıklı plazma makinesi. Havalandırmacı (HVAC) işleri ve diğer sac işleri için ideal yüksek raylı makine tasarımı. Ekstra güçlü ve hassas dizayn özellikleri sayesinde 40 mm'e kadar high definition plazma ile donatılabilme seçeneği.

The tough little machine for ducting and light cutting. A high rail machine ideal for HVAC ducting work and other light sheet work but built with extra strength and precision so it can be upgraded to high definition plasma cutting for material up to 40 mm.



GENEL ÖZELLİKLER / DESIGN AND OPERATING FEATURES

Basit kullanım

Baykal compact plazmaya takılan çok basit kontrol sayesinde yeni kullanıcılar dahi dakikalar içinde eğitilebilirler.

Kolay programlama

Makine ile birlikte teklif edilen Lantek programlama opsiyonları sayesinde en karmaşık duct parçalarının açılımı saniyeler içerisinde yapılabilir ve derhal kesim için makineye yüklenebilir veya diğer kesimlerle birleştirilebilir.

Dayanıklı yapı

Her iki taraftaki lineer kızaklar ile birlikte, işlenmiş köprü ve gövde özelliğiyle bu makine uzun ve yoğun çalışmaya uygun imal edilmiştir. Yekpare dizaynından dolayı herhangi bir karmaşık kurulumu ihtiyaç yoktur. Değişen iş yüküne göre gerektiği takdirde atölye içerisinde istenilen yere olduğu gibi taşınabilir.

Simple operation

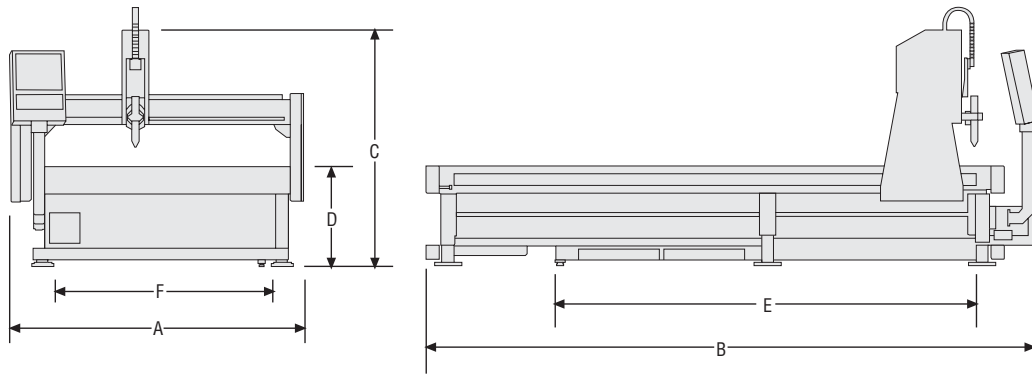
The Baykal compact is fitted with a very simple control so that new or occasional users can be trained in minutes.

Easy programming

Offered with a range of programming tools from Lantek the most complicated sheet-metal developments of ducting components hoods etc. can be produced in seconds and downloaded to the machine for immediate cutting or combined.

Rugged structure

Featuring a fully machined gantry and base with linear bearings on both longitudinal rails this machine is built to work hard and long. Because of its unitary design there is no need for a complicated installation and if necessary the machine can be readily moved around the workshop to suit changing workloads.



TEKNİK ÖZELLİKLER / TECHNICAL DATA

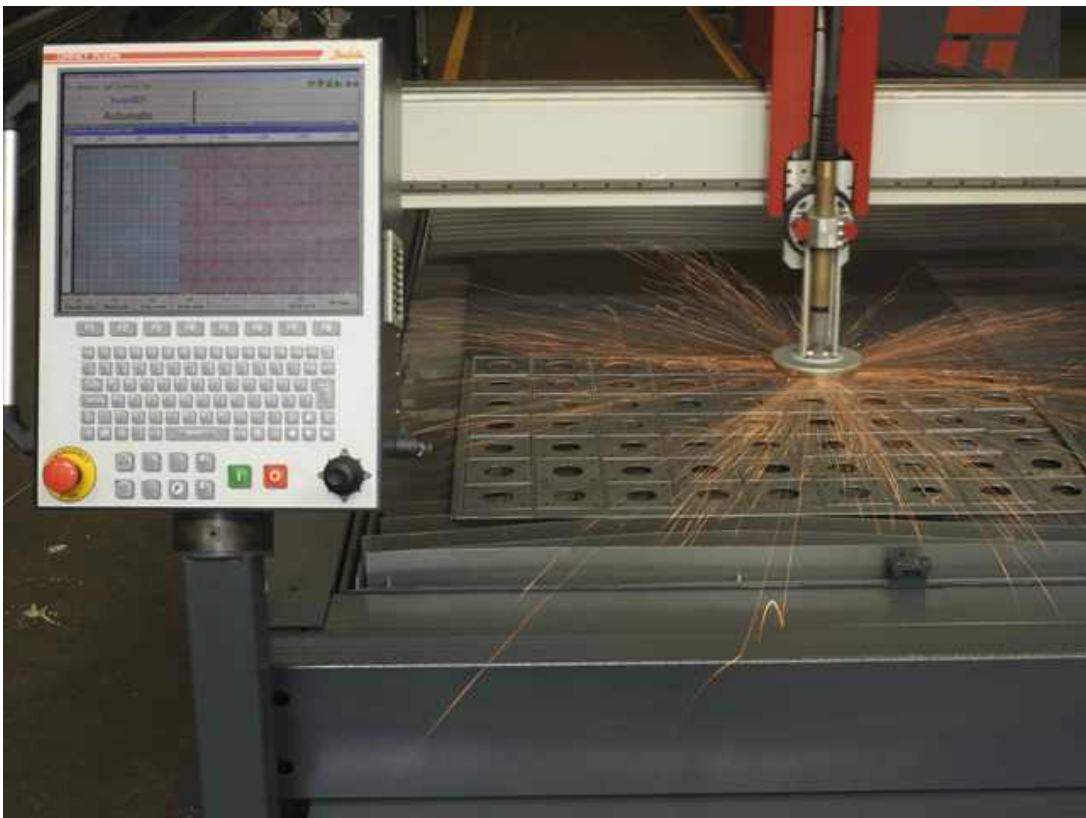
TİPLER TYPES	Makine Genişliği Machine Width (A) (mm)	Makine Uzunluğu Machine Length (B) (mm)	Makine Yüksekliği Machine Height (C) (mm)	Tabla Yüksekliği Table Height (D) (mm)	Kesim Genişliği Machine Cutting Width (E) (mm)	Kesim Uzunluğu Machine Cutting Length (F) (mm)	Makine Ağırlığı Machine Weight (kg)
BPH-Compact 1503	2140	4450	1750	750	3110	1600	2200

Dizayn ve teknik özellikler önceden haber vermeden değiştirilebilir. / Design and specifications are subject to change without notice.

CNC PLASMA CUTTING MACHINE COMPACT BPH1503

TECHNICAL FEATURES :

- 1500x3000 mm cutting table.
- High performance and high rigid machine frame.
- Hypertherm Powermax1000 air plasma supply unit (made in the USA)
- Sectional cutting table with automatic fume extraction system.
- X and Y axis travel with ball screws on dual linear guides.
- Fast and accurate positioning with AC brushless servo motors.
- Dual rack rail and pinion drive for Y axis.
- Axis positioning speed: 15 m/min.
- Torch height adjustment according to plate surface.
- Mechanical Torch safety system against crashing on working table or plate
- BAYKAL industrial Computer and TECNOS Controller.
- Nesting software: Lantek Expert II Cut Plus automatic and manual nesting-machining with great flexibility and maximum performance.
- One set of FREE consumables parts kits (without torch)
- (OPTIONAL) Air filtration unit for dust and fume collection.



OPTION OF PLASMA SUPPLY UNITS:

HYPERTHERM Powermax1000 AIR PLASMA UNIT

Type	Hypertherm Powermax1000 Performance Plasma
Cutting thicknesses	: 0.5 – 19 mm
Input voltage	: 230 V, 400 V,
Frequency	: 50 – 60 Hz
Input current	: 230 V – 26 A 400 V – 15 A
Output current	: (Selectable) 25,40,60 A
Maximum output voltage	: 140 VDC
Duty cycle rating	: 60 A de % 50
Dimensions	: 586 x 267 x 495 mm (length x width x height)
Weight	: 34.5 kg
Plasma Gas types	: Air Nitrogen (N2)
Plasma gas flow rates	: Air 189 l/min and 6.1 bar Nitrogen (N2) 189 l/min and 6.1 bar

HYPERTHERM HSD 130 PLASMA UNIT

Cutting thickness	: 0.5 – 32 mm
Supply voltage	: 220 V, 380 V, 480 V
Frequency	: 50 – 60 Hz
Supply current	: 220 V – 56 A 380 V – 33 A 480 V – 26 A
Output current	: (Adjustable) 45,50,130 A
Output voltage	: 311 VDC
Duty cycle rate	: 100% at 130 A
Outer dimensions	: 570 x 1120 x 1070 mm (L x W x H)
Weight	: 286 kg
Plasma gasses	: Oxygen Air Argon / hydrogen (H35) and Nitrogen Nitrogen
Shield gasses	: Air Nitrogen
Plasma gasses flowrate	: Air 8500 lt/h Oxygen 4250 lt/h Nitrogen 8500 lt/h Argon/Hydrogen (H35) 4250 lt/h

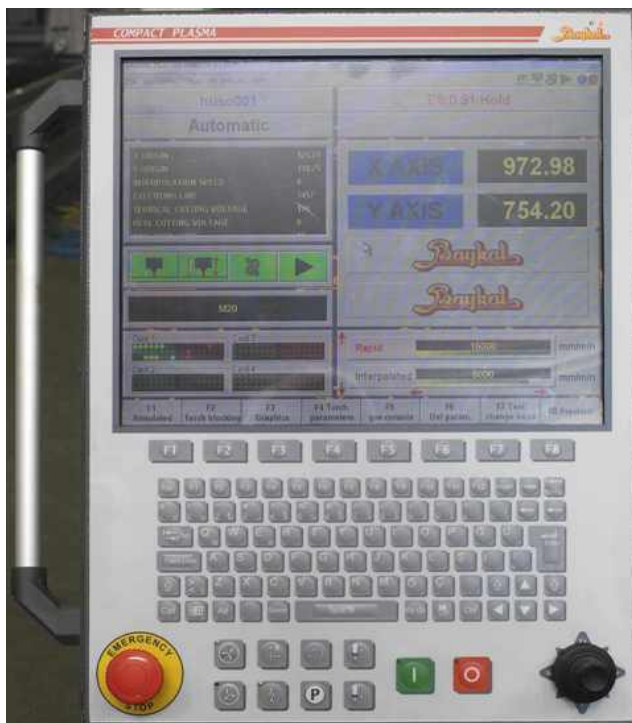
HYPERTHERM HPR 130 PLASMA UNIT

Type	: Hypertherm HPR130 HyDefinition plasma
Cutting thickness	: High-definition cutting capacity 16 mm mild-steel & stainless-steel Maximum pierce capacity 25 mm mild-steel 20 mm stainless-steel Maximum cutting capacity (edge start) 38 mm mild-steel 25 mm stainless-steel
Input voltage	: 200V , 400V , 480V , 600V
Frequency	: 50-60 Hz
Input current	: at 220 V – 38,5 A at 380 V – 22,2 A at 415 V – 20,4 A
Output current	: 130 A
Output voltage	: 50 – 150 VDC
Duty cycle rating	: 100 %
Outside dimensions	: (LxWxH) 566x1080x968 mm
Weight	: 317 kg
Plasma gas	: Oxygen Nitrogen Air 65% Argon – 35% Hydrogen (H35) 95% Nitrogen – 5% Hydrogen (F5)
Shield gas	: Oxygen Nitrogen Air

For plasma gas flow rates and other specification, please see Hypertherm brochure attached.

BAYKAL-TECNOS CNC CONTROL UNIT

- CE confirmed.
- Epcia M10000 1 GHz processor based industrial PC.
- Windows XP operating system.
- ISO user language.
- 17" TFT matrix color monitor.
- Keyboard with IP64 protection against water and chemicals.
- Ethernet board or modem plugging possibility.
- ISO programming language.
- Keyboard protected against chemicals and humidity : IP64
- Programming by office PC via Ethernet communication cable or stick memory.



SOFTWARE PACKAGE - LANTEK EXPERT II CAD SOFTWARE :

FEATURES :

- Powerful database structure and file system
- Multiple users in the same database with computers sharing the same network
- Easy switching between databases
- Smart importer and exporter (e.g. for DXF , DWG , IGES, etc.)
- Program structure with modules such as CAD, material, sheetplate, language, configuration, and operation center
- Large library of parametric parts and easy drawing with parametric shapes
- “A” class, functional drawing interface
- Full control of cutting process with the following options :

Nesting options

Machining options

Lead-in / lead-out options

Remnant plate and saving options

- Manual, semi-automatic and full-automatic nesting and machining options
- Complete control over machine with kerf, plate and cutting simulations
- Auxiliary functions such as part test, dimensions etc.
- Multi-torch connection support
- Common cutting options
- Accurate computation of cutting time and cutting cost

- Printing copy for machine operator
- Custom settings on user interface
- **Supported languages** : English, Spanish , French, German, Italian, Swedish, Portugese, Polish, Dutch, Korean, Japanese, Chinese
- **Supported operating systems** : Win2K®, Windows XP®, NT4.0® and upper version service packs

AVAILABLE SOFTWARE OPTIONS :

- **Tube cutting (Duct):** A powerful module for calculating HVAC and DUCT figures in which users simply select and enter the dimensions. Thus the figure will be automatically developed, ready for machining.
- **Expert III:** A system that provides integrated management of the whole production process in sheet metal manufacturing environments.

BPH 1503 SIMPLE CNC PLASMA FOR DUCT APPLICATIONS

(Including automatic nesting program for ducting)

- **Hypertherm Powermax 1000 Plasma Unit**

Technical Specifications :

- 1500x3000 mm cutting table.
- High performance and rigid machine frame.
- Sectional cutting table with automatic fume extraction system.
- X and Y axis travel with ball screws on dual linear guides.
- Fast and accurate positioning with AC brushless servo motors.
- Dual rack rail and pinion drive for Y axis.
- Axis positioning speed: 15 m/min.
- Torch with pneumatic down and up movement
- Torch height adjustment through balls according to plate surface.
- TN 18 Simple CNC control unit.
- Nesting software: Lantek Duct plus automatic and manual nesting-machining with great flexibility and maximum performance

TN18 CNC CONTROL UNIT

- CE confirmed
- 7" mono-color simple LCD screen
- Control board with Motorola M68K CPU
- Battery backed memory- 120 K RAM
- ISO programming language
- Keyboard protected against chemicals and humidity : IP64
- Programming by office PC via serial communication cable

NESTING SOFTWARE (LANTEK DUCT PLUS)

HYPERTHERM POWERMAX1000 PLASMA UNIT

Cutting thicknesses	: 0.5 – 19 mm
Input voltage	: 230 V, 400 V,
Frequency	: 50 – 60 Hz
Input current	: 230 V – 26 A 400 V – 15 A
Output current	: (Selectable) 25,40,60 A
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Hypertherm[®]

powermax1000[®] G3 SERIES[™]

The performance standard for air plasma cutting



3/4"
(19 mm)

Recommended capacity

1"
(25 mm)

Maximum capacity

1 1/4"
(32 mm)

Severance capacity

powermax1000[®] **G3 SERIES™**

The third generation of plasma cutting has a second great product!

The benefits of Hypertherm technology –

- **Superior speed and cutting capacity**
- **Longer parts life**
- **Lower operating cost**
- **Higher-quality cuts**
- **Safety**
- **Reliability**
- **Ease of use**

– in a robust, portable cutting system.



Hypertherm – the world leader in plasma cutting technology

When you do only one thing, you'd better do it better than anyone else. As the only major manufacturer to focus exclusively on plasma cutting technology, Hypertherm is committed to providing the highest quality systems in the world: improving the performance, reliability and value of our systems, and serving and supporting Hypertherm users. This commitment to technology leadership, quality and support makes Hypertherm the first choice of the true cutting professional.

Superior performance by hand or machine

The Powermax1000 is the latest addition to the Powermax G3 Series. With advanced technologies in both power supply and torch,



Hypertherm G3 products cut faster and more economically than any system available today. The Powermax1000's Auto-voltage™ circuit provides automatic adjustment to any input voltage from 200 to 600 volts, 1- or 3-phase (CE 230 to 400 V 3-phase only). A state-of-the-art, microprocessor-based architecture assures optimum system reliability. Add to this Hypertherm's advanced torch technology and easy-to-read controls, and you have the most advanced plasma cutter money can buy.

- **Recommended capacity:** metals to ¾ inch (19 mm) at cutting speeds of 22 inches (559 mm) per minute.
- **Maximum capacity:** metals to 1 inch (25 mm) at cutting speeds of 12 inches (304 mm) per minute.
- **Severance capacity:** rough cut on metals up to 1 ¼ inches (32 mm) at low speed.

The cut capacities above are on mild steel. Some metals, such as aluminum and stainless steel, may require up to 20% reduction in cut speed and capacity.

Machine torch operation

- **Recommended capacity:** Up to ¾ inch (10 mm).
- **Maximum capacity:** Up to ½ inch (12 mm).
Cutting above requires an edge start.

The power supply: the heart of the machine

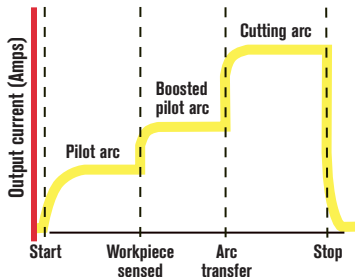
Advanced, intelligent technology gives the Powermax1000 the power to cut with greater speed, quality and efficiency.

- 60-amp, 8.4-kilowatt output provides ample power for clean, quick cutting.
- Auto-voltage runs on voltages from 200 to 600 volts, 1- or 3-phase, (CE 230 to 400 V 3-phase only) without the need for manual rewiring.
- New Boost Conditioner™ circuit compensates for input voltage variation.
- Advanced, digitally-controlled inverter design delivers continuously adjustable, constant current output from 20 to 60 amps, permitting high-quality cuts over a wide range of metal thicknesses.
- An active electronic pilot arc controller for cutting expanded metal or grating.
- New gouging setting for easier operation and faster metal removal.
- CNC/robotic machine interface is standard on all units, allowing automated control and rapid changeover to mechanized operation.

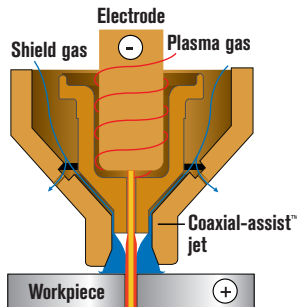
The torch: intelligent design combines performance, durability, comfort and safety

The Powermax1000 features Hypertherm's patented T60 safety trigger torch and T60M mechanized torch, which deliver outstanding cut performance, reliability and operator comfort.

- The longest consumable life in the industry, and we'll prove it. Patented HyLife® electrodes last longer than ordinary designs.
- Patented Dual-threshold™ pilot circuit significantly reduces nozzle wear by boosting pilot current precisely when needed.



- Patented nozzle shield lets you drag the torch on the workpiece at full output, without damaging consumables, and protects the nozzle from molten metal spray and double arcing.
- Postflow cooling reduces torch stress.
- Hypertherm's patented Coaxial-assist™ jet design boosts cutting speed as much as 20% over conventional designs.



- Hypertherm's ETR™ (Easy Torch Removal) system allows for easy switching between manual and mechanized torches. It also features a strain relief designed for durability.
- Hypertherm's patented safety trigger protects against accidental starts. Interlocks deactivate the torch when the consumable parts are removed, using a durable mechanical contact.



- No breakable ceramic parts.
- Patented "blow-back" technology provides a pilot arc without excessive high-frequency interference.
- Consumables for gouging, extended-nozzle cutting, pipe saddle cutting and other applications.

Engineered for superior reliability

The Powermax1000 is designed for heavy use under the harshest conditions.

- Mechanical and electrical designs are validated through aggressive, accelerated testing.
- New fan-on-demand feature minimizes dust ingestion.
- Chemically cross-linked torch cable jacket provides improved resistance to molten spray and cut-through.
- CSA/NRTL and CE certifications comply with the highest safety standards.
- IP23CS compliance for resistance to water damage.
- The Powermax1000 is backed by a full three-year power supply warranty and a one-year torch warranty. No parts excluded. Examine competitive policies closely.

Options for specialized requirements

FINECUT™ CONSUMABLES for superior cut quality on thin plate, mild and stainless steel.

CIRCLE CUTTING GUIDE

LEATHER CABLE COVERS for torch leads.

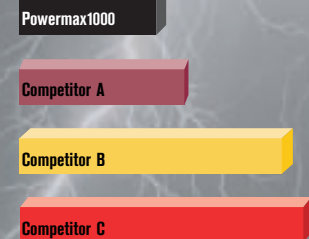
AIR FILTRATION KIT with a .85 micron filter and auto-drain filter bowl.

WHEEL KIT for easy mobility.

HEAT SHIELD protects hands from excessive reflective heat.



Relative cutting cost, Powermax1000 vs. competitors
1/2" (12 mm) mild steel



Operating cost calculations are based on consumable price, tested consumable life, tested cutting speed, estimated labor and power costs. Competitive units are in the 50 - 60 amp cutting range.

powermax1000[®] G3 SERIES[™]

High-performance portable plasma cutting system

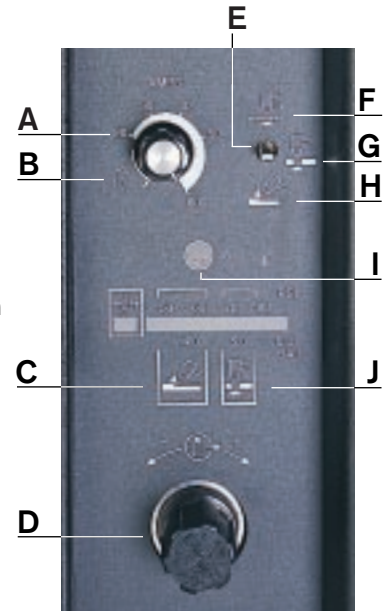
Powermax1000 G3 Series standard system components

- Power supply
- T60 or T60M torch
- Spare consumables
- Work cable with clamp
15 feet (4.5 m)
- Primary power cable

Options - (Part number)

- Circle cutting guide - 027668
- Wheel kit - 128646
- Leather cable covers - 024548
- Air filtration kit - 128647
- Extended work cable - 128717
- Hand heat shield - 128658

- A: Cutting-current output control, 20 – 60 amps
- B: Gas test/set position
- C: Air pressure range, gouging mode
- D: Air pressure adjust control knob
- E: Cutting mode selector switch
- F: Pilot arc control mode
- G: Normal cutting mode
- H: Gouging mode
- I: Power on indicator
- J: Air pressure range, cutting mode



Ordering information

	Systems part numbers		
	With 25' (7.5 m) torch	With 50' (15 m) torch	With 75' (23 m) torch
200 – 600 V, 1/3-PH, CSA			
Hand system	083178	083179	083210
Machine system	083182	083183	083212
230 – 400 V, 3-PH, CE			
Hand system	083192	083193	083211
Machine system	083194	083195	083213

Specifications



Input voltages	200 – 600 V, 1/3-PH, 50 - 60 Hz, CSA 230 – 400 V, 3-PH, 50 - 60 Hz, CE
Input current @ 8.4 kW	200/208/230/240/480 V, 1-PH: 50/48/44/42/22 A 200/208/230/240/400/480/600 V, 3-PH: 30/29/26/24/15/12/11 A
Output voltage	140 VDC
Duty cycle @ 40° C (104° F)	50% @ 60 A, 230 – 600 V, 3-PH 50% @ 60 A, 230 – 480 V, 1-PH 40% @ 60 A, 200 – 208 V, 3-PH 40% @ 60 A, 200 – 208 V, 1-PH
Maximum OCV	300 VDC
Dimensions	23.1" (586 mm) D; 10.7" (271 mm) W; 19.6" (498 mm) H
Weight with torch	83 lbs (37 kg)
Gas supply	Clean, dry, oil-free air or nitrogen
Flow rate	400 scfh; 6.7 cfm (189 l/min) at 90 psi (6.2 bar)
Flow pressure	70 psi (4.8 bar) flowing, 25' leads 75 psi (5.1 bar) flowing, 50' leads

Operating data

	Hand torch	Machine torch
Recommended capacity	3/4" (19 mm)	3/8" (10 mm)
Maximum capacity	1" (25 mm)	1/2" (12 mm)
Severance capacity	1 1/4" (32 mm)	–

Material	Thickness		Current (amps)	Maximum travel speed*	
	(inches)	(mm)		(ipm)	(mm/min.)
Mild steel	26 GA.	0.5	25	638	16205
	10 GA.	3.4	40	151	3835
	1/4	6.4	60	132	3353
	3/8	10	60	63	1600
	1/2	12	60	42	1067
	5/8	16	60	31	787
Aluminum	3/4	19	60	22	559
	1/32	0.8	25	610	15494
	1/8	3.2	40	204	5182
	1/4	6.4	60	145	3683
	3/8	10	60	74	1880
	1/2	12	60	51	1295
Stainless steel	3/8	16	60	33	838
	3/4	19	60	18	457
	26 GA.	0.5	25	631	16027
	14 GA.	1.9	40	221	5613
	1/4	6.4	60	110	2794
	3/8	10	60	53	1346
	1/2	12	60	35	889
	3/8	16	60	26	660
	1/4	19	60	18	457

*Maximum travel speeds are the results of Hypertherm's laboratory testing. For optimum cut performance, actual cutting speeds may vary based on different cutting applications. Refer to the operator's manual for more details.

Hypertherm, Powermax, G3 Series, HyLife, Boost Conditioner, Dual-threshold, Auto-voltage, Coaxial-assist, ETR (Easy Torch Removal) and FineCut are trademarks of Hypertherm, Inc. and may be registered in the United States and/or other countries.

Hypertherm[®]

The world leader in
plasma cutting technology[™]

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HySpeed[®] Plasma ***HSD130[™]***



Easy, reliable, and incredibly productive

LongLife[®] oxygen plasma cutting system

Hypertherm[®]

HySpeed Plasma HSD130



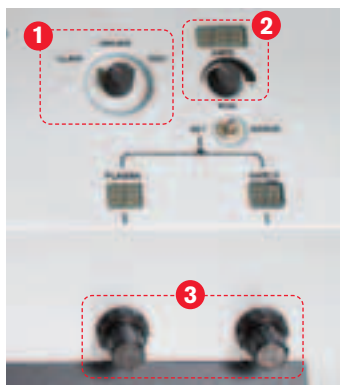
Easy, reliable, and incredibly productive

HySpeed Plasma HSD130 is an easy-to-use oxygen plasma system that is more productive and more cost-effective than other metal cutting solutions such as oxyfuel, air plasma, and non-LongLife oxygen plasma systems. With our patented LongLife technology and 100% duty cycle, HySpeed Plasma is in a class of its own – between our Powermax® air plasma line and our state-of-the-art HyPerformance® Plasma family of precision products.

Easy to use

Easiest plasma system available on the market for oxygen and air plasma cutting – easy to install, easy to run, easy to troubleshoot.

- Three steps to cutting:



1. Select process
2. Set current
3. Set gas pressures

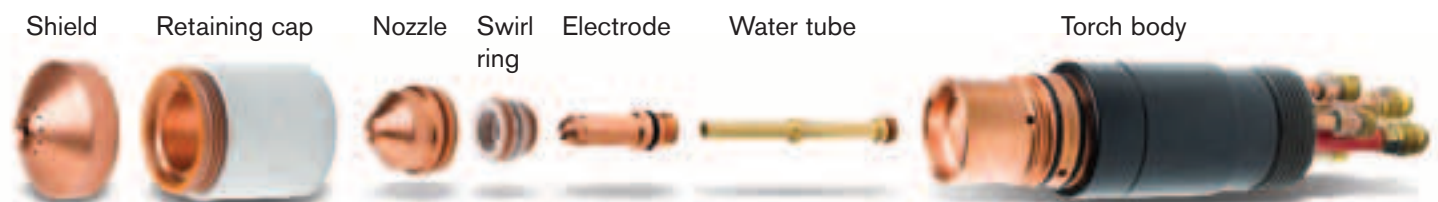
It's that easy!

- Diagnostics display greatly simplifies troubleshooting and service, which leads to greater up-time for you.
- Fewer consumable parts and quicker consumable changeout means reduced downtime.

Unmatched reliability

Rigorous, extensive testing, backed by four decades of experience, guarantees the Hypertherm quality you know you can count on.

- Endured rigorous reliability and exhaustive life testing procedures equivalent to over 10 years of use in operating environments from -10° C to +40° C (+14° F to +104° F).
- Dramatically reduced number of internal parts; less than half compared to other systems on the market. Studies have shown that fewer parts directly relates to greater reliability.
- Designed for easy access to components and simplified service, to keep you up and running.
- Self-diagnostics are performed automatically at startup and continually throughout the cutting process. This ensures the system is operating at peak performance.



Step up to a superior technology

HySpeed Plasma vs. oxyfuel

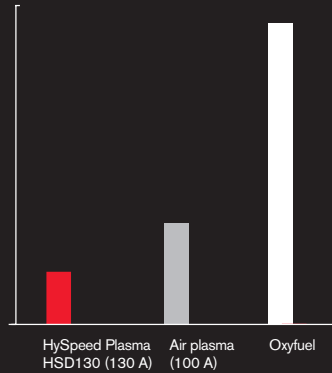
- Cut speeds as much as 7 times faster depending on material thickness translate into a lot more parts cut per hour and a faster payback on your investment
- Significantly lower cost per meter (foot), from 0.5 mm (26 ga.) to 25 mm (1")
- Virtually dross-free cut quality means no secondary operations
- Faster pierce time, with no preheat required



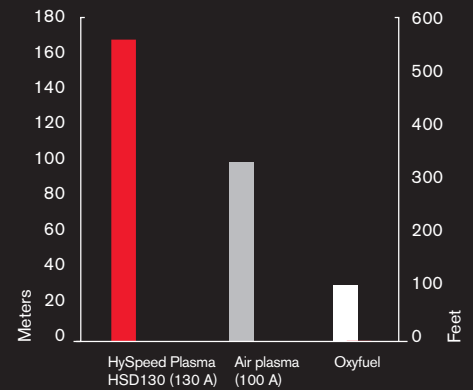
HySpeed Plasma vs. air plasma

- 100% duty cycle
- Faster cut speeds for greater productivity
- Thicker material capability
- Virtually dross-free cut quality means no secondary operations
- Better weldability

Relative cost per foot
Includes labor rate



Meters (feet) cut per hour

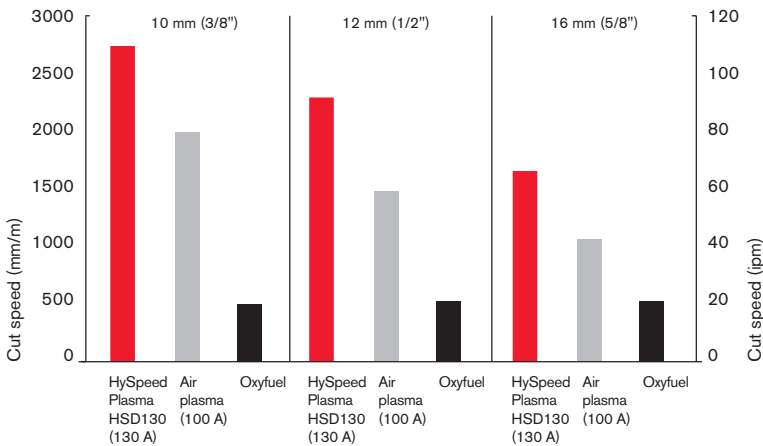


Incredibly productive

With the fastest cut speeds in this class, rapid pierce, and minimal secondary operations, you will be more productive.

- Patented LongLife technology significantly improves consumable life for both oxygen and air processes.
- 100% duty cycle for the most demanding production requirements.
- Fastest cut speed per amp compared to its closest competitors.

Tremendous speed improvements = BIG productivity gains

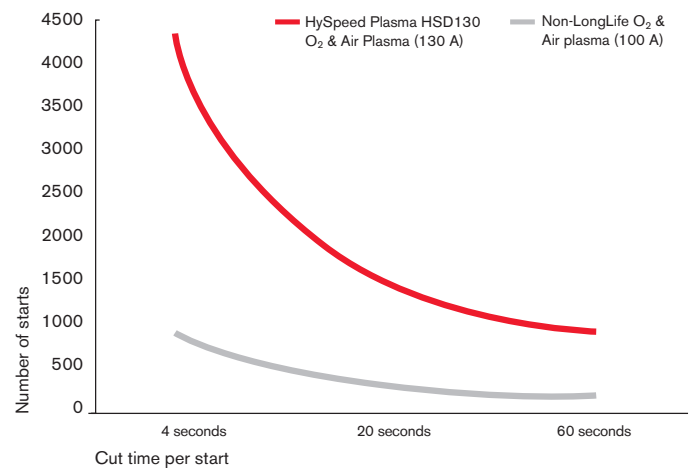


Cost-effective

Ease of use, reliability, and productivity all add up to a more cost-effective system than other metal cutting solutions.

- Less rework and more parts per hour mean lower cost per cut.
- LongLife technology means our consumables last longer, so your consumable cost per part is lower.

Longer consumable life = more cost-effective



Specifications

Input voltages	VAC	Hz	Amps	Approvals
	200/208	50-60	62/60	CSA
	220	50-60	56	CSA
	240	60	52	CSA
	380	50-60	33	CCC
	400	50-60	32	CE, GOST-R
	440	50-60	28	CSA
	480	60	26	CSA
600	60	21	CSA	
Output current	130 A (maximum)			
Duty cycle	100% at 40° C (104° F), 19.5 kW			
Maximum OCV	311 VDC			
Operating temperature	-10° C to +40° C (+14° F to +104° F)			
Dimensions	107 cm H, 57 cm W, 112 cm L 42.25" H, 22.5" W, 44" L			
Weight	286 kg (631 lb)			
Gas supply				
Plasma gas	O ₂ , Air, N ₂ , F5*, H35**			
Shield gas	Air, N ₂			
Gas pressure	7.93 bar (115 psi) 6.55 bar (95 psi) – Air			
Fuel-gas console (optional)	Required for F5 and H35 fuel gases			

* F5 = 95% N₂, 5% H₂

** H35 = 35% H₂, 65% Ar



Base model does not include fuel-gas console (pictured above on top of power supply).

Operating data

Virtually dross-free cutting capacity - mild steel

16 mm (5/8")

Production pierce capacity - mild steel

25 mm (1")

Maximum cutting capacity (edge start) - mild steel

38 mm (1 1/2")

Material	Current (amps)	Thickness (mm)	Approximate cutting speed (mm/min.)	Thickness (inches)	Approximate cutting speed (ipm)			
Mild steel Air plasma Air shield	45	0.5	8930	26 ga	360			
		1	7750	20 ga	315			
		3	3300	0.135	90			
		6	1575	1/4	60			
	O ₂ plasma Air shield	50	0.5	7550	26 ga	300		
			1	6775	20 ga	270		
			3	3650	0.135	130		
			6	1750	1/4	65		
	O ₂ plasma Air shield	130	3	6500	0.135	240		
			6	4000	1/4	150		
			10	2650	3/8	110		
			12	2200	1/2	80		
15			1650	5/8	60			
25			675	1	25			
32			480	1 1/4	20			
38			305	1 1/2	12			
Air plasma Air shield	130	3	6000	0.135	220			
		6	3850	1/4	150			
		10	2450	3/8	100			
		12	2050	1/2	75			
		20	810	3/4	35			
		25	410	1	15			
	Stainless steel	45	0.5	6800	26 ga	270		
			1	5600	20 ga	230		
			3	2250	0.135	70		
			6	1050	1/4	40		
			N ₂ plasma N ₂ shield	45	0.5	7000	26 ga	280
					1	5850	20 ga	240
3	2450	0.135			75			
6	1125	1/4			40			
F5 plasma [†] N ₂ shield	45	0.5			7000	26 ga	280	
		1			5875	20 ga	240	
		3	2740	0.135	100			
		6	1325	1/4	45			
		Air plasma Air shield	130	6	2600	1/4	100	
				10	1700	3/8	70	
12	1380			1/2	50			
15	900			5/8	30			
20	430			3/4	20			
N ₂ plasma N ₂ shield	130			6	2340	1/4	90	
		10	1640	3/8	70			
		12	1080	1/2	35			
		20	300	3/4	15			
		H35 plasma [†] N ₂ shield	130	10	980	3/8	40	
				12	820	1/2	30	
20	360			3/4	15			
25	260			1	10			
Aluminum Air plasma Air shield	45			0.5	7600	0.016	310	
				1	6350	0.032	270	
		1.5	5000	0.064	185			
		3	2400	1/8	90			
		6	1150	1/4	40			
		Air plasma Air shield	130	6	2370	1/4	90	
	10			1465	3/8	60		
	12			1225	1/2	45		
	20			725	3/4	30		
	25			525	1	20		
	H35 plasma [†] N ₂ shield			130	10	1615	3/8	65
		12	1455		1/2	55		
20		940	3/4		40			
25		540	1		20			

Note: Take care in comparison: Competitors often show maximum cutting speeds, rather than speeds that deliver the best cuts, as shown above. Cut speeds listed above deliver best cut quality, but maximum cut speeds can be up to 50% faster.

[†]Optional fuel-gas console required for H35 and F5 plasma.

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- Hypertherm is ISO 9001:2000 registered.
- Hypertherm's full-system warranty: complete coverage for one year on the torch and leads and two years on all other system components.

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
HySpeed® Plasma HSD130™

Consumables




























HySpeed Plasma
HSD130
















Mild steel

	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
45A (Air)	 220532	 220578	 220525	 220529	 220528
50A (O ₂)	 220532	 220578	 220530	 220529	 220528
130A (Air)	 220536	 220578	 220492	 220488	 220487
130A (O ₂)	 220491	 220578	 220489	 220488	 220487

Stainless steel

	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
45A (Air)	 220532	 220578	 220525	 220529	 220528
45A (N ₂ and F5)	 220532	 220534	 220525	 220529	 220528
130A (Air)	 220536	 220578	 220492	 220488	 220487
130A (N ₂)	 220536	 220578	 220535	 220488	 020415
130A (H35)	 220536	 220534	 220535	 220529	 020415

Aluminum

	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
45A (Air)	 220532	 220578	 220525	 220529	 220528
130A (Air)	 220536	 220578	 220492	 220488	 220487
130A (H35)	 220536	 220534	 220535	 220529	 020415

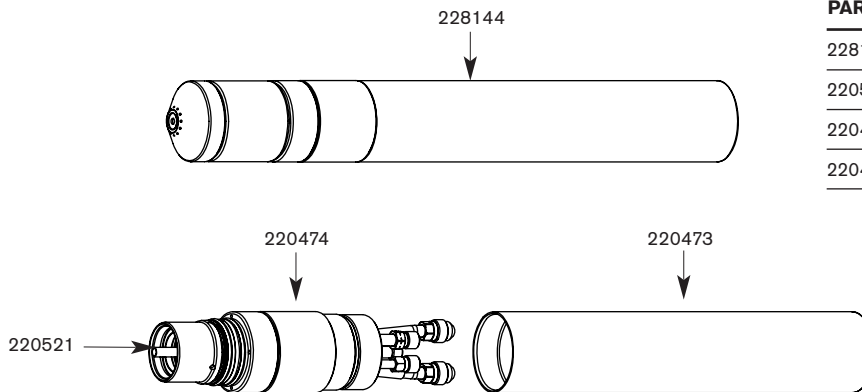


HySpeed Plasma
HSD130 torch

HSD130 consumables

MATERIAL	CONSUMABLE DESCRIPTION	45 AMPS	50 AMPS	130 AMPS	
Mild steel	Electrode	220528	220528	220487	
	Swirl ring	220529	220529	220488	
	Nozzle	220525	220530	220489 (O ₂)	
		-----	-----	220492 (Air)	
		-----	-----	220491 (O ₂)	
	Shield	220532	220532	220536 (Air)	
	-----	-----	220536 (Air)		
	Retaining Cap	220578	220578	220578	
	Stainless steel	Electrode	220528	-----	220487 (Air)
		-----	-----	-----	020415 (N ₂ , H35)
Swirl ring		220529	-----	220488 (Air)	
-----		-----	-----	220488 (N ₂)	
-----		-----	-----	220529 (H35)	
Nozzle		220525	-----	220492 (Air)	
-----		-----	-----	220535 (N ₂ , H35)	
Shield		220532	-----	220536 (Air)	
-----		-----	-----	220536 (N ₂ , H35)	
Retaining Cap		220578 (Air)	-----	220578 (Air)	
-----	220534 (N ₂ , F5)	-----	220534 (H35)		
-----	-----	-----	220578 (N ₂)		
Aluminum	Electrode	220528	-----	220487 (Air)	
	-----	-----	-----	020415 (H35)	
	Swirl ring	220529	-----	220488 (Air)	
	-----	-----	-----	220529 (H35)	
	Nozzle	220525	-----	220492 (Air)	
	-----	-----	-----	220535 (H35)	
Shield	220532	-----	220536 (Air)		
-----	-----	-----	220536 (H35)		
Retaining Cap	220578	-----	220578 (Air)		
-----	-----	-----	220534 (H35)		

HSD130 torch assembly



PART NO.	DESCRIPTION
228144	Torch assembly (includes consumables and sleeve)
220521	Water tube
220474	Torch main body
220473	Torch mounting sleeve

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