Hypertherm®

HyPro2000™ straight torch kit for the MAX200®

Congratulations on the purchase of your new HyPro2000 straight torch kit for the MAX200. This kit contains the necessary components to give you all the performance benefits of your new HyPro2000 straight torch. We have included the 200 A mild steel air plasma/air shield cut charts on the back side of this page.

The HyPro2000 straight torch kit for the MAX200 contains:

Part Number	Description	Quantity
428254*	Straight torch assembly (with 200 A consumables installed)	1
046065	Insulator: pilot arc insulator	1
027055	Silicon lubricant for o-rings	1
104119	Consumable tool	1
880850	Torch brochure: HyPro2000 on the MAX200	1
895760	Introduction and cut chart page	1
	and	
220942	1-3/4" HyPro2000 torch sleeve (in kit number 428256)	1
	or	
220943	2" HyPro2000 torch sleeve (in kit number 428255)	1

*Denotes a non-saleable part number

Follow these steps to access installation and maintenance instructions along with a complete set of cut charts for the HyPro2000 on the MAX200 straight torch.

- Go to www.hypertherm.com.
- Click on “Downloads library” in the upper right hand corner of the page.
- Once in the downloads library enter “807510” in the part number field and click “submit”.
- Expand the “Field Service Bulletin” folder to access the 807510 torch upgrade file.

Mild steel

Air Plasma / Air Shield

200 A Cutting

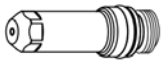
Flow rates – lpm/scfh		
	Air (Plasma)	Air (Shield)
Test	30 / 64	94 / 200
Run	30 / 64	94 / 200

420045

220936
220935 (No IHS tab)

420044

220488



220937

Metric

Plasma Gas (psi)		Shield Gas (psi)	Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Test	Run		mm	Volts	mm	mm/m	mm	factor %	seconds
30	48	45	**6**	133	1.0	4825	3.0	300	0.4
			8	136	1.3	4570	3.9		0.6
			10	140	2.5	3050	5.0	200	0.9
			12	145	3.3	2540	6.6		1.2
			15	150	4.8	1780	9.6		1.3
			20	154		1525			1.5
			25	162	6.4	890	11.5	180	2.2
			32	168		635	Edge Start		
			38	174		455			
			44	182		255			
			50	194		150			

English

Plasma Gas (psi)		Shield Gas (psi)	Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Test	Run		in	Volts	in	ipm	in	factor %	seconds
30	48	45	**1/4**	133	0.04	190	0.12	300	0.4
			5/16	136	0.05	180	0.15		0.6
			3/8	140	0.10	120	0.20	200	0.9
			1/2	145	0.13	100	0.26		1.2
			5/8	150	0.19	70	0.38		1.3
			3/4	154		60			1.5
			7/8	158		50			1.7
			1.0	162	0.25	35	0.45	180	2.2
			1-1/4	168		25	Edge Start		
			1-1/2	174		18			
			1-3/4	182		10			
			2.0	194		6			

If the torch leads are longer than 50 feet, increase the plasma test and the shield pressures by 5 psi (0.35 bar) for every 25 feet of added length.

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Cut with confidence®

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