
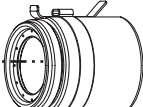


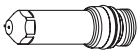




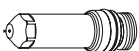

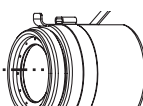




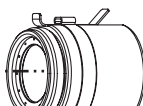





OPERATION


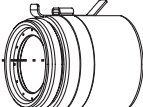


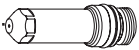

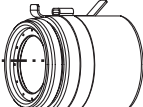


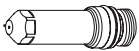

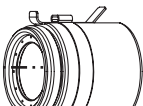




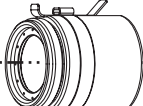


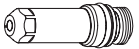

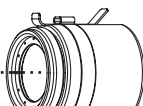



The same change shown below is also accurate for the RHF manual (805510)

Consumable selection

Mild steel

	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
45 A (Air)	 220532	 220578	 220525	 220529	 220528
50 A (O₂)	 220532	 220578	 220530	 220529	 220528
130 A (Air)	 220536	 220578	 220492	 220488	 220487
130 A (O₂)	 220491	 220578	 220489	 220488	 220487 420185 - SilverPlus

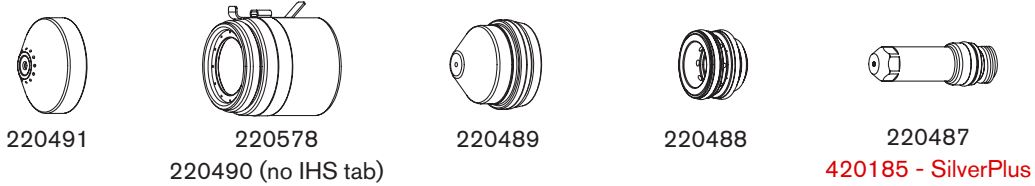
Stainless steel

	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
45 A (Air)	 220532	 220578	 220525	 220529	 220528
45 A (N₂ and F5/N₂)	 220532	 220534	 220525	 220529	 220528
130 A (Air)	 220536	 220578	 220492	 220488	 220487
130 A (H35)	 220536	 220534	 220535	 220529	 020415
130 A (N₂)	 220536	 220578	 220535	 220488	 020415

The same change shown below is also accurate for the RHF manual (805510)

Mild steel
O₂ Plasma / Air Shield
130 A Cutting

Flow Rates – lpm/scfh		
	O ₂	Air
Preflow	0 / 0	90 / 190
Cutflow	48 / 102	92 / 195



Metric

Select Gases		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield					mm	Volts	
O ₂	Air	65	48	3	128	2.5	6500	5	200	0.1
				4	129	2.8	5420	5.6	200	0.2
				6	130	2.8	4000	5.6	200	0.3
				10	134	3.0	2650	6	200	0.3
				12	136	3.0	2200	6	200	0.5
				15	141	3.8	1650	7.6	200	0.7
		43	20	142	3.8	1130	7.6	200	1	
			25	152	4.0	675	8	200	1.5	
			32	155	4.5	480	Edge Start			
			38	160	4.5	305				

English

Select Gases		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield					in	Volts	
O ₂	Air	65	48	0.1350	128	0.100	240	0.2	200	0.1
				0.1875	129	0.110	190	0.22	200	0.2
				0.2500	130	0.110	150	0.22	200	0.3
				0.3750	134	0.120	110	0.24	200	0.3
				0.5000	136	0.120	80	0.24	200	0.5
				0.6250	141	0.150	60	0.3	200	0.7
		43	0.7500	142	0.150	50	0.3	200	1	
			1	152	0.160	25	0.32	200	1.5	
			1-1/4	155	0.180	20	Edge Start			
			1-1/2	160	0.180	12				