

HPR cartridge and XD technology upgrade

for HyPerformance® plasma HPR130® and HPR260®



Upgrade your HPR plasma cutting system to experience cartridge and XD technology

Hypertherm's XD technology upgrade kit includes a new XD control board, push-connect gas fittings, leads, upgraded torch, Hypertherm's new Cartridge consumables, and a visit from a trained technician. This technician will clean, perform maintenance, and upgrade your HPR cutting system to optimize your cutting process.

Customers who have made this upgrade report:

- Improved cut angularity – especially on holes
- Significantly improved consumable life
- Increased piercing capability through PowerPierce® technology
- Consistent cut quality over the life of consumables
- The XD system torches are more robust than the standard HPR torch

Hypertherm HPR customers that have upgraded to XD technology experience improved performance, increased reliability, and a lower cost of cutting.

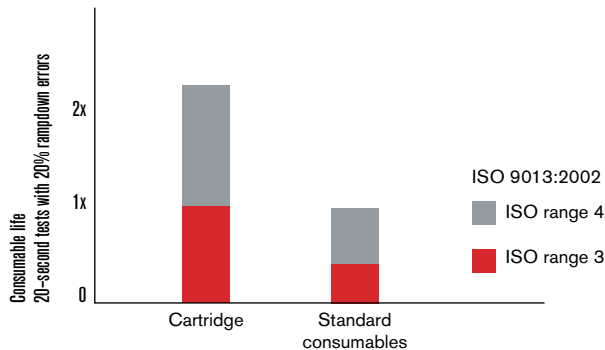
HPR Cartridge

Upgrade to XD technology and dramatically simplify your cutting process. One cartridge replaces five standard consumables and provides longer life, reduced consumable errors and faster process changeovers.

HPR cartridge quality over life

Oxygen 20/20 cut quality over life

7 mm to 20 mm (1/4" to 3/4") mild steel



Data from HyPerformance® HPRXD® 80-260 A lab testing.

Production may vary.

The cut quality ranges, shown in these test results, meet the ISO 9013:2002 industrial standard that defines cut quality of thermally cut parts. The lower the range, the smaller the angle on the cut face.

Improved angularity

Customers who have upgraded to XD technology report less angularity, particularly on holes throughout the life of the consumables. Cut angularity is a major trigger for replacing consumables, often before the consumables are fully worn.

Consistent quality over life

More consistent cut quality over the life of the consumables has been observed by customers who have upgraded to XD technology. In addition to improved angularity, they report less spatter on the torch and shield, dross-free cutting and overall excellent cut quality.

Professional installation:

Your XD upgrade includes an on-site visit by a trained technical service engineer from an authorized Hypertherm partner who will install the upgrade, perform necessary maintenance, adjust settings and optimize your cutting process.

Hypertherm recommends replacement of the main contactor and pilot arc relay during the upgrade process.



XD technology upgrade kits

What to order:

1. Upgrade kit

Part number	Description
228524	New control board with firmware for the power supply
	Gas console firmware for both auto gas selection console and metering console, and tool to remove firmware chips
	Adapter fittings for metering console, to connect new torch leads to old style connectors on metering console
	Field service bulletin
	XD and PowerPierce labels

2. Torch assembly

Part number	Description	Notes
10082294	HPR cartridge XD upgrade kit	Includes quick-disconnect torch and receptacle, torch sleeve, and one each 80 A, 130 A, and 260 A cartridges

3. Torch leads (order one)

Part number	Description	Notes
228291	Standard torch leads, 2 m / 6'	Bevel torch leads are also available
228292	Standard torch leads, 3 m / 10'	
228293	Standard torch leads, 4.5 m / 15'	
228294	Standard torch leads, 6 m / 20'	
228295	Standard torch leads, 7.5 m / 25'	
228296	Standard torch leads, 10 m / 35'	
228297	Standard torch leads, 15 m / 50'	
228547	Standard torch leads, 20 m / 65'	

4. IHS ohmic contact wire (order one)

Part number	Description	Notes
123983	IHS ohmic contact wire, 3 m / 10'	Necessary for ohmic sensing
123984	IHS ohmic contact wire, 6 m / 20'	
123985	IHS ohmic contact wire, 7.5 m / 25'	
123986	IHS ohmic contact wire, 9 m / 30'	
123987	IHS ohmic contact wire, 12 m / 40'	
123988	IHS ohmic contact wire, 15 m / 50'	
123989	IHS ohmic contact wire, 23 m / 75'	
123990	IHS ohmic contact wire, 30 m / 100'	
123991	IHS ohmic contact wire, 45 m / 150'	

5. Electronics kits

System	Cartridge kits (4 qty.)	Contactors	Relay
HPR130XD	528108	003249	003149
HPR260XD (200-240 V)	528109	003217	003149
HPR400/800XD (200-240 V)	528110	003218	003149
HPR260XD (380-600 V)	528111	003233	003149

Technologies

Chambered Swirl Ring	gradually reduces gas pressure at the end of the cut to stabilize the hafnium insert prior to arc termination; this extends nozzle and electrode life.
Cartridge	Cartridge single-piece consumable dramatically simplifies the cutting process. One cartridge replaces five standard consumables providing longer life, reduced consumable errors and faster process changeovers.
Conical Flow™	nozzle technology increases arc energy density for superior cut quality with little dross.
CoolFlow™	delivers enhanced cooling of the nozzle through key features such as a deep groove, angled o-ring seal and specific shoulder contact for increased nozzle life and cut quality.
Dimpled electrode	extends electrode life by preventing material from blowing on the nozzle when first ignited.
HDi®	delivers HyDefinition® quality to thin stainless steel cutting from 3 mm (12 ga.) to 6 mm (1/4").
HyDefinition®	vented nozzle technology aligns and focuses the plasma arc for powerful precision cutting, superior quality, and consistency.
HyLife®	extends electrode life and lowers operating costs.
LongLife®	ramps current and gas flow up and down in a tightly controlled manner to reduce electrode and nozzle erosion.
PowerPierce®	liquid cooled shield technology repels molten metal during piercing. Enables robust production pierce capability up to 50 mm (2") mild steel and 75 mm (3") stainless steel and aluminum. Delivers speed and thickness capabilities.



SHAPING POSSIBILITY[®]

PLASMA | LASER | WATERJET | AUTOMATION | SOFTWARE | CONSUMABLES

To learn more contact your authorized
Hypertherm partner or visit hypertherm.com

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