Hypertherm®

Torch Alignment Guide for Bevel Cutting

Powermax125® and MAXPRO200™

Field Service Bulletin

811280
Revision 0
January 2021

Hypertherm, Inc.
Etna Road, P.O. Box 5010
Hanover, NH 03755 USA
603-643-3441 Tel (Main Office)
603-643-5352 Fax (All Departments)
info@hypertherm.com (Main Office Email)
800-643-9878 Tel (Technical Service)
technical.service@hypertherm.com (Technical Service Email)
800-737-2978 Tel (Customer Service)
customer.service@hypertherm.com (Customer Service Email)
866-643-7711 Tel (Return Materials Authorization)
877-371-2876 Fax (Return Materials Authorization)
return.materials@hypertherm.com (RMA email)

Hypertherm México, S.A. de C.V.
Avenida Toluca No. 444, Anexo 1,
Colonia Olivar de los Padres
Delegación Álvaro Obregón
México, D.F. C.P. 01780
52 55 5681 8109 Tel
52 55 5683 2127 Fax
Soporte.Tecnico@hypertherm.com (Technical Service Email)

Hypertherm Plasmatechnik GmbH
Sophie-Scholl-Platz 5
63452 Hanau
Germany
00 800 33 24 97 37 Tel
00 800 49 73 73 29 Fax
31 (0) 165 596900 Tel (Technical Service)
00 800 4973 7843 Tel (Technical Service)
technicalservice.emea@hypertherm.com (Technical Service Email)

Hypertherm (Singapore) Pte Ltd.
82 Genting Lane
Media Centre
Annexe Block #A01-01
Singapore 349567, Republic of Singapore
65 6841 2489 Tel
65 6841 2490 Fax
Marketing.asia@hypertherm.com (Marketing Email)
TechSupportAPAC@hypertherm.com (Technical Service Email)

Hypertherm Japan Ltd.
Level 9, Edobori Center Building
2-1-1 Edobori, Nishi-ku
Osaka 550-0002 Japan
81 6 6225 1183 Tel
81 6 6225 1184 Fax
HTJapan.info@hypertherm.com (Main Office Email)
TechSupportAPAC@hypertherm.com (Technical Service Email)

Hypertherm Europe B.V.
Vaartveld 9, 4704 SE
Roosendaal, Nederland
31 165 596907 Tel
31 165 596901 Fax
31 165 596908 Tel (Marketing)
31 (0) 165 596900 Tel (Technical Service)
00 800 4973 7843 Tel (Technical Service)
technicalservice.emea@hypertherm.com
(Technical Service Email)

Hypertherm (Shanghai) Trading Co., Ltd.
B301, 495 ShangZhong Road
Shanghai, 200231
PR China
86-21-80231122 Tel
86-21-80231120 Fax
86-21-80231128 Tel (Technical Service)
techsupport.china@hypertherm.com
(Technical Service Email)

South America & Central America: Hypertherm Brasil Ltda.
Rua Bras Cubas, 231 – Jardim Maia
Guarulhos, SP – Brasil
CEP 07115-030
55 11 2409 2636 Tel
tecnico.sa@hypertherm.com (Technical Service Email)

Hypertherm Korea Branch
#3904. APEC-ro 17. Heaundae-gu. Busan.
Korea 48060
82 (0)51 747 0358 Tel
82 (0)51 701 0358 Fax
Marketing.korea@hypertherm.com (Marketing Email)
TechSupportAPAC@hypertherm.com
(Technical Service Email)

Hypertherm Pty Limited
GPO Box 4836
Sydney NSW 2001, Australia
61 (0) 437 606 995 Tel
61 7 3219 9010 Fax
au.sales@Hypertherm.com (Main Office Email)
TechSupportAPAC@hypertherm.com
(Technical Service Email)

Hypertherm (India) Thermal Cutting Pvt. Ltd
A-18 / B-1 Extension,
Mohan Co-Operative Industrial Estate,
Mathura Road, New Delhi 110044, India
91-11-40521201/ 2/ 3 Tel
91-11 40521204 Fax
HTIndia.info@hypertherm.com (Main Office Email)
TechSupportAPAC@hypertherm.com
(Technical Service Email)

© 2021 Hypertherm Inc. All rights reserved.

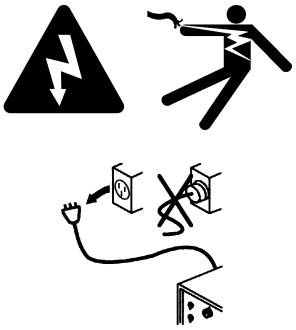
Powermax, MAXPRO200, and Hypertherm are trademarks of Hypertherm, Inc. and may be registered in the United States and/or other countries. All other trademarks are the property of their respective holders.

Environmental stewardship is one of Hypertherm's core values. www.hypertherm.com/environment

100% Associate-owned

Introduction

⚠ WARNING



ELECTRIC SHOCK CAN KILL

Disconnect electrical power before doing installation or maintenance.

The line-disconnect switch must REMAIN in the OFF position until all installation or maintenance steps are complete.

See the *Safety and Compliance Manual* (80669C) for more safety information.

⚠ WARNING



EXPLOSION HAZARD – CUTTING WITH FLAMMABLE OR OXIDIZING GASES

Do not use flammable or oxidizing gases with Powermax systems. These gases can cause explosive conditions during plasma cutting operations.

An example of an oxidizing gas is oxygen. Examples of flammable gases are acetylene, propylene, methane, and pure hydrogen. Refer to the *Safety and Compliance Manual* (80669C) for more information.

Purpose

This Field Service Bulletin shows how to use the Hypertherm torch alignment guide accessory to do bevel cutting on a track burner with a Powermax125 or a MAXPRO200.

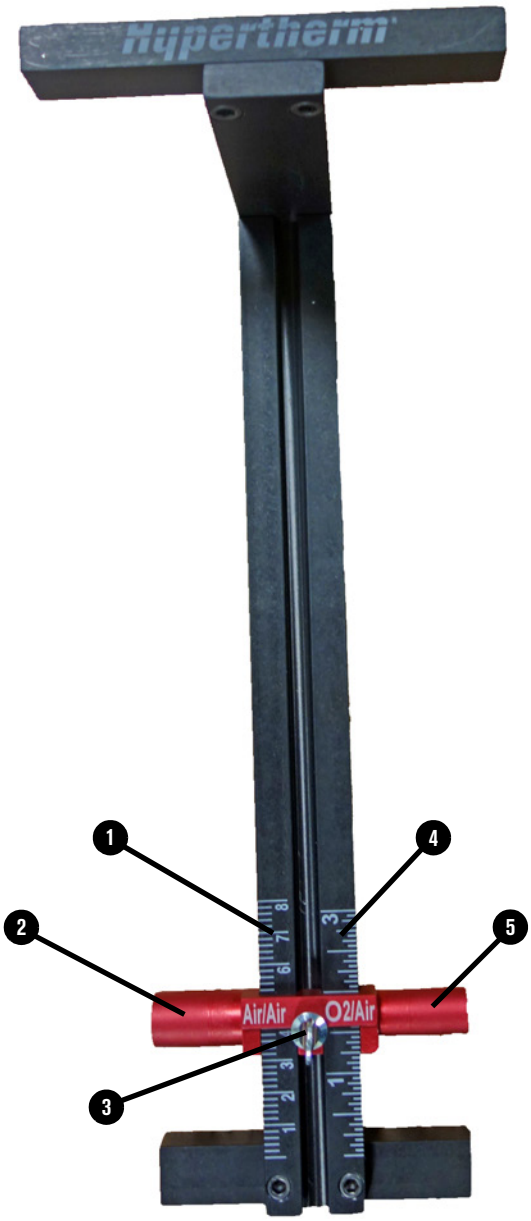
Tools and materials needed

- 3/16 inch hexagonal key wrench
- Digital level, or digital level application on a smartphone
- Remote start pendant for the plasma cutting system if the track burner cannot start and stop the plasma torch

Kit 528077 contents

Kit 528077 contains only the torch alignment guide and this Field Service Bulletin. Refer to Figure 1.

Figure 1 – Torch alignment guide



1 Metric units (cm/mm)

2 Torch clearance gauge for Air/Air processes

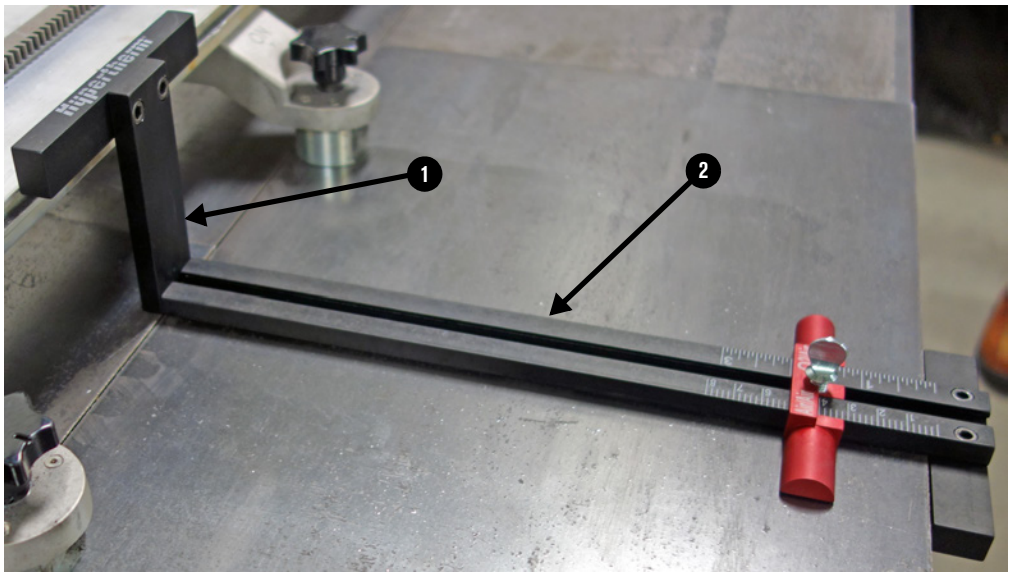
3 Set screw

4 English units (inches)

5 Torch clearance gauge for O_2/Air processes (MAXPRO200 only)

Assemble the torch alignment guide

Before you use the torch alignment guide, attach the vertical piece ❶ to the horizontal piece ❷. Use the 2 screws given in the kit.

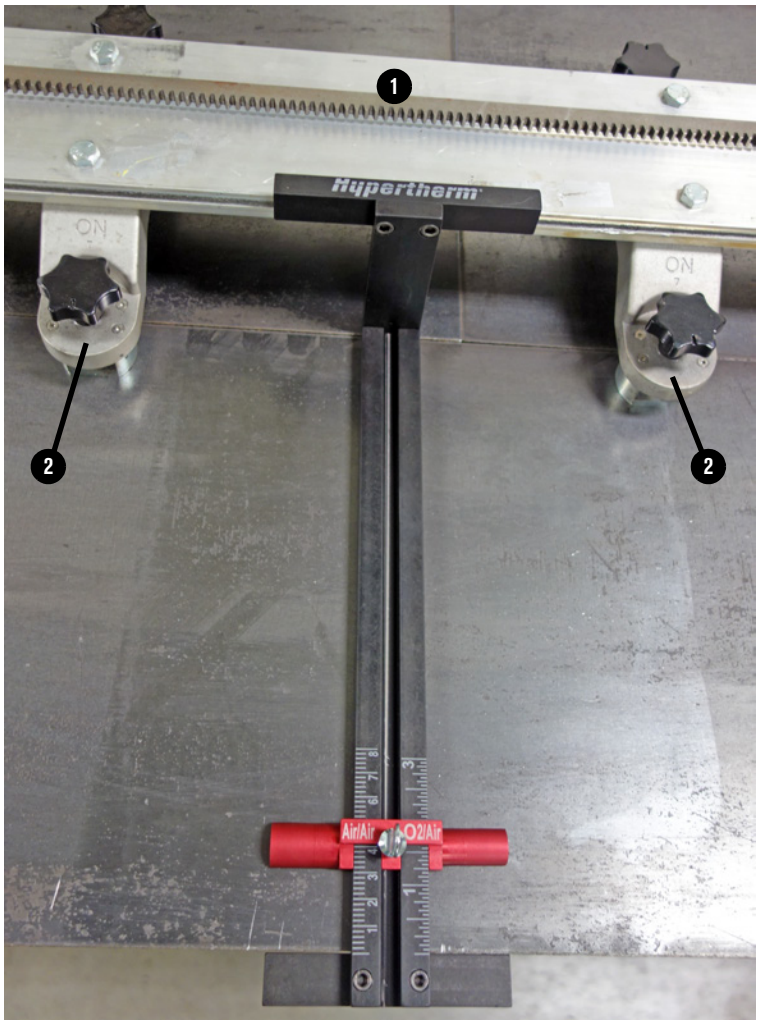


Use the torch alignment guide to put the torch in position for bevel cutting

This procedure gives general instructions for any track burner. The pictures show one example from a common track burner. Your configuration can be different.

Hypertherm recommends that you use a track burner that is compatible with plasma cutting so that you can get the best bevel cut results at the specified cut speeds. Use a remote start pendant for the plasma cutting system if the track burner cannot start and stop the plasma torch.

1. Set the power to OFF (**O**) for the track burner and the plasma power supply.
2. Select the parameters to use for the metal thickness and the correct bevel cut angle. Use the Powermax125 and MAXPRO200 Bevel compensation cut charts on page 11.
3. Put the torch alignment guide on the workpiece to be cut. Put the track ❶ down so that it is touching the guide.
4. Examine both ends of the track and different points in between to make sure that the track is touching the end of the alignment guide. Also make sure that the track is parallel to the edge of the plate.
5. When the track and the torch alignment guide are in position, engage the locking mechanism on the track to attach the track to the workpiece. This mechanism is different on different tracks. Some tracks use magnets ❷ as the locking mechanism, as shown in this example.
6. Attach the track burner tractor to the track. Connect the cables for the track burner and for the plasma power supply. Refer to the manufacturer instructions for each system.



7. Adjust the X-axis arm to be approximately in the center of the tractor. Use the horizontal racker control knob or equivalent control on your tractor.

8. Install the correct cutting consumables on the machine torch. Refer to the Powermax125 and MAXPRO200 Bevel compensation cut charts on page 11.

9. Loosen the knobs or fasteners on the torch holder, as necessary. Put the torch in the holder and tighten.

10. If there is a cable mount, make sure that the torch lead is correctly installed and tightened in the cable mount.

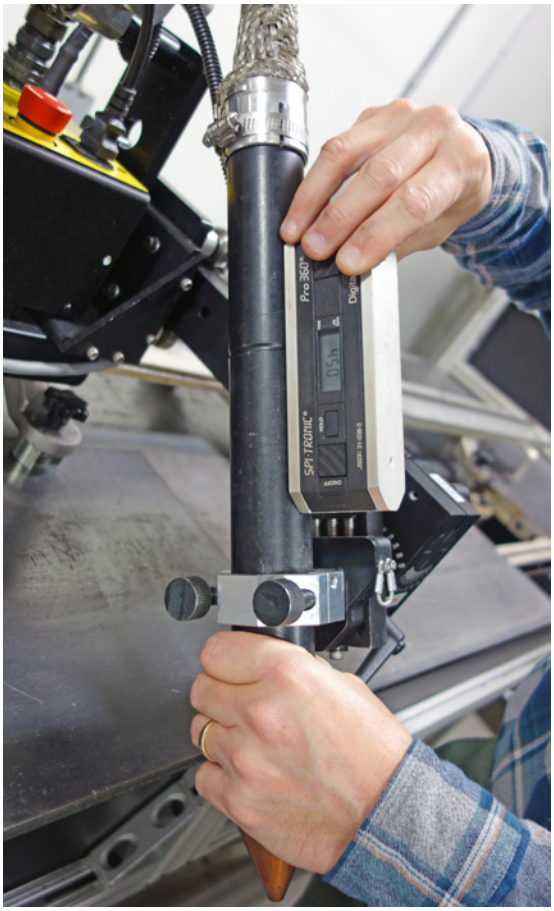
11. Loosen the control lever for the angle of the torch. Adjust the angle to 0°, or make sure that the torch is squarely aligned to the workpiece. Tighten the control lever.

12. Loosen the control lever for the torch bevel angle. Adjust the torch to the correct bevel angle to align with the settings from the bevel compensation cut charts.

    a. Use a digital level to make sure that the angle of the torch is correct. If you have a smartphone, you can also use a digital level application. In the following pictures, the digital level is used to make sure that the torch is set to a 45° angle.

    b. When the torch bevel angle is correct, tighten the control lever.

Digital level

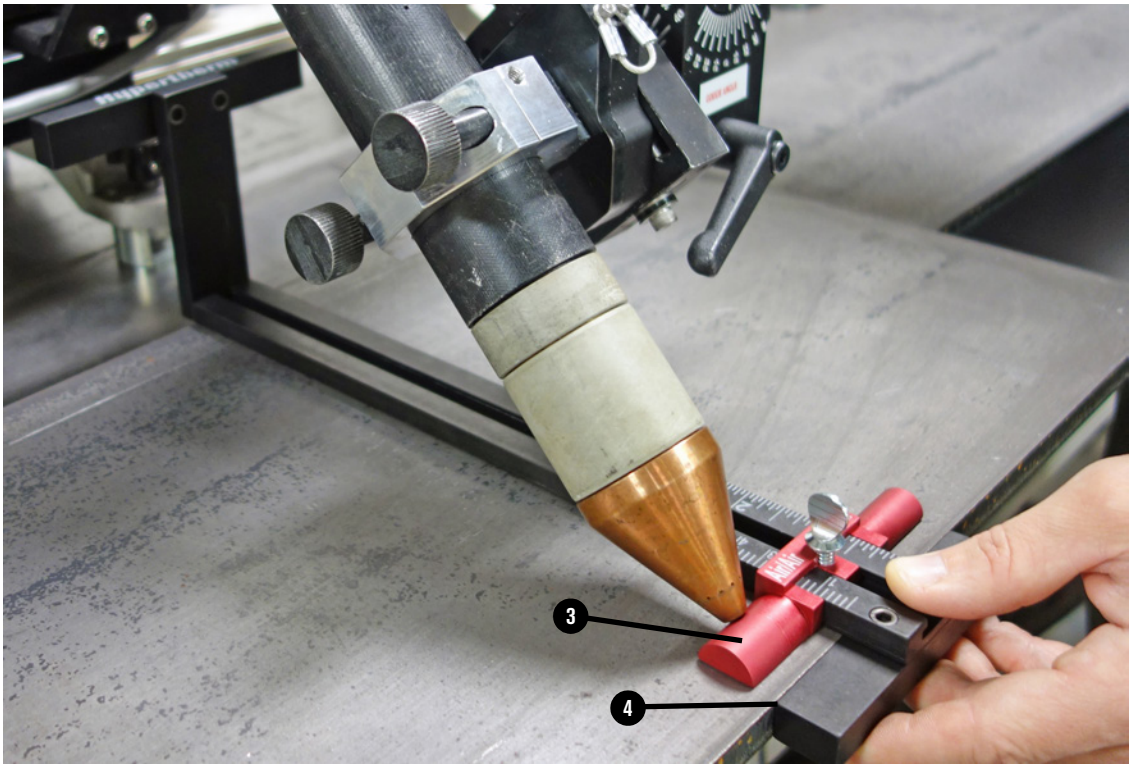


Digital level application on a smartphone

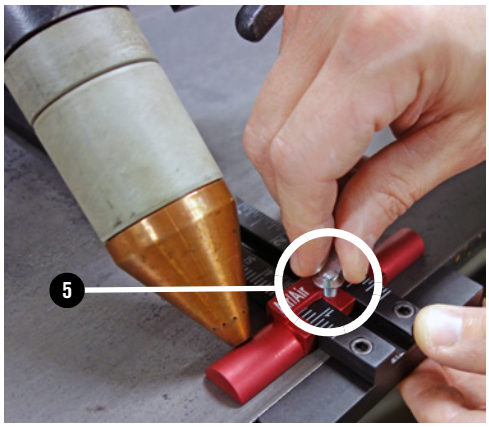


13. Move the torch alignment guide so that the correct torch clearance gauge ❸ is in front of the torch.

- One torch clearance gauge is for **Air/Air** processes. The other gauge is for **O_2/Air** processes (MAXPRO200 only). Refer to Figure 1 on page 4.
- Make sure that you keep the torch alignment guide on the edge of the workpiece ❹.

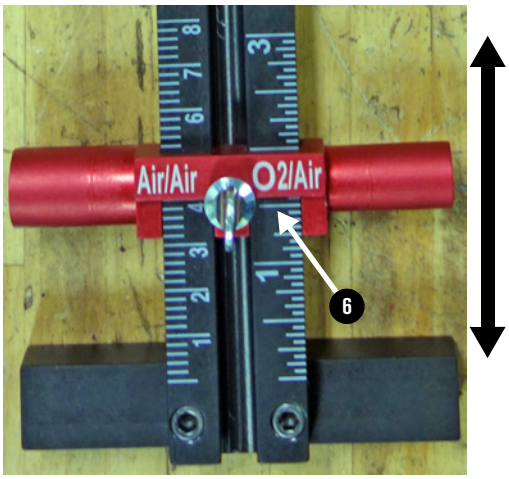


14. Use the bevel compensation cut charts to find the correct **edge offset** value to use for the torch clearance. *Clearance* is the distance between the torch and the top of the workpiece.



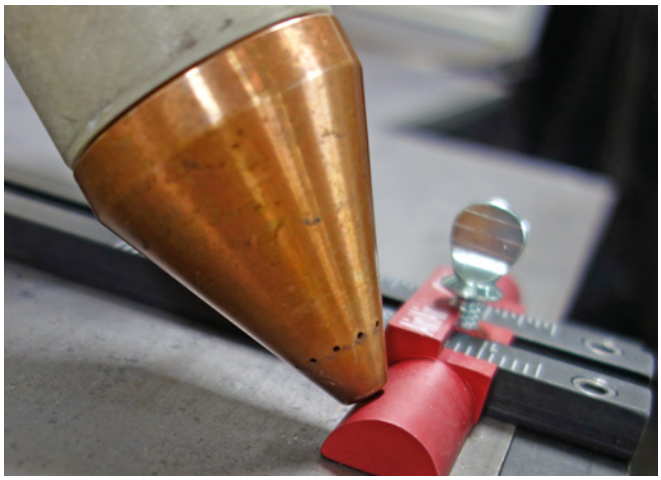
15. Put the torch clearance gauge in the correct position, as follows:

- **a.** Loosen the set screw ❺.
- **b.** Align the inside of the torch clearance gauge with the correct position on the ruler. Move the gauge higher or lower on the guide, as necessary. The position to use on the ruler is the edge offset value from step 14.
- **c.** For example, in the picture shown ❻, the torch clearance gauge is set to an edge offset of 1.5 inches.
- **d.** When the torch clearance gauge is in the correct position, tighten the set screw.



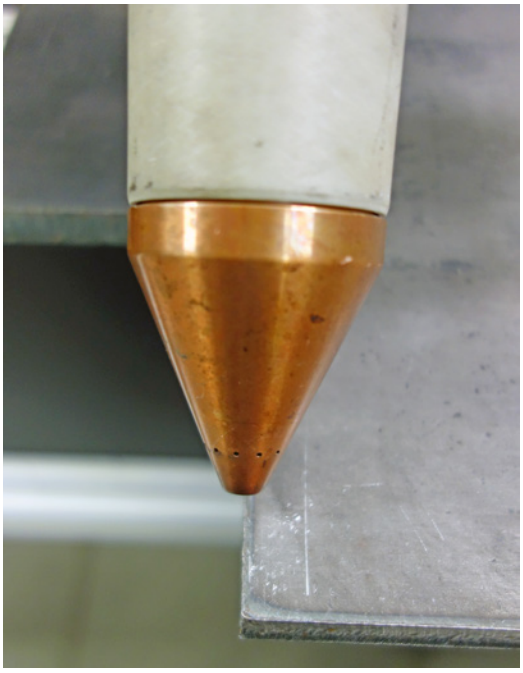
16. Move the torch closer to the torch clearance gauge, as follows:

- **a.** Move the torch horizontally, as necessary. Use the horizontal racker control knob or equivalent control on your tractor.
- **b.** Move the torch vertically, as necessary. Loosen the knobs on the torch holder. Move the torch closer to the torch clearance gauge and tighten the knobs.
- **c.** If there is a torch height control knob or similar mechanism, use that to move the torch in very small increments, as necessary. Adjust the torch height until the torch consumables touch the torch clearance gauge.
- **d.** Make sure that the tip of the torch is touching the torch clearance gauge and is approximately perpendicular to the gauge, as shown.



17. Remove the torch alignment guide from the workpiece.

18. Move the tractor as necessary until the torch consumables are centered on the edge of the workpiece, as shown.





Start to cut

1. Set the power to ON (**I**) for the track burner and for the plasma power supply.

2. Use the bevel compensation cut charts to find the following values for the bevel cut:
   - Adjust the pierce delay setting on the tractor to use the correct **pierce delay** value from the cut chart. Use the timer control knob or equivalent control on your tractor.
   - Adjust the speed of the tractor to use the correct **cut speed** value from the cut chart. Use the speed control knob or equivalent control on your tractor.
   - Adjust the plasma power supply to use the correct **current (A)** value from the cut chart. Use the amperage control knob on the front of the plasma power supply.

3. You are now ready to make the bevel cut. Can the track burner control both the tractor and the plasma torch?
   - If yes, start the tractor to start both the plasma arc and the tractor motion.
   - If no, start the tractor and the plasma torch at the same time. Use a remote start pendant to start the plasma arc.

4. Make sure that the plasma arc transfers to the workpiece and that the tractor starts the forward motion.

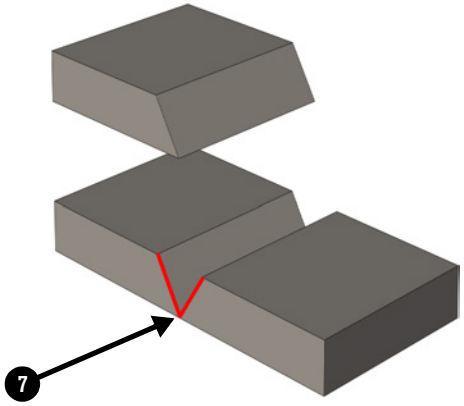
5. At the end of the cut, stop the tractor as soon as the plasma arc extinguishes, if the tractor does not stop automatically.

Bevel compensation cut charts

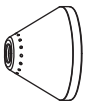
The following bevel compensation cut charts are given in metric and English units:

- Powermax125 – Mild steel – Air
- MAXPRO200 – Mild steel – 200 A – O_2 Plasma / Air Shield
- MAXPRO200 – Mild steel – 200 A – Air Plasma / Air Shield
- MAXPRO200 – Mild steel – 130 A – O_2 Plasma / Air Shield
- MAXPRO200 – Mild steel – 130 A – Air Plasma / Air Shield

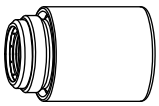
All of the cut chart processes in this document are for single-pass, V cuts ❼.



Powermax125 – Mild steel – Air



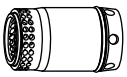
220976
Shield



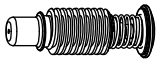
220977
Retaining cap



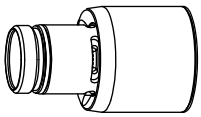
220975
Nozzle



220997
Swirl ring



220971
Electrode



Metric

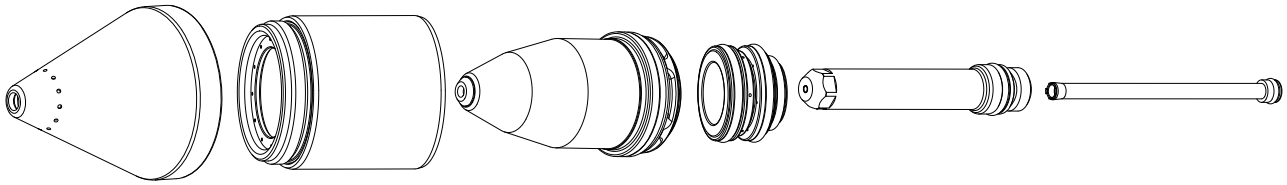
Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	mm	mm	degrees	mm/min	seconds	mm	mm
V cut	105	9.1	6	22.5	2540	0.5	2.3	4.8
				37.5	2540	0.6	2.7	7.3
				45.0	2327	0.7	3.1	9.1
	125		12	22.5	1603	0.5	2.8	7.8
				37.5	1245	0.6	3.5	12.7
				45.0	1028	0.7	4.1	16.1
			16	22.5	994	0.7	3.1	9.8
				37.5	772	1.2	3.8	16.1
				45.0	638	2.1	4.5	20.5
			20	22.5	686	1.4	3.4	11.7
				37.5	533	2.8	4.2	19.5
				45.0	440	1.0*	4.9	24.9
			25	22.5	474	1.0*	3.7	14.0
				37.5	368	1.0*	4.5	23.7
				45.0	304	1.0*	5.2	30.2

English

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	inches	inches	degrees	in/min	seconds	inches	inches
V cut	105	0.360	1/4	22.5	100.0	0.5	0.09	0.20
				37.5	99.4	0.6	0.11	0.30
				45.0	84.7	0.7	0.12	0.37
	125		1/2	22.5	57.4	0.5	0.11	0.32
				37.5	44.6	0.6	0.14	0.52
				45.0	36.8	0.7	0.16	0.66
			5/8	22.5	39.7	0.7	0.12	0.38
				37.5	30.8	1.2	0.15	0.63
				45.0	25.4	2.1	0.18	0.80
			3/4	22.5	29.3	1.4	0.13	0.44
				37.5	22.8	2.8	0.16	0.74
				45.0	18.8	1.0*	0.19	0.94
			1	22.5	18.2	1.0*	0.14	0.56
				37.5	14.1	1.0*	0.18	0.95
				45.0	11.7	1.0*	0.21	1.21

* Edge start only.

MAXPRO200 – Mild steel – 200 A – O_2 Plasma / Air Shield



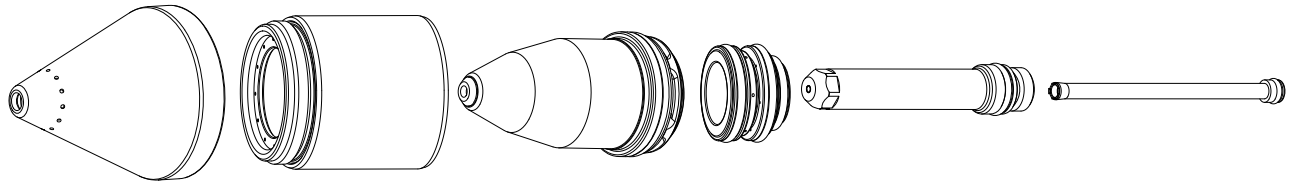
420737	220935	420733	220488	420732	420823
Shield	Retaining cap	Nozzle	Swirl ring	Electrode	Water tube

Metric

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	mm	mm	degrees	mm/min	seconds	mm	mm
V cut	200	7.6	10	22.5	2540	0.5	4.0	8.1
			10	37.5	2469	0.7	4.7	12.4
			10	45.0	2204	0.8	5.5	15.5
			12	22.5	2400	0.7	4.1	9.1
			12	37.5	2049	0.9	5.1	14.3
			12	45.0	1788	1.0	5.9	17.9
			16	22.5	1742	1.1	4.6	11.2
			16	37.5	1411	1.3	5.6	17.9
			16	45.0	1176	1.5	6.5	22.5
			20	22.5	1265	1.4	4.9	13.2
			20	37.5	972	1.7	6.0	21.4
			20	45.0	774	1.0*	6.9	26.9
			25	22.5	848	1.0*	5.3	15.6
			25	37.5	610	1.0*	6.3	25.5
			25	45.0	459	1.0*	7.3	32.3
			32	22.5	484	1.0*	5.5	18.8
			32	37.5	317	1.0*	6.6	31.1
			32	45.0	221	1.0*	7.5	39.5
			38	22.5	299	1.0*	5.7	21.4
			38	37.5	181	1.0*	6.7	35.9
			44	22.5	185	1.0*	5.8	24.0

* Edge start only.

MAXPRO200 – Mild steel – 200 A – O_2 Plasma / Air Shield



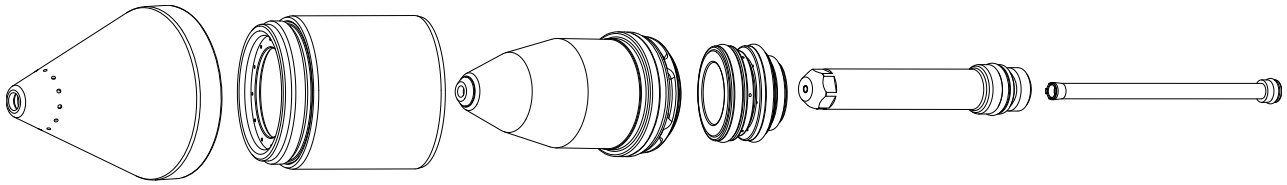
420737 Shield	**220935** Retaining cap	**420733** Nozzle	**220488** Swirl ring	**420732** Electrode	**420823** Water tube

English

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	inches	inches	degrees	in/min	seconds	inches	inches
V cut	200	0.300	0.375	22.5	100.0	0.5	0.16	0.31
			0.375	37.5	100.0	0.6	0.18	0.47
			0.375	45.0	91.2	0.7	0.21	0.59
			0.500	22.5	89.3	0.8	0.16	0.37
			0.500	37.5	75.6	1.0	0.20	0.59
			0.500	45.0	65.4	1.1	0.24	0.74
			0.625	22.5	69.3	1.1	0.18	0.44
			0.625	37.5	56.2	1.3	0.22	0.70
			0.625	45.0	46.9	1.5	0.26	0.88
			0.750	22.5	53.7	1.3	0.19	0.50
			0.750	37.5	41.8	1.6	0.23	0.81
			0.750	45.0	33.7	1.0*	0.27	1.02
			1.000	22.5	32.3	1.0*	0.21	0.62
			1.000	37.5	23.1	1.0*	0.25	1.02
			1.000	45.0	17.3	1.0*	0.29	1.29
			1.250	22.5	19.4	1.0*	0.22	0.74
			1.250	37.5	12.8	1.0*	0.26	1.22
			1.250	45.0	8.9	1.0*	0.29	1.54
			1.500	22.5	11.7	1.0*	0.22	0.84
			1.500	37.5	7.1	1.0*	0.26	1.42
			1.750	22.5	7.0	1.0*	0.23	0.95

* Edge start only.

MAXPRO200 – Mild steel – 200 A – Air Plasma / Air Shield



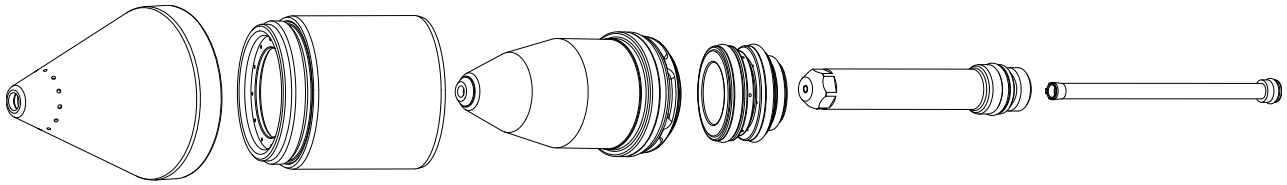
420737 Shield | **220935** Retaining cap | **420734** Nozzle | **220488** Swirl ring | **420732** Electrode | **420823** Water tube

Metric

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	mm	mm	degrees	mm/min	seconds	mm	mm
V cut	200	9.1	10	22.5	2540	0.7	4.1	8.2
			10	37.5	2540	0.8	4.8	12.4
			10	45.0	2368	0.9	5.5	15.5
			12	22.5	2540	0.9	4.1	9.1
			12	37.5	2211	1.0	5.1	14.3
			12	45.0	1944	1.1	5.9	17.9
			16	22.5	1898	1.2	4.6	11.2
			16	37.5	1556	1.4	5.6	17.9
			16	45.0	1311	1.5	6.6	22.6
			20	22.5	1403	1.5	5.0	13.2
			20	37.5	1095	1.7	6.0	21.4
			20	45.0	884	1.9	7.0	27.0
			25	22.5	963	1.9	5.3	15.6
			25	37.5	706	2.2	6.4	25.6
			25	45.0	540	1.0*	7.3	32.3
			32	22.5	568	1.0*	5.6	18.8
			32	37.5	382	1.0*	6.7	31.2
			32	45.0	271	1.0*	7.6	39.6
			38	22.5	361	1.0*	5.8	21.5
			38	37.5	225	1.0*	6.8	36.0
			44	22.5	230	1.0*	5.8	24.1

* Edge start only.

MAXPRO200 – Mild steel – 200 A – Air Plasma / Air Shield



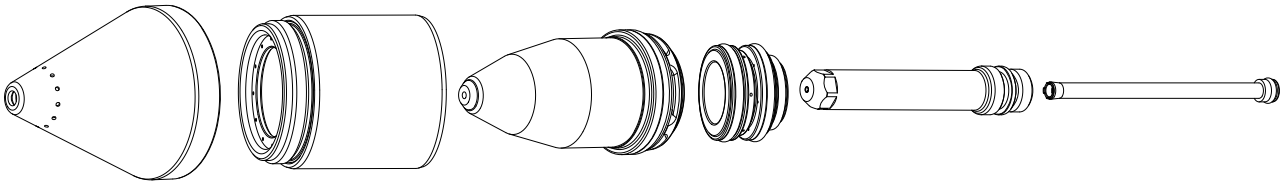
420737	**220935**	**420734**	**220488**	**420732**	**420823**
Shield	Retaining cap	Nozzle	Swirl ring	Electrode	Water tube

English

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	inches	inches	degrees	in/min	seconds	inches	inches
V cut	200	0.360	0.375	22.5	100.0	0.7	0.16	0.32
			0.375	37.5	100.0	0.8	0.19	0.48
			0.375	45.0	97.7	0.9	0.21	0.59
			0.500	22.5	95.8	0.9	0.16	0.37
			0.500	37.5	81.9	1.1	0.20	0.59
			0.500	45.0	71.4	1.2	0.24	0.74
			0.625	22.5	75.4	1.2	0.18	0.44
			0.625	37.5	61.9	1.4	0.22	0.70
			0.625	45.0	52.2	1.5	0.26	0.88
			0.750	22.5	59.4	1.4	0.19	0.50
			0.750	37.5	46.9	1.6	0.23	0.81
			0.750	45.0	38.2	1.8	0.27	1.02
			1.000	22.5	36.8	1.9	0.21	0.62
			1.000	37.5	26.8	1.0*	0.25	1.02
			1.000	45.0	20.4	1.0*	0.29	1.29
			1.250	22.5	22.8	1.0*	0.22	0.74
			1.250	37.5	15.4	1.0*	0.26	1.22
			1.250	45.0	10.9	1.0*	0.30	1.55
			1.500	22.5	14.1	1.0*	0.23	0.85
			1.500	37.5	8.8	1.0*	0.27	1.42
			1.750	22.5	8.7	1.0*	0.23	0.96

* Edge start only.

MAXPRO200 – Mild steel – 130 A – O_2 Plasma / Air Shield



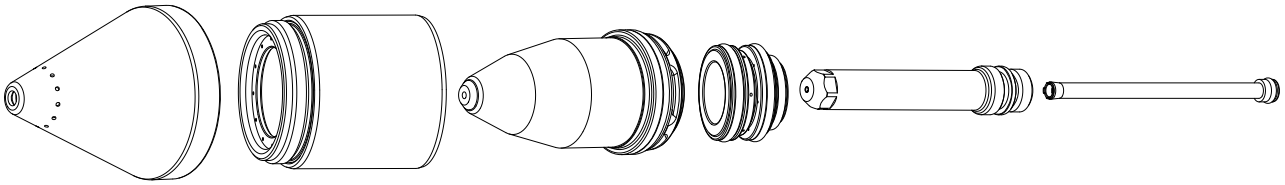
420735	**220935**	**420828**	**220529**	**420824**	**420823**
Shield	Retaining cap	Nozzle	Swirl ring	Electrode	Water tube

Metric

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	mm	mm	degrees	mm/min	seconds	mm	mm
V cut	130	7.6	6	22.5	2540	0.2	3.3	5.8
			6	37.5	2540	0.3	3.9	8.5
			6	45.0	2540	0.4	4.4	10.4
			10	22.5	2008	0.5	3.6	7.7
			10	37.5	1662	0.6	4.4	12.1
			10	45.0	1411	0.6	5.2	15.2
			12	22.5	1595	0.6	3.8	8.8
			12	37.5	1271	0.7	4.7	13.9
			12	45.0	1045	0.8	5.6	17.6
			16	22.5	1007	0.8	4.3	11.0
			16	37.5	744	1.0*	5.5	17.8
			16	45.0	573	1.0*	6.7	22.7
			20	22.5	636	1.0*	4.9	13.2
			20	37.5	436	1.0*	6.4	21.8
			20	45.0	314	1.0*	7.9	27.9

* Edge start only.

MAXPRO200 – Mild steel – 130 A – O_2 Plasma / Air Shield



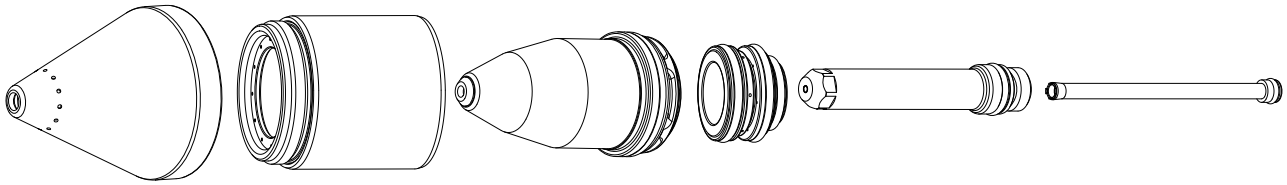
420735 Shield	**220935** Retaining cap	**420828** Nozzle	**220529** Swirl ring	**420824** Electrode	**420823** Water tube

English

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	inches	inches	degrees	in/min	seconds	inches	inches
V cut	130	0.300	0.250	22.5	100.0	0.3	0.12	0.23
			0.250	37.5	100.0	0.3	0.12	0.31
			0.250	45.0	96.1	0.4	0.12	0.37
			0.375	22.5	83.5	0.4	0.13	0.28
			0.375	37.5	69.7	0.5	0.13	0.42
			0.375	45.0	59.7	0.6	0.14	0.52
			0.500	22.5	57.9	0.6	0.14	0.35
			0.500	37.5	45.6	0.7	0.15	0.54
			0.500	45.0	37.0	0.8	0.16	0.66
			0.625	22.5	40.2	0.8	0.16	0.42
			0.625	37.5	29.8	1.0*	0.17	0.65
			0.625	45.0	23.0	1.0*	0.18	0.81
			0.750	22.5	27.9	1.0*	0.17	0.49
			0.750	37.5	19.5	1.0*	0.19	0.77
			0.750	45.0	14.3	1.0*	0.21	0.96

* Edge start only.

MAXPRO200 – Mild steel – 130 A – Air Plasma / Air Shield



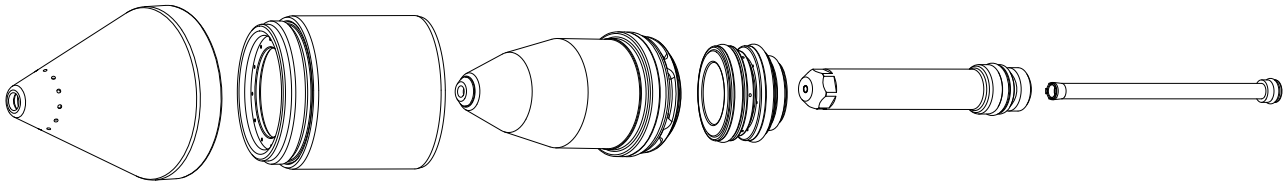
420735 Shield	**220935** Retaining cap	**420829** Nozzle	**220488** Swirl ring	**420824** Electrode	**420823** Water tube

Metric

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	mm	mm	degrees	mm/min	seconds	mm	mm
V cut	200	9.1	6	22.5	2540	0.3	3.4	5.9
			6	37.5	2540	0.3	4.0	8.6
			6	45.0	2540	0.4	4.5	10.5
			10	22.5	2058	0.6	3.7	7.8
			10	37.5	1672	0.7	4.5	12.2
			10	45.0	1397	0.8	5.3	15.3
			12	22.5	1598	0.7	3.9	8.9
			12	37.5	1246	0.8	4.8	14.0
			12	45.0	1005	0.9	5.5	17.5
			16	22.5	965	1.0	4.3	10.9
			16	37.5	692	1.0*	5.1	17.4
			16	45.0	519	1.0*	5.9	21.9
			20	22.5	582	1.0*	4.5	12.8
			20	37.5	384	1.0*	5.3	20.7
			20	45.0	268	1.0*	6.1	26.1
			25	22.5	310	1.0*	4.6	15.0

* Edge start only.

MAXPRO200 – Mild steel – 130 A – Air Plasma / Air Shield



420735 Shield	**220935** Retaining cap	**420829** Nozzle	**220488** Swirl ring	**420824** Electrode	**420823** Water tube

English

Bevel type	Current	Clearance	Material thickness	Cut angle	Cut speed	Pierce delay	Kerf offset	Edge offset
	A	inches	inches	degrees	in/min	seconds	inches	inches
V cut	130	0.360	0.250	22.5	100.0	0.3	0.13	0.24
			0.250	37.5	100.0	0.4	0.16	0.35
			0.250	45.0	100.0	0.4	0.18	0.43
			0.375	22.5	86.0	0.5	0.14	0.30
			0.375	37.5	70.6	0.6	0.17	0.46
			0.375	45.0	59.5	0.7	0.20	0.58
			0.500	22.5	57.6	0.7	0.16	0.36
			0.500	37.5	44.2	0.9	0.19	0.58
			0.500	45.0	35.2	1.0	0.22	0.72
			0.625	22.5	38.6	0.9	0.17	0.43
			0.625	37.5	27.7	1.0*	0.20	0.68
			0.625	45.0	20.9	1.0*	0.23	0.86
			0.750	22.5	25.8	1.0*	0.17	0.49
			0.750	37.5	17.4	1.0*	0.21	0.78
			0.750	45.0	12.4	1.0*	0.24	0.99
			1.000	22.5	11.6	1.0*	0.18	0.60

* Edge start only.