HYPERTHERM®
A Hypertherm Associates Brand

HPR Cartridges

Maximize arc time and minimize downtime with the complete HPR® cartridge portfolio. More time cutting. Less time changing consumables.

Increase Productivity When Cutting Thin to Thick Metal

The Hypertherm HPR cartridge replaces five standard consumables with a single-piece cartridge, simplifying mechanized plasma cutting and reducing downtime. Now available from 80 A to 400 A for mild steel cutting, the HPR cartridge brings cartridge-technology productivity benefits to thick metal cutting and beveling applications. Customers benefit from faster changeovers, fewer consumable errors, lower operating costs, and consistent cut quality, all with plug-and-play compatibility for existing HPRXD® systems.

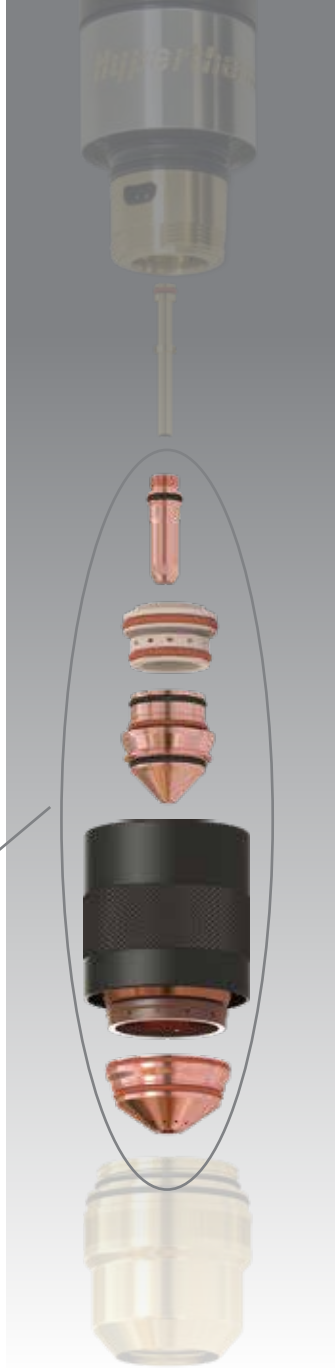
Our Complete Family of HPR Cartridges, from 80 A to 400 A, Simplifies Mechanized Cutting

Eliminates downtime and increases productivity

- **Reduces consumable parts by 80%,** giving operators more time cutting and less time changing consumables.
- **Eliminates consumable stack-up mistakes** that can lead to costly rework, plate damage, and torch or consumable failures.
- **Simplifies operator training** with one cartridge instead of five standard consumables.
- **Increases productivity for thick metal cutting and beveling applications** with the new 400 A cartridge.

Enhances cut quality

- **Provides consistent cut quality throughout consumable life** compared to standard HPR consumables.
- **Ensures peak cut** quality with factory-assembled, precision-aligned consumables in every cartridge.
- **Helps ensure operation at recommended amperages** with fewer consumable parts to manage.



One Cartridge Replaces Five Standard Consumables

HPR cartridges are available for your highest volume cutting processes.

Amps	Standard	Bevel
400	●	●
260	●	●
130	●	◆
80	●	◆

● No cut setting changes needed.

◆ 80 A and 130 A cartridges produce cuts with a small angle difference (3° or less) from bevel consumables. These angle differences are acceptable for most production environments. For additional bevel information, refer to HPR cartridge instruction manual 810992.

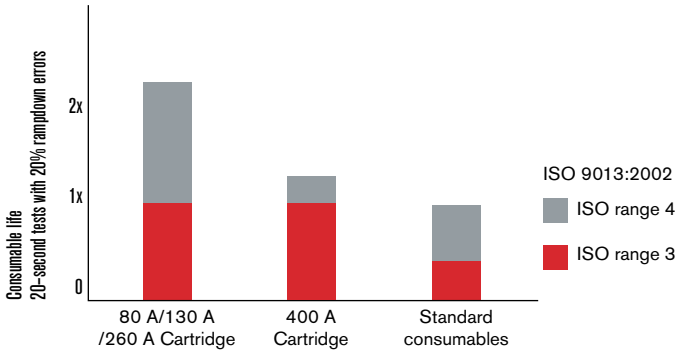
Simplifies consumable management

- **Simplifies inventory and ordering** with one consumable per process.
- **Delivers a toolless consumable** change without removing the torch.
- **Enables fast, foolproof installation** with a clearly marked single-piece cartridge.
- **Enables faster process changes and upgrades** with a simplified consumable platform.

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® 80–400 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.

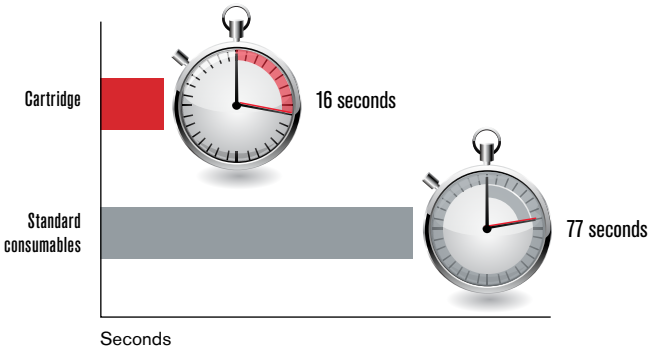
Reduces scrap, rework, and operating costs

- **Protects costly thick plates from damage** with error-proof consumable replacement.
- **Reduces costly rework and scrap** caused by consumable errors.
- **Eases secondary operations,** including grinding.
- **Decreases consumable costs associated** with purchasing, inventory, and storage.

"This cartridge cuts changeover time from over 2 minutes every time to just 10 seconds!"

–OPERATOR, STEEL SERVICE CENTER, OREGON USA

Consumable changeover time



Based on a typical consumable changeover of electrode and nozzle.

Provides plug-and-play compatibility with existing HPRXD systems

- **Installs easily on standard HPRXD systems** with direct receptacle compatibility.
- **Requires no setting changes,** eliminating additional setup requirements.
- **Maximizes equipment investment** by letting you use your existing HPRXD torch across all HPR processes.

Mild steel cartridge

HPR XD								
800	400	260	130	Amperage	Retaining cap (1)	Cartridges (10)	Water tube (1)	Torch (1)
●	●	●	●	80 A	420708	420803	420728	420729
●	●	●	●	130 A	420708	420705	420728	420729
●	●	●		260 A	420708	420715	420728	420729
●	●			400 A	420708	420727	420728	420729

Additional parts available

Part number	Description
528101	Torch kit: HPRXD cartridge torch
528102	Kit: 420803 HPRXD cartridge 80 A MS 3-pk
528103	Kit: 420705 HPRXD cartridge 130 A MS 3-pk
528104	Kit: 420715 HPRXD cartridge 260 A MS 3-pk
528105	Kit: HPRXD cartridge multi-amps MS 3-pk (80 A, 130 A, 260 A)
528106	Kit: HPRXD cartridge torch rebuild
528107	Kit: O-ring cartridge torch
528108	Kit: Electronics PM kit: HPR130XD cartridge
528109	Kit: Electronics PM kit: HPR260XD cartridge (200–240V)
528110	Kit: Electronics PM kit: HPR400/800XD cartridge (200–240V)
528111	Kit: Electronics PM kit: HPR260/400/800XD cartridge (380–600V)
528165	Kit: HPRXD cartridge 400 A MS 3-pk
528166	Kit: HPR cartridge high-amps 3-pk (130 A, 260 A, 400 A)
026919	O-ring: cartridge upper shield
026934	O-ring: cartridge lower shield

Learn more at www.hypertherm.com/hprcartridge

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