

RASOR™ 90/120 SilverLine® OXYGEN CUTTING PARAMETERS

To achieve maximum SilverLine® Electrode life:

- A fully used electrode will have a pit depth of .100 in. (2.5 mm). Standard electrodes only achieve a pit depth of .050 in. (1.3 mm).
- As the electrode wears, the torch will get closer to the plate. To compensate for this, increase arc voltage in 2-volt increments up to 10 volts higher than the initial setting.
- Make sure the torch is purged for at least 30 seconds after each parts change to remove all moisture.
- Leak check the torch after purging to make sure all o-ring and metal-to-metal seals are working as designed.

To achieve maximum nozzle life:

- Use 90 amp shield and spacer ring for all cutting. This shield provides greater nozzle protection.
- Use at least 3 kg/cm² (bar) assist gas on 1/4" plate and above. Increased assist gas flow helps to keep the nozzle clean and cool.
- Clean the shield and nozzle periodically to remove slag buildup and prevent double arcing.
- Use the lowest possible pilot arc setting to achieve arc transfer. Pilot current is adjustable with a toggle switch on the power supply or as a function in the Operator Control Unit (OCU).

Recommended Parameters for Mild Steel Cutting With Oxygen.

Metal thickness		Plasma Pressure	Air Assist	Arc Current	Nozzle Size	Arc Voltage	Pierce Height	Cut Speed
In.	mm	Kg/cm ²	Kg/cm ²	A	mm	V	In.	in./min
0.062	1.5	6	0	37	0.8	115	.125	200
0.093	2.4	6	0	37	0.8	115	.125	150
0.125	3	6	2-2	45	0.8	120	.125	125
0.187	5	6	2-3	45	0.8	125	.125	80
1/4	6	6	3-4	90	1.1	132	.250	70
5/16	8	6	3-4	90	1.1	136	.250	60
3/8	10	6	4-5	90	1.1	138	.250	50
1/2	12	6	4-5	120	1.3	130	.300	60
5/8	16	6	5-6	120	1.3	130	.300	45
3/4	20	6	5-6	120	1.3	136	.350	35

- Plasma and Assist pressures are adjusted at Plasma Unit.
- Cut speed is adjusted through Select Plate Menu function in the OCU.
- Arc voltage, cut height, and pierce height parameters are changed by pressing the 8 on the OCU keypad.
- Use feeds and speeds charts in operator's manual for parameters not listed above.



Rasor 120 Torch
K35-006 65-0442-006
O-Ring Kit
K35-021 65-0434-021
Cooling Tube,
90/120 Amp (red band)
C35-110 65-0442-009

SilverLine® Electrode
90/120 Amp
C35-1020 65-0442-001

Ceramic Guide
(with O-Ring)
C35-350 65-0434-020

Swirler, 90 Amp (CCW)
C35-018 65-0434-018
Swirler, 120 Amp (CW)
C35-003 65-0442-003

#8 Nozzle, 0.8 mm
C35-160 65-0434-017
#11 Nozzle, 1.1mm
C35-180 65-0434-007
#13 Nozzle, 1.3mm
C35-002 65-0442-002

Cap #1
C35-015 65-0434-015

Spacer Ring, 90 Amp
C35-540 65-0434-022
Spacer Ring, 120 Amp
C35-250 65-0442-004

Shield Cap, 90 Amp
C35-019 65-0434-019
Shield Cap, 120 Amp
C35-905 65-0442-005

Cap #2
K35-016 65-0434-016

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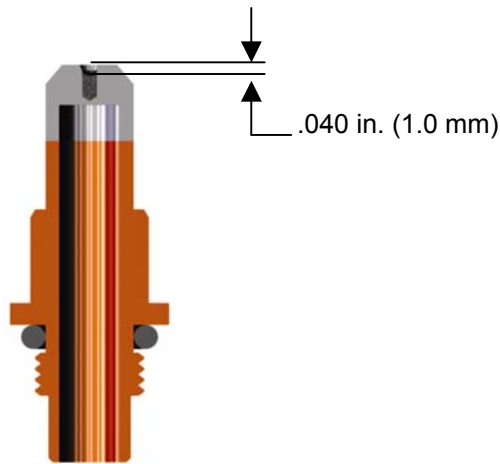
Centricut, Two Technology Drive, West Lebanon, NH USA 03784



Razor 90/120 SilverLine® Oxygen Electrode Life

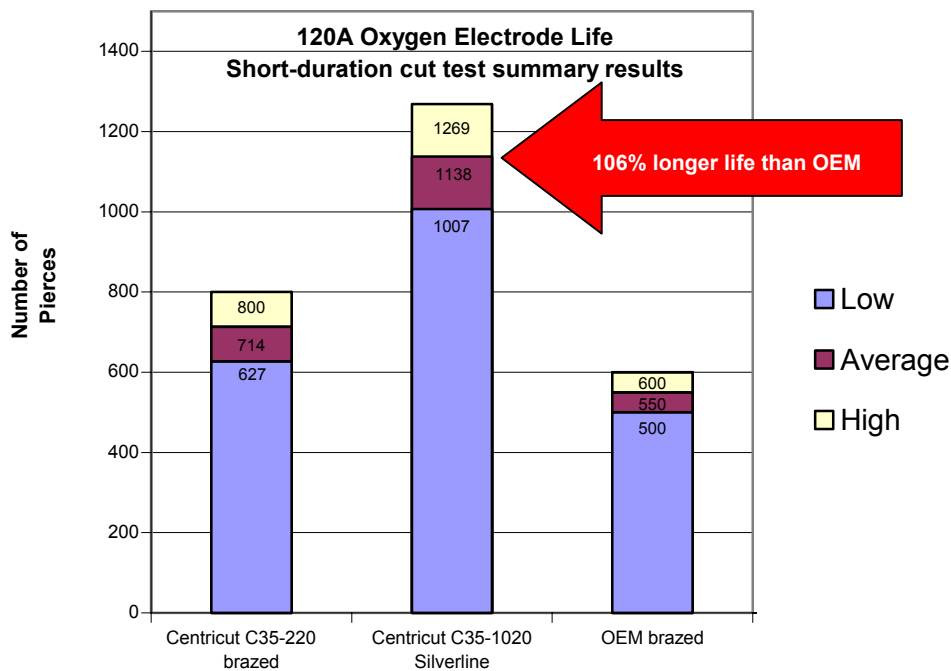
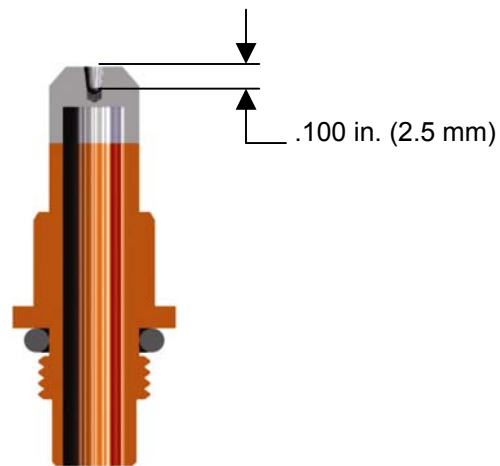
Half Used Electrode

This SilverLine® electrode is only half consumed. The pit in the center of the part is .040 in. (1.0 mm). Electrodes are often removed prematurely due to cut quality deterioration related to nozzle failure. Additional life can be achieved by replacing the nozzle.



Fully Used Electrode

This SilverLine® electrode has provided full use. The pit depth is .100 in. (2.5 mm). The operator increased the arc voltage by 8 volts from the first cuts made with this electrode to the last. This maintains a constant distance between the torch and the work-piece throughout the life of the electrode.



Note: Test performed on ¼ Mild Steel

If you do not achieve **excellent results** using **SilverLine® technology** please call our Technical Support Team. Our engineers are available 8-5 EST to help you optimize your system.

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