

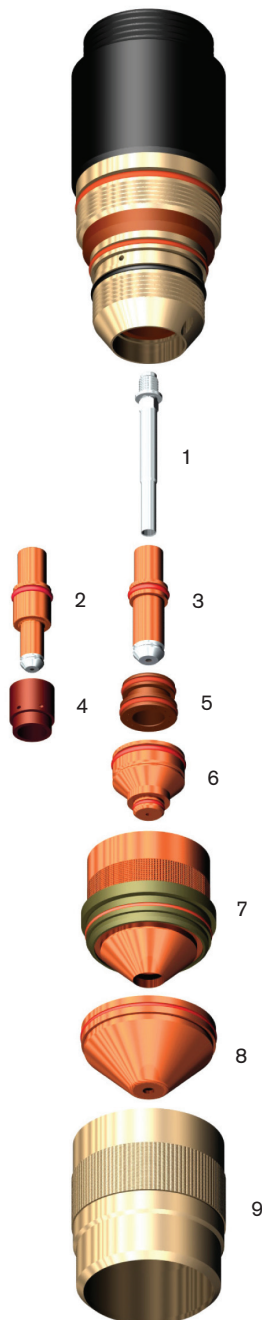
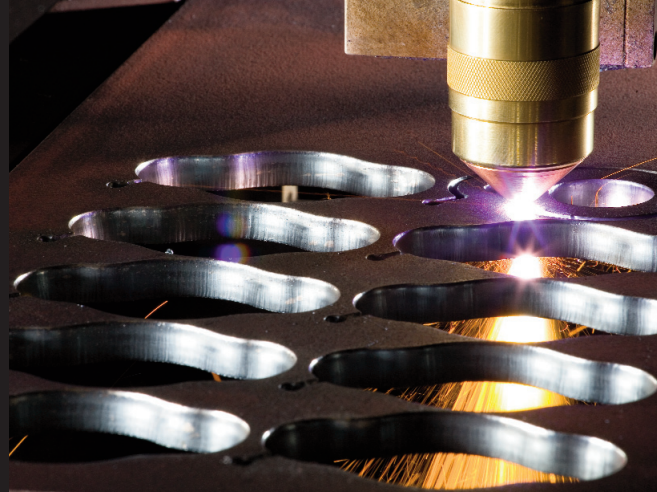
Upgrade to SilverLine® technology!

Patented SilverLine technology improves electrode and nozzle life—so you can cut more metal with one set of consumables. To start saving with SilverLine just follow the instructions on our Quick Setup card: the more you cut the more you save!

Centricut product for Kaliburn (formerly InnerLogic)

FineLine®

Quick Set-up



To achieve maximum SilverLine electrode life

A fully used SilverLine electrode will have a pit depth of .060 in. (1.5 mm). Note: This is deeper than the recommended pit depth for standard parts .040" (1 mm).

Purge torch: after each parts change purge the torch for at least 30 seconds to remove residual moisture.

Leak check the torch after purging to make sure all o-ring and metal-to-metal seals are working as designed.

Adjust gas flows: Plasma gas flow rate is critical. High flow will cause rapid electrode wear and hard starting. Low flow will cause uncontrolled arcing. (See parameters)

Adjust arc voltage: 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.

Avoid ramp-down errors: Ramp down errors can occur when rip cutting off the plate or when leading out to the dropped part as the arc stretches. These "blowouts" shorten electrode life by 10 or more starts per occurrence.

To achieve maximum nozzle life

With careful use, the nozzle can last 1:1 with the SilverLine electrode.

Properly tighten the nozzle retainer: Make sure the nozzle retainer is sealed tightly against the nozzle to maintain a metal-to-metal seal and prevent leaking.

Pierce at correct height: Piercing too low causes molten metal (spatter) to hit the shield and nozzle. This is the most common cause of premature nozzle failure. Piercing too high can cause slow arc transfer and misfires. In most applications, 1/4" (6 mm) pierce height works.

Adjust shield flows: Correct shield gas flows during pre-flow protect the nozzle and shield from damage. Make sure pre-flow is adjusted according to the cut chart.

Clean the nozzle and shield: Periodically clean the nozzle and shield to remove spatter. This will prevent double arcing.

Adjust arc voltage: As parts wear, adjust arc voltage up in 2-volt increments to keep the shield from dragging on the plate. Damage to the shield and nozzle occurs if the torch contacts the plate during cutting.

#	Centricut Part Number	Reference	Description
1	C104-112	200112	Cooling tube
	C104-214	200214	Electrode, 50-70 Amp
2	C104-1005	200215	SilverLine electrode, 100 Amp
	C104-215	200215	Electrode, 100 Amp
	C104-115	202115	Electrode, 200 Amp
	C104-1015	202115	SilverLine electrode, 200 Amp
	I104-279	200279	Swirl ring, 30 Amp
3	C104-277	200277	Swirl ring, 100 Amp
4	C104-221	200221	Swirl ring, 200 Amp
	C104-223	200223	Nozzle, 50 Amp
	C104-224	200224	Nozzle, 70 Amp
	C104-225	200225	Nozzle, 100 Amp, MS
5	C104-239	200239	Nozzle, 100 Amp, AL/SS
	C104-227	200227	Nozzle, 200 Amp
	C104-218	200218	Retaining cap, 100 Amp
6	C107-266	277266,	
		200219	Retaining cap, 200/275 Amp
7	I104-233	200233	Shield cap, 30 Amp
	C104-231	200231	Shield cap, 50-70 Amp
	C104-232	200232	Shield cap, 100 Amp
8	C104-234	200234	Shield cap, 200 Amp
	C104-210	200210	Outer cap

Fine Line 100pc & 200pc Amp cut charts Mild Steel 02/Air

Material Thickness		Amps	Preflow	Plasma	Shield	Arc	Cut Height		Pierce Height		Speed		Motion Delay
(in.)	(mm)	A	(Air)psi	(O2) psi	(Air)psi	Voltage	in.	mm	in.	mm	in/min	mm/min	msec
1/4	6	100	20	80	35	125	0.090	2	0.125	3	125	3.18	100
3/8	10	100	20	80	35	130	0.130	3	0.175	4	90	2.29	200
1/2	13	100	20	80	35	135	0.155	4	0.200	5	65	1.65	250
5/8	16	100	20	80	35	140	0.185	5	0.200	5	45	1.14	250
3/4	19	100	20	80	35	145	0.185	5	0.200	5	35	0.889	300
1/4	6	200	15	60	60	125	0.125	3	0.200	6	180	4.57	200
3/8	10	200	15	60	60	125	0.125	3	0.225	6	140	3.56	200
1/2	13	200	15	60	60	125	0.125	3	0.250	6	110	2.79	300
5/8	16	200	15	60	60	127	0.125	3	0.250	6	80	2.03	500
3/4	19	200	15	60	65	132	0.250	4	0.300	8	65	1.65	700
1	25	200	15	60	65	140	0.250	4	0.300	8	45	1.14	800
1 1/4	32	200	15	60	65	150	0.250	4	0.300	8	25	0.635	200
1 1/2	39	200	15	60	65	160	0.300	8	0.300	8	17	0.432	200
1 3/4	45	200	15	60	65	170	0.345	9	0.300	8	12	0.305	200
2	51	200	15	60	65	190	0.500	13	0.300	8	12	0.178	200

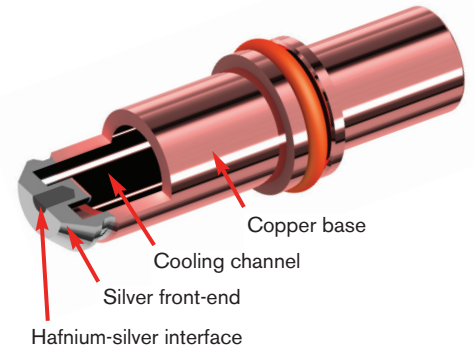
SilverLine electrode technology

SilverLine electrodes involve welding a solid silver front-end to a copper electrode base and inserting a hafnium pin into the silver. Silver front-end electrodes offer several advantages over traditional copper designs:

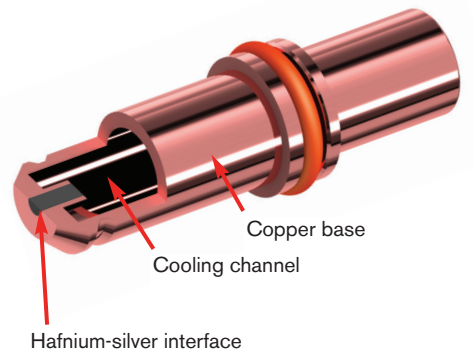
- 1) The hafnium-silver bond is stronger, allowing a deeper pit depth in the hafnium as the electrode is used.
- 2) The heat transfer properties of silver and silver oxides are superior which improves heat dissipation during use and slows the rate of hafnium wear.

Both of these benefits combine to prolong electrode life and lower the cost of cutting. See above for test results.

Centricut SilverLine electrode



OEM electrode



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Hypertherm, Inc.
Hanover, NH 03755 USA
603-643-3441 Tel

Hypertherm Europe B.V.
4704 SE Roosendaal, Nederland
31 165 596907 Tel

Hypertherm (S) Pte Ltd.
Singapore 349567
65 6 841 2489 Tel

HYPER THERM BRASIL LTDA.
Guarulhos, SP - Brasil
55 11 6409 2636 Tel

Hypertherm (Shanghai) Trading Co., Ltd.
PR China 200052
86-21 5258 3330 /1 Tel

www.hypertherm.com