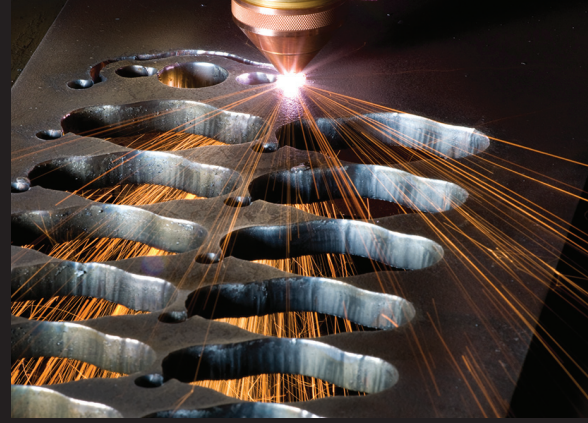


# Hypertherm®

Upgrade to high quality Centricut consumables to lower your overall cost of cutting

Centricut consumables for ESAB® PT-36 and PT-36R torches



## Quick Set-up

### ACHIEVE MAXIMUM CONSUMABLE LIFE

**Use electrode to full life:** A fully used SilverLine electrode will have a pit depth of .120" (3.0 mm). This is deeper than the recommended pit depth for standard parts of .090" (2.3 mm).

**Properly tighten the nozzle retaining cup:** Make sure the retaining cup is sealed tightly against the nozzle to prevent leaking.

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

**Leak check:** After purging the torch, make sure all o-ring seals are tight and there are no torch coolant leaks.

**Adjust plasma gas pressure:** Plasma gas flow rate is critical. High flow will cause rapid electrode wear and hard starting. Low flow will cause uncontrolled arcing.

**Adjust shield gas pressure:** Refer to the cut chart for optimum shield gas pressure. Having the correct start shield flow provides protection to the nozzle and shield during the piercing process.

**Pierce at correct height:** Refer to the cut chart for optimum pierce (initial) height. Piercing too low causes molten metal (spatter) to hit the shield and nozzle – the most common cause of premature nozzle failure. Piercing too high can cause misfires and nozzle damage.

**Adjust arc voltage:** As the consumables wear, the torch will get closer to the plate. To maintain optimum cutting height, increase arc voltage in 5-volt increments, up to 20 volts higher than the initial setting.

**Avoid arc stretching:** This can occur during rip cutting off the plate or when the lead out is improperly programmed. This shortens consumable life.

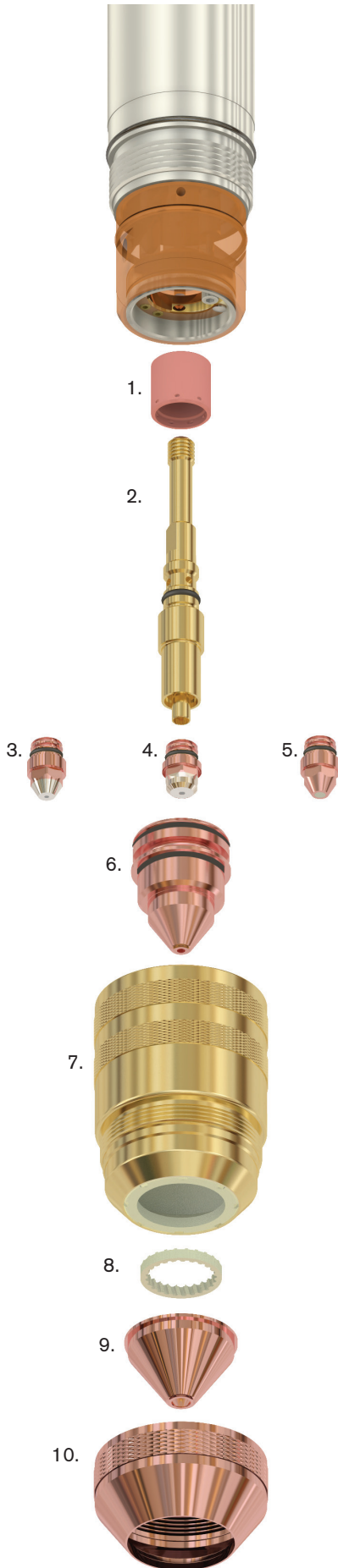
**Clean the nozzle and shield:** Periodically clean the nozzle and shield to remove spatter. This will prevent double arcing which shortens consumable life.

Centricut consumables for the ESAB PT-36 torch are designed to be “plug and play” – no special set-up is required.



**CENTRICUT**  
Innovation. Integrity. Hypertherm

# Centricut consumables for the ESAB PT-36 torch deliver value to your plasma cutting process through long life and exceptional quality.



## PARTS LIST

Centricut number	Reference number	Description
L122-804	0558003804	Torch body
C10-483	0558001626	Torch sleeve
C47-071	0558003858	Contact ring
C47-073	37073	Screw, contact ring
1. C122-457	0558005457	Gas swirl baffle, 4X.022, 35 – 70 amp
C122-533	0558002533	Gas swirl baffle, 4X.032, 100 – 280 amp
C10-660	0558001625	Gas swirl baffle, 8X.047, 300 – 600 amp
C122-530R	0558002530R	Gas swirl baffle, 8X.047, Rev, 360 – 450 amp
2. L122-924	0558003924	Electrode holder
3. C122-1059	0558005459	SilverLine electrode, O <sub>2</sub> , 50 amp
4. C122-1014	0558003914	SilverLine electrode, O <sub>2</sub> , 100 – 300 amp
C122-1091	0558007791	SilverLine electrode, O <sub>2</sub> , 360 – 450 amp
5. C122-928	0558003928	Electrode, SS/Al, 600 amp
6. C122-908	0558006908	CoolFlow nozzle, .08 mm, 35 amp
C122-8010	0558008010	CoolFlow nozzle, 1.0 mm, PR, 45 – 55 amp
C122-6010	0558006010	CoolFlow nozzle, 1.0 mm, 50 amp
C122-014	0558006014	CoolFlow nozzle, 1.4 mm, 100 amp
C122-018	0558006018	CoolFlow nozzle, 1.8 mm, 130 amp
C122-020	0558006020	CoolFlow nozzle, 2.0 mm, 200 amp
C122-023	0558006023	CoolFlow nozzle, 2.3 mm, 280 amp
C122-025	0558006025	CoolFlow nozzle, 2.5 mm, 300 amp
C122-030	0558006030	CoolFlow nozzle, 3.0 mm, 360 amp
C122-036	0558006036	CoolFlow nozzle, 3.6 mm, 450 amp
C122-041	0558006041	CoolFlow nozzle, 4.1 mm, 600 amp
7. C47-082	37082	Nozzle retainer cup
8. C47-944	21944	Diffuser
L47-796	21796	Diffuser, 50 amp
9. C122-624	0558007624	Shield, 2.4 mm, 45 – 55 amp
C122-130	0558006130	Shield, 3.0 mm, 35 – 50 amp
C122-141	0558006141	Shield, 4.1 mm, 70 – 280 amp
C122-166	0558006166	Shield, 6.6 mm, 290 – 450 amp
C122-199	0558006199	Shield, 9.9 mm, 360 – 600 amp
10. C47-081	37081	Shield retainer
L122-616	0558004616	Shield retainer, insulated

Contact Hypertherm to locate a distributor near you.

# Hypertherm®

## Centricut consumables for ESAB

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

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

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

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

**Hypertherm (India) Thermal Cutting Pvt. Ltd.**  
Chennai, Tamil Nadu  
91 0 44 2834 5361 Tel

**Hypertherm Brasil Ltda.**  
Guarulhos, SP - Brasil  
55 11 2409 2636 Tel

**Hypertherm México, S.A. de C.V.**  
México, D.F.  
52 55 5681 8109 Tel

[www.hypertherm.com](http://www.hypertherm.com)

Hypertherm, Centricut, SilverLine and CoolFlow 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 owners. Hypertherm is in no way affiliated with ESAB.