

Consumables for Kjellberg® FineFocus® 800 Plus

TECHNOLOGY UPGRADE

CENTRICUT VS OEM

Upgrade to Centricut performance consumables to lower your operating costs without sacrificing cut quality and productivity.

Lower overall costs

- Centricut consumables last more than 25% longer than Kjellberg Yellow XLife consumables.
- Full line of consumables for all cutting applications are competitively priced compared to the OEM.
- Local stocking and fast delivery reduce your inventory costs.

Hypertherm patented technology

- As the recognized global leader in plasma cutting, Hypertherm incorporates the latest engineered technologies into all consumable products.
- SilverLine® electrodes and CoolFlow™ nozzles deliver exceptional cut quality and fast cutting speeds over the full life of the consumables.
- Centricut consumables set the standard by which other manufacturers measure themselves.

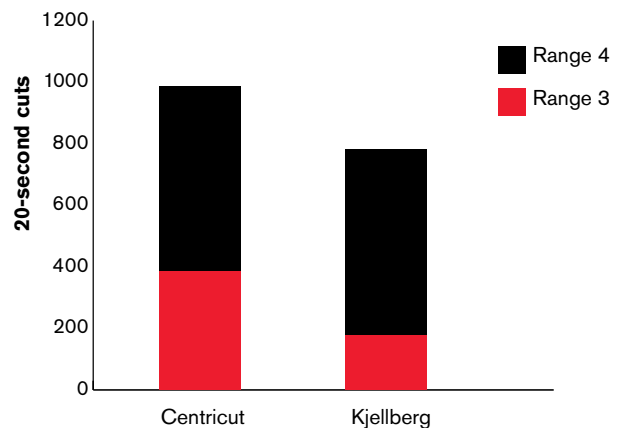
Cut with confidence – it's Hypertherm

- Designed with critical-to-function tolerances to deliver the best quality product every time.
- Precision manufacturing of consumables assures consistency of parts set to set.
- World-class plasma-process technical support.
- Easy to use – no special system set up required.



Consumable life with ISO 9013.2002(E) cut quality ranges noted

250 A cutting of 19 mm mild steel



SilverLine electrode

Solid silver front end enhances performance



Copper back end reduces cost

Yellow XLife electrode

All silver electrode increases cost



CoolFlow nozzle

Deep cooling groove maximizes life

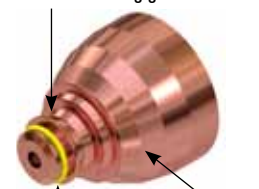


Angled o-ring seal remains cooler

Thicker walls dissipate heat and extend life

Yellow XLife nozzle

Shallower cooling groove



Hotter o-ring

Thinner walls

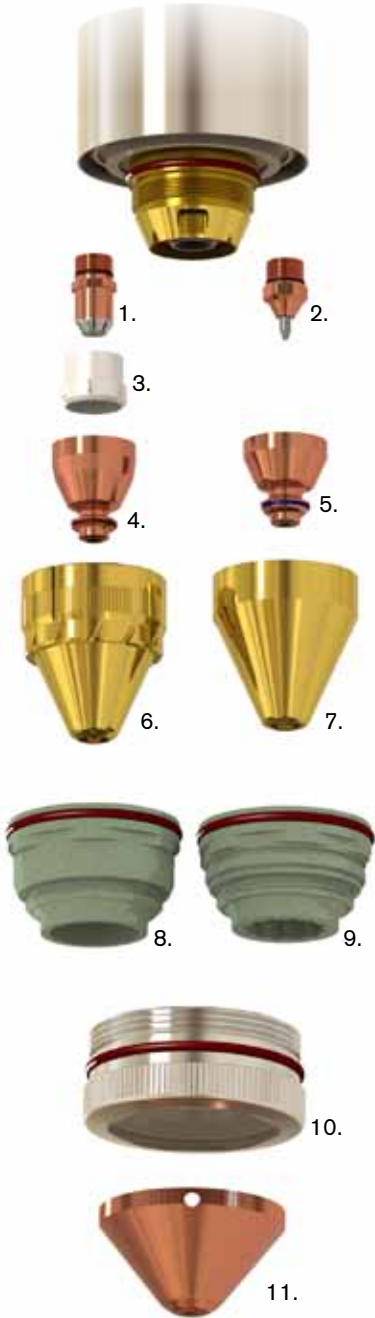
COMPATIBLE WITH

Kjellberg torch

- PB-S80W

PARTS LIST

| Reference number | Article number | Description | Centricut number |
|---|------------------------|---|------------------|
| FineFocus 800 Plus Consumables O₂ | | | |
| 1. | T012Y .11.844.921.300 | SilverLine electrode | C117-1000 |
| 3. | T101 .11.836.921.153 | Gas guide, 6x0.8, cw | C117-153 |
| | T102 .11.836.921.154 | Gas guide, 3x0.6, cw | C117-154 |
| | T104 .11.836.921.1542 | Gas guide, 3x0.4, cw | C117-542 |
| 4. | T2115Y .11.846.921.415 | CoolFlow nozzle, 120 A | C117-015 |
| | T2120Y .11.846.921.420 | CoolFlow nozzle, 200 A | C117-020 |
| | T2125Y .11.846.921.425 | CoolFlow nozzle, 250 A | C117-025 |
| | T2127Y .11.846.921.427 | CoolFlow nozzle, 300 A | C117-027 |
| | T2130Y .11.846.921.430 | CoolFlow nozzle, 360 A | C117-030 |
| 6. | T3030 .11.836.901.163 | Nozzle cap, 30° | C117-163 |
| | T3045 .11.836.901.164 | Nozzle cap, 45° | C117-164 |
| | T3060 .11.836.901.165 | Nozzle cap, 60° | C117-165 |
| 8. | T521 .11.836.901.271 | Swirl gas nozzle | C117-271 |
| | T522 .11.836.921.271 | Swirl gas nozzle | C117-0271 |
| | V522 .11.833.121.271 | Swirl gas nozzle | C117-1271 |
| 10. | V501 .11.833.101.261 | Protective cap | C53-261 |
| | V502 .11.833.121.261 | Protective cap | C117-261 |
| 11. | V4335 .11.833.101.155 | Swirl gas cap, 3.5 mm | C117-155 |
| | V4345 .11.833.101.157 | Swirl gas cap, 4.5 mm | C117-157 |
| | T902Y .11.844.901.152 | Cooling tube | C117-152 |
| Consumables air | | | |
| | K2 .12.40870 | Electrode, Air | C53-870 |
| | .12.40860 | Gas guide PB-S75 Air/O ₂ | C53-860 |
| | L2 .12.40850 | Nozzle, Air, 250 A, 2.5 mm | C53-850 |
| 7. | V3000 .12.37790 | Nozzle cap | C53-790 |
| 9. | V522 .11.833.121.271 | Swirl gas nozzle | C117-1271 |
| 10. | V502 .11.833.121.261 | Protective cap | C117-261 |
| | T502 .11.841.721.081 | Protective cap | C117-081 |
| 11. | V4350 .11.833.101.158 | Swirl gas cap 5 dry | C53-158 |
| | .12.51440 | Cooling Tube Air PB-S75 | K53-440 |
| Consumables ArH₂ | | | |
| 2. | K5 .11.828.911.550 | Electrode, ArH ₂ | C117-0550 |
| 5. | A1 .12.37780 | CoolFlow nozzle, 120 A ArH ₂ , 1.5 mm | C117-780 |
| | A3 .11.828.511.620 | CoolFlow nozzle, 180 A ArH ₂ , 2.0 mm | C117-620 |
| | A2 .12.40910 | CoolFlow nozzle, 300 A, ArH ₂ , 2.3 mm | C117-910 |
| 7. | V3000 .12.37790 | Nozzle cap | C53-790 |
| 9. | V522 .11.833.121.271 | Swirl gas nozzle | C117-1271 |
| 10. | V502 .11.833.121.261 | Protective cap | C117-261 |
| | T502 .11.841.721.081 | Protective cap | C117-081 |
| 11. | V4330 .11.833.101.1550 | Swirl gas cap 3.0 dry | C117-550 |
| | V4335 .11.833.101.155 | Swirl gas cap 3.5 dry | C117-155 |
| | V4340 .11.833.101.156 | Swirl gas cap 4.0 dry | C117-156 |
| | V4345 .11.833.101.157 | Swirl gas cap 4.5 dry | C117-157 |
| | V4350 .11.833.101.158 | Swirl gas cap 5.0 dry | C53-158 |
| | V4360 .11.833.101.159 | Swirl gas cap 6.0 dry | C117-159 |
| | .11.828.911.230 | Cooling tube PB-S75 ArH ₂ | C117-230 |



To achieve maximum consumable life

A fully used SilverLine® electrode will have a pit depth of 2.5 mm (.100").

Properly tighten the nozzle cap: Make sure the nozzle cap is sealed tightly against the nozzle to maintain a proper seal and prevent leaking.

Purge torch and leak check: After each parts change purge the torch for at least 30 seconds to remove residual moisture. Check for leaks.

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 cutting tables in your owner's manual.)

Pierce at correct height: Piercing too low causes molten metal (spatter) to hit the swirl gas cap and nozzle. This is the most common cause of premature nozzle failure. Piercing too high can cause slow arc transfer and misfires.

Adjust arc voltage: As the electrode wears, the torch will get closer to the plate. To maintain optimum cutting height, increase arc voltage in 2-volt increments, up to 10 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 swirl gas cap: Periodically clean the nozzle and swirl gas cap to remove spatter. This will prevent double arcing which shortens consumable life.

Adjust swirl gas flows: Correct swirl gas flows during pre-flow protect the nozzle and swirl gas cap from damage. Make sure pre-flow is adjusted according to the cutting tables in your owner's manual.

Contact Hypertherm to locate a distributor near you.

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