

Hypertherm®

Centricut consumables for Kjellberg® FineFocus® 800 Plus and HiFocus® 280i/360i/440i

TECHNOLOGY UPGRADE

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

Hypertherm patented technology

- SilverLine® and CoolFlow® technologies deliver exceptional cut quality, long life, and fast cutting speeds.
- SilverLine and CoolFlow consumables set the standard by which other manufacturers measure themselves.
- Run SilverLine electrodes and CoolFlow nozzles for their full life without risking damage to other consumables.

Lower overall cost

- Competitively priced compared to the OEM.
- Local stocking on a global basis – product is delivered quickly reducing your inventory carrying costs.

Hypertherm quality and consistency

- Precision manufacturing assures reliability of your cutting process.
- Designed with critical-to-function tolerances to deliver the best quality product every time.
- Easy to use – no special system set-up required.

SilverLine electrodes and CoolFlow nozzles are engineered and manufactured to Hypertherm standards, with industry-leading quality and consistency.



CENTRICUT VS OEM

SilverLine electrode

Solid silver front end enhances performance



Copper back end reduces cost

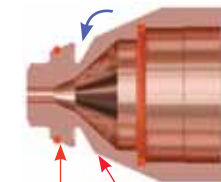
Yellow XLife electrode



All silver electrode increases cost

CoolFlow nozzle

Deep cooling groove maximizes life

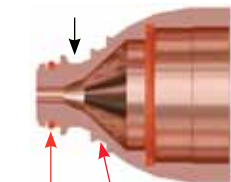


Angled o-ring seal remains cooler

Thicker walls dissipate heat and extend life

Yellow XLife nozzle

Shallower cooling groove



Hotter o-ring

Thinner walls

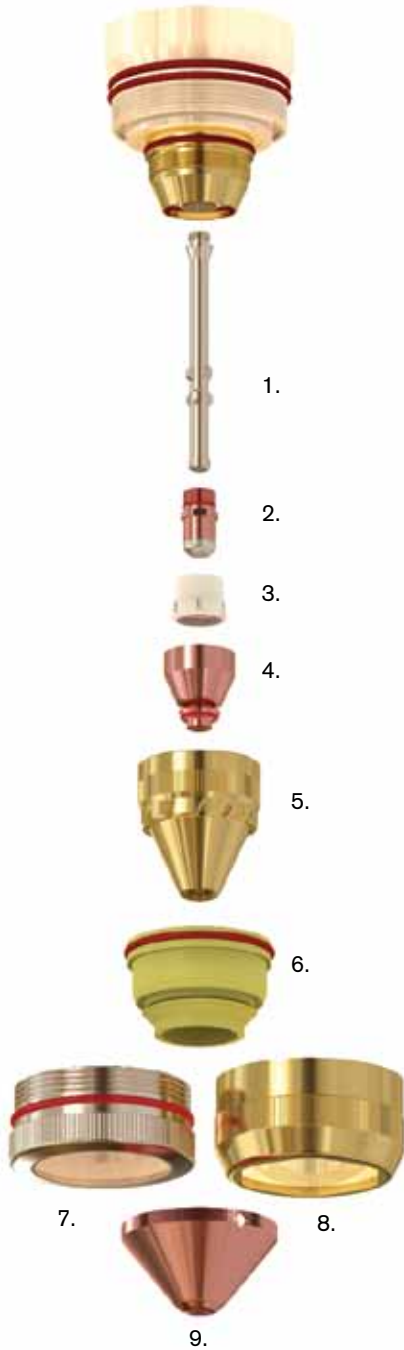
COMPATIBLE WITH

Kjellberg torches

- PerCut 370.2
- PB-S80W



Centricut products deliver long consumable life and exceptional cut quality at a competitive price.



OPERATOR INFORMATION

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: 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 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 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.

PARTS LIST

Reference number	Article number	Description	Centricut number
1.	T902Y	Water tube	C117-152
2.	T012Y	SilverLine electrode	C117-1300
3.	T101	Gas guide, 6x0.8, cw	C117-153
	T102	Gas guide, 3x0.6, cw	C117-154
	T104	Gas guide, 3x0.4, cw	C117-542
4.	T2115Y	CoolFlow nozzle, 120 amp	C117-415
	T2120Y	CoolFlow nozzle, 200 amp	C117-420
	T2125Y	CoolFlow nozzle, 250 amp	C117-425
	T2127Y	CoolFlow nozzle, 300 amp	C117-427
	T2130Y	CoolFlow nozzle, 360 amp	C117-430
5.	T3030	Nozzle cap, 30°	C117-163
	T3045	Nozzle cap, 45°	C117-164
	T3060	Nozzle cap, 60°	C117-165
6.	T521	Swirl gas nozzle, PB-S80	C117-271
	T522	Swirl gas nozzle, PB-S80	C117-0271
	V522	Swirl gas nozzle, PerCut 370.2	C117-1271
7.	V501	Protective cap, PB-S80	C53-261
	V502	Protective cap, PB-S80	C117-261
8.	T502	Protective cap, PerCut 370.2	C117-081
9.	V4335	Swirl gas cap, 3.5	C117-155
	V4345	Swirl gas cap, 4.5	C117-157

Contact Hypertherm to locate a distributor near you.

Hypertherm®

Centricut consumables for Kjellberg

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