



# Consumables for Kjellberg® PA-S70, PA-S75, FineFocus® 800 and FineFocus 900

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 15% longer than Kjellberg mild steel 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.

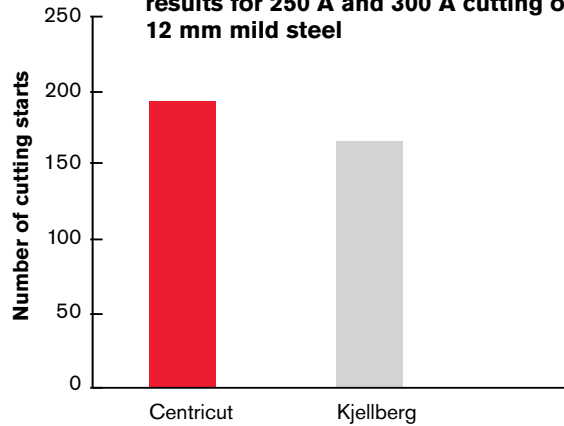
**Hypertherm patented technology**

- 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.

Average consumable life from field test results for 250 A and 300 A cutting of 12 mm mild steel



**SilverLine electrode**

Solid silver front end enhances performance



Copper back end reduces cost

**Kjellberg electrode**

All silver electrode increases cost



**CoolFlow nozzle**

Deep cooling groove maximizes life

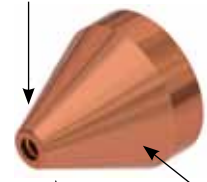


O-ring seal prevents torch leaking

Thicker walls dissipate heat and extend life

**Kjellberg nozzle**

No cooling groove



No o-ring seal

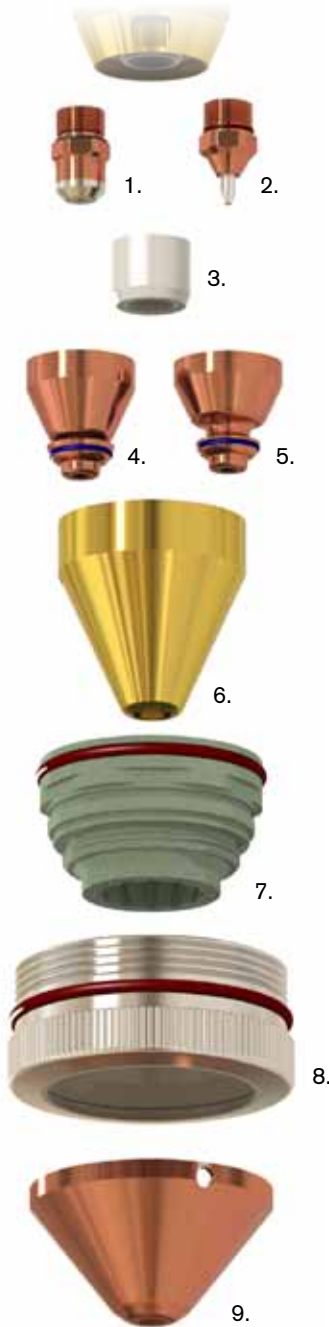
Thinner walls



**COMPATIBLE WITH**

**Kjellberg torch**

- PB-S70
- PB-S75
- PB-S77



### 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.

### PARTS LIST

| Reference number | Article number | Description                                      | Centricut number |
|------------------|----------------|--|------------------|
| 1.               | K2-XL          | SilverLine electrode                             | C53-1000         |
|                  | K2             | Electrode  | C53-870          |
| 2.               | K5             | Electrode ArH <sub>2</sub>                       | C117-0550        |
| 3.               |                | Gas guide cap                                    | C53-860          |
| 4.               | L1-XL          | CoolFlow nozzle, O <sub>2</sub> , 160A           | C53-920          |
|                  | L2-XL          | CoolFlow nozzle, O <sub>2</sub> , 250A           | C53-925          |
|                  | L4-XL          | CoolFlow nozzle, O <sub>2</sub> , 300A           | C53-927          |
|                  | L1             | Nozzle, Air, 160A, 2.0 mm                        | C53-050          |
|                  | L2             | Nozzle, Air, 250A, 2.5 mm                        | C53-850          |
| 5.               | A1             | CoolFlow nozzle, ArH <sub>2</sub> , 120A, 1.5 mm | C117-780         |
|                  | A3             | CoolFlow nozzle, ArH <sub>2</sub> , 180A, 2.0 mm | C117-620         |
|                  | A2             | CoolFlow nozzle, ArH <sub>2</sub> , 300A, 2.3 mm | C117-910         |
| 6.               | V3000          | Nozzle cap                                       | C53-790          |
| 7.               | V521           | Swirl gas nozzle                                 | K53-271          |
| 8.               | V501           | Protective cap                                   | C53-261          |
|                  |                | Protective cap PB-S75                            | K53-160          |
| 9.               | V4540          | Swirl gas cap, 4.0 mm                            | K53-1156         |
|                  | V4550          | Swirl gas cap, 5.0 mm                            | C53-158          |
|                  |                | Cooling tube PB-S75 ArH <sub>2</sub>             | C117-230         |
|                  |                | Cooling tube PB-S75 Air                          | K53-440          |

**Contact Hypertherm to locate a distributor near you.**

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