

Upgrade to SilverLine® technology!

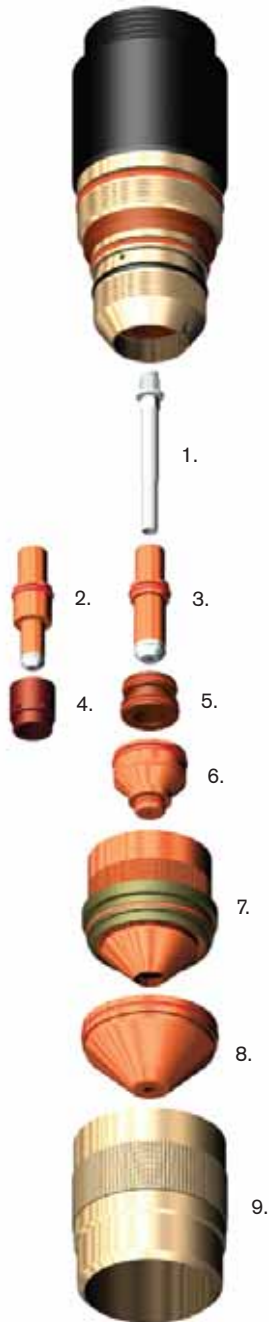
Patented SilverLine technology improves electrode and nozzle life so you can cut more metal with one set of consumables. To start saving with SilverLine just follow the instructions on our Quick Setup card: the more you cut the more you save!



Centricut product for Kaliburn (formerly InnerLogic)

FineLine® 200PC and 150PC

Quick Set-up



To achieve maximum SilverLine electrode life

A fully used SilverLine electrode will have a pit depth of .090" (2.3 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 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 on back)

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.

Part number	Reference	Description
1. C104-112	200112	Cooling tube
C104-109	200109	Wrench, cooling tube
C104-214	200214	Electrode, 50-70 amp
C104-215	200215	Electrode, 100 amp
C104-115	202115	Electrode, 200 amp
2. C104-1005	200215	SilverLine electrode, 100 amp
3. C104-1015	202115	SilverLine electrode, 200 amp
I104-279	200279	Swirl ring, 30 amp
4. C104-277	200277	Swirl ring, 100 amp
5. C104-221	200221	Swirl ring, 200 amp
6. C104-223	200223	Nozzle, 50 amp
C104-224	200224	Nozzle, 70 amp
C104-225	200225	Nozzle, 100 amp, MS
C104-239	200239	Nozzle, 100 amp, AL/SS
C104-227	200227	Nozzle, 200 amp
C104-217	200217	Retaining cap, 30/50/70 amp
7. C104-218	200218	Retaining cap, 100 amp
C107-266	200219	Retaining cap, 200/275 amp
I104-233	200233	Shield cap, 30 amp
8. C104-231	200231	Shield cap, 50-70 amp
C104-232	200232	Shield cap, 100 amp
C104-234	200234	Shield cap, 200 amp
9. C104-210	200210	Outer cap

Recommended parameters for cutting mild steel with oxygen

Thickness		Amps A	Preflow Air psi	Plasma O ₂ psi	Shield Air psi	Arc voltage V	Cut height		Pierce height		Speed		Motion delay msec
in.	mm						in.	mm	in.	mm	in.	mm	
1/4	6	100	20	80	35	125	0.090	2	0.125	3	125	3175	100
3/8	10		20	80	35	130	0.130	3	0.175	4	90	2286	200
1/2	13		20	80	35	135	0.155	4	0.200	5	65	1651	250
5/8	16		20	80	35	140	0.185	5	0.200	5	45	1143	250
3/4	19		20	80	35	145	0.185	5	0.200	5	35	889	300
1/4	6	200	15	60	60	125	0.125	3	0.200	5	180	4572	200
3/8	10		15	60	60	125	0.125	3	0.225	6	140	3556	200
1/2	13		15	60	60	125	0.125	3	0.250	6	110	2794	300
5/8	16		15	60	60	127	0.125	3	0.250	6	80	2032	500
3/4	19		15	60	65	132	0.250	6	0.300	8	65	1651	700
1	25		15	60	65	140	0.250	6	0.300	8	45	1143	800
1-1/4	32		15	60	65	150	0.250	6	0.300	8	25	635	200
1-1/2	39		15	60	65	160	0.300	8	0.300	8	17	432	200
1-3/4	45		15	60	65	170	0.345	9	0.300	8	12	305	200
2	51		15	60	65	190	0.500	13	0.300	8	12	305	200

Edge start or moving pierce recommended.

SilverLine technology involves fusing a silver front-end onto a copper electrode base. Inserting the hafnium emitter into an all-silver front end versus copper creates two advantages.

1. The hafnium-silver bond is stronger, allowing a deeper pit depth in the hafnium as the electrode is used.
2. By diffusing more heat during use, silver slows the rate of hafnium wear.

Both of these benefits combine to prolong electrode life and lower the cost of cutting.



To achieve maximum nozzle life

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

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.

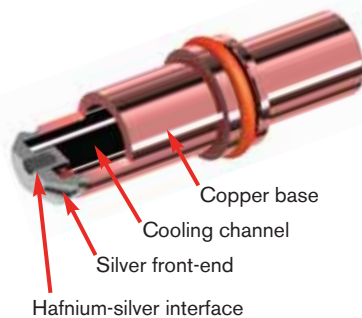
Adjust shield flows: Shield gas protects the nozzle and shield from damage during piercing. Make sure the shield pressure is adjusted according to the cut chart and flow is adequate.

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

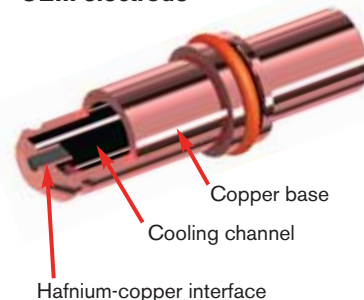
Adjust arc voltage: As parts wear, adjust arc voltage up in 2-volt increments to keep the shield from dragging on the plate. Damage to the shield and nozzle occurs if the torch contacts the plate during cutting.

Contact your Hypertherm distributor or call 1-800-752-7623 for the location nearest to you.

Centricut SilverLine electrode



OEM electrode



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