

Hypertherm®

Centricut consumables for Koike Super-400 Plus

TECHNOLOGY UPGRADE

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

Lower overall cost of cutting

- Cut 50% more metal per consumable set
- Reduce consumable usage by one third
- Available at a lower cost than OEM
- Reduce system downtime associated with consumable changes

Hypertherm technology and consistency

- Excellent cut quality throughout the life of the consumables
- Easy to use and require no special system set-up
- Precision manufacturing process assures consistent product quality from set to set.
- Hypertherm patented consumable technologies deliver value to the cutting process beyond the capabilities of the OEM
 - CoolFlow nozzles provide increased life through robust construction and exceptional cooling of the nozzle
 - SilverLine electrodes offer superior heat transfer extending the life of the consumable set

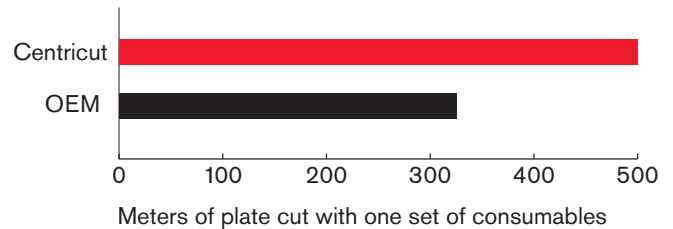
COMPATIBLE WITH

Koike torches
Super-400 Plus



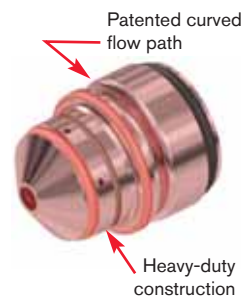
PERFORMANCE

Consumables life comparison at 360 – 400 amps

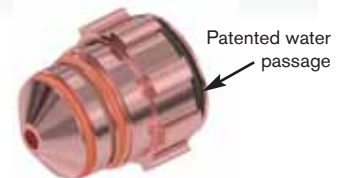


CENTRICUT VS OEM

CoolFlow™ nozzle



OEM nozzle



SilverLine® electrode



OEM electrode



SilverLine electrodes and CoolFlow nozzles last longer, achieve better cut quality and lower your overall cost of cutting. Upgrade today to Centricut.



OPERATOR INFORMATION

Achieve maximum consumable life

A fully used SilverLine electrode will have a pit depth of 2.0 mm. This is deeper than the pit depth for standard parts.

With proper use, the CoolFlow nozzle will last 1:1 with the SilverLine electrode.

Properly tighten the shield and protection cap: Make sure the shield is sealed tightly against the nozzle and the protection cap is properly tightened to the torch 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 working as designed.

Adjust plasma gas flow: 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 flow: Having the correct shield gas flow provides protection to the nozzle during the cutting process.

Pierce at correct height: Piercing too low causes molten metal (spatter) to hit the nozzle – the most common cause of premature nozzle failure. Piercing too high can cause misfires.

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 leadout is improperly programmed. This shortens consumable life.

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

PARTS LIST

Part number	Reference	Description
1. C121-1058	40016358	SilverLine electrode
2. C121-899	40001899	Swirl ring, R
	C121-567	Swirl ring, L
3. C121-233	40017233	CoolFlow nozzle, 2.9R
	C121-234	CoolFlow nozzle, 2.9L
	C121-360	CoolFlow nozzle, 2.3R
	C121-363	CoolFlow nozzle, 2.3L
	C121-359	CoolFlow nozzle, 1.7R
	C121-362	CoolFlow nozzle, 1.7L
4. C121-366	40016366	Shield
5. C121-503	40020503	Protection cap

Contact your Hypertherm distributor for the location nearest to you.

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www.hypertherm.com

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