



## Consumables for Kaliburn®

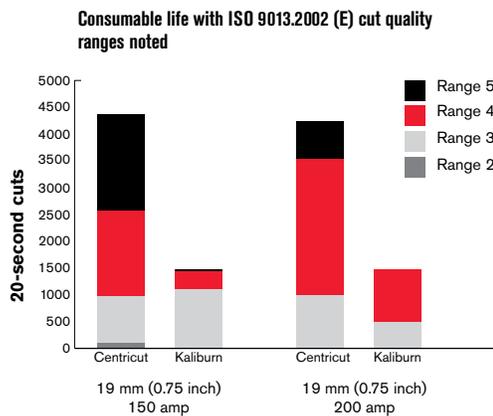
Spirit and ProLine systems



# Centricut consumables combine Hypertherm technology and manufacturing excellence to deliver superior performance to your cutting process.

## Lower overall costs and improve cut quality

- Centricut consumables last two to three times longer than Kaliburn consumables up to 275 amps and on average more than 50% longer at 400 amps.
- Achieve substantially higher cut quality over the life of Centricut consumables compared to Kaliburn.
- Centricut lava swirl rings are more robust than Kaliburn ceramic swirl rings at a substantially lower cost.
- Centricut low-amperage stainless steel consumables have more than 20% longer life than Kaliburn consumables.



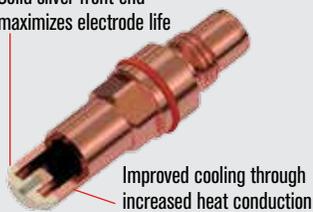
## Cut with confidence – it's Hypertherm

- As the recognized global leader in plasma cutting, Hypertherm incorporates the latest engineered and patented technologies into all consumable products.
- 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.

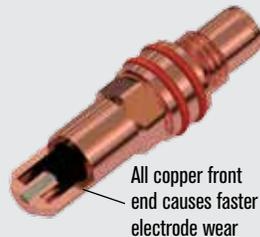


### SilverLine electrode

Solid silver front end maximizes electrode life

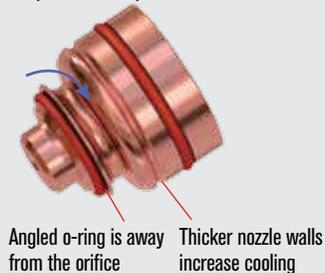


### Kaliburn electrode



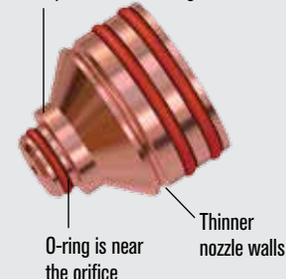
### CoolFlow nozzle

Deep contours improve coolant flow



### Kaliburn nozzle

Inadequate nozzle cooling



## SilverLine® electrode technology

- A solid silver front end maximizes hafnium pit depth and reduces the hafnium wear rate delivering longer consumables life.
- Advanced cooling features reduce the operating temperature of the electrode to maximize life.
- A robust welded copper/silver interface guarantees consistent performance.

## CoolFlow® nozzle technology

- Improved cooling maintains the size and shape of the orifice for maximum life.
- Computer-designed contours optimize the coolant flow around the nozzle and substantially lower the operating temperature.
- Nozzle walls and o-ring placement are designed to maximize cooling and extend life.

# The Centricut quick-disconnect torch incorporates proven Hypertherm torch technologies bringing you excellent performance and reliability.

- Quick-disconnect torch technology enables rapid job change-over increasing productivity.
- Detachable torch head makes changing consumables quick and easy.
- Optimized gas and coolant flow through the torch maximizes performance and reliability.

**Advance to a better cutting experience with the Centricut quick-disconnect torch upgrade kit for your Kaliburn cutting system today.**



## Centricut torch features:

- Designed with engineering materials proven by Hypertherm for optimal torch performance while reducing the cost.
- Coupler ring designed to give a better grip when attaching torch head to base.
- Dust seals prevent metal chips and other debris from collecting in the coupler threads.
- Centricut torch components and consumables are fully compatible with OEM.

## Compatible with Kaliburn systems

- Spirit 150a, 200a, 275a, 400a
- ProLine 2150, 2200, 2260



## To achieve maximum consumable life

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

Properly tighten the inner retaining cap: Make sure the inner retaining 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.

Verify 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: On Kaliburn systems, Hypertherm recommends piercing at twice the specified cut height. Piercing too low causes molten metal (spatter) to hit the shield 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 shield cap: Periodically clean the nozzle and shield cap to remove spatter. This will prevent double arcing which shortens consumable life.

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

Centricut products deliver longer consumable life and improved cut quality at a competitive price.



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**Parts list**

Centricut number	Article number	Description
C107-9050	279050	Torch base, Spirit 150 A-275 A
1. C107-9150	279150	Torch head, Spirit 150 A-275 A
C107-1050	N/A	Torch upgrade kit, Spirit 150 A-275 A
C107-9000	279000	Torch base, Spirit 400 A
1. C107-9100	279100	Torch head, Spirit 400 A
C107-1000	N/A	Torch upgrade kit, Spirit 400 A
2. C107-130	277130	Electrode, 30 A, MS/Al
C107-137	277137	Electrode, 30/50 A, SS, Air
C107-131	277131	Electrode, 50/70 A, MS/SS/Al
3. C107-1082	277282	SilverLine® electrode, 100 A, MS/SS/Al
C107-1092	277292	SilverLine electrode, 150 A, MS/SS/Al
C107-1091	277291	SilverLine electrode, 200 A, MS/SS/Al
C107-1070	277270	SilverLine electrode, 275 A, MS/SS/Al
4. C107-1024	284124	SilverLine electrode, 400 A, MS
5. C107-140	277140	Swirl ring, 30/50/70 A, MS/SS/Al
C107-138	277138	Swirl ring, 30 A, SS, Air
C107-142	277142	Swirl ring, 50/70 A, MS/SS/Al
C107-283	277283	Swirl ring, 100 A, MS/SS/Al
6. C107-139	277139	Swirl ring, 150 A, MS/SS/Al
C107-259	277259	Swirl ring, 200 A, SS, H17
C107-143	277143	Swirl ring, 200 A, MS/SS/Al
C107-258	277258	Swirl ring, 275 A, MS/SS/Al
C107-022	284122	Swirl ring, 400 A, MS/SS/Al
C107-021	277121	CoolFlow™ nozzle, 30 A SS, Air
7. C107-120	277120	CoolFlow nozzle, 30 A, MS
C107-122	277122	CoolFlow nozzle, 50 A, MS/Al
C107-023	277123	CoolFlow nozzle 50 A, SS, Air
C107-125	277125	CoolFlow nozzle, 70 A, MS/SS/Al
8. C107-284	277284	CoolFlow nozzle, 100 A, MS/SS/Al
C107-293	277293	CoolFlow nozzle, 150 A, MS/SS/Al
C107-289	277289	CoolFlow nozzle, 200 A, MS/SS/Al
C107-269	277269	CoolFlow nozzle, 275 A, MS
C107-276	277276	CoolFlow nozzle, 275 A, SS/Al
9. C107-025	284125	CoolFlow nozzle, 400 A, MS
10. C107-153	277153	Retaining cap, 30/50/70 A, MS/SS/Al
C107-110	277110	Retaining cap, 30/50 A, SS, Air
C107-113	277113	Retaining cap, 70/100 A, SS
C107-151	277151	Retaining cap, 100/150 A, MS/SS/Al
C107-152	277152	Retaining cap, 150 A, MS/SS/Al
C107-266	277266	Retaining cap, 200/275 A, MS/SS/Al
11. C107-121	284121	Retaining cap, 400 A, MS
12. C107-145	277145	Shield cap, 30 A, MS/Al
C107-144	277144	Shield cap, 30 A, SS, Air
C107-115	277115	Shield cap, 50 A, MS
C107-149	277149	Shield cap, 50 A, SS, Air
C107-150	277150	Shield cap, 70 A, MS/SS/Al
C107-286	277286	Shield cap, 100 A, MS/SS/Al
C107-117	277117	Shield cap, 150 A, MS/SS/Al
C107-274	277274	Shield cap, 200 A, MS/SS/Al
C107-263	277263	Shield cap, 275 A, MS/SS/Al
13. C107-123	284123	Shield cap, 400 A, MS
14. C107-154	277154	Outer cap
C107-050	284150	Outer cap, 400 A

For a free trial of Centricut consumables visit:  
[response.hypertherm.com/CentricutTrial](http://response.hypertherm.com/CentricutTrial)

**Hypertherm®**  
**Cut with confidence®**

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One of Hypertherm's long-standing core values is a focus on minimizing our impact on the environment. Doing so is critical to our, and our customers' success. We are always striving to become better environmental stewards; it is a process we care deeply about.

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