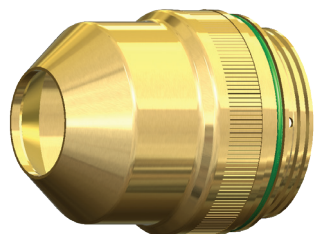
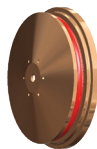


70A MILD STEEL

O₂ PLASMA AIR SHIELD



Shield Cap
90-0747



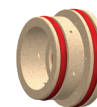
Shield
90-0189



Nozzle Retaining Cap
90-0756



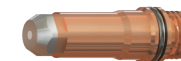
Nozzle
90-0188



Swirl Ring
90-0179



Electrode
90-0187



**CleanCut™
Electrode**
90-0566



Water Tube
90-0340

Thickness	Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed	Cutting Height	Pierce Height	Pierce Time	Kerf Width
inches	psi	psi	psi	psi	volts	ipm	inches	inches	msec	inches
1/8	25	76	35	74	110	190	.100	.150	100	.056
3/16			40		113	130		.200	200	.057
1/4			40		116	120	.110	300	.059	
3/8			40		122	75	.140	400	.065	

ENGLISH

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For Kaliburn Spirit system
90-070 L & R

METRIC

Thickness	Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed	Cutting Height	Pierce Height	Pierce Time	Kerf Width
mm	psi	psi	psi	psi	volts	mm/m	mm	mm	msec	mm
3	25	76	35	74	109	4995	2.5	3.6	100	1.4
5			40		113	3265		5.1		
6			115		3105	2.7	5.5	300	1.5	

MARKING

Type of Gas		Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed		Marking Height		Initial Height		Pierce Time
Plasma Shield		psi	psi	psi	psi	volts	ipm		inches		inches		msec
Nitrogen	Nitrogen	NA	25	25	NA	135	250	6350	.096	2.4	.100	2.5	0
Argon	Air	NA	50	25	NA	62	100	2540	.100	2.5	.100	2.5	0

WARNING: Do not connect H17 (combustible gas) to the gas inputs (Pre/Postflow, Plasma, or Shield) at the same time as Oxygen or Air.

Use an arc transfer height (ignition height) of .150" (3.8 mm) for cutting and .100" (2.5 mm) for marking.

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**For Kaliburn Spirit system
90-070 L & R**