



Consumables for Kaliburn®

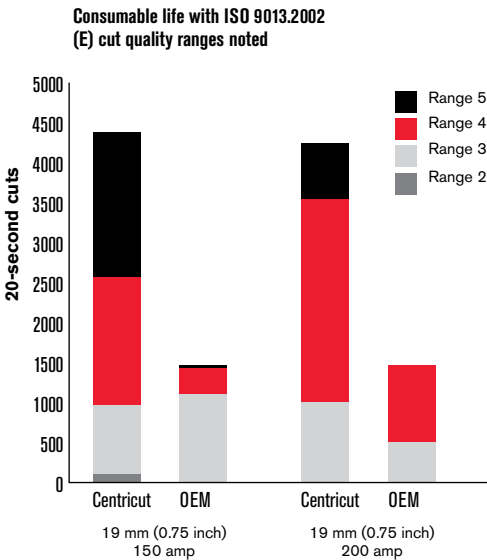
Spirit and ProLine systems



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.



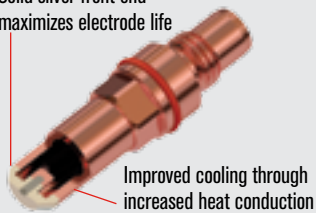
Cut with confidence – it's Hypertherm

- 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.

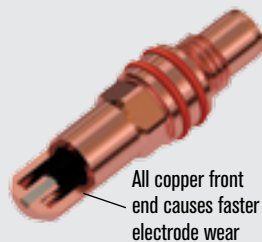


SilverLine electrode

Solid silver front end maximizes electrode life



Kaliburn electrode

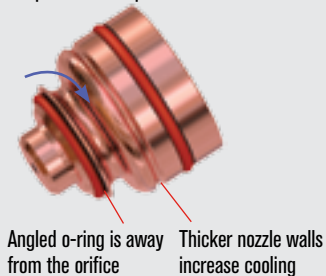


SilverLine® electrode technology

- 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.

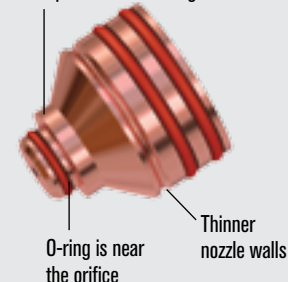
CoolFlow nozzle

Deep contours improve coolant flow



Kaliburn nozzle

Inadequate nozzle cooling



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.

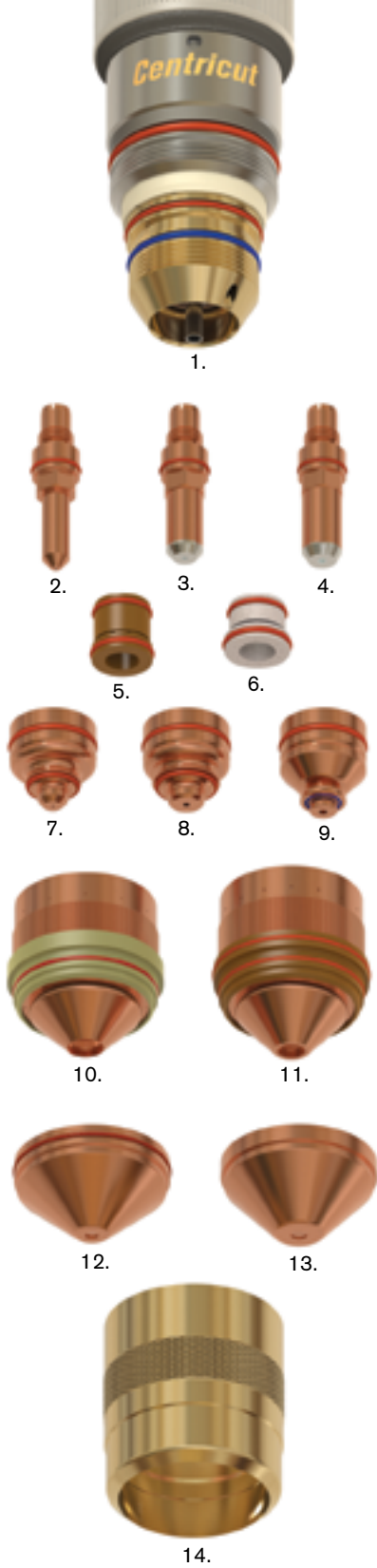
Adjust arc voltage: As the electrode wears, the torch will get closer to the plate. To maintain optimum cutting height, increase arc voltage in 2-volt increments up to 10 volts higher than the initial setting.

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.



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
	I107-113 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

Hypertherm
 SHAPING POSSIBILITY™

Hypertherm, Centricut, SilverLine, CopperLine, and CoolFlow are trademarks of Hypertherm Inc., and may be registered in the United States and/or other countries. All other trademarks are the property of their respective owners. Hypertherm is in no way affiliated with Kalburn.

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.

© 8/2016 Hypertherm, Inc. Revision 3
 881360

