

HIFOCUS 440i neo

TORCH PERCUT 451

TORCH LEADS:

COMPACT SYSTEM** or IGNITION UNIT WITH CONNECTION HOSE AND CABLE PACKAGE:

** Only for small cutting systems at track length < 8 m

max. length 15 m

max. length 55 m

		O ₂ / O ₂ N ₂ HiFocus (S235/S355)	O ₂ / Air, N ₂ HiFocus (S235/S355)	F5/N ₂ HiFinox (1.4301)***	Ar, H ₂ /N ₂ HiFocus (1.4301)***	Air/N ₂ HiFocus (AlMg ₃)	Ar, H ₂ /N ₂ HiFocus (AlMg ₃)
CUTTING RANGE	(recommended) [mm]	2,0 - 20	8 - 50	2 - 6	6 - 50	2 - 8	8 - 40
CUTTING RANGE	(min/max.) [mm]	0,5 - 20	4 - 60	1 - 6	6 - 70	1 - 8	6 - 60
CUTTING RANGE	(max. sep.) [mm]	30	120 ⁸⁰	6	120	8	120
HOLE PIERCING	(max.) [mm]	20 (30*)	50	6	50	8	40

⁸⁰ < 80 % d.c.

* reduced life time

CUTTING EXAMPLES

(Speed approx. values)

Plate thickness [mm]	S235/S355					1.4301					AlMg ₃				
	3	6	10	20	40	3	6	10	20	40	3	6	10	20	40
Quality cut [mm/min]	1200	2000	1800	1800	1150	2600	1800	1700	1500	900	2300	1300	1600	3500	1800
High-speed cut [mm/min]	6000	6500	4500	3600	1400	2800	2000		1700	1000	2400	2500	2000	4500	2400

GASES

	Min. supply pressure [bar]	Working pressure [bar]	Max. flow rate [l/min.]	S235/S355		1.4301		AlMg ₃	
				thin	thick	thin	thick	thin	thick
Air Plasma	13 ⁺⁺⁺	11±1 ⁺⁺⁺	89	X	X				X
Air Swirl	13 ⁺⁺⁺ 11	11±1 ⁺⁺⁺ 9+1	60		X				
O ₂ Plasma/Swirl	13	11±1	60	X	X				
N ₂ Plasma/Swirl	13 ⁺⁺⁺ 11	11±1 ⁺⁺⁺ 9+1	89	X	X	X	X		
Ar Plasma	13 ⁺⁺⁺ 11	11±1 ⁺⁺⁺ 9+1	52				X	X	X
H ₂ Plasma	13 ⁺⁺⁺ 11	11±1 ⁺⁺⁺ 9+1	39				X		X
F5 Plasma	13 ⁺⁺⁺ 11	11±1 ⁺⁺⁺ 9+1	30			X			
Ar Marking ⁺⁺	13 ⁺⁺⁺	11±1 ⁺⁺⁺ 5+1	52	X	X	X	X	X	X

⁺⁺ Marking only with automatic gas flow control

⁺⁺⁺ Values for automatic gas control

NOZZLE LIFE	unit / shift (approx.)	0,7	1,2 (1,3*)	1	2,0 (3,0*)	1	2,5
ELECTRODE LIFE	unit / shift (approx.)	0,7	1,2 (1,3*)	0,5	0,9 (1,4*)	0,5	1,2
NUMBER OF STARTS per electrode	(approx.)	1600	900 (760*)	2200	1200 (800*)	2000	900

* Values valid for bevel cutting

GAS PURITY

O ₂ :	99,5 %	(2.5)	The oxygen must be free of odorants.
N ₂ :	99,999 %	(5.0)	
H ₂ :	99,95 %	(3.5)	
Ar:	99,996 %	(4.6)	
F5:	99,95 %	(3.5)	

COMPRESSED AIR:	max. particle size	0,1 µm	(Class 1	ISO 8573)
	max. remaining oil content	0,01 mg/m ³	(Class 1	ISO 8573)
	max. compression dew point	+ 3 °C	(Class 4	ISO 8573)

- H35 = 65% Ar + 35% H₂ F5 = 95% N₂ + 5% H₂
- Pipeline network supply: Connecting of micro filter in series, supplied by the customer for air and O₂.
- Manual gas console **is standard** (In combination with this gas console the operator adjusts all cut charts manually).
- Automatic gas console **is charged optionally** (remote operation by separate panel or by machine's CNC. Current programming by part program is not possible).
- The torch is equipped with shielded parts, swirl gas, neo - technology and "Contour Cut" for O₂.
- Marking does not allow for velocity dependent current control.

Cutting current (max.):	440 A	Cutting power at 100 % d.c.:	88 kW (440A)
Input power:	127kVA + 1,75 kVA	Rated frequency:	50 Hz
Main supply voltage:	400 V	Max. voltage deviation:	- 10 / +10 %
Input current:	200 A	Ambient temperatures:	0 to 40 °C
Dimensions L x W x H:	1030 x 680 x 1450 mm	Weight:	approx.. 747 kg (with KWE 360)
Noise (depending on plate thickness):	> 95 dB (A)	UV - light protection required	