

Powermax45 consumables

	Description	Part number
Shielded	Retaining cap	220713
	Shield hand held	220674
	Swirl ring	220670
	Shielded nozzle	220671
	Electrode	220669
Extended	Retaining cap	220713
	Deflector	220717
	Swirl ring	220670
	Unshielded nozzle	220718
	Electrode	220669
Gouging	Retaining cap	220713
	Gouging shield	220675
	Swirl ring	220670
	Gouging nozzle	220672
	Electrode	220669
T30v 30 amp*	Deflector (optional)	220569
	Retaining cap	220483
	Nozzle	220480
	Swirl ring	220479
	Electrode	220478
Kit	Powermax45 consumable kit**	850490

*T30v 30 amp consumables are compatible with the T45v torch.

**Not included: T30v 30 amp parts.

Hypertherm®

www.hypertherm.com

© 8/08 Hypertherm, Inc. Revision 0
860300

Power up your Powermax®

with Genuine Hypertherm Consumables

powermax45®

More of what matters.



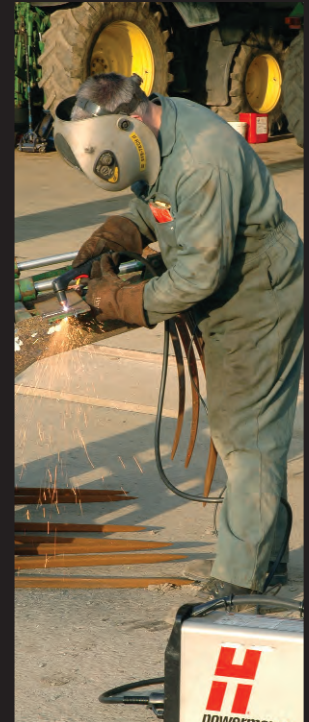
Patented drag-cutting technology

Makes it easy to follow
a line or template.



Gouging

For tough metal removal
jobs with less time and
effort.



Extended consumables

Narrow profile for
better arc visibility and
more clearance.

Hypertherm®

www.hypertherm.com

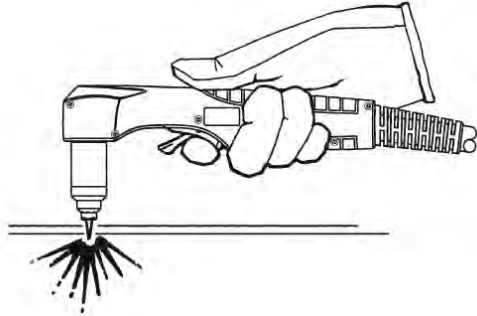


Hand cutting techniques and recommendations

Using the proper techniques will help ensure longer consumable life

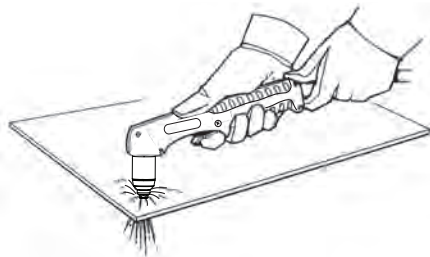
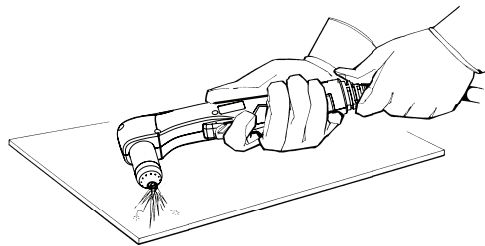
CUTTING

- Sparks should exit from the bottom of the work piece. Upward sparks indicate a torch moving too fast or a torch with insufficient power
- Torch nozzle should be held vertical to the cutting position and the cut monitored with appropriate face/eye protection
- Pulling rather than pushing a torch through a cut enables better control
- For shielded consumables – Lightly drag the torch across the work piece
- For unshielded consumables – Maintain approximately .08" torch-to-work distance
- To cut thinner material, reduce the amps until you get the best quality cut. FineCut consumables are recommended for cutting 24 to 10 ga (.5 to 3.5 mm)
- For straight-line cuts, use a straight edge as a guide
- To cut circles, use a template or a Hypertherm circle cut guide, part number 027668



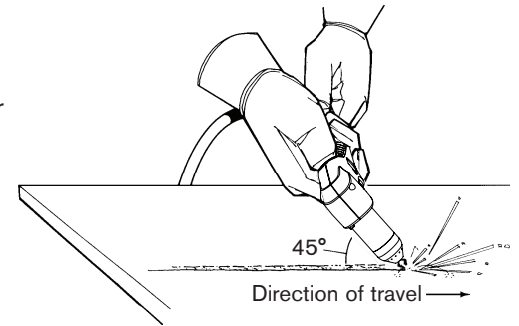
PIERCING

- Torch to work piece distance before firing torch = approximately 1/8" (3 mm)
- Steps:
 1. Fire the torch at a 40-45 degree angle to the work piece – Slowly rotate it to an upright position
 2. When sparks are exiting from the bottom of the work piece, the arc has pierced through the material
 3. When the pierce is complete, proceed with the cut



GOUGING

- Torch to work piece distance before firing torch = approximately 1/16" (1.5 mm)
- Steps:
 1. Hold the torch at a 40-45 degree angle to the work piece – Pull the trigger to obtain a pilot arc – Transfer the arc to the work piece
 2. Maintain a 45° angle, approximately, from the work piece
 3. Feed into the gouge – the slower the motion, the deeper the gouge. It is better to move faster and make another pass than mistakenly remove more metal than desired on the first pass.
 4. A heat shield is available for added hand and torch protection (part no. #220049).



OVERTIGHTENING RETAINING CAP WILL DAMAGE TORCH – Finger tighten only!