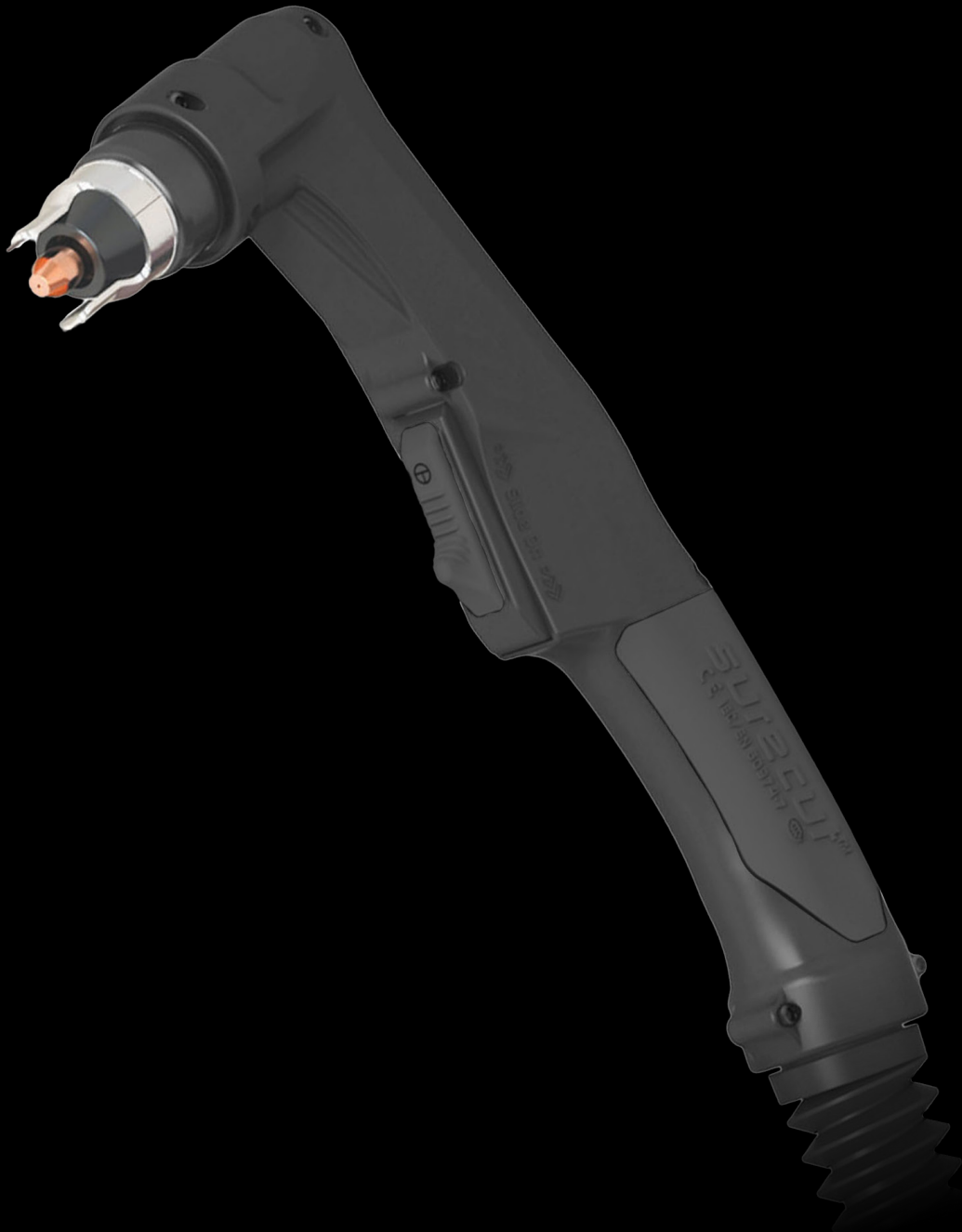


UNI-MIG



PLASMA TORCHES

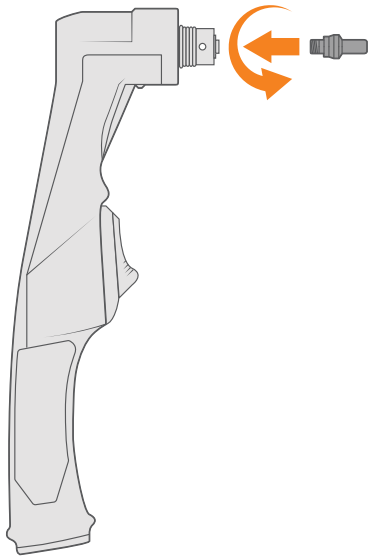
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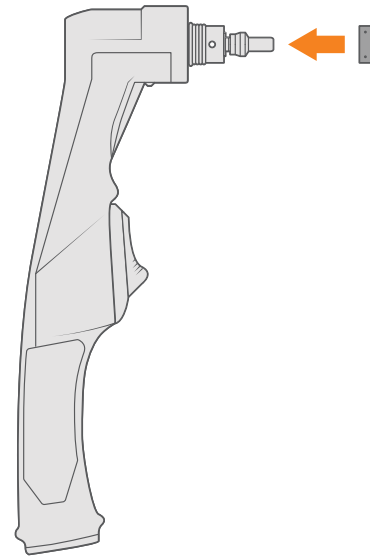
1. Installation

1.1 Assembling the SC30, SC80 & SC120 Plasma Torch

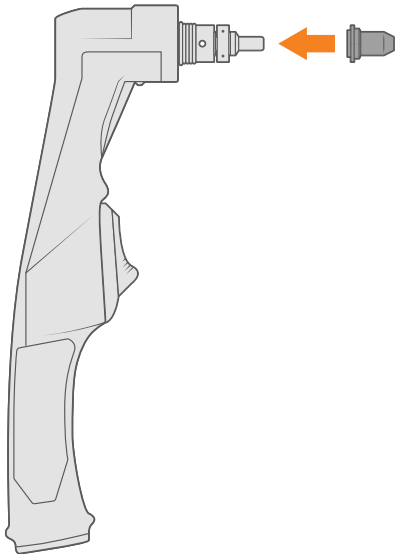
1. Screw the electrode into the torch head. Fasten securely.



2. Place the swirl-ring onto the electrode.

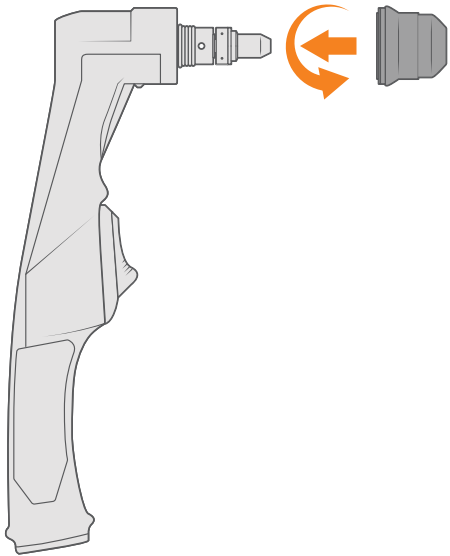


3. Screw the cutting tip into the torch head. Fasten securely.

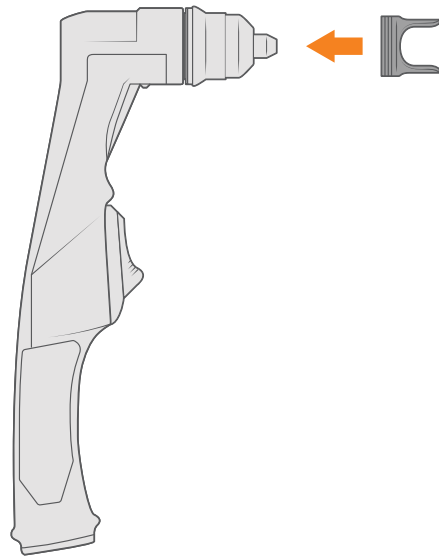


1.1.1 For Standoff Cutting

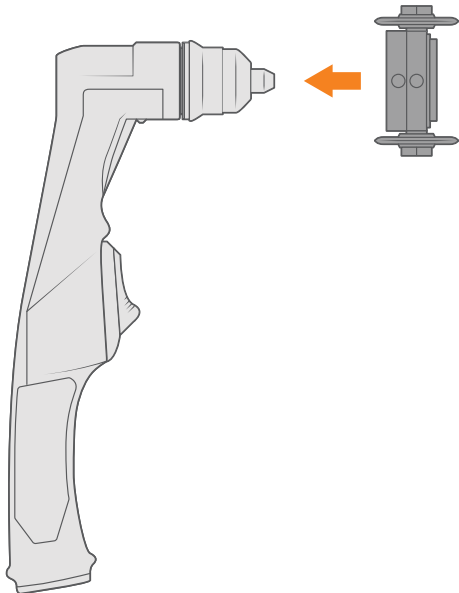
1. Screw the retaining cap into the torch head. Fasten securely.



2. a) Place the stand-off guide onto the retaining cap.

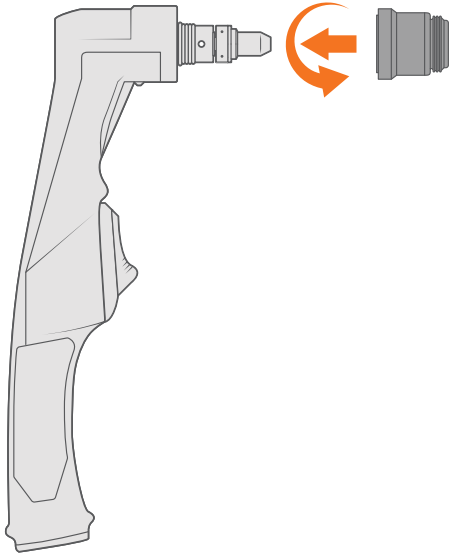


b) For circle cutting, place the cutting guide onto the retaining cap.

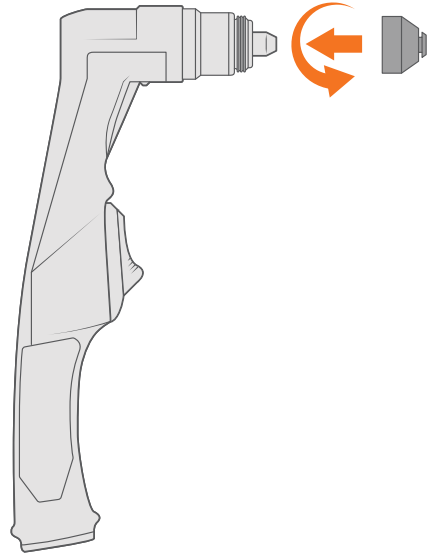


1.1.2 For Contact Cutting

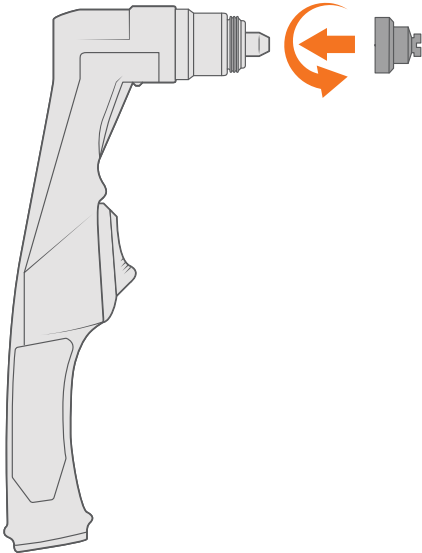
1. Screw the shield cap body into the torch head. Fasten securely.



2. a) Screw the shield cap onto the shield cap body. Fasten securely.

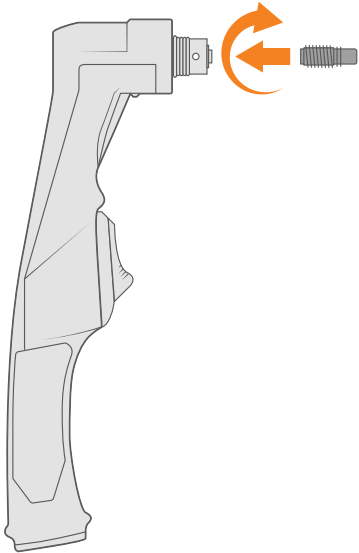


2. b) For gouging, screw the gouging shield cap onto the shield cap body.

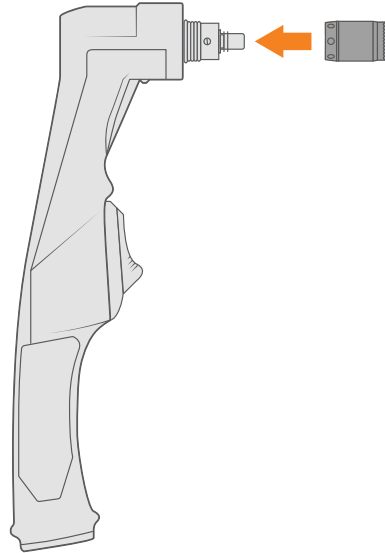


1.2 Assembling the SC160 Plasma Torch

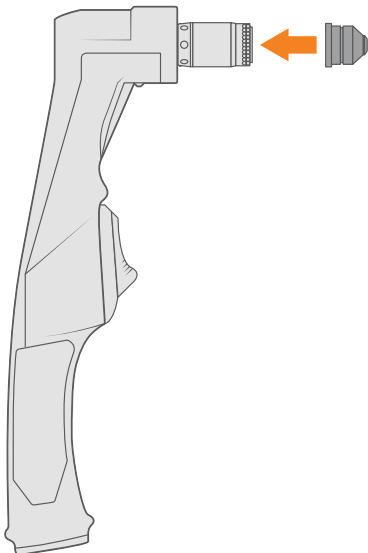
1. Screw the electrode into the torch head.
Fasten securely.



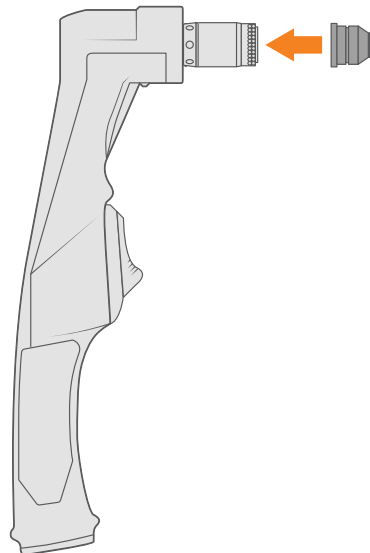
2. Place the swirl ring onto the electrode.



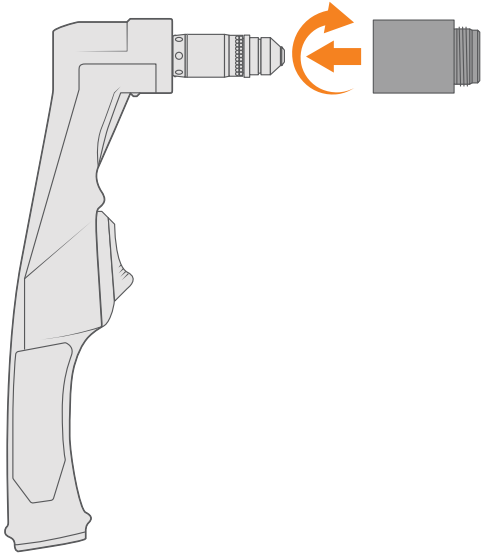
3. Place the cutting tip onto the swirl ring.



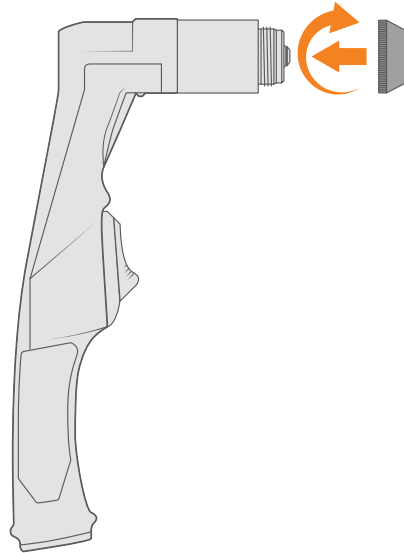
3. a) For gouging, place the gouging tip onto the swirl ring.



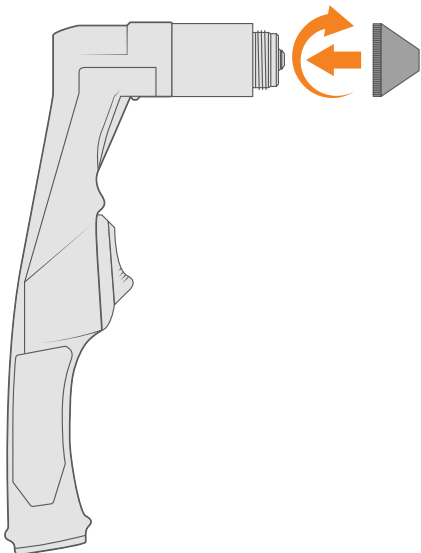
- 4.** Screw the shield cap body onto the torch head.
Fasten securely.



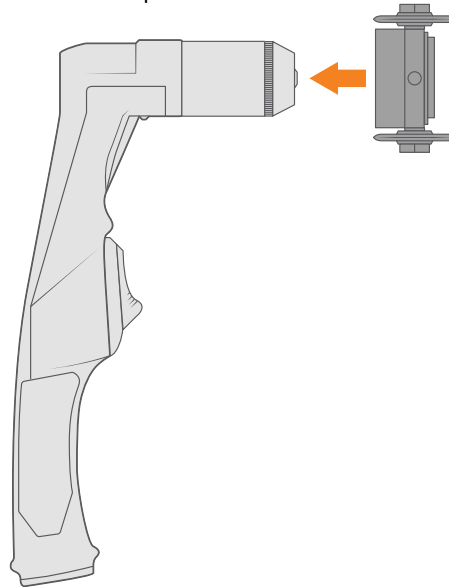
- 5.** Screw the shield cap onto the shield cap body.
Fasten securely.



- 5. a)** For gouging, screw the gouging shield cap onto the shield cap body.

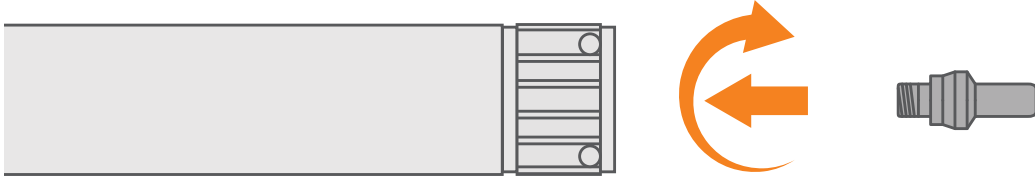


- 5. b)** For circle cutting, place the cutting guide onto the shield cap.



1.3 Assembling the CNC SC80 & CNC SC120 Plasma Torch

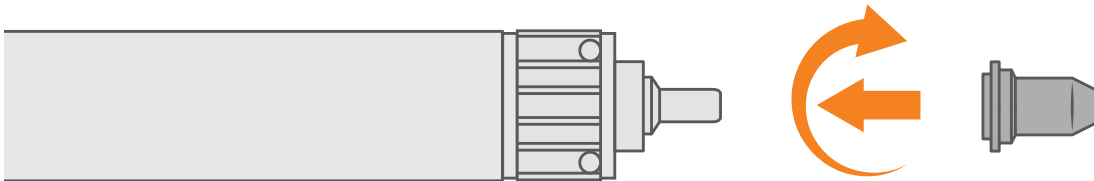
1. Screw the electrode into the torch head. Fasten securely.



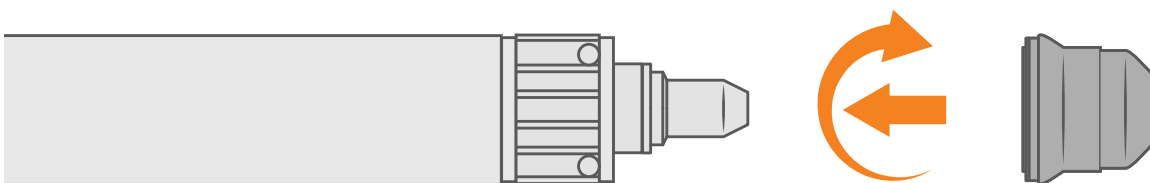
2. Place the swirl ring onto the electrode.



3. Place the cutting tip onto the swirl ring.

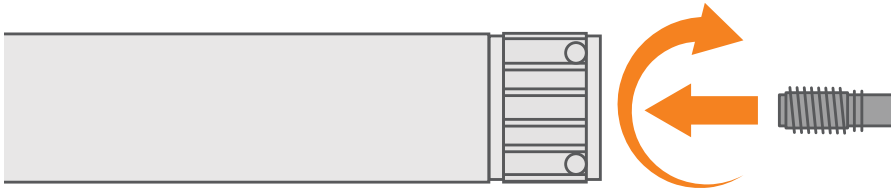


4. Screw the retaining cap into the torch head. Fasten securely.



1.4 Assembling the CNC SC160 Plasma Torch

1. Screw the electrode into the torch head. Fasten securely.



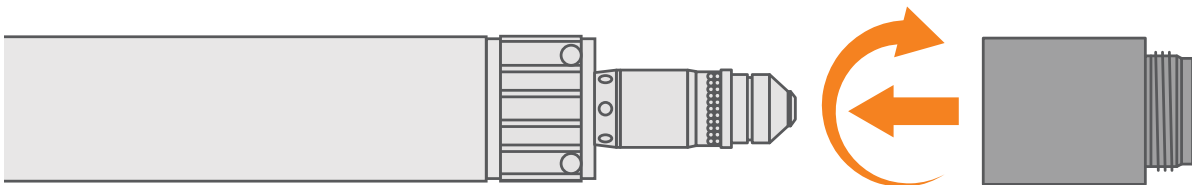
2. Place the swirl ring onto the electrode.



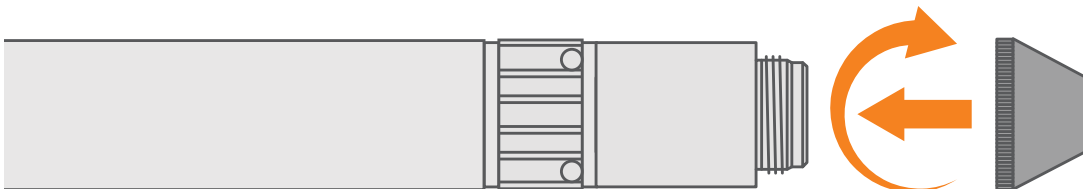
3. Place the cutting tip onto the swirl ring.



4. Screw the shield cap body onto the torch head. Fasten securely.

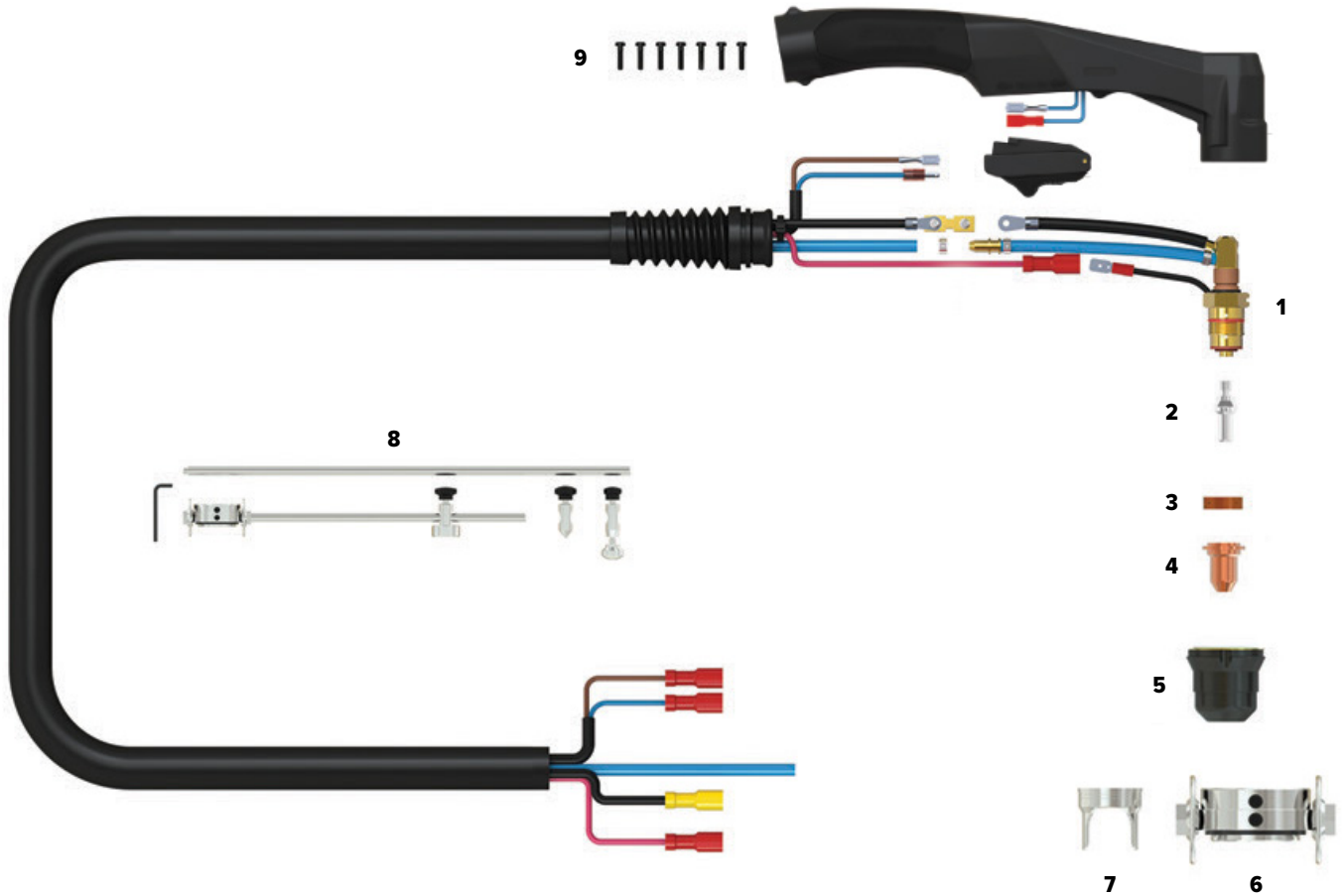


5. Screw the shield cap onto the shield cap body.



2. Plasma Torch & Consumables

2.1 SC30 Plasma Torch



Length	4m	
SKU	U43002	
1	SC3001	PLASMA TORCH HEAD SUIT SC30
2	PWGSC2504	ELECTRODES SUIT SC30 QTY 5
3	WGSC2506	SWIRL RING SUIT SC30 QTY 1
4	PWGSC2520-09	CUTTING TIPS SUIT SC30 0.9MM QTY 5
5	WGSC2530	RETAINING CAP SUIT SC30 QTY 1
6	WGSC2551	CUTTING GUIDE SUIT SC30 QTY 1
7	WGSC2540	STANDOFF GUIDE SUIT SC30 QTY 1
8	WGSC2550	CIRCLE CUTTING KIT SUIT SC30
9	SCSP1	SCREW PACK TO SUIT HANDLE
	COOLING METHOD	Air-Cooled
	DUTY CYCLE	60% @ 30A
	CUTTING THICKNESS	8-12mm
	GAS	Air/N ₂
	GAS PRESSURE	4.5-5.0 Bar / 65-75 psi
	GAS FLOW	100L/min
	IGNITION	Pilot Arc
	POST FLOW	90s
	STANDARD	EN60974-7

2.2 SC30 Plasma Torch Consumables



Electrode

PWGSC2504	ELECTRODES SUIT SC30 QTY 5
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Swirl Ring

WGSC2506	SWIRL RING SUIT SC30 QTY 1
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Cutting Tips

PWGSC2520-09	CUTTING TIPS SUIT SC30 0.9MM QTY 5
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Retaining Cap

WGSC2530	RETAINING CAP SUIT SC30 QTY 1
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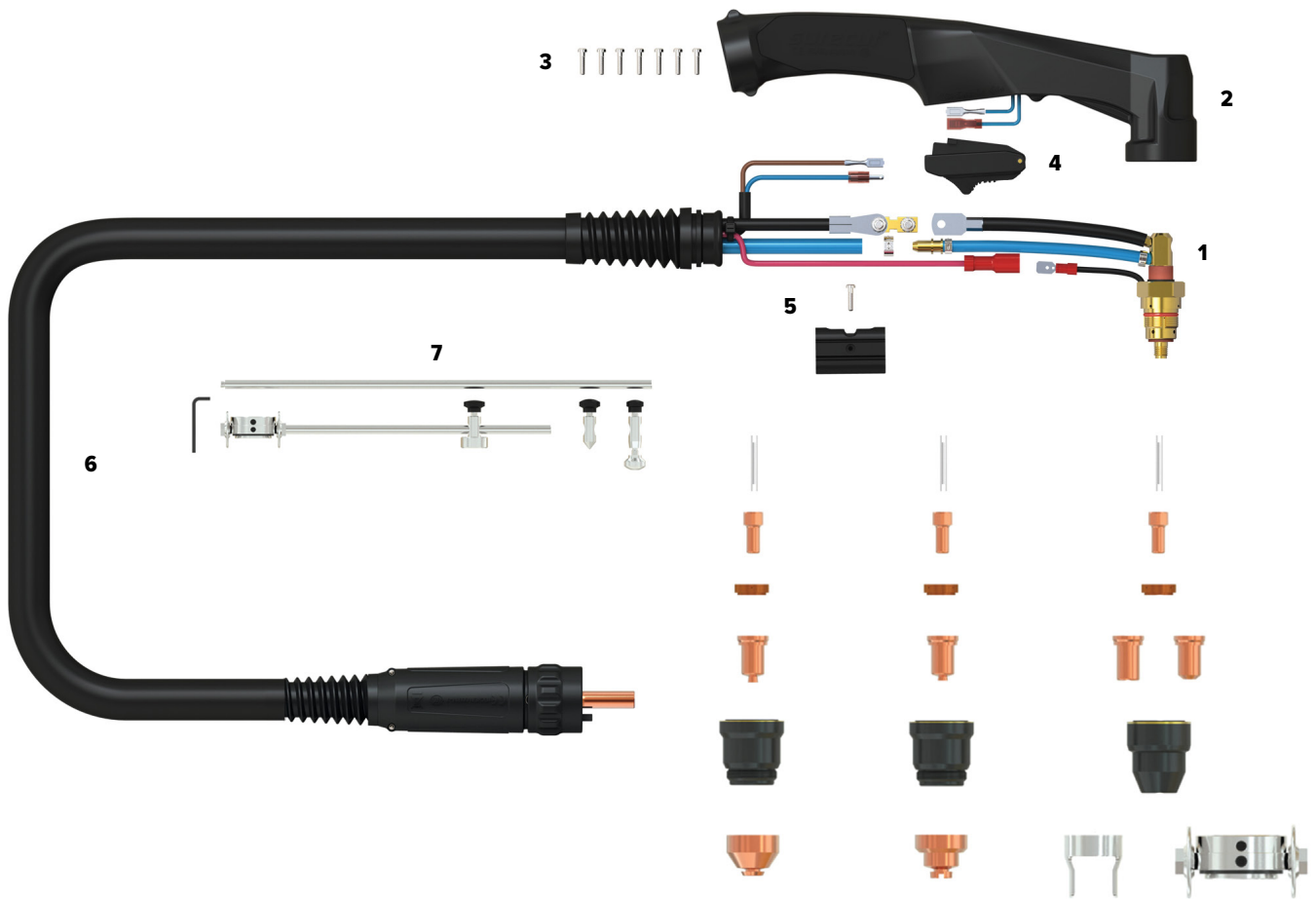
Standoff Guide

WGSC2540	STANDOFF GUIDE SUIT SC30 QTY 1
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Cutting Guide

WGSC2551	CUTTING GUIDE SUIT SC30 QTY 1
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2.3 SC80 Plasma Torch



Length	4m
SKU	WG-SC80-60-CC1-1.0-1

1	SC8001	PLASMA TORCH HEAD SUIT SC80
2	SC8014	PLASMA HANDLE
3	SCSP1	SCREW PACK
4	SC2516	PLASMA TRIGGER
5	SC8015	LOCATION BLOCK
6	SC8019-60-CF4	CABLE ASSEMBLY
7	SC8050	CIRCLE CUTTING KIT SUIT SC80

COOLING METHOD	Air-Cooled
DUTY CYCLE	60% @ 80A
CUTTING THICKNESS	20-25mm
GAS	Air/N ₂
GAS PRESSURE	4.5-5.0 Bar / 65-75 psi
GAS FLOW	110L/min
IGNITION	Pilot Arc
POST FLOW	90s
STANDARD	EN60974-7

2.4 SC80 Plasma Torch Consumables

2.4.1 Gouging



Cooling Tube

SC8002	COOLING TUBE SUIT SC80 QTY 1
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Electrode

PSC8004	ELECTRODE SUIT SC80 QTY 5
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Swirl Ring

SC8006	SWIRL RING SUIT SC80 QTY 1
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Gouging Tips

PSC8028-16	GOUGING TIPS SUIT SC80 1.6MM QTY 5
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Shield Cap Body

SC8031	SHIELD CAP BODY SUIT SC80 QTY 1
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Shield Cap Gouging

SC8043	SHIELD CAP GOUGING SUIT SC80 QTY 1
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2.4.2 Contact Cutting



Cooling Tube

SC8002	COOLING TUBE SUIT SC80 QTY 1
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Electrode

PSC8004	ELECTRODE SUIT SC80 QTY 5
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Swirl Ring

SC8006	SWIRL RING SUIT SC80 QTY 1
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Contact Cutting Tips

PSC8026-10	CONTACT CUTTING TIPS SUIT SC80 1.0MM 40-50A QTY 5
PSC8026-11	CONTACT CUTTING TIPS SUIT SC80 1.1MM 50-60A QTY 5
PSC8026-12	CONTACT CUTTING TIPS SUIT SC80 1.2MM 60-70A QTY 5
PSC8026-13	CONTACT CUTTING TIPS SUIT SC80 1.3MM 70-80A QTY 5

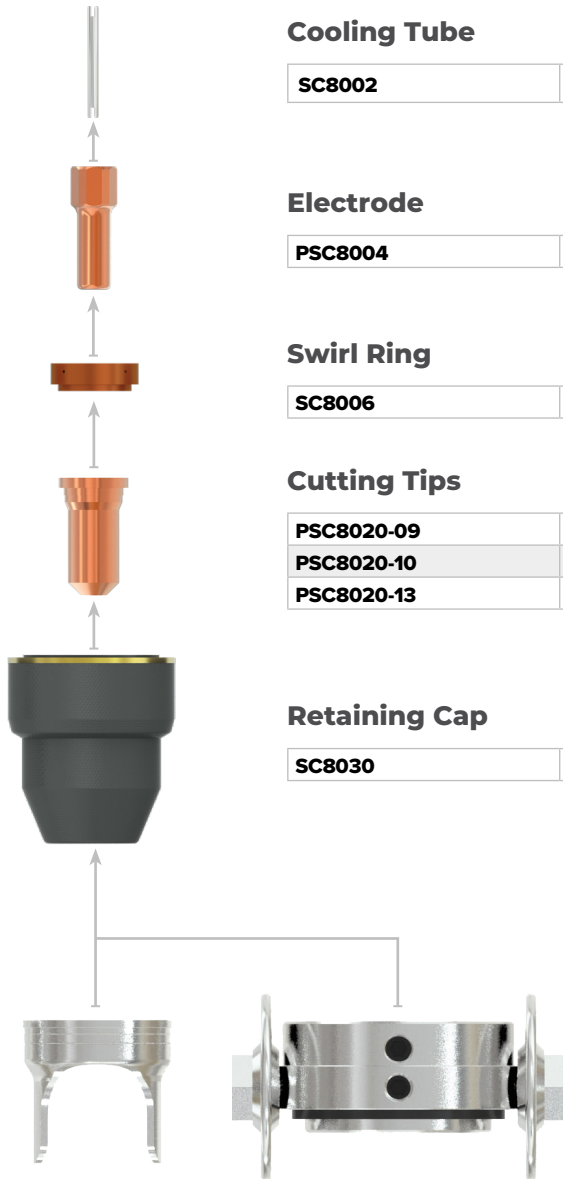
Shield Cap Body

SC8031	SHIELD CAP BODY SUIT SC80 QTY 1
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Shield Cap Contact Cutting

SC8041	SHIELD CAP CONTACT CUTTING SUIT SC80/SC120 QTY 1
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2.4.3 Standoff Cutting



Cooling Tube

SC8002	COOLING TUBE SUIT SC80 QTY 1
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Electrode

PSC8004	ELECTRODE SUIT SC80 QTY 5
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Swirl Ring

SC8006	SWIRL RING SUIT SC80 QTY 1
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Cutting Tips

PSC8020-09	CUTTING TIPS SUIT SC80 0.9MM 30-40A QTY 5
PSC8020-10	CUTTING TIPS SUIT SC80 1.0MM 40-50A QTY 5
PSC8020-13	CUTTING TIPS SUIT SC80 1.3MM 70-80A QTY 5

Retaining Cap

SC8030	RETAINING CAP SUIT SC80 QTY 1
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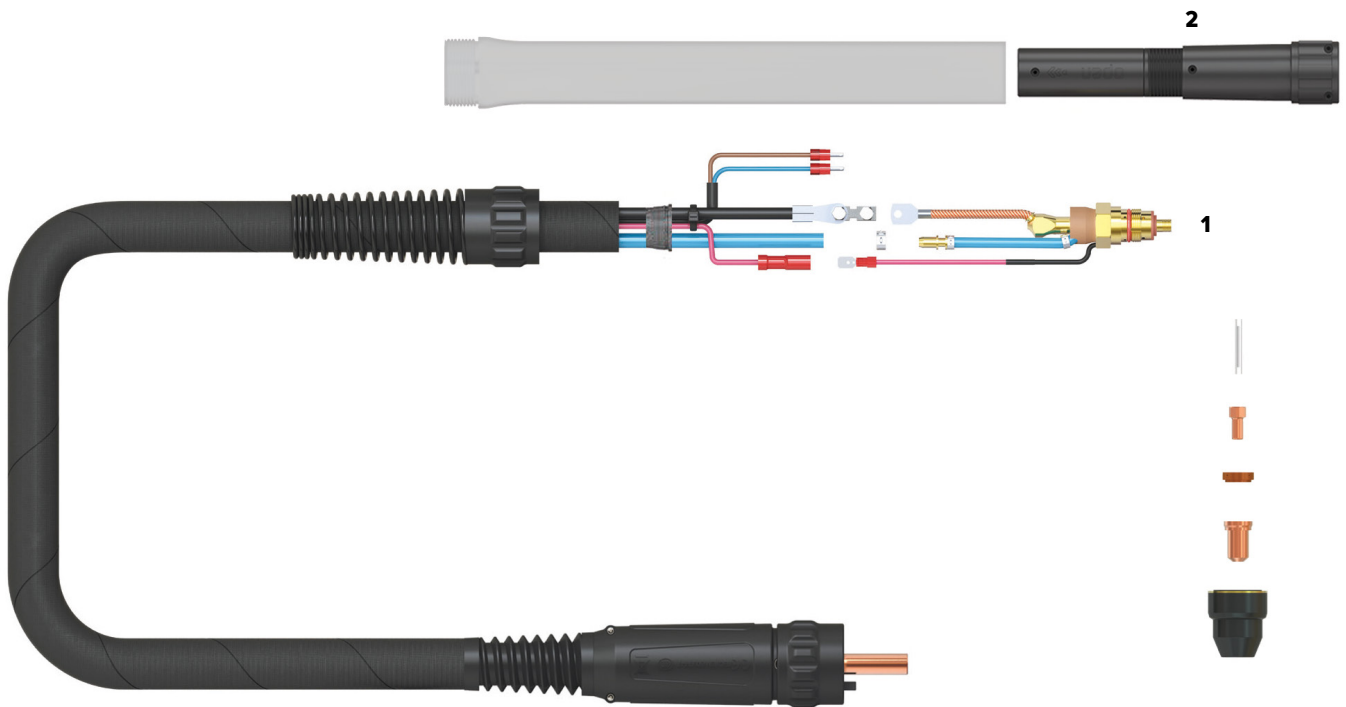
Standoff Guide

SC8040	STANDOFF GUIDE SUIT SC80 QTY 1
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Cutting Guide

SC8051	CUTTING GUIDE SUIT SC80 QTY 1
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2.5 SC80 CNC Plasma Torch

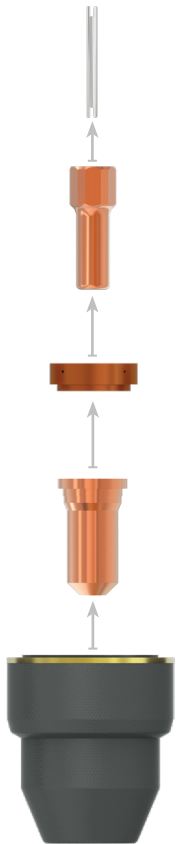


Length	4m	6m	10m
SKU	WG-SCM80R-40	WG-SCM80R-60	WG-SCM80R-100-CC3-BX

1	SCM8001	PLASMA TORCH HEAD SUIT SCM80R
2	SC8118	AUTO TORCH HEAD HOUSING

COOLING METHOD	Air-Cooled
DUTY CYCLE	60% @ 80A
CUTTING THICKNESS	20-25mm
GAS	Air/N ₂
GAS PRESSURE	4.5-5.0 Bar / 65-75 psi
GAS FLOW	110L/min
IGNITION	Pilot Arc
POST FLOW	90s
STANDARD	EN60974-7

2.6 SC80 CNC Plasma Torch Consumables



Cooling Tube

SC8002	COOLING TUBE SUIT SC80 QTY 1
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Electrode

PSC8004	ELECTRODE SUIT SC80 QTY 5
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Swirl Ring

SC8006	SWIRL RING SUIT SC80 QTY 1
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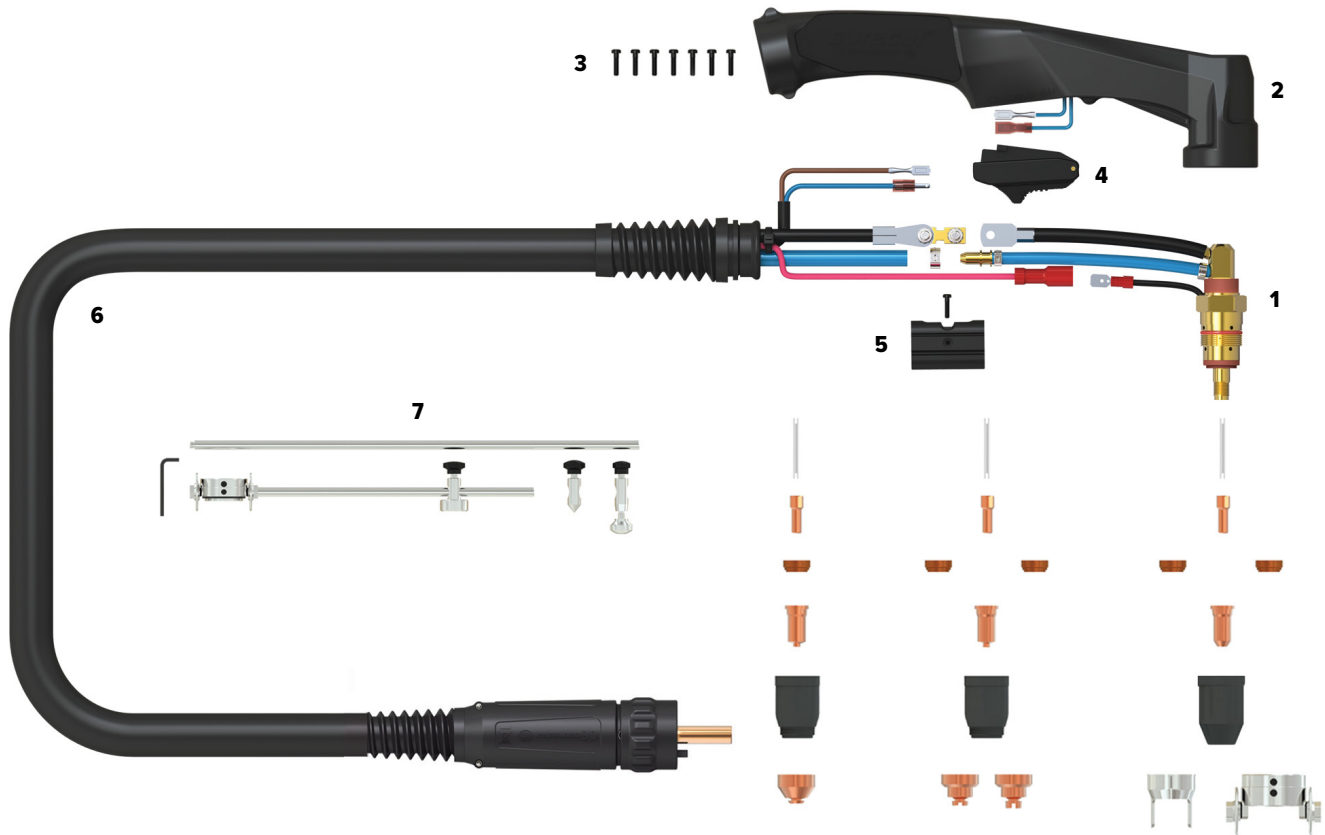
Cutting Tips

PSC8020-09	CUTTING TIPS SUIT SC80 0.9MM 30-40A QTY 5
PSC8020-10	CUTTING TIPS SUIT SC80 1.0MM 40-50A QTY 5
PSC8020-13	CUTTING TIPS SUIT SC80 1.3MM 70-80A QTY 5

Retaining Cap

SC8030	RETAINING CAP SUIT SC80 QTY 1
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2.7 SC120 Plasma Torch



Length	6m
SKU	WGSC1206M

1	SC1201	PLASMA TORCH HEAD SUIT SC120
2	SC8014	PLASMA HANDLE
3	SCSP1	SCREW PACK
4	SC2516	PLASMA TRIGGER
5	SC8015	LOCATION BLOCK
6	SC8019-60-CF4	CABLE ASSEMBLY
7	U43004	CIRCLE CUTTING KIT SUIT SC120 QTY 1

COOLING METHOD	Air-Cooled
DUTY CYCLE	60% @ 120A
CUTTING THICKNESS	30-35mm
GAS	Air/N ₂
GAS PRESSURE	4.5-5.0 Bar / 65-75 psi
GAS FLOW	200L/min
IGNITION	Pilot Arc
POST FLOW	90s
STANDARD	EN60974-7

2.8 SC120 Plasma Torch Consumables

2.8.1 Gouging



Cooling Tube

SC1202	COOLING TUBE SUIT SC120 QTY 1
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Electrode

PSC1204	ELECTRODES SUIT SC120 QTY 5
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Swirl Ring

SC1206	SWIRL RING HEAVY DUTY SUIT SC120 QTY 1
SC1207	SWIRL RING SUIT SC120 QTY 1

Gouging Tips

PSC1228-22	GOUGING TIPS SUIT SC120 2.2MM QTY 5
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Shield Cap Body

SC1232	SHIELD CAP BODY SUIT SC120 QTY 1
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Shield Cap Gouging

SC8043	SHIELD CAP GOUGING SUIT SC80/SC120 QTY 1
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2.8.2 Contact Cutting



Cooling Tube

SC1202	COOLING TUBE SUIT SC120 QTY 1
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Electrode

PSC1204	ELECTRODES SUIT SC120 QTY 5
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Swirl Ring

SC1206	SWIRL RING HEAVY DUTY SUIT SC120 QTY 1
SC1207	SWIRL RING SUIT SC120 QTY 1

Contact Cutting Tips

PSC1222-09	CONTACT CUTTING TIPS SUIT SC120 0.9MM 30-40A QTY 5
PSC1226-10	CONTACT CUTTING TIPS SUIT SC120 1.0MM 40-50A QTY 5
PSC1226-11	CONTACT CUTTING TIPS SUIT SC120 1.1MM 50-60A QTY 5
PSC1226-12	CONTACT CUTTING TIPS SUIT SC120 1.2MM 60-70A QTY 5
PSC1227-14	CONTACT CUTTING TIPS SUIT SC120 1.4MM 80-90A QTY 5
PSC1227-15	CONTACT CUTTING TIPS SUIT SC120 1.5MM 100-110A QTY 5
PSC1227-16	CONTACT CUTTING TIPS SUIT SC120 1.6MM 110-120A QTY 5

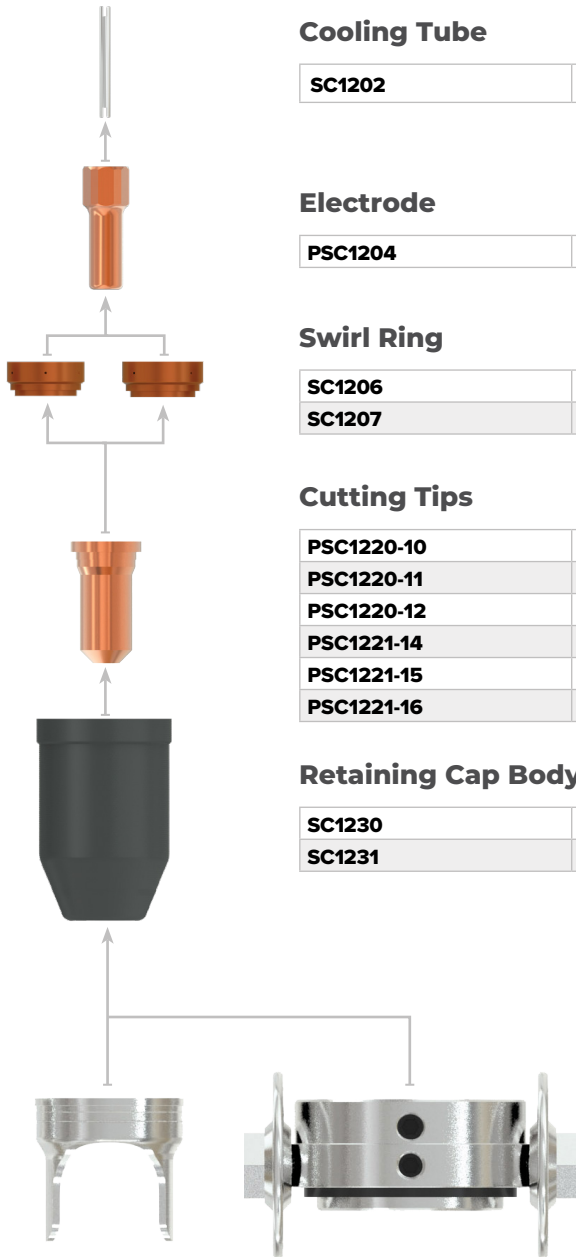
Shield Cap Body

SC1232	SHIELD CAP BODY SUIT SC120 QTY 1
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Shield Cap Contact Cutting

SC1241	SHEILD CAP CONTACT CUTTING SUIT SC120 QTY 1
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2.8.3 Standoff Cutting



Cooling Tube

SC1202	COOLING TUBE SUIT SC120 QTY 1
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Electrode

PSC1204	ELECTRODES SUIT SC120 QTY 5
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Swirl Ring

SC1206	SWIRL RING HEAVY DUTY SUIT SC120 QTY 1
SC1207	SWIRL RING SUIT SC120 QTY 1

Cutting Tips

PSC1220-10	CUTTING TIPS SUIT SC120 1.0MM 40-50A QTY 5
PSC1220-11	CUTTING TIPS SUIT SC120 1.1MM 50-60A QTY 5
PSC1220-12	CUTTING TIPS SUIT SC120 1.2MM 60-70A QTY 5
PSC1221-14	CUTTING TIPS SUIT SC120 1.4MM 80-90A QTY 5
PSC1221-15	CUTTING TIPS SUIT SC120 1.5MM 100-110A QTY 5
PSC1221-16	CUTTING TIPS SUIT SC120 1.6MM 110-120A QTY 5

Retaining Cap Body

SC1230	RETAINING CAP SUIT SC120 30-70A QTY 1
SC1231	RETAINING CAP HEAVY DUTY SUIT SC120 80-120A QTY 1

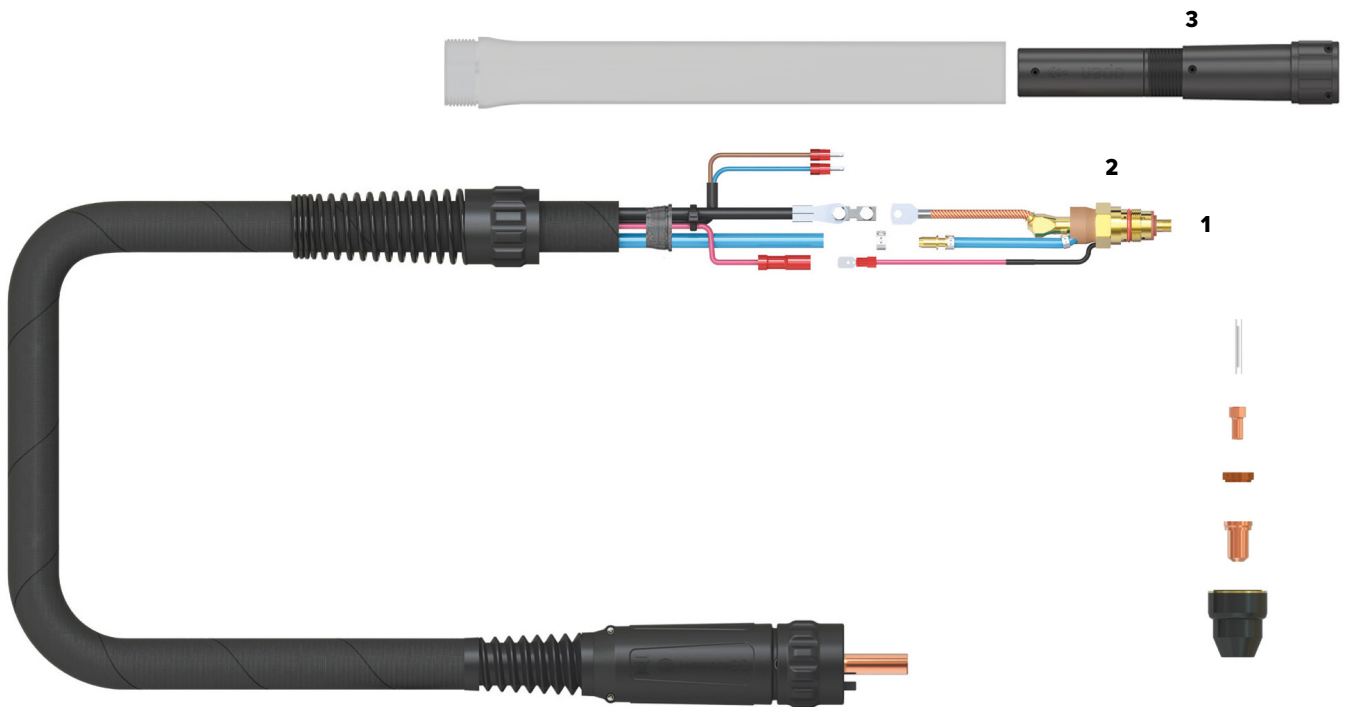
Standoff Guide

SC1240	STANDOFF GUIDE SUIT SC120 QTY 1
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Cutting Guide

SC1251	CUTTING GUIDE SUIT SC120 QTY 1
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2.9 SC120 CNC Plasma Torch

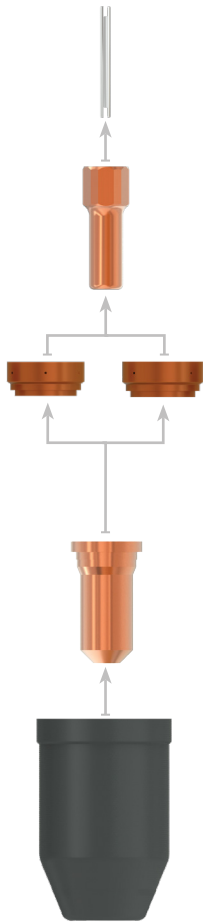


Length	12m
SKU	U43001

1	SCM12001	PLASMA TORCH HEAD SUIT CNC SC120
2	SC2508	'O' RING
3	SC8118	AUTO TORCH HEAD HOUSING

COOLING METHOD	Air-Cooled
DUTY CYCLE	60% @ 120A
CUTTING THICKNESS	30-35mm
GAS	Air/N ₂
GAS PRESSURE	4.5-5.0 Bar / 65-75 psi
GAS FLOW	200L/min
IGNITION	Pilot Arc
POST FLOW	90s
STANDARD	EN60974-7

2.10 SC120 CNC Plasma Torch Consumables



Cooling Tube

SC1202	COOLING TUBE SUIT SC120 QTY 1
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Electrode

PSC1204	ELECTRODES SUIT SC120 QTY 5
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Swirl Ring

SC1206	SWIRL RING HEAVY DUTY SUIT SC120 QTY 1
SC1207	SWIRL RING SUIT SC120 QTY 1

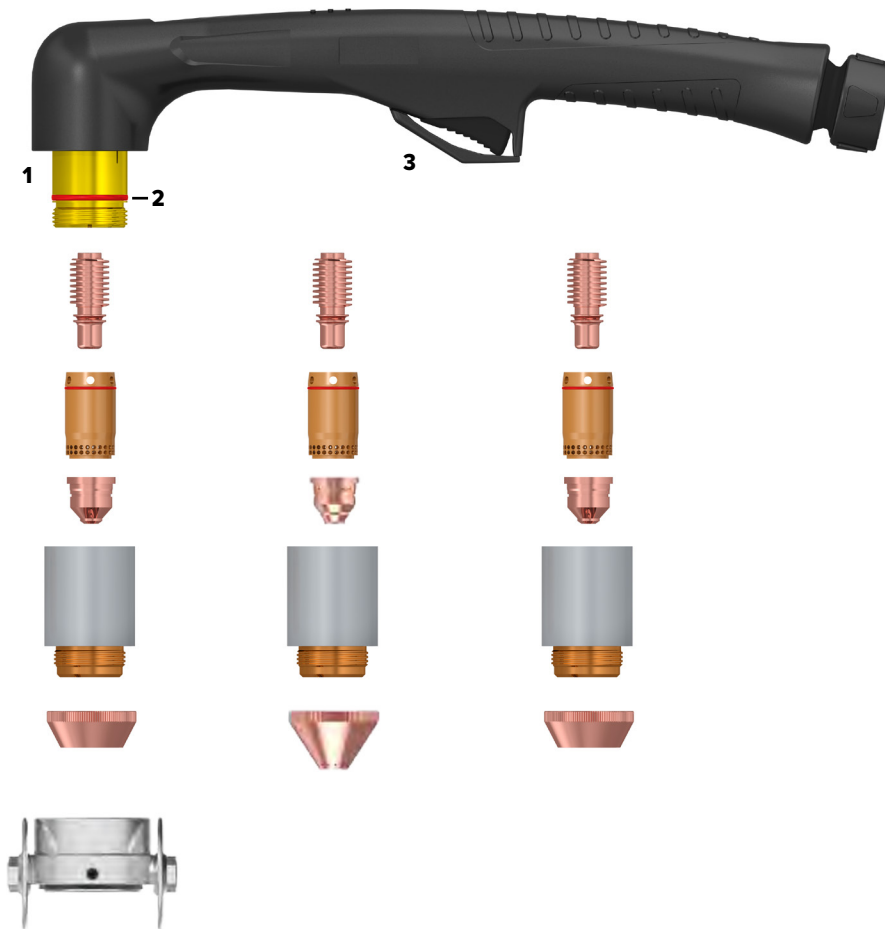
Cutting Tips

PSC1220-10	CUTTING TIPS SUIT SC120 1.0MM 40-50A QTY 5
PSC1220-11	CUTTING TIPS SUIT SC120 1.1MM 50-60A QTY 5
PSC1220-12	CUTTING TIPS SUIT SC120 1.2MM 60-70A QTY 5
PSC1221-14	CUTTING TIPS SUIT SC120 1.4MM 80-90A QTY 5
PSC1221-15	CUTTING TIPS SUIT SC120 1.5MM 100-110A QTY 5
PSC1221-16	CUTTING TIPS SUIT SC120 1.6MM 110-120A QTY 5

Retaining Cap Body

SC1230	RETAINING CAP SUIT SC120 30-70A QTY 1
SC1231	RETAINING CAP HEAVY DUTY SUIT SC120 80-120A QTY 1

2.11 SC160 Plasma Torch



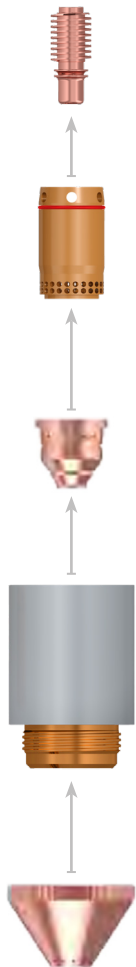
Length	6m
SKU	U43010

1	U11132	PLASMA TORCH HEAD SUIT SC160
2	U11133	O RING SUIT SC160 QTY 1
3	U11134	PLASMA TORCH HANDLE SUIT SC160

COOLING METHOD	Air-Cooled
DUTY CYCLE	80% @ 160A
GAS PRESSURE	5.0-6.0 Bar / 75-90 psi
GAS FLOW	420L/min
STANDARD	EN60974-7

2.12 SC160 Plasma Torch Consumables

2.12.1 Gouging



Electrode

U43009P	ELECTRODE SUIT SC160 QTY 5
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Swirl Ring

U43008	SWIRL RING SUIT SC160 QTY 1
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Gouging Tips

U11215	GOUGING TIPS SUIT SC160 105-125A QTY 5
U11216	GOUGING TIPS SUIT SC160 160A QTY 5

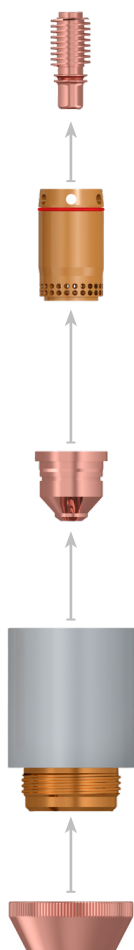
Shield Cap Body

U11139	SHIELD CAP BODY SUIT SC160 45-85A QTY 1
U43006	SHIELD CAP BODY SUIT SC160 105-160A QTY 1

Shield Cap

U11217	SHIELD CAP GOUGING SUIT SC160 QTY 1
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2.12.2 Precision Cutting



Electrode

U43009P	ELECTRODE SUIT SC160 QTY 5
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Swirl Ring

U11253	SWIRL RING PRECISION CUT SUIT SC160 30-45A QTY 1
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Cutting Tips

U11140	CUTTING TIPS PRECISION CUT SUIT SC160 30-45A QTY 5
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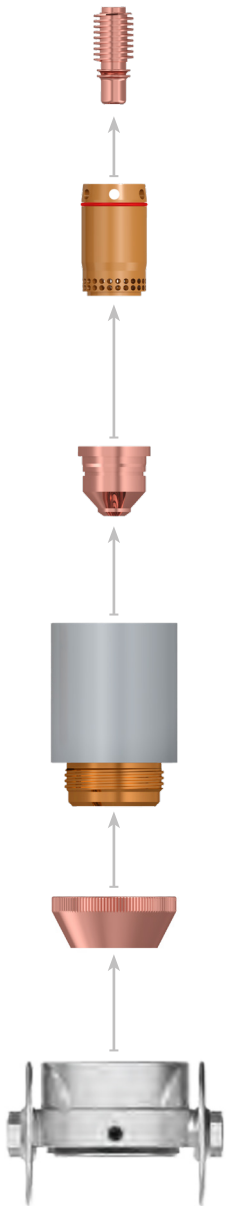
Shield Cap Body

U11139	SHIELD CAP BODY SUIT SC160 45-85A QTY 1
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Shield Cap

U11141	SHIELD CAP SUIT SC160 30-45A QTY 1
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2.12.3 Cutting



Electrode

U43009P	ELECTRODE SUIT SC160 QTY 5
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Swirl Ring

U43008	SWIRL RING SUIT SC160 QTY 1
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Cutting Tips

U11135	CUTTING TIPS SUIT SC160 45A QTY 5
U11136	CUTTING TIPS SUIT SC160 45A QTY 5
U11137	CUTTING TIPS SUIT SC160 85A QTY 5
U11138	CUTTING TIPS SUIT SC160 105-125A QTY 5
U43007P	CUTTING TIPS SUIT SC160 160A QTY 5

Shield Cap Body

U11139	SHIELD CAP BODY SUIT SC160 45-85A QTY 1
U43006	SHIELD CAP BODY SUIT SC160 105-160A QTY 1

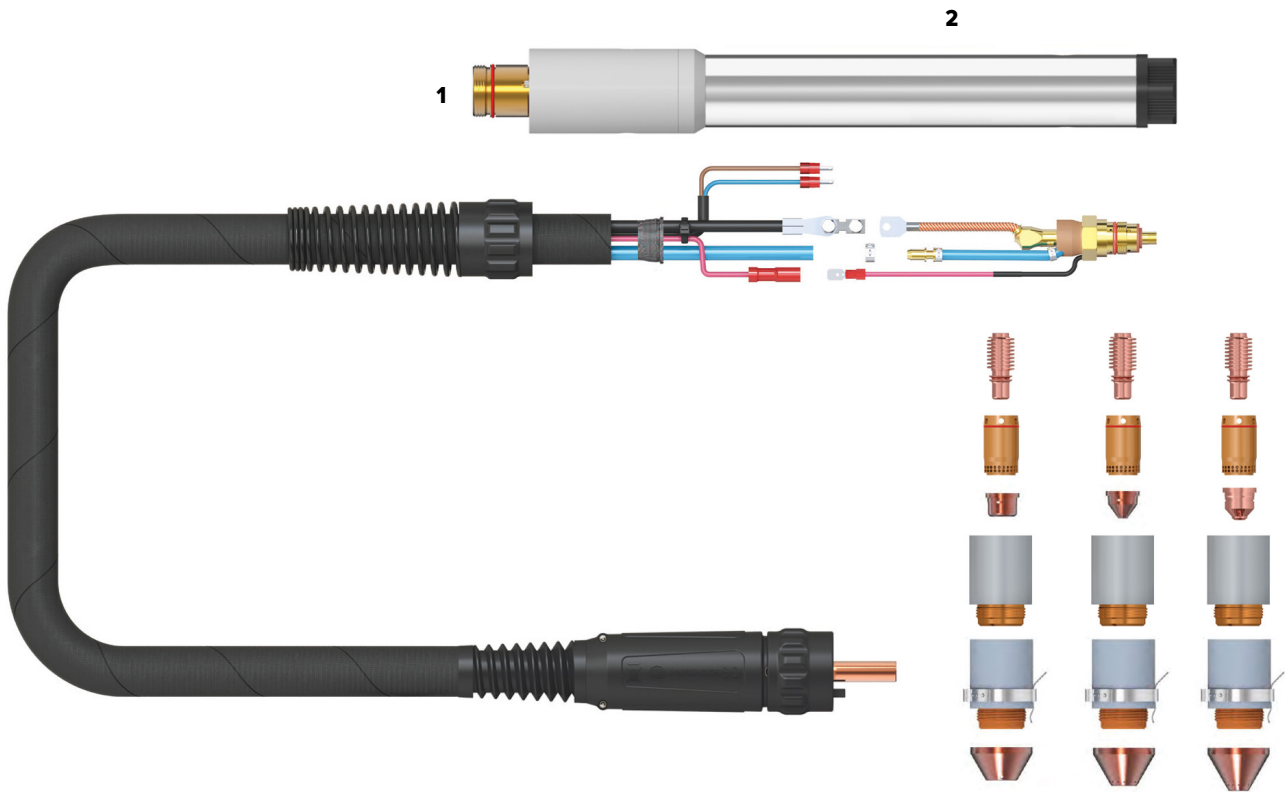
Shield Cap

U11248	SHIELD CAP SUIT SC160 45-85A QTY 1
U43005	SHIELD CAP SUIT SC160 105-160A QTY 1

Cutting Guide

U11254	CUTTING GUIDE SUIT SC160 QTY 1
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2.13 SC160 CNC Plasma Torch



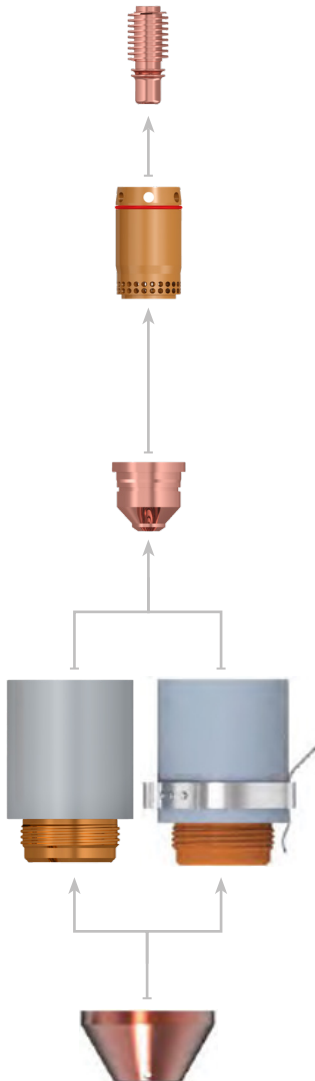
Length	6m	10m
SKU	U43011	U11247

1	U11255	PLASMA TORCH HEAD SUIT CNC SC160
2	U11256	PLASMA TORCH HANDLE SUIT CNC SC160

COOLING METHOD	Air-Cooled
DUTY CYCLE	80% @ 160A
GAS	Air
IGNITION	Pilot Arc
STANDARD	EN60974-7

2.14 SC160 CNC Plasma Torch Consumables

2.14.1 Precision Cutting



Electrode

U43009P	ELECTRODES SUIT SC160 QTY 5
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Swirl Ring

U43008	SWIRL RING SUIT SC160 QTY 1
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Cutting Tips

U1140	CUTTING TIPS PRECISION CUT SUIT SC160 30-45A QTY 5
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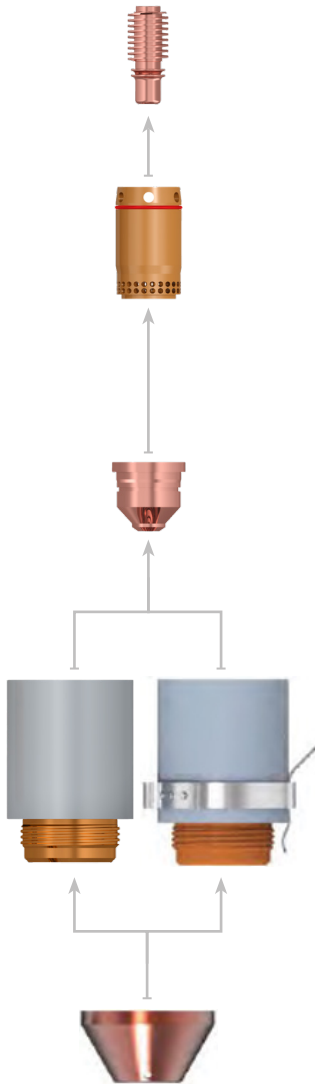
Shield Cap Body

U11139	SHIELD CAP BODY SUIT SC160 45-85A QTY 1
U11251	SHIELD CAP BODY OHMIC CONTACT SUIT CNC SC160 45-85A QTY 1

Shield Cap

U11141	SHIELD CAP PRECISION CUT SUIT SC160 30-45A QTY 1
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2.14.2 Cutting



Electrode

U43009P	ELECTRODES SUIT SC160 QTY 5
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Swirl Ring

U43008	SWIRL RING SUIT SC160 QTY 1
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Cutting Tips

U11135	CUTTING TIPS SUIT SC160 45A QTY 5
U11136	CUTTING TIPS SUIT SC160 45A QTY 5
U11137	CUTTING TIPS SUIT SC160 85A QTY 5
U11138	CUTTING TIPS SUIT SC160 105-125A QTY 5
U43007P	CUTTING TIPS SUIT SC160 160A QTY 5

Shield Cap Body

U11139	SHIELD CAP BODY SUIT SC160 45-85A QTY 1
U43006	SHIELD CAP BODY SUIT SC160 105-160A QTY 1
U11251	SHIELD CAP BODY OHMIC CONTACT SUIT CNC SC160 45-85A QTY 1
U11252	SHIELD CAP BODY OHMIC CONTACT SUIT CNC SC160 105-160A QTY 1

Shield Cap

U11249	SHIELD CAP SUIT CNC SC160 45-85A QTY 1
U11250	SHIELD CAP SUIT CNC SC160 105-160A QTY 1

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