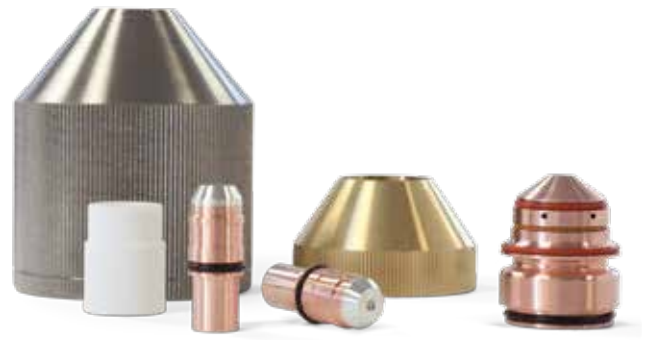




Consumables for Koike® Super-400 Plus torches

Upgrade to Centricut consumables to lower operating costs without sacrificing cut quality or productivity.



Lower costs

- Cut 50% more metal per consumable set.
- Reduce consumable usage by one third.
- Available at a lower price than OEM.
- Local stocking and fast delivery reduce your inventory costs.

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.

To achieve maximum consumable life

A fully used SilverLine electrode will have a pit depth of 2.0 mm. This is deeper than the pit depth for standard copper electrodes.

With proper use, the CoolFlow nozzle will last 1:1 with the SilverLine electrode.

Properly tighten the shield and protection cap: Make sure the shield is sealed tightly against the nozzle and the protection cap is properly tightened to the torch to prevent leaking.

Purge torch: After each parts-change, purge the torch for at least 30 seconds to remove residual moisture.

Leak check: After purging the torch, make sure all o-ring seals are working as designed.

Adjust plasma gas flow: Plasma gas flow rate is critical. High flow will cause rapid electrode wear and hard starting. Low flow will cause uncontrolled arcing.

Adjust shield gas flow: Having the correct shield gas flow provides protection to the nozzle during the cutting process.

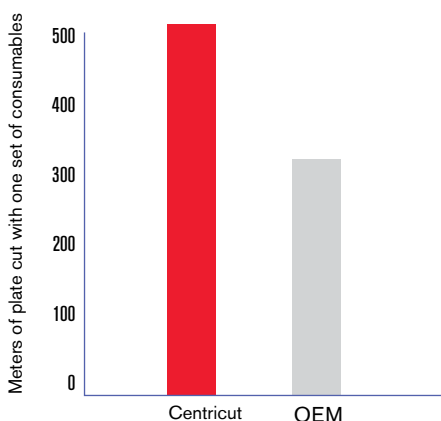
Pierce at correct height: Piercing too low causes molten metal (spatter) to hit the nozzle – the most common cause of premature nozzle failure. Piercing too high can cause misfires.

Adjust arc voltage: As the consumables wear, the torch will get closer to the plate. To maintain optimum cutting height, increase arc voltage in 5-volt increments up to 20 volts higher than the initial setting.

Avoid arc stretching: This can occur during rip cutting off the plate or when the leadout is improperly programmed. This shortens consumable life.

Clean the nozzle: Periodically clean the nozzle to remove spatter. This will prevent double arcing which shortens consumable life.

Consumable life comparison at 360-400 amps



Centricut consumables for the Koike® Super 400 Plus will lower your cost of cutting.



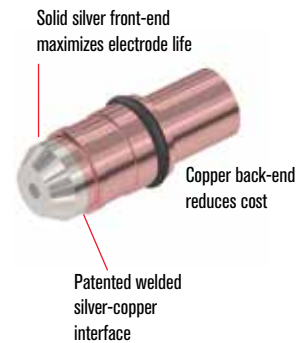
Parts list

	Part number	Reference	Description
1	C121-1058	40016358	SilverLine® electrode
2	C121-899	40001899	Swirl ring, R
	C121-567	40004567	Swirl ring, L
3	C121-233	40017233	CoolFlow® nozzle, 2.9R
	C121-234	40017234	CoolFlow nozzle, 2.9L
	C121-360	40016360	CoolFlow nozzle, 2.3R
	C121-363	40016363	CoolFlow nozzle, 2.3L
	C121-359	40016359	CoolFlow nozzle, 1.7R
	C121-362	40016362	CoolFlow nozzle, 1.7L
4	C121-366	40016366	Shield
5	C121-503	40020503	Protection cap

SilverLine electrodes and CoolFlow nozzles deliver exceptional cut quality and fast cutting over the full life of the consumables

Centricut vs. OEM

SilverLine electrode



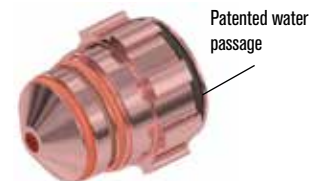
Koike electrode



CoolFlow nozzle



Koike nozzle



Contact Hypertherm to locate a distributor near you.

Hypertherm, Centricut, SilverLine 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 Koike.

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.

© 6/2014 Hypertherm Inc. Revision 1
88078D



Hypertherm®
Cut with confidence®

