



***Torch and Consumables
Cross-reference Guide
for Mechanized Systems***

Hypertherm®

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How to use this Guide


















This cross-reference guide includes all the relevant information for our mechanized system torches and consumables in one, easy-to-use reference. We hope that it will help channel partners provide correct information to their customers who may be using a system that is no longer being sold or who may not know which parts are needed for specific applications.

The table of contents lists the first page of the section dealing with a particular system. It includes a picture of the system (if available) to help customers who cannot recall which system they are using. It also includes the name of the torch.

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Hypertherm®

HyPerformance® Plasma

HPR400XD®

Consumables



HPR400XD



HPR400XD torch

Mild steel

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|---------------------|------------|--------|----------------------|--------|------------|--------------------------------------|------------|
| 30 A | 220747 | 220194 | 220754 | 220193 | 220180 | 220192 Standard | 220340 |
| 50 A | 220747 | 220555 | 220754 | 220554 | 220553 | 220552 Standard | |
| 80 A | 220747 | 220189 | 220756 | 220188 | 220179 | 220187 Standard | |
| 130 A | 220747 | 220183 | 220756 | 220182 | 220179 | 220181 Standard 220665 SilverPlus | |
| 200 A | 220637 | 220761 | 220757 | 220354 | 220353 | 220352 Standard | 220571 |
| 260 A | 220637 | 220764 | 220760 | 220439 | 220436 | 220666 SilverPlus | |
| | | | | | | 220435 Standard 220668 SilverPlus | |
| 400 A | 220637 | 220636 | 220635 | 220632 | 220631 | 220629 | 220571 |
| 80 A bevel | 220637 | 220742 | 220845 | 220806 | 220179 | 220802 | 220700 |
| 130 A bevel | 220637 | 220742 | 220740 | 220646 | 220179 | 220649 | 220700 |
| 260 A bevel | 220637 | 220741 | 220740 | 220542 | 220436 | 220541 | 220571 |
| *260 A bevel | 220637 | 220897 | 220896 | 220898 | 220436 | 220899 | 220571 |
| 400 A bevel | 220637 | 220636 | 220635 | 220632 | 220631 | 220629 | 220571 |

* recommended for use if you have a problem with excessive slag, or problems with the torch misfiring, when using standard bevel consumables.

Stainless steel

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|--------------------|------------|--------|------------------------------------------|--------|------------|-----------|------------|
| 45 A | 220747 | 220202 | 220755 | 220201 | 220180 | 220308 | 220340 |
| 80 A | 220747 | 220338 | 220755 | 220337 | 220179 | 220339 | |
| 130 A | 220747 | 220198 | 220755 (H35) 220756 (N ₂) | 220197 | 220179 | 220307 | |
| 200 A | 220637 | 220762 | 220758 | 220343 | 220342 | 220307 | 220571 |
| 260 A | 220637 | 220763 | 220758 | 220406 | 220405 | 220307 | |
| 400 A | 220637 | 220707 | 220712 | 220708 | 220405 | 220709 | 220571 |
| 130 A bevel | 220637 | 220738 | 220739 | 220656 | 220179 | 220606 | 220571 |
| 260 A bevel | 220637 | 220738 | 220739 | 220607 | 220405 | 220606 | |
| 400 A bevel | 220637 | 220707 | 220712 | 220708 | 220405 | 220709 | 220571 |

Aluminum

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|--------------|------------|--------|------------------------------|--------|------------|------------------------------|------------|
| 45 A | 220747 | 220202 | 220756 | 220201 | 220180 | 220308 | 220340 |
| 130 A | 220747 | 220198 | 220755 (H35) 220756 (Air) | 220197 | 220179 | 220307 (H35) 220181 (Air) | |
| | | | | | | | |
| 200 A | 220637 | 220762 | 220759 | 220346 | 220342 | 220307 | 220571 |
| 260 A | 220637 | 220763 | 220758 | 220406 | 220405 | 220307 | |
| 400 A | 220637 | 220707 | 220712 | 220708 | 220405 | 220709 | 220571 |

HPR400XD consumables

Bevel cutting

| Material | Consumable Description | 400 A | 260 A | 200 A | 130 A | 80 A | 50 A | 45 A | 30 A | 400 A | 260 A | *260 A | 130 A | 80 A |
|-----------------|------------------------|--------|--------|--------|--------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| Mild steel | Standard electrode | 220629 | 220435 | 220352 | 220181 | 220187 | 220552 | ----- | 220192 | 220629 | 220541 | 220899 | 220649 | 220802 |
| | SilverPlus | ----- | 220668 | 220666 | 220665 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| | Swirl ring | 220631 | 220436 | 220353 | 220179 | 220179 | 220553 | ----- | 220180 | 220631 | 220436 | 220436 | 220179 | 220179 |
| | Nozzle | 220632 | 220439 | 220354 | 220182 | 220188 | 220554 | ----- | 220193 | 220632 | 220542 | 220898 | 220646 | 220806 |
| | Nozzle retaining cap | 220635 | 220760 | 220757 | 220756 | 220756 | 220754 | ----- | 220754 | 220635 | 220740 | 220896 | 220740 | 220845 |
| | Shield | 220636 | 220764 | 220761 | 220183 | 220189 | 220555 | ----- | 220194 | 220636 | 220741 | 220897 | 220742 | 220742 |
| | Shield cap | 220637 | 220637 | 220637 | 220747 | 220747 | 220747 | ----- | 220747 | 220637 | 220637 | 220637 | 220637 | 220637 |
| Water tube | 220571 | 220340 | 220340 | 220340 | 220340 | 220340 | ----- | 220340 | 220571 | 220571 | 220571 | 220700 | 220700 | |
| Stainless steel | Standard electrode | 220709 | 220307 | 220307 | 220307 | 220339 | ----- | 220308 | ----- | 220709 | 220606 | ----- | 220606 | ----- |
| | Swirl ring | 220405 | 220405 | 220342 | 220179 | 220179 | ----- | 220180 | ----- | 220405 | 220405 | ----- | 220179 | ----- |
| | Nozzle | 220708 | 220406 | 220343 | 220197 | 220337 | ----- | 220201 | ----- | 220708 | 220607 | ----- | 220656 | ----- |
| | Nozzle retaining cap | 220712 | 220758 | 220758 | 220755 (H35) | 220755 | ----- | 220755 | ----- | 220712 | 220739 | ----- | 220739 | ----- |
| | | ----- | ----- | ----- | 220756 (N2) | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| | Shield | 220707 | 220763 | 220762 | 220198 | 220338 | ----- | 220202 | ----- | 220707 | 220738 | ----- | 220738 | ----- |
| | Shield cap | 220637 | 220637 | 220637 | 220747 | 220747 | ----- | 220747 | ----- | 220637 | 220637 | ----- | 220637 | ----- |
| Water tube | 220571 | 220340 | 220340 | 220340 | 220340 | ----- | 220340 | ----- | 220571 | 220571 | ----- | 220571 | ----- | |
| Aluminum | Standard electrode | 220709 | 220307 | 220307 | 220307 (H35) | ----- | ----- | 220308 | ----- | ----- | ----- | ----- | ----- | ----- |
| | | ----- | ----- | ----- | 220181 (Air) | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| | Swirl ring | 220405 | 220405 | 220342 | 220179 | ----- | ----- | 220180 | ----- | ----- | ----- | ----- | ----- | ----- |
| | Nozzle | 220708 | 220406 | 220346 | 220197 | ----- | ----- | 220201 | ----- | ----- | ----- | ----- | ----- | ----- |
| | Nozzle retaining cap | 220712 | 220758 | 220759 | 220755 (H35) | ----- | ----- | 220756 | ----- | ----- | ----- | ----- | ----- | ----- |
| | | ----- | ----- | ----- | 220756 (Air) | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| | Shield | 220707 | 220763 | 220762 | 220198 | ----- | ----- | 220202 | ----- | ----- | ----- | ----- | ----- | ----- |
| Shield cap | 220637 | 220637 | 220637 | 220747 | ----- | ----- | 220747 | ----- | ----- | ----- | ----- | ----- | ----- | |
| Water tube | 220571 | 220340 | 220340 | 220340 | ----- | ----- | 220340 | ----- | ----- | ----- | ----- | ----- | ----- | |

* recommended for use if you have a problem with excessive slag, or problems with the torch misfiring, when using standard bevel consumables.

HyPerformance Plasma HPR400XD torch assembly

| PART NO. | DESCRIPTION |
|----------|-------------------------------------------------------------------|
| 220706 | Quick-disconnect torch |
| 220571 | Water tube with o-ring (400 A) |
| 220340 | Water tube with o-ring (30/40/50/80/130/200/260 A) |
| 220705 | Quick-disconnect receptacle |
| 220789 | Torch mounting sleeve assembly |
| 128879 | Torch kit: Bullet plugs, o-rings, water tube and seal (not shown) |
| 128880 | Quick-disconnect kit: o-ring and connector (not shown) |
| 228895 | 25' (7.5 m) leads |
| 228297 | 50' (15 m) leads |
| 220700 | Bevel water tube (mild steel – 130 A) |
| 220571 | Bevel water tube (mild steel 260 A, stainless steel 130/260 A) |

Hypertherm[®]

HyPerformance[®] Plasma

HPR260XD[®]

Consumables



Mild steel

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|---------------------|------------|--------|----------------------|--------|------------|--------------------------------------|------------|
| | | | | | | | |
| 30 A | 220747 | 220194 | 220754 | 220193 | 220180 | 220192 Standard | 220340 |
| 50 A | 220747 | 220555 | 220754 | 220554 | 220553 | 220552 Standard | |
| 80 A | 220747 | 220189 | 220756 | 220188 | 220179 | 220187 Standard | |
| 130 A | 220747 | 220183 | 220756 | 220182 | 220179 | 220181 Standard 220665 SilverPlus | |
| | | | | | | | |
| 200 A | 220637 | 220761 | 220757 | 220354 | 220353 | 220352 Standard 220666 SilverPlus | |
| 260 A | 220637 | 220764 | 220760 | 220439 | 220436 | 220435 Standard 220668 SilverPlus | |
| | | | | | | | |
| 80 A bevel | 220637 | 220742 | 220845 | 220806 | 220179 | 220802 | 220700 |
| 130 A bevel | 220637 | 220742 | 220740 | 220646 | 220179 | 220649 | 220700 |
| 260 A bevel | 220637 | 220741 | 220740 | 220542 | 220436 | 220541 | 220571 |
| *260 A bevel | 220637 | 220897 | 220896 | 220898 | 220436 | 220899 | 220571 |

* recommended for use if you have a problem with excessive slag, or problems with the torch misfiring, when using standard bevel consumables.

HPR260XD



HPR260XD torch

Stainless steel

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|--------------------|------------|--------|------------------------------------------|--------|------------|-----------|------------|
| | | | | | | | |
| 45 A | 220747 | 220202 | 220755 | 220201 | 220180 | 220308 | 220340 |
| 80 A | 220747 | 220338 | 220755 | 220337 | 220179 | 220339 | |
| 130 A | 220747 | 220198 | 220755 (H35) 220756 (N ₂) | 220197 | 220179 | 220307 | |
| | | | | | | | |
| 200 A | 220637 | 220762 | 220758 | 220343 | 220342 | 220307 | |
| 260 A | 220637 | 220763 | 220758 | 220406 | 220405 | 220307 | |
| | | | | | | | |
| 130 A bevel | 220637 | 220738 | 220739 | 220656 | 220179 | 220606 | 220571 |
| 260 A bevel | 220637 | 220738 | 220739 | 220607 | 220405 | 220606 | |

Aluminum

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|--------------|------------|--------|------------------------------|--------|------------|------------------------------|------------|
| | | | | | | | |
| 45 A | 220747 | 220202 | 220756 | 220201 | 220180 | 220308 | 220340 |
| 130 A | 220747 | 220198 | 220755 (H35) 220756 (Air) | 220197 | 220179 | 220307 (H35) 220181 (Air) | |
| | | | | | | | |
| 200 A | 220637 | 220762 | 220759 | 220346 | 220342 | 220307 | |
| 260 A | 220637 | 220763 | 220758 | 220406 | 220405 | 220307 | |

HPR260XD consumables

| Material | Consumable Description | | | | | | | | | Bevel cutting | |
|-----------------|------------------------|--------|--------|--------------|--------|--------|--------|--------|--------|---------------|--|
| | | 260 A | 200 A | 130 A | 80 A | 50 A | 45 A | 30 A | 260 A | 130 A | |
| Mild steel | Standard electrode | 220435 | 220352 | 220181 | 220187 | 220552 | ----- | 220192 | 220541 | 220649 | |
| | SilverPlus | 220668 | 220666 | 220665 | ----- | ----- | ----- | ----- | ----- | ----- | |
| | Swirl ring | 220436 | 220353 | 220179 | 220179 | 220553 | ----- | 220180 | 220436 | 220179 | |
| | Nozzle | 220439 | 220354 | 220182 | 220188 | 220554 | ----- | 220193 | 220542 | 220646 | |
| | Nozzle retaining cap | 220760 | 220757 | 220756 | 220756 | 220754 | ----- | 220754 | 220740 | 220740 | |
| | Shield | 220764 | 220761 | 220183 | 220189 | 220555 | ----- | 220194 | 220741 | 220742 | |
| | Shield cap | 220637 | 220637 | 220747 | 220747 | 220747 | ----- | 220747 | 220637 | 220637 | |
| | Water tube | 220340 | 220340 | 220340 | 220340 | 220340 | ----- | 220340 | 220571 | 220700 | |
| Stainless steel | Standard electrode | 220307 | 220307 | 220307 | 220339 | ----- | 220308 | ----- | 220606 | 220606 | |
| | Swirl ring | 220405 | 220342 | 220179 | 220179 | ----- | 220180 | ----- | 220405 | 220179 | |
| | Nozzle | 220406 | 220343 | 220197 | 220337 | ----- | 220201 | ----- | 220607 | 220656 | |
| | Nozzle retaining cap | 220758 | 220758 | 220755 (H35) | 220755 | ----- | 220755 | ----- | 220739 | 220739 | |
| | ----- | ----- | ----- | 220756 (N2) | ----- | ----- | ----- | ----- | ----- | ----- | |
| | Shield | 220763 | 220762 | 220198 | 220338 | ----- | 220202 | ----- | 220738 | 220738 | |
| | Shield cap | 220637 | 220637 | 220747 | 220747 | ----- | 220747 | ----- | 220637 | 220637 | |
| | Water tube | 220340 | 220340 | 220340 | 220340 | ----- | 220340 | ----- | 220571 | 220571 | |
| Aluminum | Standard electrode | 220307 | 220307 | 220307 (H35) | ----- | ----- | 220308 | ----- | ----- | ----- | |
| | ----- | ----- | ----- | 220181 (Air) | ----- | ----- | ----- | ----- | ----- | ----- | |
| | Swirl ring | 220405 | 220342 | 220179 | ----- | ----- | 220180 | ----- | ----- | ----- | |
| | Nozzle | 220406 | 220346 | 220197 | ----- | ----- | 220201 | ----- | ----- | ----- | |
| | Nozzle retaining cap | 220758 | 220759 | 220755 (H35) | ----- | ----- | 220756 | ----- | ----- | ----- | |
| | ----- | ----- | ----- | 220756 (Air) | ----- | ----- | ----- | ----- | ----- | ----- | |
| | Shield | 220763 | 220762 | 220198 | ----- | ----- | 220202 | ----- | ----- | ----- | |
| | Shield cap | 220637 | 220637 | 220747 | ----- | ----- | 220747 | ----- | ----- | ----- | |
| Water tube | 220340 | 220340 | 220340 | ----- | ----- | 220340 | ----- | ----- | ----- | | |

HyPerformance Plasma HPR260XD torch assembly

220705

220789

220571
220340
220700

220706

228895
228297

| PART NO. | DESCRIPTION |
|----------|-------------------------------------------------------------------|
| 220706 | Quick-disconnect torch |
| 220571 | Water tube with o-ring (400 A) |
| 220340 | Water tube with o-ring (30/40/50/80/130/200/260 A) |
| 220705 | Quick-disconnect receptacle |
| 220789 | Torch mounting sleeve assembly |
| 128879 | Torch kit: Bullet plugs, o-rings, water tube and seal (not shown) |
| 128880 | Quick-disconnect kit: o-ring and connector (not shown) |
| 228895 | 25' (7.5 m) leads |
| 228297 | 50' (15 m) leads |
| 220700 | Bevel water tube (mild steel – 130 A) |
| 220571 | Bevel water tube (mild steel 260 A, stainless steel 130/260 A) |

Hypertherm®

HyPerformance® Plasma

HPR130XD®

Consumables



HPR130XD



HPR130XD torch

Mild steel

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|--------------------|------------|--------|----------------------|--------|------------|--------------------------------------|------------|
| | | | | | | | |
| 30 A | 220747 | 220194 | 220754 | 220193 | 220180 | 220192 Standard | 220340 |
| 50 A | 220747 | 220555 | 220754 | 220554 | 220553 | 220552 Standard | |
| 80 A | 220747 | 220189 | 220756 | 220188 | 220179 | 220187 Standard | |
| 130 A | 220747 | 220183 | 220756 | 220182 | 220179 | 220181 Standard 220665 SilverPlus | |
| | | | | | | | |
| 80 A bevel | 220637 | 220742 | 220845 | 220806 | 220179 | 220802 | 220700 |
| 130 A bevel | 220637 | 220742 | 220740 | 220646 | 220179 | 220649 | 220700 |
| | 220637 | 220741 | 220740 | 220542 | 220436 | 220541 | 220571 |
| | 220637 | 220897 | 220896 | 220898 | 220436 | 220899 | 220571 |

Stainless steel

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|--------------------|------------|--------|------------------------------------------|--------|------------|-----------|------------|
| | | | | | | | |
| 45 A | 220747 | 220202 | 220755 | 220201 | 220180 | 220308 | 220340 |
| 80 A | 220747 | 220338 | 220755 | 220337 | 220179 | 220339 | |
| 130 A | 220747 | 220198 | 220755 (H35) 220756 (N ₂) | 220197 | 220179 | 220307 | |
| | | | | | | | |
| 130 A bevel | 220637 | 220738 | 220739 | 220656 | 220179 | 220606 | 220571 |

Aluminum

| | Shield cap | Shield | Nozzle retaining cap | Nozzle | Swirl ring | Electrode | Water tube |
|--------------|------------|--------|------------------------------|--------|------------|------------------------------|------------|
| | | | | | | | |
| 45 A | 220747 | 220202 | 220756 | 220201 | 220180 | 220308 | 220340 |
| 130 A | 220747 | 220198 | 220755 (H35) 220756 (Air) | 220197 | 220179 | 220307 (H35) 220181 (Air) | |

HPR130XD consumables

| Material | Consumable Description | | | | | | Bevel cutting | |
|-----------------|------------------------|--------------|--------|--------|--------|--------|---------------|--|
| | | 130 A | 80 A | 50 A | 45 A | 30 A | 130 A | |
| Mild steel | Standard electrode | 220181 | 220187 | 220552 | ----- | 220192 | 220649 | |
| | SilverPlus | 220665 | ----- | ----- | ----- | ----- | ----- | |
| | Swirl ring | 220179 | 220179 | 220553 | ----- | 220180 | 220179 | |
| | Nozzle | 220182 | 220188 | 220554 | ----- | 220193 | 220646 | |
| | Nozzle retaining cap | 220756 | 220756 | 220754 | ----- | 220754 | 220740 | |
| | Shield | 220183 | 220189 | 220555 | ----- | 220194 | 220742 | |
| | Shield cap | 220747 | 220747 | 220747 | ----- | 220747 | 220637 | |
| Water tube | 220340 | 220340 | 220340 | ----- | 220340 | 220700 | | |
| Stainless steel | Standard electrode | 220307 | 220339 | ----- | 220308 | ----- | 220606 | |
| | Swirl ring | 220179 | 220179 | ----- | 220180 | ----- | 220179 | |
| | Nozzle | 220197 | 220337 | ----- | 220201 | ----- | 220656 | |
| | Nozzle retaining cap | 220755 (H35) | 220755 | ----- | 220755 | ----- | 220739 | |
| | | 220756 (N2) | ----- | ----- | ----- | ----- | ----- | |
| | Shield | 220198 | 220338 | ----- | 220202 | ----- | 220738 | |
| | Shield cap | 220747 | 220747 | ----- | 220747 | ----- | 220637 | |
| Water tube | 220340 | 220340 | ----- | 220340 | ----- | 220571 | | |
| Aluminum | Standard electrode | 220307 (H35) | ----- | ----- | 220308 | ----- | ----- | |
| | | 220181 (Air) | ----- | ----- | ----- | ----- | ----- | |
| | Swirl ring | 220179 | ----- | ----- | 220180 | ----- | ----- | |
| | Nozzle | 220197 | ----- | ----- | 220201 | ----- | ----- | |
| | Nozzle retaining cap | 220755 (H35) | ----- | ----- | 220756 | ----- | ----- | |
| | | 220756 (Air) | ----- | ----- | ----- | ----- | ----- | |
| | Shield | 220198 | ----- | ----- | 220202 | ----- | ----- | |
| Shield cap | 220747 | ----- | ----- | 220747 | ----- | ----- | | |
| Water tube | 220340 | ----- | ----- | 220340 | ----- | ----- | | |

HyperPerformance Plasma HPR130XD torch assembly

| PART NO. | DESCRIPTION |
|----------|-------------------------------------------------------------------|
| 220706 | Quick-disconnect torch |
| 220571 | Water tube with o-ring (400 A) |
| 220340 | Water tube with o-ring (30/40/50/80/130/200/260 A) |
| 220705 | Quick-disconnect receptacle |
| 220789 | Torch mounting sleeve assembly |
| 128879 | Torch kit: Bullet plugs, o-rings, water tube and seal (not shown) |
| 128880 | Quick-disconnect kit: o-ring and connector (not shown) |
| 228895 | 25' (7.5 m) leads |
| 228297 | 50' (15 m) leads |
| 220700 | Bevel water tube (mild steel – 130 A) |
| 220571 | Bevel water tube (mild steel 260 A, stainless steel 130/260 A) |

Hypertherm®

HyPerformance™ Plasma

HPR260™

Consumables



HPR260



HPR260 torch

Mild steel

| | Shield cap | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|--------------------|------------|--------|---------------|--------|------------|--------------------------------------|
| 30 A | 220173 | 220194 | 220313 | 220193 | 220180 | 220192-Standard |
| 50 A | 220173 | 220555 | 220313 | 220554 | 220553 | 220552-Standard |
| 80 A | 220173 | 220189 | 220176 | 220188 | 220179 | 220187-Standard |
| 130 A | 220173 | 220183 | 220176 | 220182 | 220179 | 220181-Standard 220665-SilverPlus |
| 200 A | | | | | | |
| | | 220356 | 220355 | 220354 | 220353 | 220352-Standard 220666-SilverPlus |
| 260 A | 220398 | | | | | |
| | | 220440 | 220433 | 220439 | 220436 | 220435-Standard 220668-SilverPlus |
| 130 A bevel | 220398 | 220645 | 220603 | 220646 | 220179 | 220649 |
| 260 A bevel | 220398 | 220545 | 220603 | 220542 | 220436 | 220541 |

Stainless steel

| | Shield cap | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|--------------------|------------|--------|------------------------------------------|--------|------------|-----------|
| 45 A | 220173 | 220202 | 220304 | 220201 | 220180 | 220308 |
| 80 A | 220173 | 220338 | 220304 | 220337 | 220179 | 220339 |
| 130 A | 220173 | 220198 | 220304 (H35) 220176 (N ₂) | 220197 | 220179 | 220307 |
| 200 A | | | | | | |
| | | 220345 | 220344 | 220343 | 220342 | 220307 |
| 260 A | 220398 | | | | | |
| | | 220407 | 220344 | 220406 | 220405 | 220307 |
| 130 A bevel | 220398 | 220609 | 220608 | 220656 | 220179 | 220606 |
| 260 A bevel | 220398 | 220609 | 220608 | 220607 | 220405 | 220606 |

Aluminum

| | Shield cap | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|--------------|------------|--------|------------------------------|--------|------------|------------------------------|
| 45 A | | | | | | |
| | | 220202 | 220176 | 220201 | 220180 | 220308 |
| 130 A | 220173 | | | | | |
| | | 220198 | 220304 (H35) 220176 (Air) | 220197 | 220179 | 220307 (H35) 220181 (Air) |
| 200 A | | | | | | |
| | | 220345 | 220347 | 220346 | 220342 | 220307 |
| 260 A | 220398 | | | | | |
| | | 220407 | 220344 | 220406 | 220405 | 220307 |

HPR260 consumables

| MATERIAL | CONSUMABLE DESCRIPTION | Bevel cutting | | | | | | | | |
|-----------------|------------------------|---------------|--------|--------------------------|--------|--------|--------|--------|--------|--------|
| | | 260 A | 200 A | 130 A | 80 A | 50 A | 45 A | 30 A | 130 A | 260 A |
| Mild steel | Standard electrode | 220435 | 220352 | 220181 | 220187 | 220552 | ----- | 220192 | 220649 | 220541 |
| | SilverPlus electrode | 220668 | 220666 | 220665 | ----- | ----- | ----- | ----- | ----- | ----- |
| | Swirl ring | 220436 | 220353 | 220179 | 220179 | 220553 | ----- | 220180 | 220179 | 220436 |
| | Nozzle | 220439 | 220354 | 220182 | 220188 | 220554 | ----- | 220193 | 220646 | 220542 |
| | Inner retaining cap | 220433 | 220355 | 220176 | 220176 | 220313 | ----- | 220313 | 220603 | 220603 |
| | Shield | 220440 | 220356 | 220183 | 220189 | 220555 | ----- | 220194 | 220645 | 220545 |
| | Shield cap | 220398 | 220398 | 220173 | 220173 | 220173 | ----- | 220173 | 220398 | 220398 |
| Stainless steel | Electrode | 220307 | 220307 | 220307 | 220339 | ----- | 220308 | ----- | 220606 | 220606 |
| | Swirl ring | 220405 | 220342 | 220179 | 220179 | ----- | 220180 | ----- | 220179 | 220405 |
| | Nozzle | 220406 | 220343 | 220197 | 220337 | ----- | 220201 | ----- | 220656 | 220607 |
| | Inner retaining cap | 220344 | 220344 | 220304 (H35) | 220304 | ----- | 220304 | ----- | 220608 | 220608 |
| | ----- | ----- | ----- | 220176 (N ₂) | ----- | ----- | ----- | ----- | ----- | ----- |
| | Shield | 220407 | 220345 | 220198 | 220338 | ----- | 220202 | ----- | 220609 | 220609 |
| | Shield cap | 220398 | 220398 | 220173 | 220173 | ----- | 220173 | ----- | 220398 | 220398 |
| Aluminum | Electrode | 220307 | 220307 | 220307 (H35) | ----- | ----- | 220308 | ----- | ----- | ----- |
| | ----- | ----- | ----- | 220181 (Air) | ----- | ----- | ----- | ----- | ----- | ----- |
| | Swirl ring | 220405 | 220342 | 220179 | ----- | ----- | 220180 | ----- | ----- | ----- |
| | Nozzle | 220432 | 220346 | 220197 | ----- | ----- | 220201 | ----- | ----- | ----- |
| | Inner retaining cap | 220344 | 220347 | 220304 (H35) | ----- | ----- | 220176 | ----- | ----- | ----- |
| | ----- | ----- | ----- | 220176 (Air) | ----- | ----- | ----- | ----- | ----- | ----- |
| | Shield | 220407 | 220345 | 220198 | ----- | ----- | 220202 | ----- | ----- | ----- |
| Shield cap | 220398 | 220398 | 220173 | ----- | ----- | 220173 | ----- | ----- | ----- | |

HyPerformance Plasma HPR260 torch assembly

| PART NO. | DESCRIPTION |
|----------|-------------------------------------------------------------------|
| 220162 | Quick-disconnect torch |
| 220340 | Water tube with o-ring |
| 220163 | Quick-disconnect receptacle |
| 024249 | Insulating sleeve |
| 220232 | Torch mounting sleeve assembly |
| 128879 | Torch kit: bullet plugs, o-rings, water tube and seal (not shown) |
| 128880 | Quick-disconnect kit: o-ring and connector (not shown) |
| 128784 | 25' (7.5 m) leads |
| 128785 | 50' (15 m) leads |
| 220700 | Bevel water tube (mild steel – 130 A) |
| 220571 | Bevel water tube (stainless steel – 130/260 A) |

Hypertherm®

HyPerformance™ Plasma

HPR130™

Consumables



HPR130



HPR130 torch

Mild steel

| | Shield cap | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|--------------------|------------|--------|---------------|--------|------------|--------------------------------------|
| 30 A | 220173 | 220194 | 220313 | 220193 | 220180 | 220192-Standard 220665-SilverPlus |
| 50 A | 220173 | 220555 | 220313 | 220554 | 220553 | 220552-Standard |
| 80 A | 220173 | 220189 | 220176 | 220188 | 220179 | 220187-Standard |
| 130 A | 220173 | 220183 | 220176 | 220182 | 220179 | 220181-Standard |
| 130 A bevel | 220398 | 220645 | 220603 | 220646 | 220179 | 220649 |

Stainless steel

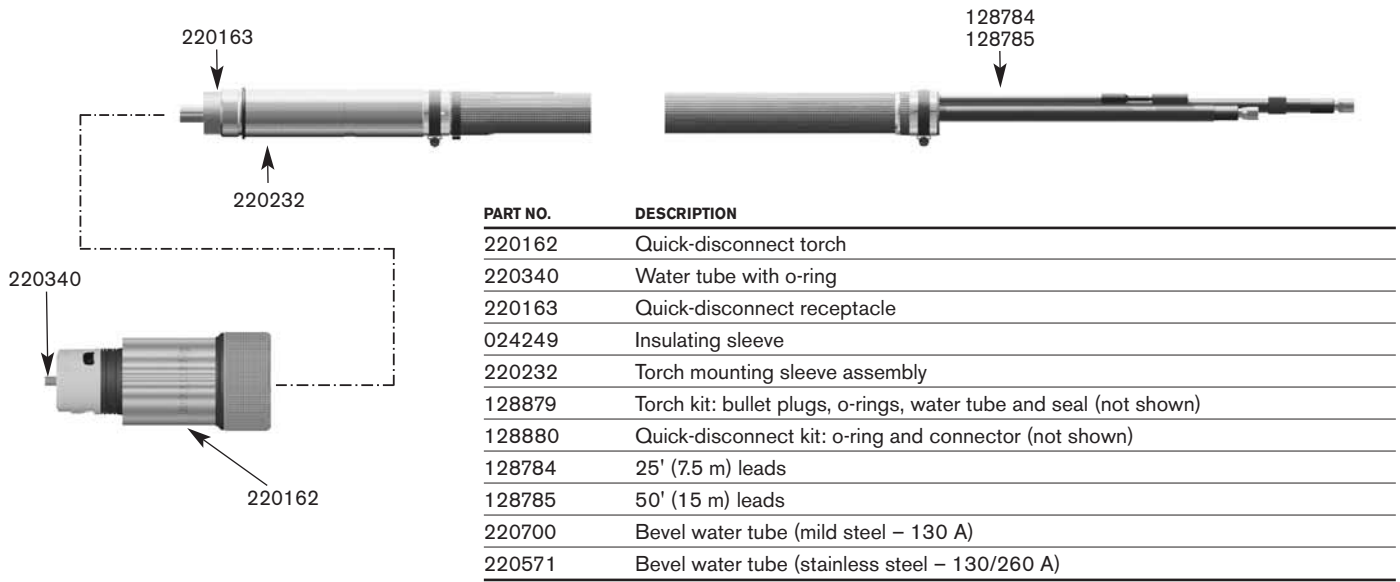
| | Shield cap | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|--------------------|------------|--------|------------------------------------------|--------|------------|-----------|
| 45 A | 220173 | 220202 | 220304 | 220201 | 220180 | 220308 |
| 80 A | 220173 | 220338 | 220304 | 220337 | 220179 | 220339 |
| 130 A | 220173 | 220198 | 220304 (H35) 220176 (N ₂) | 220197 | 220179 | 220307 |
| 130 A bevel | 220398 | 220609 | 220608 | 220656 | 220179 | 220606 |

Aluminum

| | Shield cap | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|--------------|------------|--------|------------------------------|--------|------------|------------------------------|
| 45 A | 220173 | 220202 | 220304 | 220201 | 220180 | 220308 |
| 130 A | | 220198 | 220304 (H35) 220176 (Air) | 220197 | 220179 | 220307 (H35) 220181 (Air) |

| MATERIAL | CONSUMABLE DESCRIPTION | 130 A | 80 A | 50 A | 45 A | 30 A | Bevel cutting 130 A |
|-----------------|------------------------|------------------------------------------|--------|--------|--------|--------|---------------------|
| Mild steel | Standard electrode | 220181 | 220187 | 220552 | ----- | 220192 | 220649 |
| | SilverPlus electrode | 220655 | ----- | ----- | ----- | ----- | ----- |
| | Swirl ring | 220179 | 220179 | 220553 | ----- | 220180 | 220179 |
| | Nozzle | 220182 | 220188 | 220554 | ----- | 220193 | 220646 |
| | Inner retaining cap | 220176 | 220176 | 220313 | ----- | 220313 | 220603 |
| | Shield | 220183 | 220189 | 220555 | ----- | 220194 | 220645 |
| | Shield cap | 220173 | 220173 | 220173 | ----- | 220173 | 220398 |
| Stainless steel | Electrode | 220307 | 220339 | ----- | 220308 | ----- | 220606 |
| | Swirl ring | 220179 | 220179 | ----- | 220180 | ----- | 220179 |
| | Nozzle | 220197 | 220337 | ----- | 220201 | ----- | 220656 |
| | Inner retaining cap | 220304 (H35) 220176 (N ₂) | 220304 | ----- | 220304 | ----- | 220608 |
| | Shield | 220198 | 220338 | ----- | 220202 | ----- | 220609 |
| | Shield cap | 220173 | 220173 | ----- | 220173 | ----- | 220398 |
| Aluminum | Electrode | 220307 (H35) 220181 (Air) | ----- | ----- | 220308 | ----- | ----- |
| | Swirl ring | 220179 | ----- | ----- | 220180 | ----- | ----- |
| | Nozzle | 220197 | ----- | ----- | 220201 | ----- | ----- |
| | Inner retaining cap | 220304 (H35) 220176 (Air) | ----- | ----- | 220304 | ----- | ----- |
| | Shield | 220198 | ----- | ----- | 220202 | ----- | ----- |
| | Shield cap | 220173 | ----- | ----- | 220173 | ----- | ----- |

Hypertherm Plasma HPR130 torch assembly



Hypertherm®

HyPerformance® HD4070®

Consumables



HD4070



HyperPerformance HD4070 torch

Mild steel

| | Retaining cap | Shield | Inner retaining cap | Nozzle | Swirl ring | Electrode |
|------|---------------|--------|---------------------|--------|------------|-----------|
| 30A | | 220194 | 220313 | 220193 | 220180 | 220192 |
| 50A | 220173 | 220555 | 220313 | 220554 | 220553 | 220552 |
| 80A | | 220189 | 220176 | 220188 | 220179 | 220187 |
| 130A | | 220183 | 220176 | 220182 | 220179 | 220181 |
| 200A | 220398 | 220356 | 220355 | 220354 | 220353 | 220352 |

Stainless steel

| | Retaining cap | Shield | Inner retaining cap | Nozzle | Swirl ring | Electrode |
|------|---------------|--------|---------------------|--------|------------|-----------|
| 45A | | 220202 | 220304 | 220201 | 220180 | 220308 |
| 80A | 220173 | 220338 | 220304 | 220337 | 220179 | 220339 |
| 130A | | 220198 | 220304 | 220197 | 220179 | 220307 |
| 200A | 220398 | 220345 | 220344 | 220343 | 220342 | 220307 |

Aluminum

| | Retaining cap | Shield | Inner retaining cap | Nozzle | Swirl ring | Electrode |
|------|---------------|--------|---------------------|--------|------------|-----------|
| 45A | | 220202 | 220176 | 220201 | 220180 | 220308 |
| 130A | 220173 | 220198 | 220304 | 220197 | 220179 | 220307 |
| 200A | 220398 | 220345 | 220347 | 220346 | 220342 | 220307 |

HyPerformance HD4070 consumables

| MATERIAL | CONSUMABLE DESCRIPTION | 200 AMPS | 130 AMPS | 80 AMPS | 50 AMPS | 45 AMPS | 30 AMPS |
|-----------------|------------------------|----------|---------------------------------------------------|---------|---------|---------|---------|
| Mild steel | Electrode | 220352 | 220181 | 220187 | 220552 | ----- | 220192 |
| | Swirl ring | 220353 | 220179 | 220179 | 220553 | ----- | 220180 |
| | Nozzle | 220354 | 220182 | 220188 | 220554 | ----- | 220193 |
| | Inner retaining cap | 220355 | 220176 | 220176 | 220313 | ----- | 220313 |
| | Shield | 220356 | 220183 | 220189 | 220555 | ----- | 220194 |
| | Shield cap | 220398 | 220173 | 220173 | 220173 | ----- | ----- |
| Stainless steel | Electrode | 220307 | 220307 | 220339 | ----- | 220308 | ----- |
| | Swirl ring | 220342 | 220179 | 220179 | ----- | 220180 | ----- |
| | Nozzle | 220343 | 220197 | 220337 | ----- | 220201 | ----- |
| | Inner retaining cap | 220344 | 220304 (H35) ----- 220176 (N ₂) | 220304 | ----- | 220304 | ----- |
| | Shield | 220345 | 220198 | 220338 | ----- | 220202 | ----- |
| | Shield cap | 220398 | 220173 | 220173 | ----- | 220173 | ----- |
| Aluminum | Electrode | 220307 | 220307 (H35) ----- 220181 (Air) | ----- | ----- | 220308 | ----- |
| | Swirl ring | 220342 | 220179 | ----- | ----- | 220180 | ----- |
| | Nozzle | 220346 | 220197 | ----- | ----- | 220201 | ----- |
| | Inner retaining cap | 220347 | 220304 (H35) ----- 220176 (Air) | ----- | ----- | 220176 | ----- |
| | Shield | 220345 | 220198 | ----- | ----- | 220202 | ----- |
| | Shield cap | 220398 | 220173 | ----- | ----- | 220173 | ----- |

HyPerformance HD4070 Plasma torch assembly

| PART NO. | DESCRIPTION |
|----------|-------------------------------------------------------|
| 220162 | Quick-disconnect torch |
| 220340 | Water tube with o-ring |
| 220163 | Quick-disconnect receptacle |
| 220516 | Torch mounting sleeve |
| 128879 | Torch kit: bullet plugs, o-rings, water tube and seal |
| 128880 | Quick-disconnect kit: o-ring and connector |

RETROFIT KITS:

| PART NO. | DESCRIPTION |
|----------|---------------------------------------------|
| 128943 | Kit:HPR/HD4070 upgrade with 6' torch leads |
| 128944 | Kit:HPR/HD4070 upgrade with 10' torch leads |
| 128945 | Kit:HPR/HD4070 upgrade with 15' torch leads |

Hypertherm®

HyPerformance® HD3070®

Consumables



HD3070



HyPerformance HD3070 torch

Mild steel

| | Retaining cap | Shield | Inner retaining cap | Nozzle | Swirl ring | Electrode |
|------|---------------|--------|---------------------|--------|------------|-----------|
| 30A | | 220194 | 220313 | 220193 | 220180 | 220192 |
| 50A | 220173 | 220555 | 220313 | 220554 | 220553 | 220552 |
| 80A | | 220189 | 220176 | 220188 | 220179 | 220187 |
| 100A | | 220183 | 220176 | 220510 | 220179 | 220181 |

Stainless steel

| | Retaining cap | Shield | Inner retaining cap | Nozzle | Swirl ring | Electrode |
|------|---------------|--------|---------------------|--------|------------|-----------|
| 45A | | 220202 | 220304 | 220201 | 220180 | 220308 |
| 70A | 220173 | 220189 | 220176 | 220188 | 220179 | 220187 |
| 80A | | 220338 | 220304 | 220337 | 220179 | 220339 |
| 100A | | 220627 | 220644 | 220626 | 220640 | 220641 |

Aluminum

| | Retaining cap | Shield | Inner retaining cap | Nozzle | Swirl ring | Electrode |
|------|---------------|--------|---------------------|--------|------------|-----------|
| 45A | | 220202 | 220176 | 220201 | 220180 | 220308 |
| 70A | 220173 | 220189 | 220176 | 220188 | 220179 | 220187 |
| 100A | | 220627 | 220644 | 220626 | 220640 | 220641 |

HyPerformance HD3070 consumables

| MATERIAL | CONSUMABLE DESCRIPTION | 100 AMPS | 80 AMPS | 70 AMPS | 50 AMPS | 45 AMPS | 30 AMPS |
|-----------------|------------------------|----------|---------|---------|---------|---------|---------|
| Mild steel | Electrode | 220181 | 220187 | ----- | 220552 | ----- | 220192 |
| | Swirl ring | 220179 | 220179 | ----- | 220553 | ----- | 220180 |
| | Nozzle | 220510 | 220188 | ----- | 220554 | ----- | 220193 |
| | Inner retaining cap | 220176 | 220176 | ----- | 220313 | ----- | 220313 |
| | Shield | 220183 | 220189 | ----- | 220555 | ----- | 220194 |
| | Shield cap | 220173 | 220173 | ----- | 220173 | ----- | ----- |
| Stainless steel | Electrode | 220641 | 220339 | 220187 | ----- | 220308 | ----- |
| | Swirl ring | 220640 | 220179 | 220179 | ----- | 220180 | ----- |
| | Nozzle | 220626 | 220337 | 220188 | ----- | 220201 | ----- |
| | Inner retaining cap | 220644 | 220304 | 220176 | ----- | 220304 | ----- |
| | Shield | 220627 | 220338 | 220189 | ----- | 220202 | ----- |
| | Shield cap | 220173 | 220173 | 220173 | ----- | 220173 | ----- |
| Aluminum | Electrode | 220641 | ----- | 220187 | ----- | 220308 | ----- |
| | Swirl ring | 220640 | ----- | 220179 | ----- | 220180 | ----- |
| | Nozzle | 220626 | ----- | 220188 | ----- | 220201 | ----- |
| | Inner retaining cap | 220644 | ----- | 220176 | ----- | 220176 | ----- |
| | Shield | 220627 | ----- | 220189 | ----- | 220202 | ----- |
| | Shield cap | 220173 | ----- | 220173 | ----- | 220173 | ----- |

HyPerformance HD3070 Plasma torch assembly

| PART NO. | DESCRIPTION |
|----------|-------------------------------------------------------|
| 220162 | Quick-disconnect torch |
| 220340 | Water tube with o-ring |
| 220163 | Quick-disconnect receptacle |
| 220624 | Torch mounting sleeve |
| 128879 | Torch kit: bullet plugs, o-rings, water tube and seal |
| 128880 | Quick-disconnect kit: o-ring and connector |

| RETROFIT KIT: | |
|---------------|-------------------------|
| PART NO. | DESCRIPTION |
| 228132 | Kit: HPR/HD3070 upgrade |

Hypertherm®

HySpeed® HT4400®

Machine torch parts

HT4400 consumables



HySpeed HT4400
with accessories



HT4400 torch

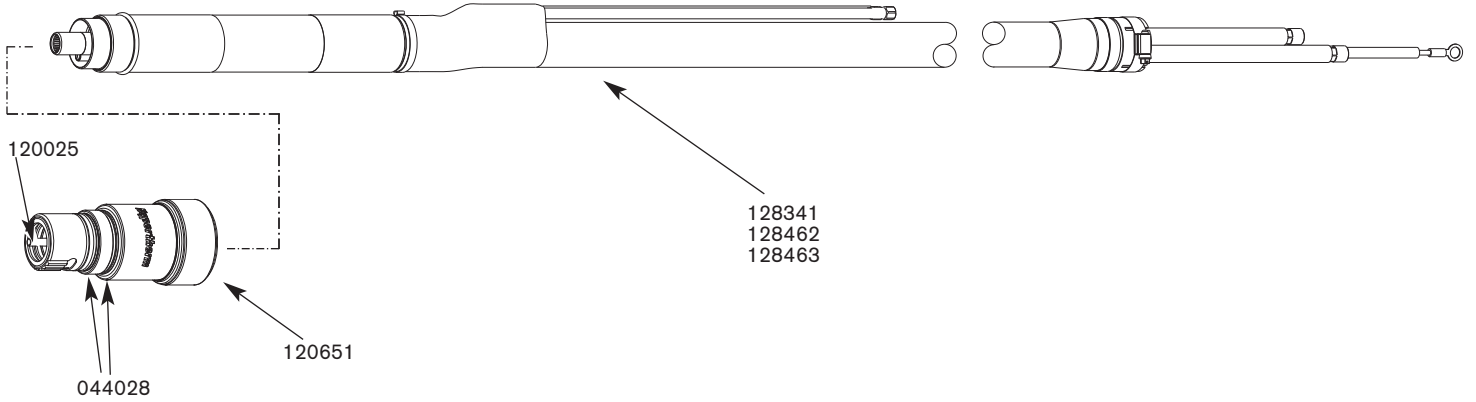
| | Retaining cap | Nozzle | Swirl ring | Electrode | |
|------------------------|--------------------------------------------------------|------------------------|------------------------|------------------------------------------|--|
| Oxygen plasma | | | | | |
| 400A | 120786 120907 (with IHS tab) 120984 (underwater) | 120934 120935 (CCW) | 120939 120940 (CCW) | 120810 – Standard 220412 – SilverPlus | |
| 300A | 120786 120907 (with IHS tab) 120984 (underwater) | 120794 120795 (CCW) | 120913 120914 (CCW) | 120802 – Standard 220412 – SilverPlus | |
| 200A | 120786 120907 (with IHS tab) 120984 (underwater) | 120787 120788 (CCW) | 120791 120792 (CCW) | 120793 | |
| 100A | 120786 120907 (with IHS tab) 120984 (underwater) | 120777 120778 (CCW) | 120783 120784 (CCW) | 120785 | |
| Nitrogen plasma | | | | | |
| 400A | 120786 120907 (with IHS tab) 120984 (underwater) | 120856 120857 (CCW) | 120853 120854 (CCW) | 120855 | |
| 200A | 120786 120907 (with IHS tab) 120984 (underwater) | 120794 120795 (CCW) | 120853 120854 (CCW) | 120855 | |

| APPLICATION | PLASMA GAS | CONSUMABLE DESCRIPTION | 400 AMPS BEVEL | 400 AMPS | 300 AMPS | 200 AMPS | 100 AMPS |
|-----------------------------------------------------------------------|------------|------------------------------|----------------|----------|----------|----------|----------|
| CUTTING | Oxygen | Electrode – Standard | 120810* | 120810* | 120802* | 120793** | 120785** |
| | | Electrode – SilverPlus | 220412 | 220412 | 220412 | ----- | ----- |
| | | Swirl ring | 120939 | 120939 | 120913 | 120791 | 120783 |
| | | Nozzle | 120934 | 120934 | 120794 | 120787 | 120777 |
| | | Retaining cap | 120786 | 120786 | 120786 | 120786 | 120786 |
| | | Retaining cap (with IHS tab) | 120907 | 120907 | 120907 | 120907 | 120907 |
| | | Retaining cap (underwater) | 120984 | 120984 | 120984 | 120984 | 120984 |
| | Nitrogen | Electrode | ----- | 120855 | ----- | 120855 | ----- |
| | | Swirl ring | ----- | 120853 | ----- | 120853 | ----- |
| | | Nozzle | ----- | 120856 | ----- | 120794 | ----- |
| | | Retaining cap | ----- | 120786 | ----- | 120786 | ----- |
| | | Retaining cap (underwater) | ----- | 120984 | ----- | 120984 | ----- |
| Cutting with counterclockwise gas swirl (substitute designated parts) | Oxygen | Swirl ring | 120940 | 120940 | 120914 | 120792 | 120784 |
| | | Nozzle | 120935 | 120935 | 120795 | 120788 | 120778 |
| | Nitrogen | Swirl ring | ----- | 120854 | ----- | 120854 | ----- |
| | | Nozzle | ----- | 120857 | ----- | 120795 | ----- |

* CoolCore™ technology

** HyLife® technology

HT4400 torch assembly



| PART NO. | DESCRIPTION |
|----------|--------------------------------------|
| 120651 | HT4400 torch main body |
| 128462 | HT4400 torch adapter with 6' leads |
| 128463 | HT4400 torch adapter with 10' leads |
| 128341 | HT4400 torch adapter with 15' leads |
| 128430 | HT4400 torch assembly with 6' leads |
| 128431 | HT4400 torch assembly with 10' leads |
| 128342 | HT4400 torch assembly with 15' leads |
| 120025 | Water cooling tube |
| 044028 | O-ring |

Hypertherm®

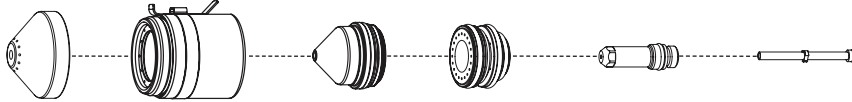
HyPro2000™ upgrade torch

For the HT2000



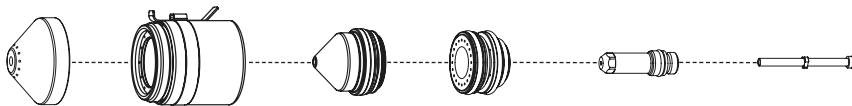
Consumables

Mild steel – O₂



| | Shield | Shield cap | Nozzle | Swirl ring | SilverPlus | Electrode | Water tube |
|--------------|--------|--------------------|--------|------------|------------|-----------|------------|
| 130 A | 220491 | 220936 | 220893 | 220488 | | 220487 | 220521 |
| | | 220935 without tab | | | | | |
| 200 A | 220832 | 220936 | 220831 | 220834 | 220925 | 220937 | 220521 |
| | | 220935 without tab | | | | | |

Mild steel/Stainless steel/Aluminum – Air



| | Shield | Shield cap | Nozzle | Swirl ring | Electrode | Water tube |
|--------------|--------|--------------------|--------|------------|-----------|------------|
| 130 A | 220536 | 220936 | 220892 | 220488 | 220487 | 220521 |
| | | 220935 without tab | | | | |
| 200 A | 220832 | 220936 | 220903 | 220488 | 220937 | 220521 |
| | | 220935 without tab | | | | |



TECHNOLOGIES

- Chambered Swirl Ring**
- Conical Flow™**
- CoolFlow™**
- LongLife®**
- SilverPlus®**
- TrueFlow™**
- Vented Shield**
- HyLife®**

HyPro2000™

Torch assembly options

Standard leads – RHF

| Lead length | Part number |
|--------------|-------------|
| 3 m (10') | 028657 |
| 4.6 m (15') | 028658 |
| 6.1 m (20') | 028659 |
| 7.6 m (25') | 028546 |
| 9.2 m (30') | 028660 |
| 10.6 m (35') | 028661 |
| 12.2 m (40') | 028662 |
| 13.7 m (45') | 028663 |
| 15.3 m (50') | 028547 |
| 16.8 m (55') | 028767 |
| 18.3 m (60') | 028768 |

Standard leads – LHF

| Lead length | Part number |
|--------------|-------------|
| 3 m (10') | 028657 |
| 4.6 m (15') | 028658 |
| 6.1 m (20') | 028659 |
| 7.6 m (25') | 028546 |
| 9.2 m (30') | 028660 |
| 10.6 m (35') | 028661 |
| 12.2 m (40') | 028662 |
| 13.7 m (45') | 028663 |

Mounting sleeves

| Description | Length | Diameter | Part number |
|-------------|----------------|------------------|-------------|
| Standard | 279.4 mm (11") | 50.8 mm (2") | 220943 |
| Standard | 279.4 mm (11") | 44.45 mm (1.75") | 220942 |

Quick-disconnect receptacle

220913

HyPro2000 Quick-disconnect torch

220921

Torch upgrade kits – HyPro2000 (Systems prior to 2003)

228549

Serial number 2000-06450 and below

Includes:

- 1 – Control board
- 1 – Machine torch (loaded with consumables)
- 1 – Quick-disconnect receptacle
- 2 – Mounting sleeves (2" and 1.75")
- 1 – 200 A O₂ Shield
- 1 – 200 A O₂ Shield cap
- 5 – 200 A O₂ Nozzles
- 1 – 200 A O₂ Swirl ring
- 3 – 200 A O₂ SilverPlus electrodes
- 2 – 200 A O₂ Copper electrodes
- 1 – Silicon lubricant for o-rings
- 1 – Consumable removal tool
- 1 – Chip removal tool
- 1 – Chip upgrade
- 1 – Pressure gage
- 1 – Plastic tube for hoses
- 1 – Hose (24")
- 1 – Operating manual

Torch upgrade kits – HyPro2000 (2003 – current systems)

228550

Serial number 2000-06451 and above

Includes:

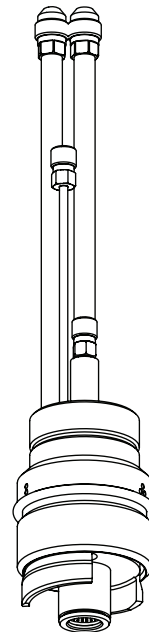
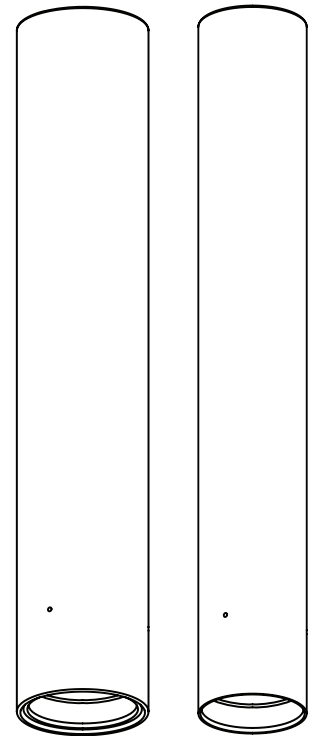
- 1 – Machine torch (loaded with consumables)
- 1 – Quick-disconnect receptacle
- 2 – Mounting sleeves (2" and 1.75")
- 1 – 200 A O₂ Shield
- 1 – 200 A O₂ Shield cap
- 5 – 200 A O₂ Nozzles
- 1 – 200 A O₂ Swirl ring
- 3 – 200 A O₂ SilverPlus electrodes
- 2 – 200 A O₂ Copper electrodes
- 1 – Silicon lubricant for o-rings
- 1 – Consumable removal tool
- 1 – Chip removal tool
- 1 – Chip upgrade
- 1 – Pressure gage
- 1 – Plastic tube for hoses
- 1 – Hose (24")
- 1 – Operating manual

Additional parts available (not shown)

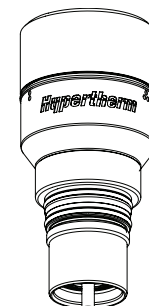
| | |
|------------------------------------------------------------------|--------|
| Machine torch (Quick-disconnect torch, set of 200 A consumables) | 228557 |
| Chip upgrade (includes two chips) | 228571 |
| Chip removal tool | 027338 |
| Consumables removal tool | 104119 |
| Silicon lubricant for o-rings | 027055 |

Mounting sleeve
(2" outside
diameter)

Mounting sleeve
(1.75" outside
diameter)



Quick disconnect

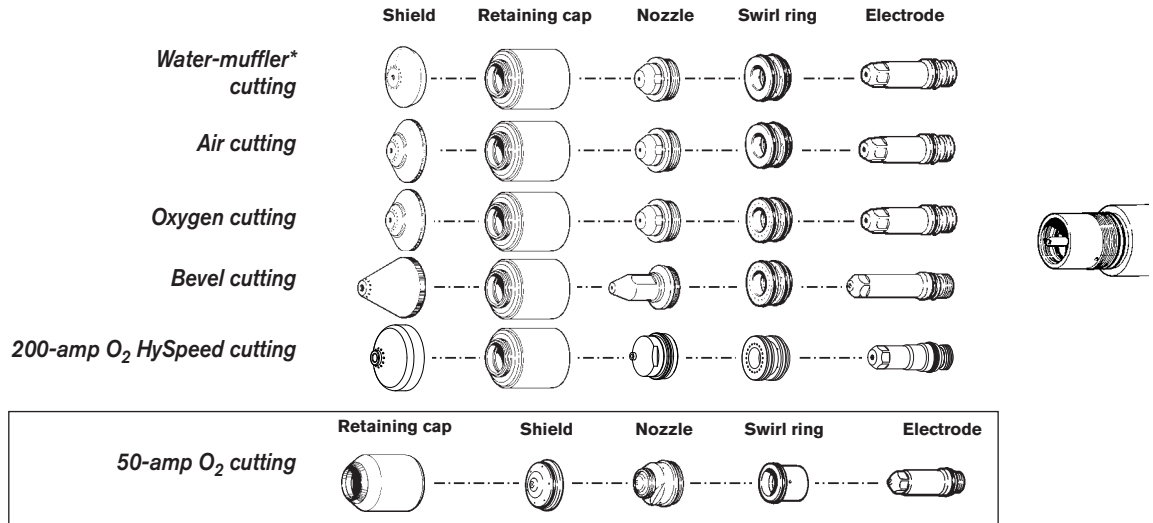


HyPro2000 torch

Hypertherm®

HySpeed® HT2000®

Consumables



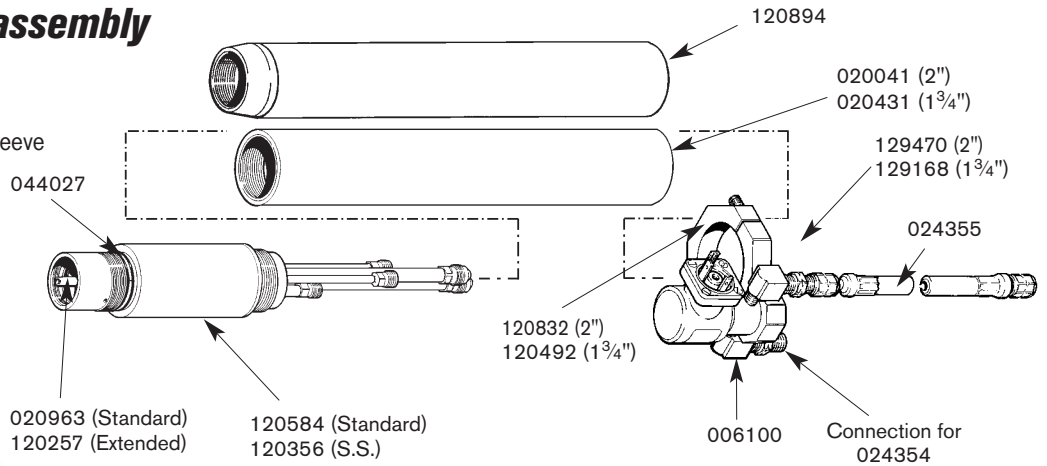
| APPLICATION | PLASMA GAS | CONSUMABLE DESCRIPTION | PART NUMBER | | | | | |
|-----------------------------------------------------------------------|-------------------|------------------------|-----------------|---------------|----------|----------|---------|---------|
| | | | 200 AMP HySpeed | 200 AMP BEVEL | 200 AMPS | 100 AMPS | 50 AMPS | 40 AMPS |
| CUTTING | Oxygen | Electrode | 220235 | 120258 | 120667 | 120547 | 120178 | ----- |
| | | Electrode SilverPlus | ----- | ----- | 220084 | ----- | ----- | ----- |
| | | Swirl ring | 220236 | 120833 | 120833 | 020613 | 120179 | ----- |
| | | Nozzle | 220237 | 120259 | 020605 | 020690 | 120182 | ----- |
| | | Retaining cap* | 220238 | 020423 | 020423 | 020423 | 120185 | ----- |
| | | Shield | 220239 | 120260 | 020424 | 020424 | 120186 | ----- |
| | (Water muffler**) | Shield | 220295 | ----- | 020566 | 020566 | ----- | ----- |
| | Air | Electrode | ----- | ----- | 120667 | 120547 | ----- | 120667 |
| | | Swirl ring | ----- | ----- | 020679 | 020607 | ----- | 020613 |
| | | Nozzle | ----- | ----- | 020608 | 020611 | ----- | 020689 |
| | | Retaining cap* | ----- | ----- | 020423 | 020423 | ----- | 020423 |
| | | Shield | ----- | ----- | 020424 | 020448 | ----- | 020688 |
| | | (Water muffler**) | Shield | ----- | ----- | 020566 | 020618 | ----- |
| | Argon/Hydrogen | Electrode | ----- | ----- | 020415 | 020415 | ----- | ----- |
| | | Swirl ring | ----- | ----- | 020607 | 020607 | ----- | ----- |
| | | Nozzle | ----- | ----- | 020608 | 020611 | ----- | ----- |
| | | Retaining cap* | ----- | ----- | 020423 | 020423 | ----- | ----- |
| | Nitrogen | Electrode | ----- | ----- | 020415 | ----- | ----- | ----- |
| | | Swirl ring | ----- | ----- | 020607 | ----- | ----- | ----- |
| | | Nozzle | ----- | ----- | 020608 | ----- | ----- | ----- |
| Retaining cap* | | ----- | ----- | 020423 | ----- | ----- | ----- | |
| Shield | | ----- | ----- | 020424 | ----- | ----- | ----- | |
| (Water muffler*) | | Shield | ----- | ----- | 020566 | ----- | ----- | ----- |
| Cutting with counterclockwise gas swirl (substitute designated parts) | Oxygen | Swirl ring | 220244 | 120834 | 120834 | 120252 | ----- | ----- |
| | | Retaining cap* | 220241 | 020955 | 020955 | 020955 | ----- | ----- |
| | Air | Swirl ring | ----- | ----- | ----- | 020956 | ----- | ----- |
| | | Retaining cap* | ----- | ----- | ----- | 020955 | ----- | ----- |
| Argon/Hydrogen | Swirl ring | ----- | ----- | 020956 | 020956 | ----- | ----- | |
| | Retaining cap* | ----- | ----- | 020955 | 020955 | ----- | ----- | |
| | Nitrogen | Swirl ring | ----- | ----- | 020956 | ----- | ----- | ----- |
| | | Retaining cap* | ----- | ----- | 020955 | ----- | ----- | ----- |
| GOUGING | Air | Electrode | ----- | ----- | 120667 | ----- | ----- | ----- |
| | | Swirl ring | ----- | ----- | 020607 | ----- | ----- | ----- |
| | | Nozzle | ----- | ----- | 020615 | ----- | ----- | ----- |
| | | Retaining cap | ----- | ----- | 020423 | ----- | ----- | ----- |
| | | Shield | ----- | ----- | 020485 | ----- | ----- | ----- |
| | Argon/Hydrogen | Electrode | ----- | ----- | 020415 | ----- | ----- | ----- |
| | | Swirl ring | ----- | ----- | 020607 | ----- | ----- | ----- |
| | | Nozzle | ----- | ----- | 020615 | ----- | ----- | ----- |
| | | Retaining cap | ----- | ----- | 020423 | ----- | ----- | ----- |
| | | Shield | ----- | ----- | 020485 | ----- | ----- | ----- |

* If using the Command THC or other ohmic sensing device, use retaining caps with an IHS tab: for standard cutting - 120837 clockwise; 120838 counter clockwise for all cutting currents except 50 A; 120185 for 50 A only. For HySpeed use 220242 clockwise; 220243 counter clockwise.

** Water muffler cannot be used with 2" 120356 stainless steel torch.

HySpeed HT2000 torch assembly

- 128381 Standard body – 2" sleeve;
- 128367 Stainless steel body – 2" sleeve
- 128141 Standard body, optional – 1 3/4" sleeve



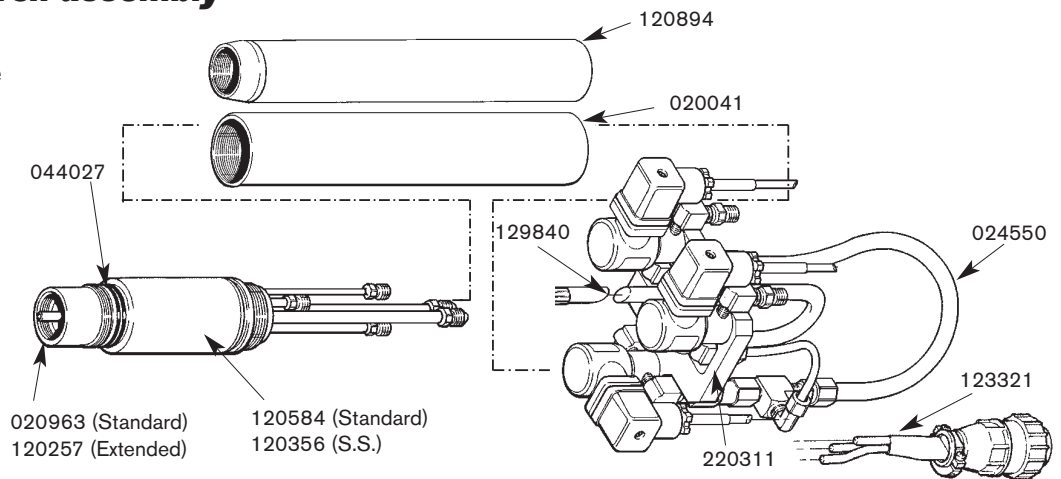
| STANDARD BODY PART NO. | DESCRIPTION | STAINLESS STEEL BODY PART NO. |
|------------------------|-----------------------------------------------------|-------------------------------|
| 128381 | HT2000 torch assembly with valve | 128367 |
| 120584 | MAX200/HT2000 machine torch main body | 120356 |
| 020963 | Water tube, electrode cooling, standard | 020963 |
| 120257 | Water tube, electrode cooling, extended | 120257 |
| 044027 | O-ring: Buna 70 Duro 1.301 x .070 | 044027 |
| 129470/129168* | HT2000 off-valve assembly | 129470 |
| 006100 | Solenoid valve, 120# 1/8" FPT | 006100 |
| 024355 | Hose, off-valve assembly to torch main body, 1' | 024355 |
| 120894/020431 | Torch mounting sleeve | 020041 |
| 020407 | Adapter: 1 3/4" – 2" torch mounting sleeve | Not needed |
| 120832/120492** | Valve mounting bracket | 120832 |
| 123185 | Torch off-valve cable (not shown) | 123185 |
| 024354 | Hose, motor-valve box to off-valve assembly, 10.25' | 024354 |

*129168 Off-valve assembly is required with the optional 020431 1 3/4" mounting sleeve.

** 120492 Valve mounting bracket is required with the 020431 mounting sleeve.

HySpeed HT2000LHF torch assembly

- 128255 Standard body – 2" sleeve
- 128369 Stainless steel body – 2" sleeve



| STANDARD BODY PART NO. | DESCRIPTION | STAINLESS STEEL BODY PART NO. |
|------------------------|---------------------------------------------|-------------------------------|
| 128255 | HT2000 torch assembly with valve | 128369 |
| 120584 | MAX200/HT2000 machine torch main body | 120356 |
| 120894 | Torch mounting sleeve: 2" | 020041 |
| 020963 | Water tube, electrode cooling, standard | 020963 |
| 120257 | Water tube, electrode cooling, extended | 120257 |
| 044027 | O-ring: Buna 70 Duro 1.301 x .070 | 044027 |
| 024550 | Hose, off-valve assembly to torch main body | 024550 |
| 123321 | Cable: HT2000LHF torch off-valve 24" | 123321 |
| 129290 | Off-valve sub assembly | 129840 |
| 220311 | Bracket: HT2000LHF off-valve | 220311 |

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Hypertherm®

MAX200

Machine torch parts

MAX200 consumables



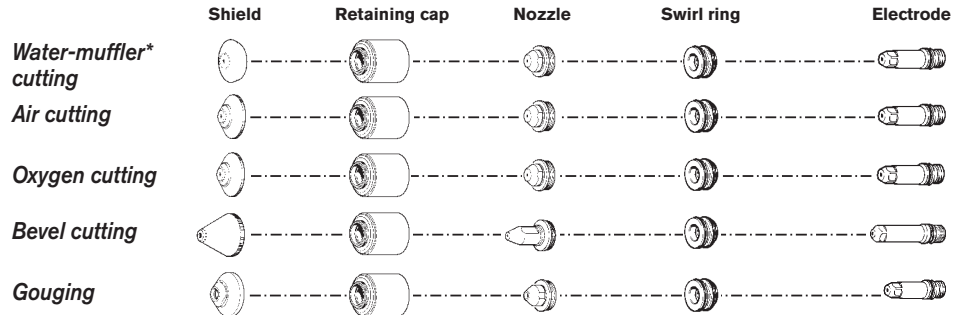
MAX200



128380 - Standard body - 2" sleeve



128365 - Stainless steel body

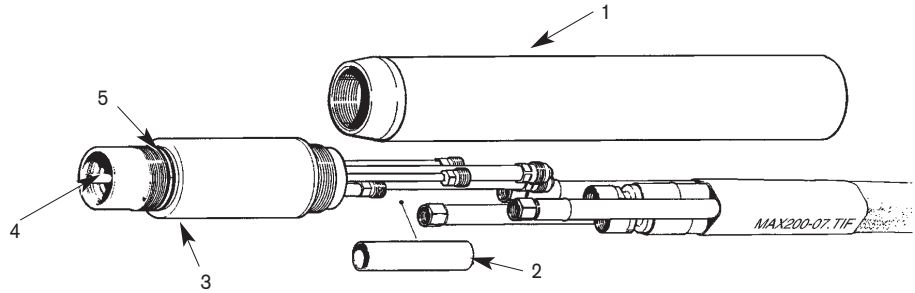


| APPLICATION | PLASMA GAS | CONSUMABLE DESCRIPTION | PART NUMBER | | | | QUANTITY PER PACKAGE | |
|-------------|----------------------|------------------------|---------------|----------|----------|---------|----------------------|---|
| | | | 200 AMP BEVEL | 200 AMPS | 100 AMPS | 40 AMPS | | |
| CUTTING | Oxygen | Electrode-Standard | 120258 | 220021 | 120547 | ----- | 5 | |
| | | Electrode-SilverPlus | ----- | 220083 | ----- | ----- | 5 | |
| | | Swirl ring | 120833 | 020604 | 020617 | ----- | 1 | |
| | | Nozzle | 120259 | 020605 | 020616 | ----- | 5 | |
| | | Retaining cap | 020423 | 020423 | 020423 | ----- | 1 | |
| | | Retaining cap, ohmic | 120837 | 120837 | 120837 | ----- | 1 | |
| | | Shield | 120260 | 020424 | 020448 | ----- | 1 | |
| | | (Water muffler*) | Shield | ----- | 020566 | 020618 | ----- | 1 |
| | | Air | Electrode | ----- | 220021 | 120547 | 120667 | 5 |
| | | | Swirl ring | ----- | 020607 | 020607 | 020613 | 1 |
| | Nozzle | | ----- | 020608 | 020611 | 020689 | 5 | |
| | Retaining cap | | ----- | 020423 | 020423 | 020423 | 1 | |
| | Retaining cap, ohmic | | ----- | 120837 | 120837 | 120837 | 1 | |
| | Shield | | ----- | 020424 | 020448 | 020688 | 1 | |
| | (Water muffler*) | | Shield | ----- | 020566 | 020618 | ----- | 1 |
| | Argon/Hydrogen | Electrode | ----- | 020415 | 020415 | ----- | 5 | |
| | | Swirl ring | ----- | 020607 | 020607 | ----- | 1 | |
| | | Nozzle | ----- | 020608 | 020611 | ----- | 5 | |
| | | Retaining cap | ----- | 020423 | 020423 | ----- | 1 | |
| | | Retaining cap, ohmic | ----- | 120837 | 120837 | ----- | 1 | |
| Shield | | ----- | 020602 | 020448 | ----- | 1 | | |
| Nitrogen | | Electrode | ----- | 020415 | ----- | ----- | 5 | |
| | Swirl ring | ----- | 020607 | ----- | ----- | 1 | | |
| | Nozzle | ----- | 020608 | ----- | ----- | 5 | | |
| | Retaining cap | ----- | 020423 | ----- | ----- | 1 | | |
| | Retaining cap, ohmic | ----- | 120837 | ----- | ----- | 1 | | |
| | Shield | ----- | 020424 | ----- | ----- | 1 | | |
| | (Water muffler*) | Shield | ----- | 020566 | ----- | ----- | 1 | |
| GOUGING | Air | Electrode | ----- | 220021 | ----- | ----- | 5 | |
| | | Swirl ring | ----- | 020607 | ----- | ----- | 1 | |
| | | Nozzle | ----- | 020615 | ----- | ----- | 5 | |
| | | Retaining cap | ----- | 020423 | ----- | ----- | 1 | |
| | | Shield | ----- | 020485 | ----- | ----- | 1 | |
| | Argon/Hydrogen | Electrode | ----- | 020415 | ----- | ----- | 5 | |
| | | Swirl ring | ----- | 020607 | ----- | ----- | 1 | |
| | | Nozzle | ----- | 020615 | ----- | ----- | 5 | |
| | | Retaining cap | ----- | 020423 | ----- | ----- | 1 | |
| | | Shield | ----- | 020485 | ----- | ----- | 1 | |

* Water muffler cannot be used with 2" 120356 stainless steel torch or with ohmic height sensing.

MAX200 machine torch assembly

128380 – Standard body – 2" sleeve
 128364 – Optional body – 1¾" sleeve



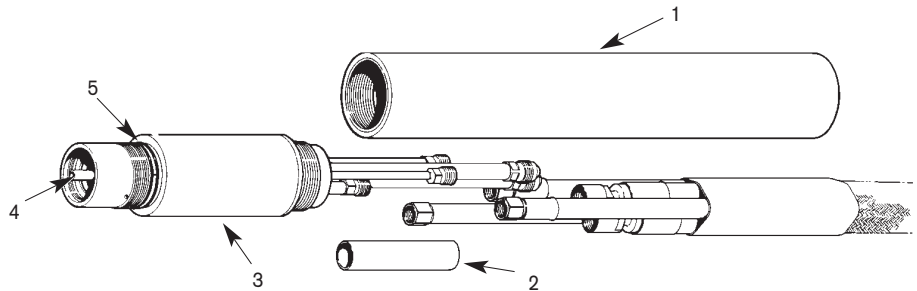
128380 – Standard body – 2" sleeve

| ITEM NUMBER | STANDARD BODY (2") PART NO. | DESCRIPTION | OPTIONAL BODY (1¾") PART NO. |
|-------------|-----------------------------|-----------------------------------------|------------------------------|
| | 128380* | MAX200 machine torch assembly | 128364 |
| | 028383** | Leads, torch, 25' / 7.6 m | 028383 |
| | 028384** | Leads, torch, 50' / 15.2 m | 028384 |
| 1 | 120894 | Torch mounting sleeve | 020431 |
| 2 | 020536 | Lead insulator, 9/16 x 2.5" | 020536 |
| 3 | 120584 | MAX200/HT2000 machine torch main body | 120584 |
| 4 | 020963 | Water tube, electrode cooling, standard | 020963 |
| 4 | 120257 | Water tube, electrode cooling, extended | 120257 |
| 5 | 044027 | O-ring: Buna 70 Duro 1.301 x .070 | 044027^ |

* Assembly includes consumables

** Other lead lengths available.
 Consult your Operating Manual.

128365 – Stainless steel body



128365 – Stainless steel body

| ITEM NUMBER | PART NO. | DESCRIPTION |
|-------------|----------|-----------------------------------------|
| | 128365* | MAX200 machine torch assembly |
| | 120356 | MAX200/HT2000 machine torch main body |
| | 028384** | Leads, torch, 50' / 15.2 m |
| 1 | 020041 | Torch mounting sleeve |
| 2 | 020536 | Lead insulator, 9/16 x 2.5" |
| 3 | 028383** | Leads, torch, 25' / 7.6 m |
| 4 | 020963 | Water tube, electrode cooling, standard |
| 4 | 120257 | Water tube, electrode cooling, extended |
| 5 | 044027 | O-ring: Buna 70 Duro 1.301 x .070 |

* Assembly includes consumables

** Other lead lengths available.
 Consult your Operating Manual.

Hypertherm®

HySpeed Plasma HSD130™

Consumables



HySpeed Plasma
HSD130



HySpeed Plasma
HSD130 torch

Mild steel

| | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|------------------------|--------|---------------|--------|------------|-----------|
| 45A (Air) | | | | | |
| | 220532 | 220578 | 220525 | 220529 | 220528 |
| 50A (O ₂) | | | | | |
| | 220532 | 220578 | 220530 | 220529 | 220528 |
| 130A (Air) | | | | | |
| | 220536 | 220578 | 220492 | 220488 | 220487 |
| 130A (O ₂) | | | | | |
| | 220491 | 220578 | 220489 | 220488 | 220487 |

Stainless steel

| | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|-----------------------------|--------|---------------|--------|------------|-----------|
| 45A (Air) | | | | | |
| | 220532 | 220578 | 220525 | 220529 | 220528 |
| 45A (N ₂ and F5) | | | | | |
| | 220532 | 220534 | 220525 | 220529 | 220528 |
| 130A (Air) | | | | | |
| | 220536 | 220578 | 220492 | 220488 | 220487 |
| 130A (N ₂) | | | | | |
| | 220536 | 220578 | 220535 | 220488 | 020415 |
| 130A (H35) | | | | | |
| | 220536 | 220534 | 220535 | 220529 | 020415 |

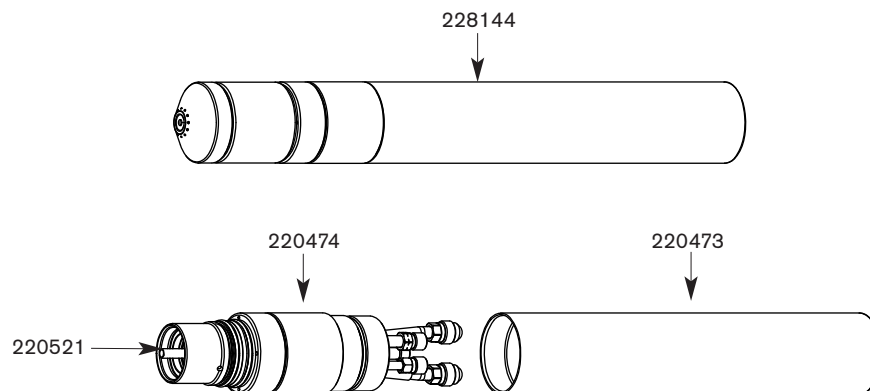
Aluminum

| | Shield | Retaining cap | Nozzle | Swirl ring | Electrode |
|------------|--------|---------------|--------|------------|-----------|
| 45A (Air) | | | | | |
| | 220532 | 220578 | 220525 | 220529 | 220528 |
| 130A (Air) | | | | | |
| | 220536 | 220578 | 220492 | 220488 | 220487 |
| 130A (H35) | | | | | |
| | 220536 | 220534 | 220535 | 220529 | 020415 |

HSD130 consumables

| MATERIAL | CONSUMABLE DESCRIPTION | 45 AMPS | 50 AMPS | 130 AMPS |
|-----------------|-------------------------------|----------------|-------------------------------|-------------------------------|
| Mild steel | Electrode | 220528 | 220528 | 220487 |
| | Swirl ring | 220529 | 220529 | 220488 |
| | Nozzle | 220525 | 220530 | 220489 (O ₂) |
| | ----- | ----- | ----- | 220492 (Air) |
| | Shield | 220532 | 220532 | 220491 (O ₂) |
| | ----- | ----- | ----- | 220536 (Air) |
| Stainless steel | Retaining cap | 220578 | 220578 | 220578 |
| | Electrode | 220528 | ----- | 220487 (Air) |
| | ----- | ----- | ----- | 020415 (N ₂ , H35) |
| | Swirl ring | 220529 | ----- | 220488 (Air) |
| | ----- | ----- | ----- | 220488 (N ₂) |
| | ----- | ----- | ----- | 220529 (H35) |
| Nozzle | 220525 | ----- | 220492 (Air) | |
| ----- | ----- | ----- | 220535 (N ₂ , H35) | |
| Shield | 220532 | ----- | 220536 (Air) | |
| ----- | ----- | ----- | 220536 (N ₂ , H35) | |
| Retaining cap | 220578 (Air) | ----- | 220578 (Air) | |
| ----- | 220534 (N ₂ , F5) | ----- | 220534 (H35) | |
| ----- | ----- | ----- | 220578 (N ₂) | |
| Aluminum | Electrode | 220528 | ----- | 220487 (Air) |
| | ----- | ----- | ----- | 020415 (H35) |
| | Swirl ring | 220529 | ----- | 220488 (Air) |
| | ----- | ----- | ----- | 220529 (H35) |
| | Nozzle | 220525 | ----- | 220492 (Air) |
| | ----- | ----- | ----- | 220535 (H35) |
| Shield | 220532 | ----- | 220536 (Air) | |
| ----- | ----- | ----- | 220536 (H35) | |
| Retaining cap | 220578 | ----- | 220578 (Air) | |
| ----- | ----- | ----- | 220534 (H35) | |

HSD130 torch assembly



| PART NO. | DESCRIPTION |
|-----------------|--------------------------------------------------|
| 228144 | Torch assembly (includes consumables and sleeve) |
| 220521 | Water tube |
| 220474 | Torch main body |
| 220473 | Torch mounting sleeve |

Hypertherm®

MAX70/100

70/100 consumables



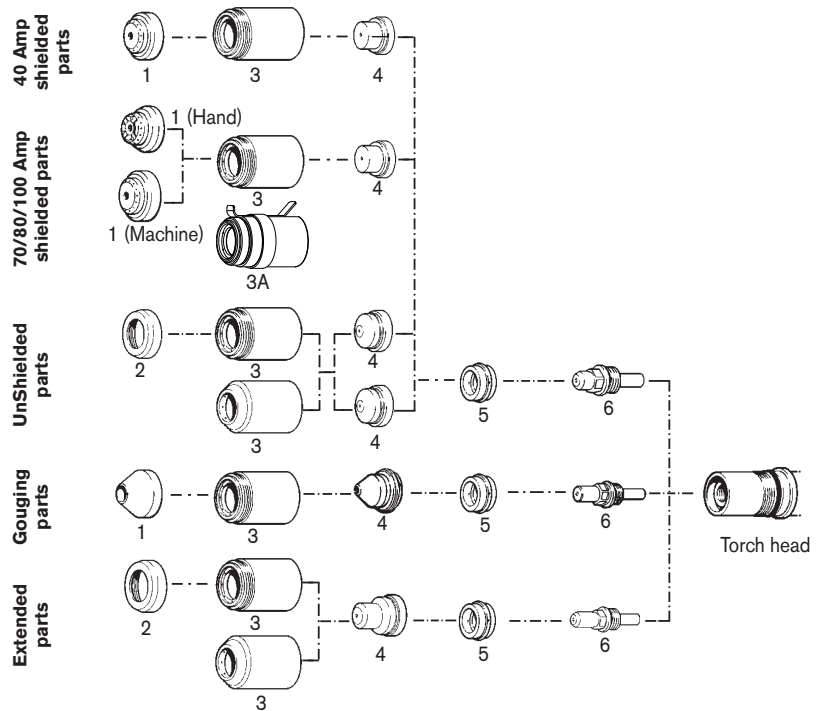
MAX70



MAX100



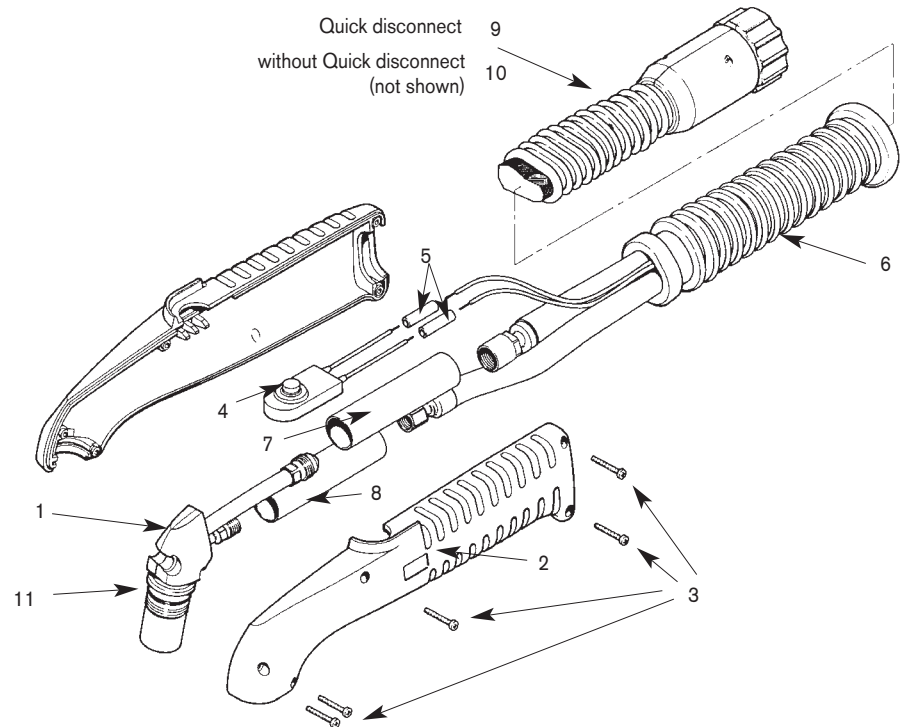
PAC130 torch



| | DESCRIPTION | PART NUMBER CURRENT RATING | | | | QUANTITY PER PACKAGE |
|---------------------------|------------------------------------|-------------------------------|---------|---------|---------|----------------------------|
| | | 100 AMPS | 80 AMPS | 70 AMPS | 40 AMPS | |
| Cutting parts shielded | 6 Electrode, air, HyLife | 120433 | 120433 | 120433 | 120433 | 5 |
| | 6 Electrode, nitrogen | 020193 | 020193 | 020193 | 020193 | 5 |
| | 5 Swirl ring | 020194 | 020194 | 020194 | 020194 | 1 |
| | 4 Nozzle | 020337 | 020397 | 020397 | 020396 | 5 |
| | 3 Retaining cap | 020336 | 020336 | 020336 | 020490 | 1 |
| | 3A Retaining cap, ohmic | 120966 | 120966 | 120966 | ----- | 1 |
| | 1 Shield, hand | 020335 | 020335 | 020335 | ----- | 1 |
| | 1 Shield, machine | 020334 | 020334 | 020334 | 020492 | 1 |
| Unshielded parts | 6 Electrode, air, HyLife | 120433 | 120433 | 120433 | 120433 | 5 |
| | 6 Electrode, nitrogen | 020193 | 020193 | 020193 | 020193 | 5 |
| | 5 Swirl ring | 020194 | 020194 | 020194 | 020194 | 1 |
| | 4 Nozzle | 020195 | 020345 | 020345 | 020203 | 5 |
| | 3 Retaining cap* | 020184 | 020184 | 020184 | 020184 | 1 |
| | 1 Shield cap* | 020336 | 020336 | 020336 | 020336 | 1 |
| | 2 Deflector* | 020333 | 020333 | 020333 | 020333 | 1 |
| Gouging parts | 6 Electrode | 020744 | ----- | 020744 | ----- | 5 |
| | 5 Swirl ring | 020194 | ----- | 020194 | ----- | 1 |
| | 4 Nozzle | 120459 | ----- | 020878 | ----- | 5 |
| | 3 Retaining cap | 020336 | ----- | 020336 | ----- | 1 |
| | 1 Shield | 020712 | ----- | 020712 | ----- | 1 |
| Cutting parts extended | 6 Electrode, air, HyLife, extended | ----- | 120444 | 120444 | ----- | 5 |
| | 6 Electrode, nitrogen, extended | ----- | 020886 | 020886 | ----- | 5 |
| | 5 Swirl ring | ----- | 020194 | 020194 | ----- | 1 |
| | 4 Nozzle | ----- | 020563 | 020563 | ----- | 5 |
| | 3 Retaining cap* | ----- | 020184 | 020184 | ----- | 1 |
| | 1 Shield cap* | ----- | 020336 | 020336 | ----- | 1 |
| | 2 Deflector* | ----- | 020333 | 020333 | ----- | 1 |

* Non-shielded cutting may use a retaining cap or a combination shield cap/deflector.

MAX70/100 PAC130 hand torch assembly



PAC130 torch

| ITEM NUMBER | PART NUMBER | DESCRIPTION |
|---------------------------------------------|-------------|---------------------------------------------|
| Torch leads with quick disconnect | | |
| | 059093* | Torch assembly, 25' / 7.6 m, with QD |
| | 059094* | Torch assembly, 50' / 15.2 m, with QD |
| | 059095* | Torch assembly, 75' / 22.9 m, with QD |
| Torch leads without quick disconnect | | |
| 10 | 029198 | Leads, hand torch, 25' / 7.6 m, without QD |
| 10 | 029199 | Leads, hand torch, 50' / 15.2 m, without QD |
| 10 | 029229 | Leads, hand torch, 75' / 22.9 m, without QD |
| 1 | 020461 | Torch main body, PAC130 |
| 2 | 001214 | Handle, PAC130 (both halves included) |
| 3 | 075365 | Screw, #6 x 3/4" (five required) |
| 4 | 005094 | Switch, pushbutton, torch |
| 5 | 074069 | Splice, butt, insulated (two required) |
| 6 | 001217 | Boot, PAC130 |
| 7 | 024249 | Negative lead insulator, 1 1/16 x 3 1/2" |
| 8 | 020536 | Pilot arc lead insulator, 9/16 x 2 1/2" |
| 9 | 029667 | Leads, hand torch, 25' / 7.6 m, with QD |
| 9 | 029668 | Leads, hand torch, 50' / 15.2 m, with QD |
| 9 | 029669 | Leads, hand torch, 75' / 22.9 m, with QD |
| 11 | 026018 | O-ring, Silico |

* Assembly includes consumables

Hypertherm®

MAX100D

Machine torch parts

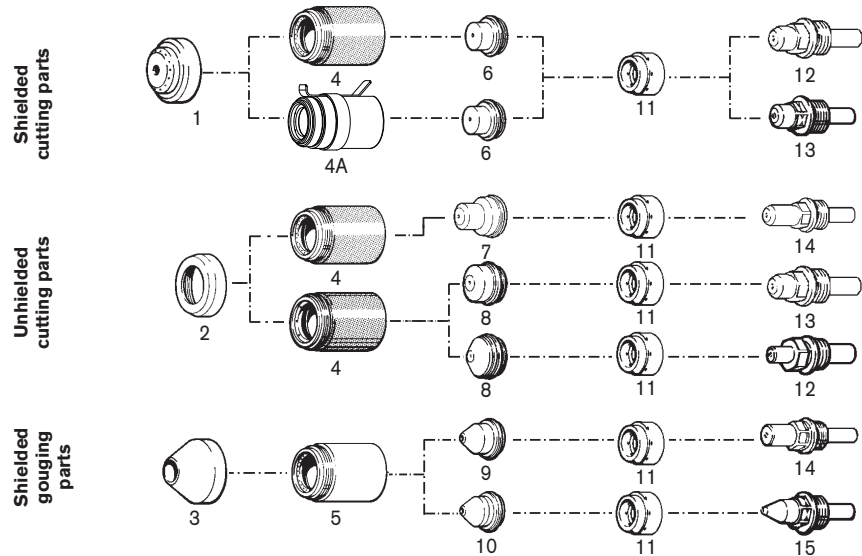
PAC160 consumables



MAX100D

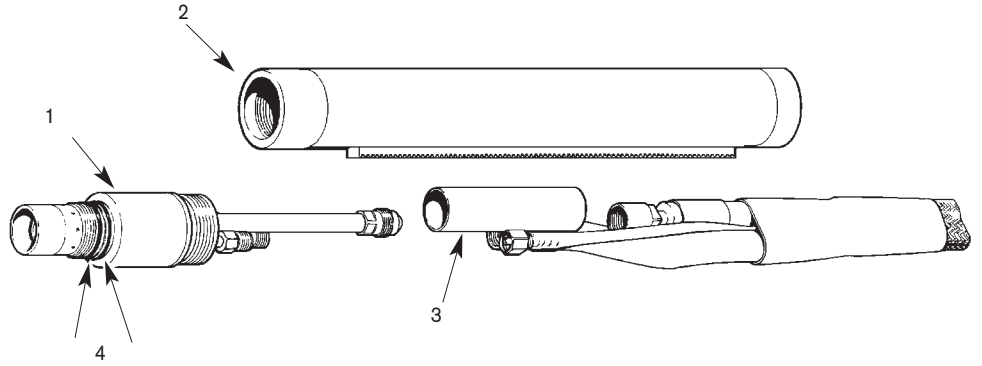


MAX100D machine torch



| | DESCRIPTION | PART NUMBER CURRENT RATING | | | QUANTITY PER PACKAGE |
|-----------------------------------------|-------------------------------|-------------------------------|---------|------------|----------------------------|
| | | 100 AMPS | 60 AMPS | 30/40 AMPS | |
| Shielded cutting parts | 12 Electrode, air, | 120433 | 120433 | ----- | 5 |
| | 13 Electrode, N ₂ | 020193 | 020193 | ----- | 5 |
| | 11 Swirl ring | 020706 | 020706 | ----- | 1 |
| | 6 Nozzle | 020705 | 120336 | ----- | 5 |
| | 4 Retaining cap | 020846 | 020756 | ----- | 1 |
| | 4A Retaining cap, ohmic | 120969 | ----- | ----- | 1 |
| | 1 Shield | 020334 | 020492 | ----- | 1 |
| Unshielded cutting parts | 12 Electrode, air | ----- | 120433 | 020951 | 5 |
| | 13 Electrode, N ₂ | ----- | 020193 | ----- | 5 |
| | 11 Swirl ring | ----- | 020706 | 020950 | 1 |
| | 8 Nozzle | ----- | 020922 | 020921 | 5 |
| | 4 Retaining cap | ----- | 020756 | 020756 | 1 |
| | 2 Deflector | ----- | 020333 | 020333 | 1 |
| | 14 Electrode, air, extended | 120444** | ----- | ----- | 1 |
| 14 Electrode, N ₂ , extended | 020887 | ----- | ----- | 1 | |
| 11 Swirl ring | 020706 | ----- | ----- | 1 | |
| 7 Nozzle, extended | 020754 | ----- | ----- | 1 | |
| 4 Retaining cap | 020846 | ----- | ----- | 1 | |
| 2 Deflector | 020333 | ----- | ----- | 1 | |
| Shielded gouging parts | 14 Electrode, air, extended | 020744 | ----- | ----- | 5 |
| | 15 Electrode, H ₃₅ | 020703 | ----- | ----- | 5 |
| | 11 Swirl ring | 020750 | ----- | ----- | 1 |
| | 9 Nozzle, air | 020745 | ----- | ----- | 5 |
| | 10 Nozzle, H ₃₅ | 020704 | ----- | ----- | 5 |
| | 5 Retaining cap | 020699 | ----- | ----- | 1 |
| | 3 Shield | 020712 | ----- | ----- | 1 |

MAX100D PAC160/E machine torch assembly



MAX100D machine torch

| ITEM NUMBER | PART NUMBER | DESCRIPTION |
|-------------|-------------|----------------------------------------------------|
| | 028596* | MAX100D machine torch assembly |
| 1 | 020713 | MAX100D machine torch main body |
| 2 | 020243 | MAX100D torch positioning sleeve |
| 3 | 020468 | Negative lead insulator, 1 1/16 x 3 1/2" |
| 4 | 058019 | O-ring: Viton .801 x .071 (two required) |
| | 059115* | MAX100D machine torch assembly, 25' / 7.6 m leads |
| | 059116* | MAX100D machine torch assembly, 50' / 15.2 m leads |
| | 059117* | MAX100D machine torch assembly, 75' / 22.9 m leads |
| | 028555 | MAX100D machine torch leads, 25' / 7.6 m |
| | 028556 | MAX100D machine torch leads, 50' / 15.2 m |
| | 028557 | MAX100D machine torch leads, 75' / 22.9 m |
| | 028910 | MAX100D quick disconnect assembly |
| | 002190 | Boot, 80/100 amp quick disconnect |

* Assembly includes consumables

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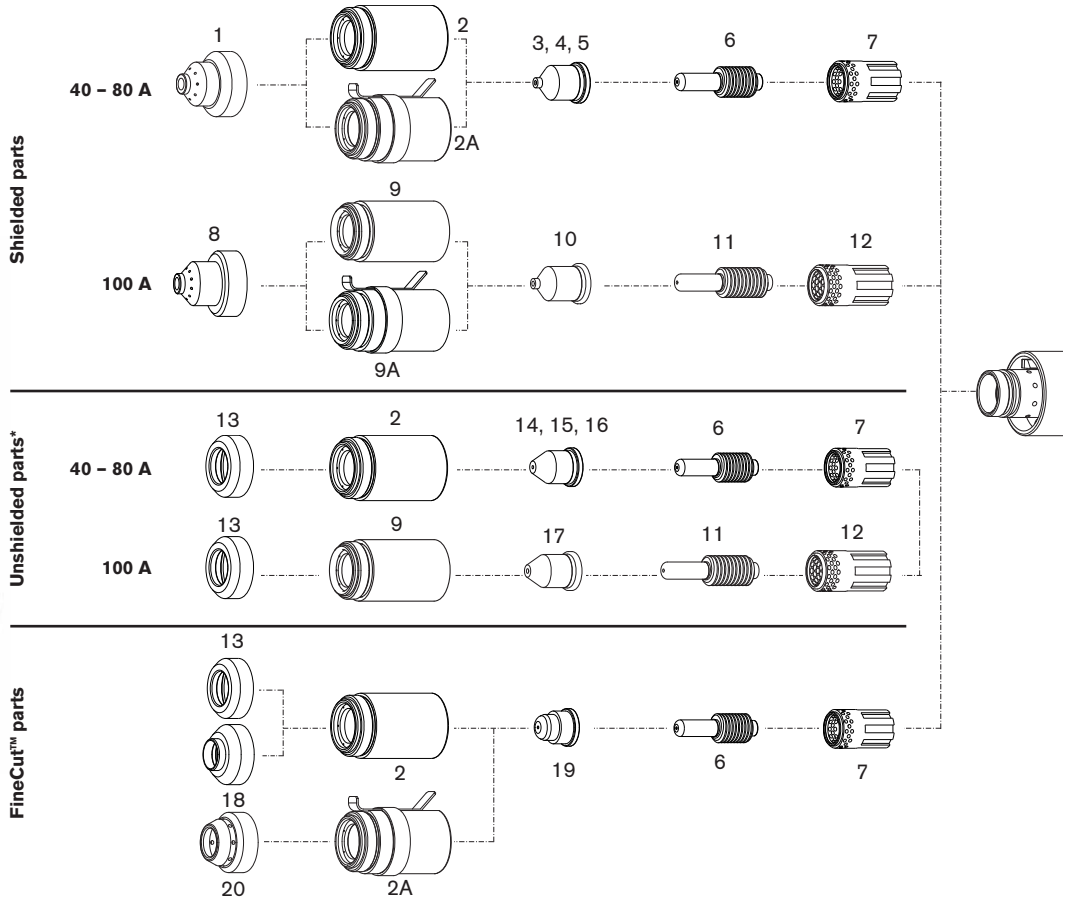
powermax1650® G3 SERIES™

Machine torch parts

T100 consumables



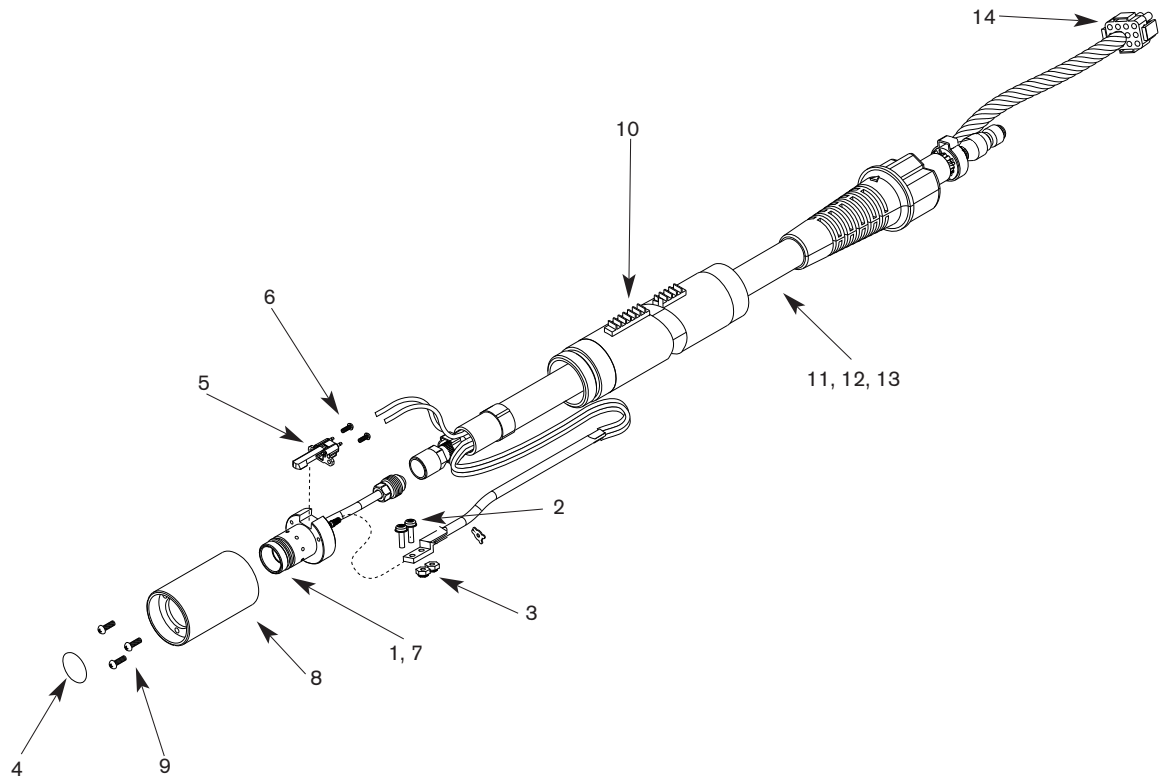
Powermax1650



T100M-2 torch

| | DESCRIPTION | 100 AMP | | 80 AMP | | 60 AMP | | 40 AMP | | QUANTITY PER PACKAGE |
|-------------------|----------------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|----------------------|
| | | ITEM NUMBER | PART NUMBER | ITEM NUMBER | PART NUMBER | ITEM NUMBER | PART NUMBER | ITEM NUMBER | PART NUMBER | |
| Shielded parts | Shield | 8 | 220047 | 1 | 120930 | 1 | 120930 | 1 | 120930 | 1 |
| | Retaining cap | 9 | 220048 | 2 | 120928 | 2 | 120928 | 2 | 120928 | 1 |
| | Retaining cap, ohmic | 9A | 220206 | 2A | 220061 | 2A | 220061 | 2A | 220061 | 1 |
| | Nozzle | 10 | 220011 | 5 | 120927 | 4 | 120931 | 3 | 120932 | 5 |
| | Electrode | 11 | 220037 | 6 | 120926 | 6 | 120926 | 6 | 120926 | 5 |
| | Swirl ring | 12 | 220051 | 7 | 120925 | 7 | 120925 | 7 | 120925 | 1 |
| Unshielded parts* | Deflector | 13 | 120979 | 13 | 120979 | 13 | 120979 | 13 | 120979 | 1 |
| | Retaining cap | 9 | 220048 | 2 | 120928 | 2 | 120928 | 2 | 120928 | 1 |
| | Nozzle | 17 | 220064 | 16 | 120980 | 15 | 220007 | 14 | 220006 | 5 |
| | Electrode | 11 | 220037 | 6 | 120926 | 6 | 120926 | 6 | 120926 | 5 |
| | Swirl ring | 12 | 220051 | 7 | 120925 | 7 | 120925 | 7 | 120925 | 1 |
| FineCut™ parts | Deflector | — | — | — | — | — | — | 13 | 120979 | 1 |
| | Deflector, CE | — | — | — | — | — | — | 18 | 220325 | 1 |
| | Shield, ohmic | — | — | — | — | — | — | 20 | 220404 | 1 |
| | Retaining cap | — | — | — | — | — | — | 2 | 120928 | 1 |
| | Retaining cap, ohmic | — | — | — | — | — | — | 2A | 220061 | 1 |
| | Nozzle | — | — | — | — | — | — | 19 | 220329 | 5 |
| | Electrode | — | — | — | — | — | — | 6 | 120926 | 5 |
| Swirl ring | — | — | — | — | — | — | 7 | 120925 | 1 | |

Powermax 1650 T100M-2 machine torch assembly



T100M-2 torch

| ITEM NUMBER | PART NUMBER | DESCRIPTION | QUANTITY |
|-------------|-------------|---------------------------------------------------------|----------|
| | 059315* | T100M-2 machine torch assembly with 25 ft (7.6 m) lead | |
| | 059324* | T100M-2 machine torch assembly with 35 ft (10.7 m) lead | |
| | 059325* | T100M-2 machine torch assembly with 50 ft (15.2 m) lead | |
| | 059326* | T100M-2 machine torch assembly with 75 ft (22.9 m) lead | |
| 1 | 228523 | T100M-2 torch main body replacement kit | 1 |
| 2 | 075473 | Machine screws | 2 |
| 3 | 075503 | Lock nuts | 2 |
| 4 | 058519 | O-ring | 1 |
| 5 | 128639 | Cap-off sensor replacement kit | 1 |
| 6 | 075571 | Cap-off sensor screws | 2 |
| 7 | 228522 | T100M-2 torch head repair kit | 1 |
| 8 | 128643 | Torch mounting sleeve replacement kit | 1 |
| 9 | 075004 | Torch mounting screws | 3 |
| 17 | 128710 | Torch positioning sleeve | 1 |
| 11 | 228222 | 25 ft (7.6 m) torch lead replacement kit | 1 |
| 12 | 228223 | 35 ft (10.7 m) torch lead replacement kit | 1 |
| 13 | 228224 | 50 ft (15.2 m) torch lead replacement kit | 1 |
| | 228225 | 75 ft (22.9 m) torch lead replacement kit | 1 |
| 14 | 128638 | ETR repair kit (Regional Repair Centers only) | 1 |
| | 128645 | Torch mounting kit (for reassembly after installation) | 1 |

* Assembly includes consumables

Hypertherm®

powermax1250® G3 SERIES™

Machine torch parts

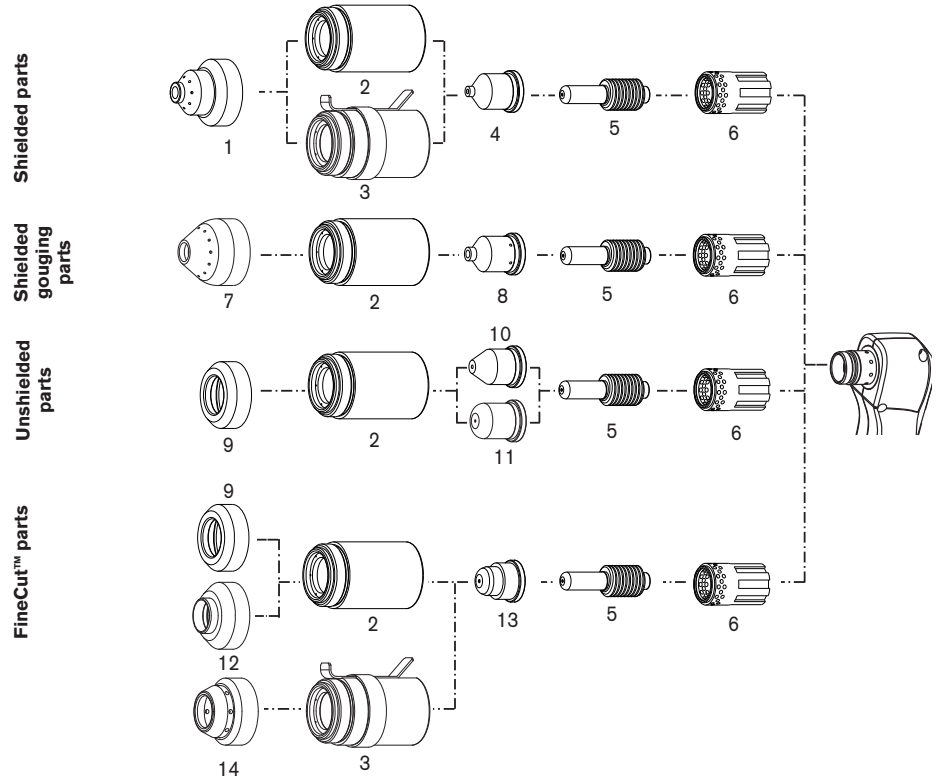
T80 consumables



Powermax1250

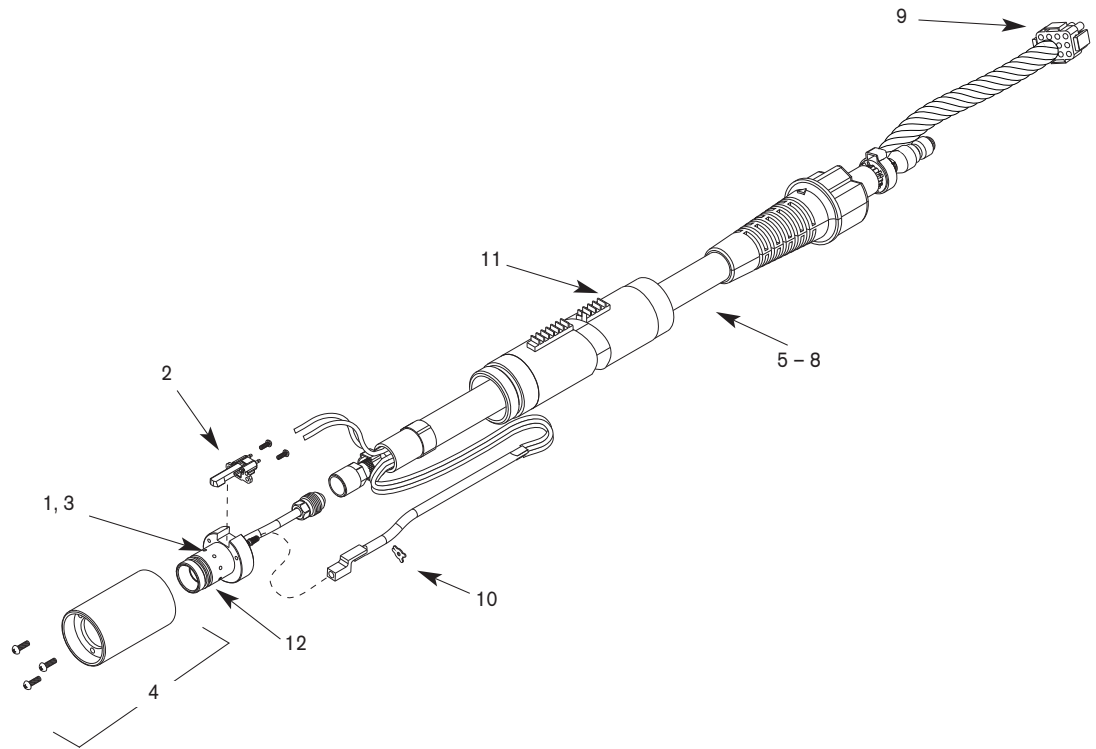


T80M torch



| | ITEM NUMBER | PART NUMBER | DESCRIPTION | QUANTITY PER PACKAGE |
|------------------------|-------------|-------------|--------------------------|----------------------|
| Shielded parts | 1 | 120930 | Shield | 1 |
| | 2 | 120928 | Retaining cap | 1 |
| | 3 | 220061 | Retaining cap, ohmic | 1 |
| | 4 | 120927 | Nozzle, 80 amp | 5 |
| | 4 | 120931 | Nozzle, 60 amp | 5 |
| | 4 | 120932 | Nozzle, 40 amp | 5 |
| Shielded gouging parts | 5 | 120926 | Electrode | 5 |
| | 6 | 120925 | Swirl ring | 1 |
| | 7 | 120977 | Shield, gouging | 1 |
| | 2 | 120928 | Retaining cap | 1 |
| Unshielded parts | 8 | 220059 | Nozzle, gouging | 5 |
| | 5 | 120926 | Electrode | 5 |
| | 6 | 120925 | Swirl ring | 1 |
| | 9 | 120979 | Deflector | 1 |
| | 2 | 120928 | Retaining cap | 1 |
| | 10 | 120980 | Nozzle, extended, 80 amp | 5 |
| FineCut™ parts | 10 | 220007 | Nozzle, extended, 60 amp | 5 |
| | 11 | 220006 | Nozzle, extended, 40 amp | 5 |
| | 5 | 120926 | Electrode | 5 |
| | 6 | 120925 | Swirl ring | 1 |
| | 9 | 120979 | Deflector | 1 |
| | 12 | 220325 | Deflector, CE | 1 |
| FineCut™ parts | 14 | 220404 | Shield, ohmic | 1 |
| | 2 | 120928 | Retaining cap | 1 |
| | 3 | 220061 | Retaining ring, ohmic | 1 |
| | 13 | 220329 | Nozzle | 5 |
| | 5 | 120926 | Electrode | 5 |
| | 6 | 120925 | Swirl ring | 1 |

Powermax1250 T80M torch assembly



T80M torch

| ITEM NUMBER | PART NUMBER | DESCRIPTION |
|-------------|-------------|----------------------------------------------------------|
| | 087003* | T80M machine torch assembly, 15' / 4.6 m |
| | 087004* | T80M machine torch assembly, 25' / 7.6 m |
| | 087005* | T80M machine torch assembly, 35' / 10.7 m |
| | 087006* | T80M machine torch assembly, 50' / 15.2 m |
| | 128645 | Kit: torch mounting |
| 1 | 128640 | Kit: T80M torch main body replacement |
| 2 | 128639 | Kit: cap sensor switch replacement |
| 3 | 128521 | Kit: T60/T80/T60M/T80M torch head repair |
| 4 | 128643 | Kit: T60M/T80M mounting sleeve replacement |
| 5 | 128634 | Kit: T80M lead replacement, 15' / 4.6 m |
| 6 | 128633 | Kit: T80M lead replacement, 25' / 7.6 m |
| 7 | 128635 | Kit: T80M lead replacement, 35' / 10.7 m |
| 8 | 128641 | Kit: T80M lead replacement, 50' / 15.2 m |
| 9 | 128638 | Kit: ETR connector repair (regional repair centers only) |
| 10 | 027889 | Retaining clip |
| 11 | 128710 | T60M/T80M positioning sleeve replacement (with rack) |
| 11 | 220070 | T60M/T80M positioning sleeve replacement (without rack) |
| 12 | 058519 | Torch o-ring |

* Assembly includes consumables

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powermax1000® G3 SERIES™

Machine torch parts

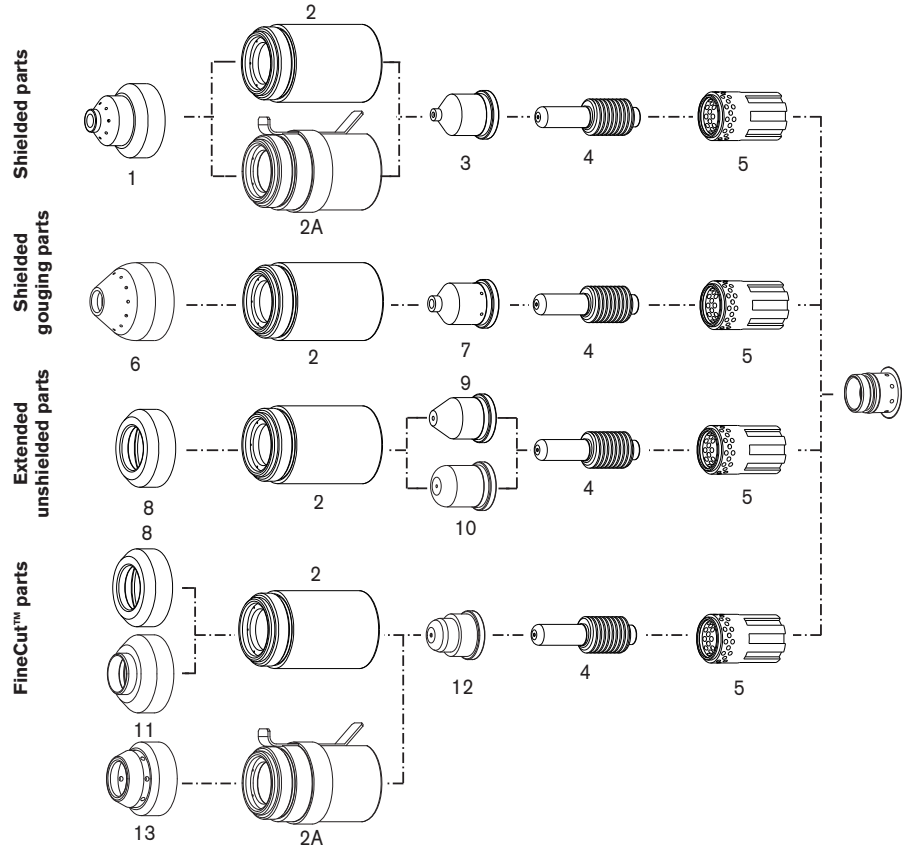
T60M consumables



Powermax1000

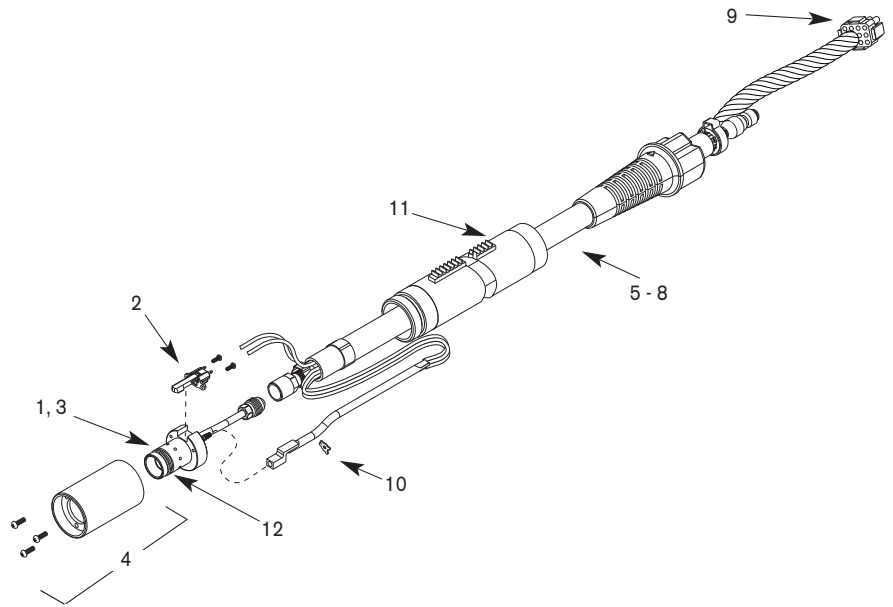


T60M torch



| | ITEM NUMBER | PART NUMBER | DESCRIPTION | QUANTITY PER PACKAGE |
|---------------------------|-------------|-------------|--------------------------|----------------------|
| Shielded parts | 1 | 120930 | Shield | 1 |
| | 2 | 120928 | Retaining cap | 1 |
| | 2A | 220061 | Retaining cap, ohmic | 1 |
| | 3 | 120931 | Nozzle, 60 amp | 5 |
| | 3 | 120932 | Nozzle, 40 amp | 5 |
| | 4 | 120926 | Electrode | 5 |
| Shielded gouging parts | 5 | 120925 | Swirl ring | 1 |
| | 6 | 120977 | Shield, gouging | 1 |
| | 2 | 120928 | Retaining cap | 1 |
| | 7 | 220059 | Nozzle, gouging | 5 |
| | 4 | 120926 | Electrode | 5 |
| Extended unshielded parts | 5 | 120925 | Swirl ring | 1 |
| | 8 | 120979 | Deflector | 1 |
| | 2 | 120928 | Retaining cap | 1 |
| | 9 | 220007 | Nozzle, extended, 60 amp | 5 |
| | 10 | 220006 | Nozzle, extended, 40 amp | 5 |
| FineCut™ parts | 4 | 120926 | Electrode | 5 |
| | 5 | 120925 | Swirl ring | 1 |
| | 8 | 120979 | Deflector | 1 |
| | 11 | 220325 | Deflector, CE | 1 |
| | 13 | 220404 | Shield, ohmic | 1 |
| | 2 | 120928 | Retaining cap | 1 |
| | 2A | 220061 | Retaining cap, ohmic | 1 |
| | 12 | 220329 | Nozzle, T60/T80/T100 | 5 |
| | 4 | 120926 | Electrode | 5 |
| | 5 | 120925 | Swirl ring | 1 |

Powermax1000 T60M torch assembly



T60M torch

| ITEM NUMBER | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------------------------------------------------------|
| | 083175* | T60M machine torch assembly 15' (4.6m) |
| | 083174* | T60M machine torch assembly 25' (7.6m) |
| | 083176* | T60M machine torch assembly 35' (10.7m) |
| | 083177* | T60M machine torch assembly 50' (15.2m) |
| | 128645 | Kit: torch mounting |
| 1 | 128640 | Kit: T60M/T80M torch main body replacement |
| 2 | 128639 | Kit: cap sensor switch replacement |
| 3 | 128521 | Kit: T60/T80, T60M/T80M torch head repair |
| 4 | 128643 | Kit: T60M/T80M mounting sleeve replacement |
| 5 | 128634 | Kit: T60M/T80M lead replacement 15' (4.6m) |
| 6 | 128633 | Kit: T60M/T80M lead replacement 25' (7.6m) |
| 7 | 128635 | Kit: T60M/T80M lead replacement 35' (10.7m) |
| 8 | 128641 | Kit: T60M/T80M lead replacement 50' (15.2m) |
| 9 | 128638 | Kit: ETR connector repair (regional repair centers only) |
| 10 | 027889 | Retaining clip |
| 11 | 128710 | Kit: T60/T80M positioning sleeve replacement (with rack) |
| 11 | 220070 | Kit: T60/T80M positioning sleeve replacement (without rack) |
| 12 | 058519 | Torch o-ring |

* Assembly includes consumables

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powermax600

Machine torch parts

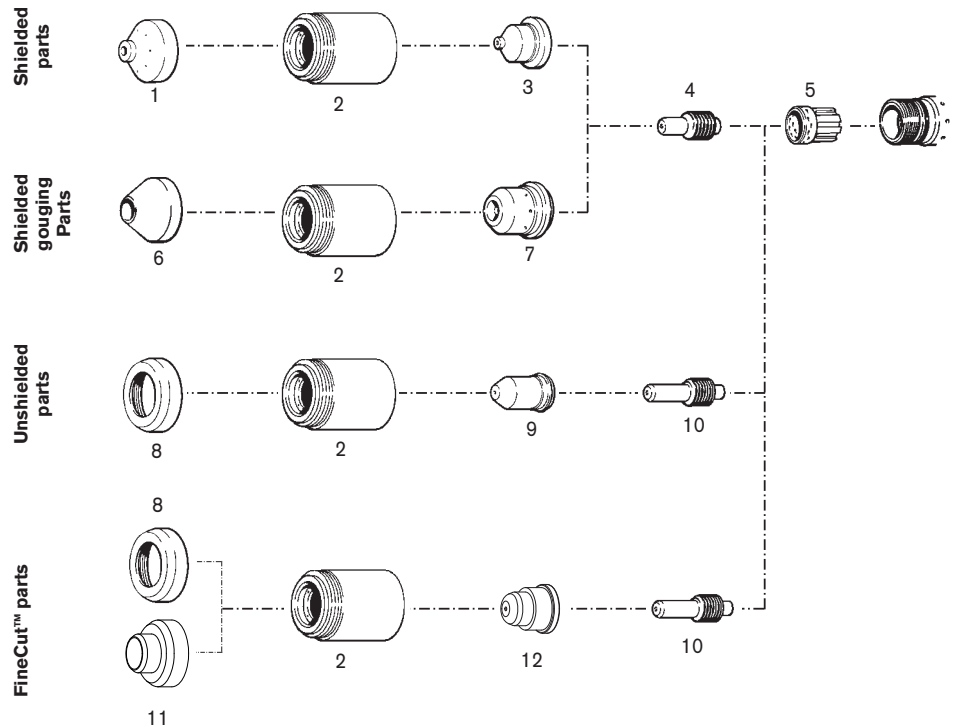
PAC123M consumables



Powermax600



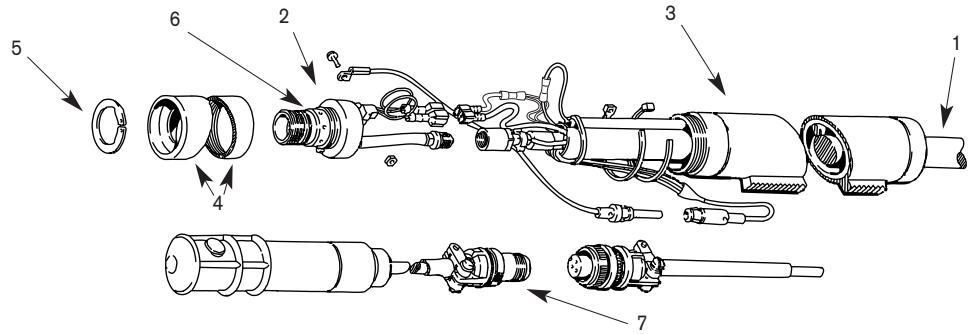
PAC123M torch



| | ITEM NUMBER | PART NUMBER | DESCRIPTION | QUANTITY PER PACKAGE |
|------------------------|-------------|-------------|-----------------------------|----------------------|
| Shielded parts | 1 | 120827 | Shield | 1 |
| | 2 | 120600 | Retaining cap | 1 |
| | 3 | 120826 | Nozzle | 5 |
| | 4 | 120573 | Electrode | 5 |
| | 5 | 120576 | Swirl ring | 1 |
| Shielded gouging parts | 6 | 120608 | Shield, gouging | 1 |
| | 2 | 120600 | Retaining cap | 1 |
| | 7 | 120831 | Nozzle, gouging | 5 |
| | 4 | 120573 | Electrode | 5 |
| | 5 | 120576 | Swirl ring | 1 |
| Unshielded parts | 8 | 120303 | Deflector | 1 |
| | 2 | 120600 | Retaining cap | 1 |
| | 9 | 120606 | Nozzle, pipe saddle, 35 amp | 5 |
| | 10 | 120574 | Electrode, extended | 5 |
| | 5 | 120576 | Swirl ring | 1 |
| FineCut™ parts | 8 | 120303 | Deflector | 1 |
| | 11 | 220326 | Deflector, CE | 1 |
| | 2 | 120600 | Retaining cap | 1 |
| | 12 | 220330 | Nozzle | 5 |
| | 10 | 120574 | Electrode | 5 |
| | 5 | 120576 | Swirl ring | 1 |

Note: The nozzles and swirl rings shown must be used as a set.

Powermax600 PAC123M torch assembly



PAC123M torch

| ITEM NUMBER | PART NUMBER | DESCRIPTION |
|--------------------------------------------------------------------------------------------|-------------|---------------------------------------------------------------|
| Torch assemblies with quick disconnects only for use with 208-240V and 480V systems | | |
| | 086026* | PAC123M torch assembly, with pigtail and QD 15' / 4.6 m |
| | 086027* | PAC123M torch assembly, with pigtail and QD 25' / 7.6 m |
| | 086029* | PAC123M torch assembly, with pigtail and QD 50' / 15.2 m |
| 1 | 128572 | Torch lead, with pigtail and QD 15' / 4.6 m |
| 1 | 128573 | Torch lead, with pigtail and QD 25' / 7.6 m |
| 1 | 128574 | Torch lead, with pigtail and QD 50' / 15.2 m |
| Torch assemblies without quick disconnects only for use with 230V and 400V systems | | |
| | 086004* | PAC123M torch assembly, with pigtail, without QD 15' / 4.6 m |
| | 086005* | PAC123M torch assembly, with pigtail, without QD 25' / 7.6 m |
| | 086006* | PAC123M torch assembly, with pigtail, without QD 50' / 15.2 m |
| 1 | 128374 | Torch lead, with pigtail, without QD 15' / 4.6 m |
| 1 | 128375 | Torch lead, with pigtail, without QD 25' / 7.6 m |
| 1 | 128376 | Torch lead, with pigtail, without QD 50' / 15.2 m |
| 2 | 120583 | Torch main body with switch |
| 3 | 020620 | Torch position sleeve |
| 4 | 120613 | Torch sleeve |
| 5 | 027599 | Snap ring |
| 6 | 044016 | O-ring, Buna - N 90 Duro |
| 7 | 028714 | On/Off pendant, 25' / 7.6 m |
| 7 | 128061 | On/Off pendant, 50' / 15.2 m |
| 7 | 128062 | On/Off pendant, 75' / 22.9 m |

* Assembly includes consumables

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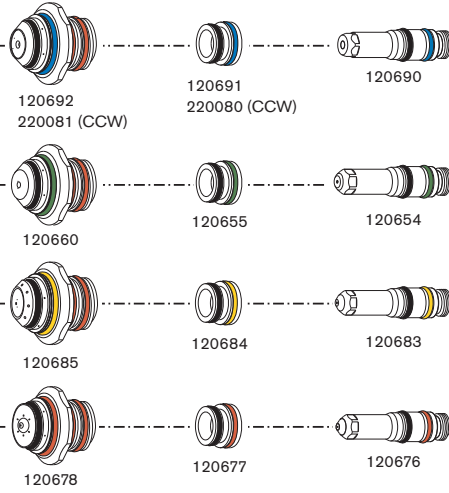
HyDefinition® HD4070®

Consumables

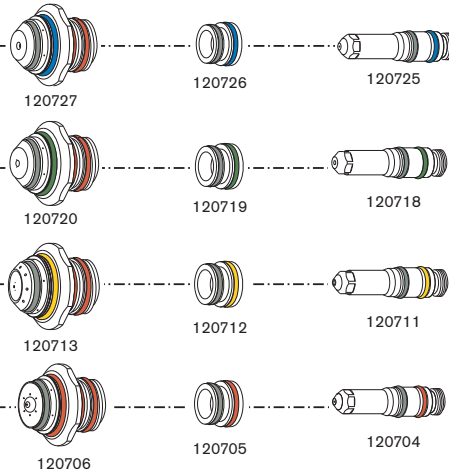
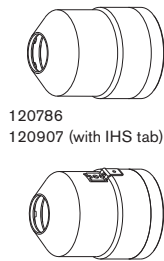


HyDefinition HD4070

Mild steel



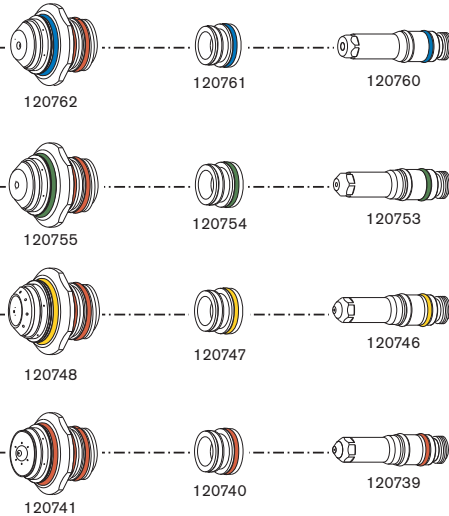
Stainless steel



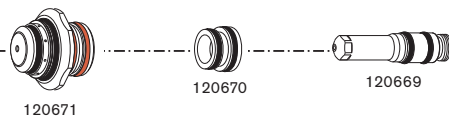
Aluminum



HD4070 torch



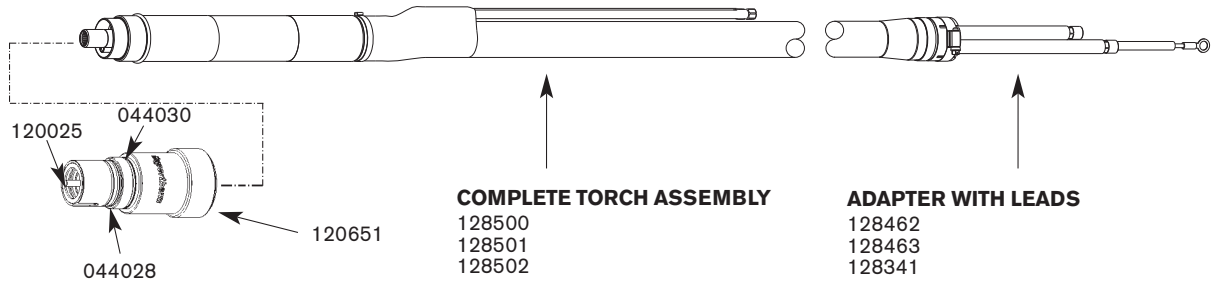
Marking



HD4070 consumables

| APPLICATION | MATERIAL | CONSUMABLE DESCRIPTION | 200 AMPS CCW | 200 AMPS | 100 AMPS | 70 AMPS | 30/45* AMPS |
|----------------|-----------------|------------------------------|-----------------|----------|----------|---------|-------------|
| CUTTING | Mild steel | Electrode | 120690 | 120690 | 120654 | 120683 | 120676 |
| | | Swirl ring | 220080 | 120691 | 120655 | 120684 | 120677 |
| | | Nozzle | 220081 | 120692 | 120660 | 120685 | 120678 |
| | | Retaining cap | 120786 | 120786 | 120786 | 120786 | 120786 |
| | | Retaining cap (with IHS tab) | 120907 | 120907 | 120907 | 120907 | 120907 |
| | Stainless steel | Electrode | | 120725 | 120718 | 120711 | 120704* |
| | | Swirl ring | | 120726 | 120719 | 120712 | 120705* |
| | | Nozzle | | 120727 | 120720 | 120713 | 120706* |
| | | Retaining cap | | 120786 | 120786 | 120786 | 120786* |
| | | Retaining cap (with IHS tab) | | 120907 | 120907 | 120907 | 120907* |
| | Aluminum | Electrode | | 120760 | 120753 | 120746 | 120739 |
| | | Swirl ring | | 120761 | 120754 | 120747 | 120740 |
| | | Nozzle | | 120762 | 120755 | 120748 | 120741 |
| | | Retaining cap | | 120786 | 120786 | 120786 | 120786 |
| | | Retaining cap (with IHS tab) | | 120907 | 120907 | 120907 | 120907 |
| MARKING | All materials | Electrode | | 120669 | | | |
| | | Swirl ring | | 120670 | | | |
| | | Nozzle | | 120671 | | | |
| | | Retaining cap | | 120786 | | | |
| | | Retaining cap (with IHS tab) | | 120907 | | | |

HD4070 torch assembly



| PART NO. | DESCRIPTION |
|----------|----------------------------------------------|
| 120651 | HD4070 torch main body |
| 128462 | HD4070 torch adapter with 6' (2 m) leads |
| 128463 | HD4070 torch adapter with 10' (3 m) leads |
| 128341 | HD4070 torch adapter with 15' (4.5 m) leads |
| 128500 | HD4070 torch assembly with 6' (2 m) leads |
| 128501 | HD4070 torch assembly with 10' (3 m) leads |
| 128502 | HD4070 torch assembly with 15' (4.5 m) leads |
| 120025 | Water cooling tube |
| 044028 | O-ring |
| 044030 | O-ring |

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HyDefinition® HD3070®

Consumables



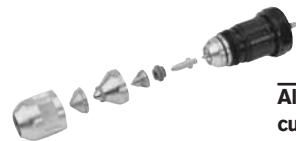
HyDefinition HD3070



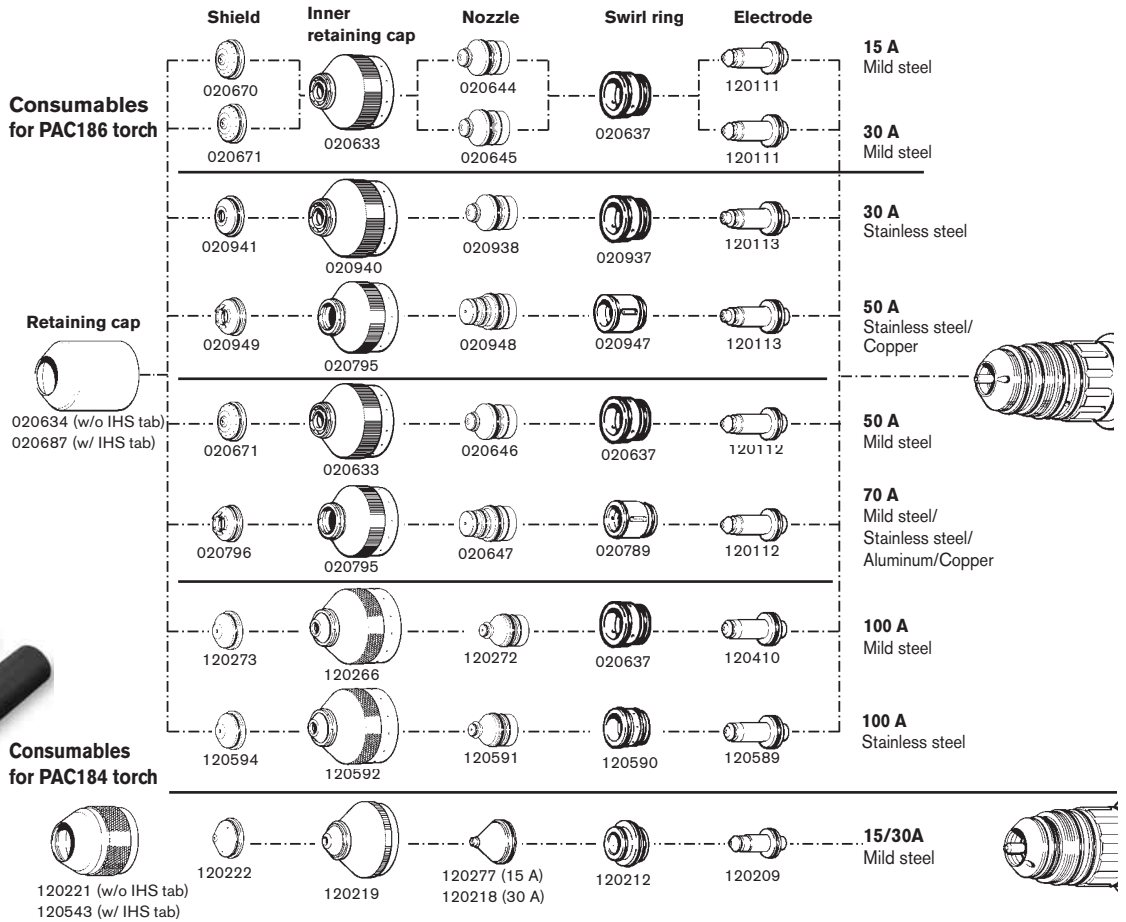
PAC184 torch - left
PAC186 torch - right



PAC186 consumables

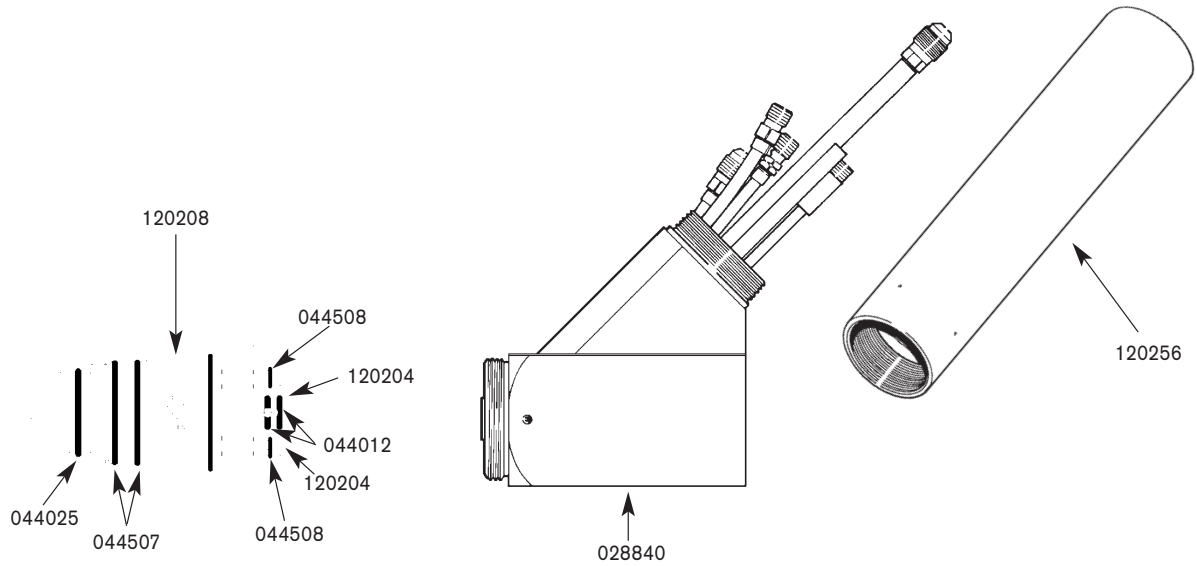


PAC184 consumables

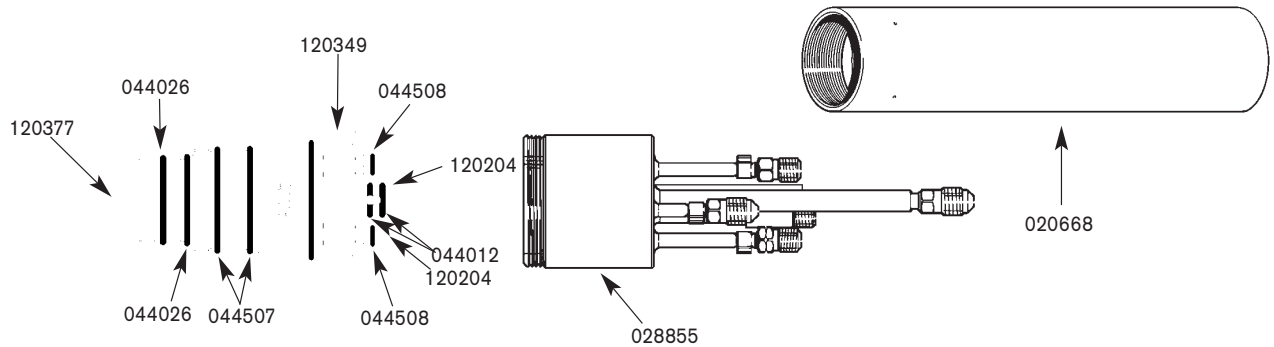


| PART DESCRIPTION | PAC186 TORCH | | | | | PAC184 TORCH | | |
|--------------------------------------------------------------------------|-----------------------|--------|--------|--------|---------|--------------|--------|--------|
| | 15-AMP | 30-AMP | 50-AMP | 70-AMP | 100-AMP | 15-AMP | 30-AMP | |
| Retaining caps (to be used with all applications listed below) | With IHS tab | 020687 | 020687 | 020687 | 020687 | 020687 | 120543 | 120543 |
| | Without IHS tab | 020634 | 020634 | 020634 | 020634 | 020634 | 120221 | 120221 |
| Mild steel cutting | Electrode | 120111 | 120111 | 120112 | 120112 | 120410 | 120209 | 120209 |
| | Swirl ring | 020637 | 020637 | 020637 | 020789 | 020637 | 120212 | 120212 |
| | Nozzle | 020644 | 020645 | 020646 | 020647 | 120272 | 120277 | 120218 |
| | Inner retaining cap | 020633 | 020633 | 020633 | 020795 | 120266 | 120219 | 120219 |
| | Shield/Shield adapter | 020670 | 120671 | 020671 | 020796 | 120273 | 120222 | 120222 |
| Stainless steel cutting | Electrode | ----- | 120113 | 120113 | 120112 | 120589 | ----- | ----- |
| | Swirl ring | ----- | 020937 | 020947 | 020789 | 120590 | ----- | ----- |
| | Nozzle | ----- | 020938 | 020948 | 020647 | 120591 | ----- | ----- |
| | Inner retaining cap | ----- | 020940 | 020795 | 020795 | 120592 | ----- | ----- |
| | Shield/Shield adapter | ----- | 120941 | 020949 | 020796 | 120594 | ----- | ----- |
| Aluminum cutting | Electrode | ----- | ----- | ----- | 120112 | ----- | ----- | ----- |
| | Swirl ring | ----- | ----- | ----- | 020789 | ----- | ----- | ----- |
| | Nozzle | ----- | ----- | ----- | 020647 | ----- | ----- | ----- |
| | Inner retaining cap | ----- | ----- | ----- | 020795 | ----- | ----- | ----- |
| | Shield/Shield adapter | ----- | ----- | ----- | 020796 | ----- | ----- | ----- |

HyDefinition HD3070 PAC184 torch assembly



HyDefinition HD3070 PAC186 torch assembly




| PART NUMBER | DESCRIPTION |
|-------------|---------------------------------------------|
| 120208 | Torch main body, PAC184 |
| 120349 | Torch main body, PAC186 |
| 120256 | Sleeve, mounting, PAC184 |
| 020668 | Sleeve, mounting, PAC186 |
| 044012 | O-ring, Buna, 70 Duro 0.364 x .070 |
| 044026 | O-ring, Buna, 70 Duro 1.239 x .070 |
| 044507 | O-ring, Buna, 70 Duro 1.424 x .070 |
| 044508 | O-ring, Buna, 70 Duro 0.216 x .053 |
| 028840 | Assy, PAC184, 45° torch quick-disconnect |
| 028855 | Assy, PAC185/186, straight quick-disconnect |
| 120377 | Tube, water electrode cooling, PAC186 |
| 120204 | Bullet connector |

Hypertherm®

HT4001

Consumables HT4001 without slave

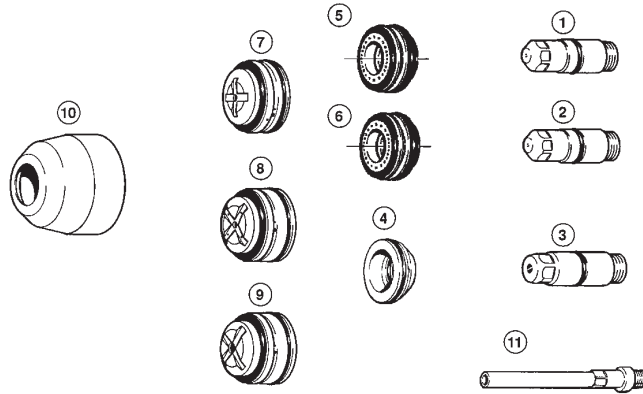
| | |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
|  | WARNING |
| <p>CE countries must operate the PAC620 machine torch using a special CE retaining cap in order to comply with CE regulations. Cap removal tool (004732) must be used to put on and remove the retaining caps. Part numbers for the CE retaining caps are indicated in the cut charts.</p> | |

| METAL | PLASMA GAS | CONSUMABLE DESCRIPTION | 260 AMPS STANDARD | 260 AMPS BEVEL | 340 AMPS STANDARD | 340 AMPS BEVEL | 400 AMPS STANDARD | 400 AMPS BEVEL |
|--------------------|------------|------------------------|-------------------|----------------|-------------------|----------------|-------------------|----------------|
| Mild Steel | Oxygen | Electrode | 020663 | 020975 | 120630 | 120836 | ----- | ----- |
| | | Swirl ring | 020623 | 020623 | 120135 | 120460 | ----- | ----- |
| | | Nozzle | 020086 | 120384 | 020086 | 120384 | ----- | ----- |
| | | Retaining cap | 020579 | 120390 | 020579 | 120390 | ----- | ----- |
| | Nitrogen | Electrode | 020082 | ----- | ----- | ----- | 020082 | ----- |
| | | Swirl ring | 020039 | ----- | ----- | ----- | 020039 | ----- |
| | | Nozzle | 020089 | ----- | ----- | ----- | 020084 | ----- |
| | | Retaining cap | 020579 | ----- | ----- | ----- | 020579 | ----- |
| Mild/ Stainless | Nitrogen | Electrode | ----- | 020968 | ----- | ----- | ----- | 020968 |
| | | Swirl ring | ----- | 020039 | ----- | ----- | ----- | 020039 |
| | | Nozzle | ----- | 120386 | ----- | ----- | ----- | 120387 |
| | | Retaining cap | ----- | 120390 | ----- | ----- | ----- | 120390 |
| Stainless | Nitrogen | Electrode | 020082 | ----- | ----- | ----- | 020082 | ----- |
| | | Swirl ring | 020039 | ----- | ----- | ----- | 020039 | ----- |
| | | Nozzle | 020089 | ----- | ----- | ----- | 020084 | ----- |
| | | Retaining cap | 020579 | ----- | ----- | ----- | 020579 | ----- |
| Aluminum | Nitrogen | Electrode | 020082 | 020968 | ----- | ----- | 020082 | 020968 |
| | | Swirl ring | 020039 | 020039 | ----- | ----- | 020039 | 020039 |
| | | Nozzle | 020089 | 120386 | ----- | ----- | 020084 | 120387 |
| | | Retaining cap | 020579 | 120390 | ----- | ----- | 020579 | 120390 |

* Use standard consumables with the PAC620 if the torch will only be making cuts 90° to the work surface.

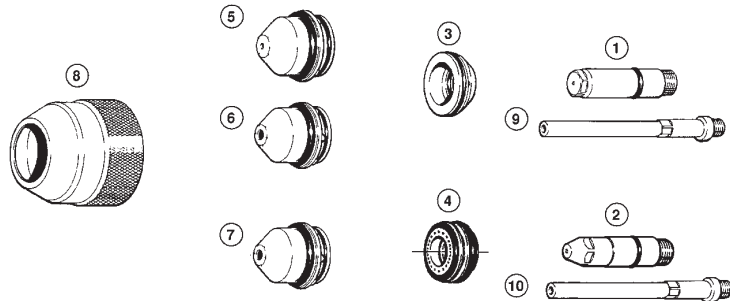
** Use bevel consumables with the PAC620 if the torch will be making cuts between 45° and 90° to the work surface.

HT4001 PAC620 torch assembly standard without slave



| STANDARD ITEM | PART NUMBER | DESCRIPTION |
|---------------|-------------|----------------------------------------------|
| 1 | 020663 | Electrode: oxygen, 260A |
| 2 | 120630 | Electrode: oxygen, 340A |
| 3 | 020082 | Electrode: nitrogen, 400A |
| 4 | 020039 | Swirl ring: nitrogen, .120/.166/.187 |
| 5 | 020623 | Swirl ring: oxygen |
| 6 | 120135 | Swirl ring: oxygen, 340A |
| 7 | 020086 | Nozzle: oxygen |
| 8 | 020089 | Nozzle: nitrogen, .120 |
| 9 | 020084 | Nozzle: nitrogen, .166 |
| 10 | 020579 | Retaining cap: tprd nozzle standard (Vectra) |
| 11 | 020990 | Water tube: 400/600/170 |

HT4001 PAC620 torch assembly Bevel without slave




| BEVEL ITEM | PART NUMBER | DESCRIPTION |
|------------|-------------|--------------------------------------|
| 1 | 020968 | Electrode: PAC620 bevel nitrogen |
| 2 | 020975 | Electrode: PAC620 bevel oxygen |
| 3 | 020039 | Swirl ring: nitrogen |
| 4 | 020623 | Swirl ring: oxygen |
| 5 | 120386 | Nozzle: PAC620 bevel nitrogen, .120 |
| 6 | 120387 | Nozzle: PAC620 bevel nitrogen, .166 |
| 7 | 120384 | Nozzle: PAC620 bevel oxygen, .099 |
| 8 | 120390 | Retaining cap: PAC620 bevel (Vectra) |
| 9 | 020991 | Water tube: PAC620 bevel, nitrogen |
| 10 | 020992 | Water tube: PAC620 bevel, oxygen |

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HT4001

Consumables HT4001 with slave

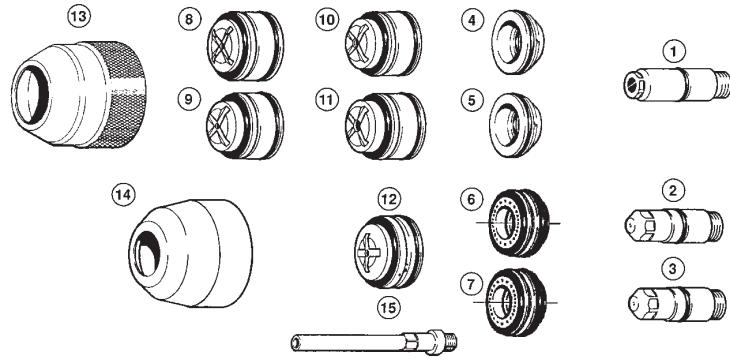
| | |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
|  | WARNING |
| <p>CE countries must operate the PAC620 machine torch using a special CE retaining cap in order to comply with CE regulations. Cap removal tool (004732) must be used to put on and remove the retaining caps. Part numbers for the CE retaining caps are indicated in the cut charts.</p> | |

| METAL | PLASMA GAS | CONSUMABLE DESCRIPTION | 260 AMPS STANDARD | 260 AMPS BEVEL | 400 AMPS STANDARD | 400 AMPS BEVEL | 600 AMPS STANDARD | 600 AMPS BEVEL | 760 AMPS STANDARD | 760 AMPS BEVEL |
|----------------|------------|------------------------|-------------------|----------------|-------------------|----------------|-------------------|----------------|-------------------|----------------|
| Mild Stainless | Nitrogen | Electrode | 020285 | 020968 | 020285 | 020968 | 020285 | 020968 | 020285 | 020968 |
| | | Swirl ring | 020039 | 020039 | 020039 | 020039 | 020039 | 020039 | 020040 | 020040 |
| | | Nozzle | 020281 | 120386 | 020282 | 120387 | 020283 | 120388 | 020284 | 120389 |
| | | Retaining cap | 020580 | 120390 | 020580 | 120390 | 020580 | 120390 | 020580 | 120390 |
| Aluminum | Nitrogen | Electrode | 020285 | 020968 | 020285 | 020968 | 020285 | 020968 | 020285 | 020968 |
| | | Swirl ring | 020039 | 020039 | 020039 | 020039 | 020039 | 020039 | 020040 | 020040 |
| | | Nozzle | 020281 | 120386 | 020282 | 120387 | 020283 | 120388 | 020284 | 120389 |
| | | Retaining cap | 020580 | 120390 | 020580 | 120390 | 020580 | 120390 | 020580 | 120390 |

* Use standard consumables with the PAC620 if the torch will only be making cuts 90° to the work surface.

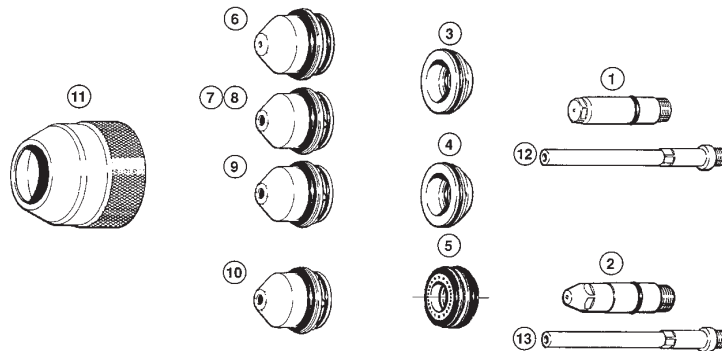
** Use bevel consumables with the PAC620 if the torch will be making cuts between 45° and 90° to the work surface.

HT4001 PAC620 torch assembly standard with slave



| STANDARD ITEM | PART NUMBER | DESCRIPTION |
|---------------|-------------|----------------------------------------------|
| 1 | 020285 | Electrode: nitrogen |
| 2 | 020663 | Electrode: oxygen, 260A |
| 3 | 120630 | Electrode: oxygen, 340A |
| 4 | 020039 | Swirl ring: nitrogen, .120/.166/.187 |
| 5 | 020040 | Swirl ring: nitrogen, .220 |
| 6 | 020623 | Swirl ring: oxygen |
| 7 | 120135 | Swirl ring: oxygen, 340A |
| 8 | 020281 | Nozzle: nitrogen, .120 |
| 9 | 020282 | Nozzle: nitrogen, .166 |
| 10 | 020283 | Nozzle: nitrogen, .187 |
| 11 | 020284 | Nozzle: nitrogen, .220 |
| 12 | 020086 | Nozzle: oxygen |
| 13 | 020580 | Retaining cap: nitrogen, standard (Vectra) |
| 14 | 020579 | Retaining cap: tprd nozzle standard (Vectra) |
| 15 | 020990 | Water tube: 400/600/170 |

HT4001 PAC620 torch assembly bevel with slave



| BEVEL ITEM | PART NUMBER | DESCRIPTION |
|------------|-------------|--------------------------------------|
| 1 | 020968 | Electrode: PAC620 bevel nitrogen |
| 2 | 020975 | Electrode: PAC620 bevel oxygen |
| 3 | 020039 | Swirl ring: nitrogen, .120/.166/.187 |
| 4 | 020040 | Swirl ring: nitrogen, .220 |
| 5 | 020623 | Swirl ring: oxygen |
| 6 | 120386 | Nozzle: PAC620 bevel nitrogen, .120 |
| 7 | 120387 | Nozzle: PAC620 bevel nitrogen, .166 |
| 8 | 120388 | Nozzle: PAC620 bevel nitrogen, .187 |
| 9 | 120389 | Nozzle: PAC620 bevel, nitrogen, .220 |
| 10 | 120384 | Nozzle: PAC620 bevel, oxygen, .099 |
| 11 | 120390 | Retaining cap: PAC620 bevel (Vectra) |
| 12 | 020991 | Water tube: PAC620 bevel, nitrogen |
| 13 | 020992 | Water tube: PAC620 bevel, oxygen |

HT4001 CE PAC620 torch assembly standard without slave

| PART NUMBER | DESCRIPTION |
|--------------------|-------------------------------------------------|
| 020663 | Electrode: oxygen, 260A |
| 120630 | Electrode: oxygen, 340A |
| 020082 | Electrode: nitrogen, 400A |
| 020039 | Swirl ring: nitrogen, .120/.166/.187 |
| 020623 | Swirl ring: oxygen |
| 120135 | Swirl ring: oxygen, 340A |
| 020086 | Nozzle: oxygen |
| 020089 | Nozzle: nitrogen, .120 |
| 020084 | Nozzle: nitrogen, .166 |
| 120466 | Retaining cap CE: tprd nozzle standard (Vectra) |
| 020990 | Water tube: 400/600/170 |

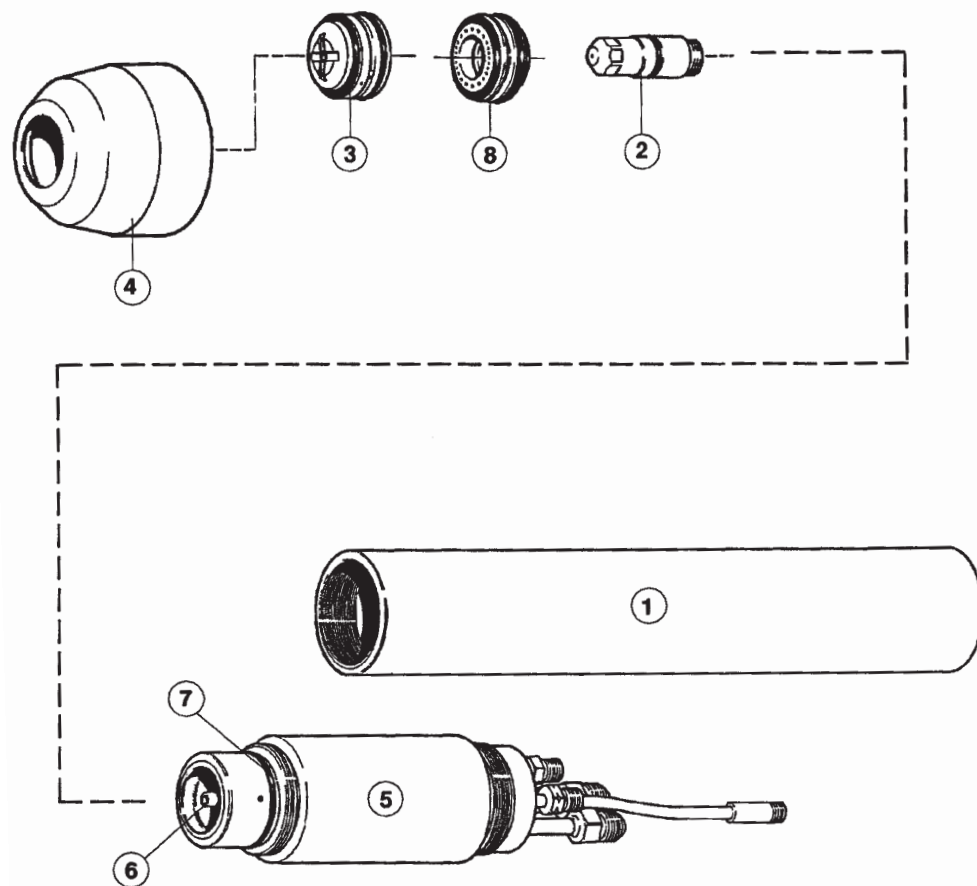
HT4001 CE PAC620 torch assembly standard with slave

| PART NUMBER | DESCRIPTION |
|--------------------|-------------------------------------------------|
| 020285 | Electrode: nitrogen |
| 020663 | Electrode: oxygen, 260A |
| 120630 | Electrode: oxygen, 340A |
| 020039 | Swirl ring: nitrogen, .120/.166/.187 |
| 020040 | Swirl ring: nitrogen, .220 |
| 020623 | Swirl ring: oxygen |
| 120135 | Swirl ring: oxygen, 340A |
| 020281 | Nozzle: nitrogen, .120 |
| 020282 | Nozzle: nitrogen, .166 |
| 020283 | Nozzle: nitrogen, .187 |
| 020284 | Nozzle: nitrogen, .220 |
| 020086 | Nozzle: oxygen |
| 120464 | Retaining cap CE: nitrogen, standard (Vectra) |
| 120466 | Retaining cap CE: tprd nozzle standard (Vectra) |
| 020990 | Water tube: 400/600/170 |

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HT4000

Consumables PAC170

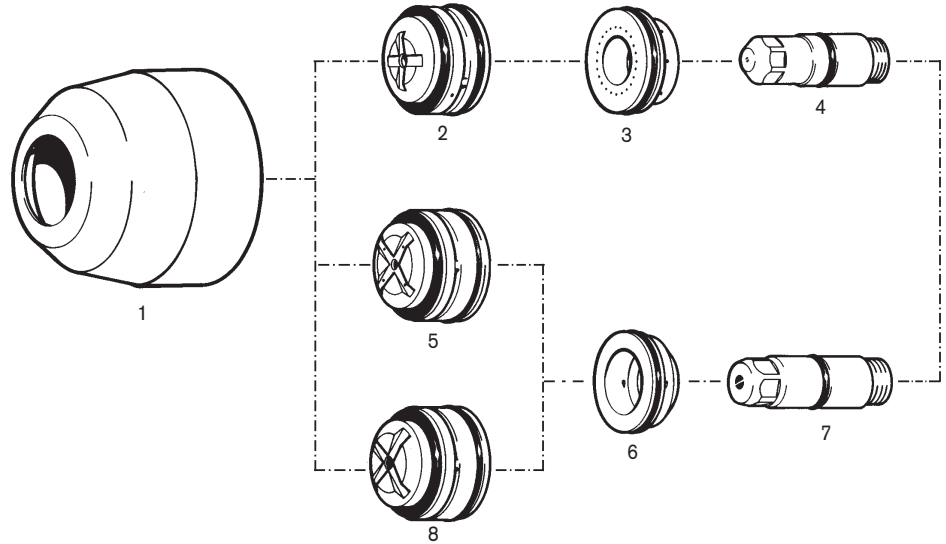


| PART NUMBER | DESCRIPTION | QTY |
|-------------|--------------------------------------|-----|
| 020046 | Brkt w/clevis: 2" tch mtg (standard) | 1 |
| 029044 | Tch mtng SA:2" (for IHS system) | |
| 020039 | Swirl ring, .120 | 2 |
| 020082 | Electrode, nitrogen | 3 |
| 020084 | Nozzle, .166, nitrogen | 5 |
| 020086 | Nozzle, .099, oxygen | 5 |
| 020579 | Cap, nozzle retaining | 1 |
| 020089 | Nozzle, .120, nitrogen | 3 |
| 020623 | Swirl ring, PAC170 | 3 |
| 020663 | Electrode, PAC170. oxygen | 5 |
| 027001 | Wrench, electrode | 1 |
| 027012 | Lubricant, silicon | 1 |
| 027347 | Water tube tool | 1 |

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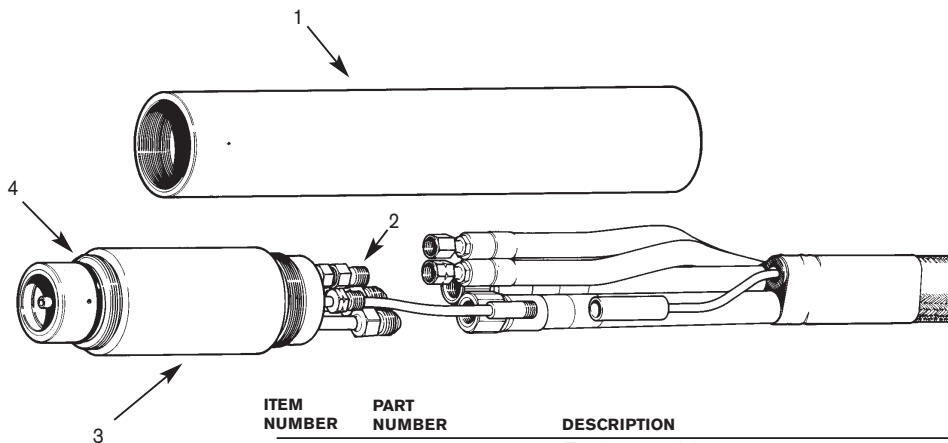
HT400

Consumables



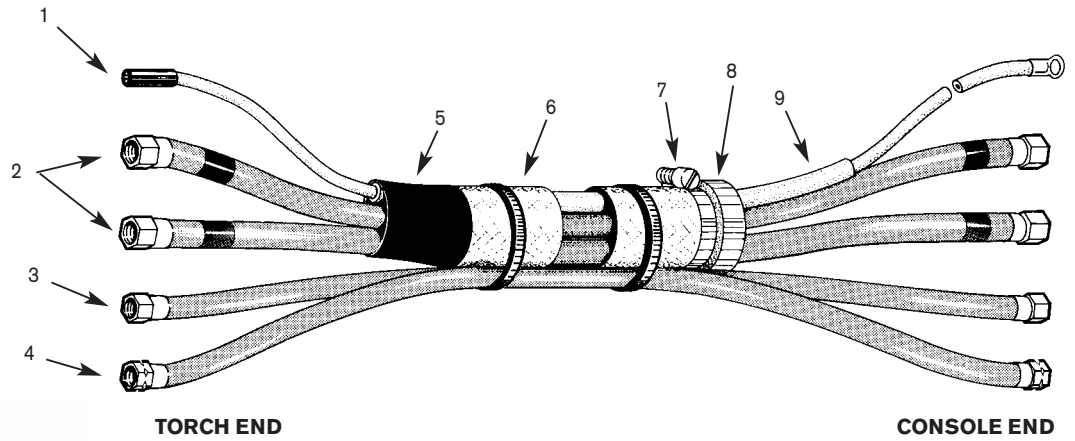
| | ITEM NUMBER | PART NUMBER | DESCRIPTION |
|-----------------------|-------------|-------------|-----------------------|
| Oxygen parts | 1 | 020579 | Cap, nozzle retaining |
| | 2 | 020086 | Nozzle, .099 oxygen |
| | 3 | 020096 | Swirl ring, oxygen |
| | 4 | 020081 | Electrode, oxygen |
| Nitrogen parts | 1 | 020579 | Cap, nozzle retaining |
| | 5 | 020089 | Nozzle, .120 nitrogen |
| | 6 | 020039 | Swirl ring, nitrogen |
| | 7 | 020082 | Electrode, nitrogen |
| | 8 | 020084 | Nozzle, .166 nitrogen |

HT400 torch assembly



| ITEM NUMBER | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------------|
| | 028229 | Torch assembly |
| 1 | 020041 | Sleeve, insulating |
| 2 | 004146 | Orifice, critical |
| 3 | 020080 | Torch main body |
| 4 | 044028 | O-ring, Buna |

HT400 torch leads package



| PART NUMBER | DESCRIPTION |
|-------------|-------------|
|-------------|-------------|

20-foot shielded torch leads package components

| PART NUMBER | DESCRIPTION |
|-------------|--------------------------------------------------------------|
| 1 | 023036 Lead, high frequency, 1 -plug |
| 2 | 023012 Cable, water cooled (two required) |
| 3 | 024017 Hose assembly, torch gas |
| 4 | 024018 Hose assembly, torch water |
| 5 | 046026 Tubing, 1 1/2" inner diameter shrink black (3 inches) |
| 6 | 046010 Tubing, 1 1/8" inner diameter tinned braid (25 feet) |
| 7 | 015090 Clamp, hose, 1 5/16"-2 1/4" |
| 8 | 004080 Collar, shield torch leads |
| 9 | 046033 Tubing, 3/8" inner diameter nylobrade (20 feet) |

HT400 torch leads packages

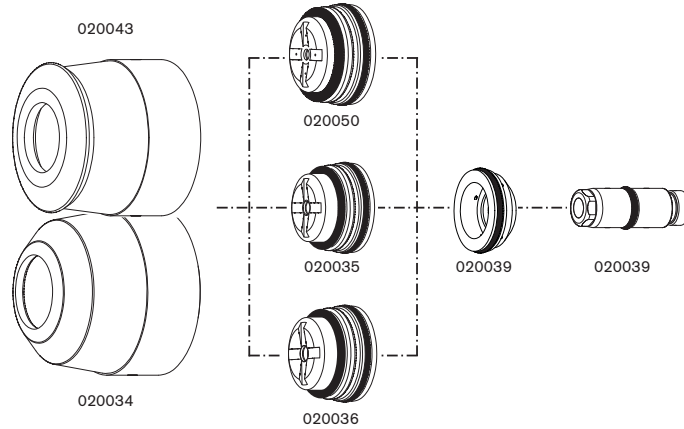
| | |
|--------|-----------------------------|
| 028137 | Leads, torch, shielded, 10' |
| 028138 | Leads, torch, shielded, 15' |
| 028139 | Leads, torch, shielded, 20' |
| 028140 | Leads, torch, shielded, 25' |
| 028141 | Leads, torch, shielded, 30' |
| 028142 | Leads, torch, shielded, 35' |
| 028143 | Leads, torch, shielded, 40' |

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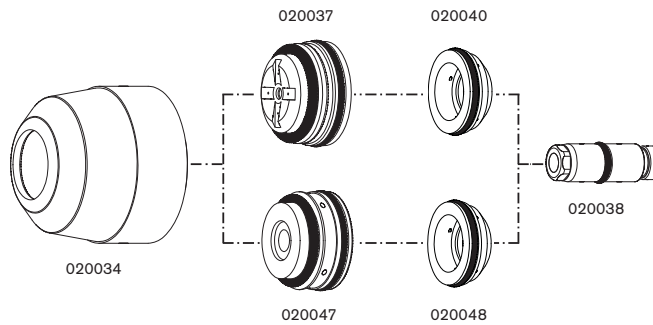
PAC500®

Consumables

Up to 600 Amps

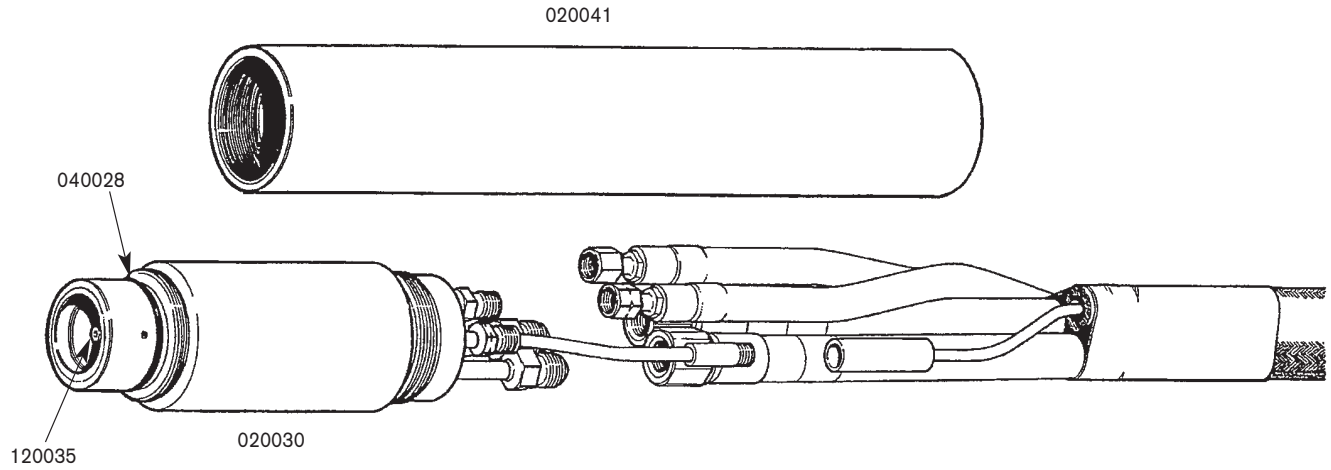


600 to 1000 Amps



| | PART NUMBER | DESCRIPTION |
|------------------|-------------|--------------------------------|
| Up to 600 Amps | 020043 | Cap, nozzle retaining, flared |
| | 020034 | Cap, nozzle retaining, tapered |
| | 020050 | Nozzle, .120 |
| | 020035 | Nozzle, .166 |
| | 020036 | Nozzle, .187 |
| | 020039 | Swirl ring, .120/.166/.187 |
| | 020038 | Electrode |
| 600 to 1000 Amps | 020034 | Cap, nozzle retaining, tapered |
| | 020037 | Nozzle, .220 |
| | 020047 | Nozzle, .250 |
| | 020040 | Swirl ring, .220 |
| | 020048 | Swirl ring, .250 |
| | 020038 | Electrode |

PAC500 torch assembly (028031, 028160)



| PART NUMBER | DESCRIPTION |
|-------------|-----------------------------|
| 028031 | Torch assembly, flared cap |
| 028160 | Torch assembly, tapered cap |
| 020030 | Torch main body |
| 020536 | Lead insulator, 9/16 x 2.5" |
| 020041 | Sleeve, insulating |
| 044028 | O-ring, Buna-N |
| 120035 | Water tube |

The Hypertherm mechanized systems



HPR260



HPR130



HyPerformance HD4070



HyPerformance HD3070



HySpeed HT4400



HySpeed HT2000



MAX200



HySpeed Plasma HSD130



MAX 70/100



MAX100D



Powermax1650



Powermax1250



Powermax1000



Powermax600



HyDefinition HD3070



HyDefinition HD4070

Not shown: HT4001, HT4000, HT400, PAC500